

Cutting and stamping machine

Type C052 B

Translation of the original operating manual

Streckfuss USA

Reservation of title

We reserve all rights for this document.
It may not be duplicated or made accessible to third parties
without our consent.

This documentation and the information contained therein
have been compiled with the appropriate care.

The company Streckfuss USA however shall not accept
responsibility for typing and other errors
or damages resulting therefrom.

Version: 2.4

Stand: September 2021

Hersteller: Streckfuss USA
PO Box 140008
Dallas, TX 75214
USA
Tel. +1 972 7901614

E-Mail: sales@streckfuss.com
Internet: www.streckfuss.com

Streckfuss USA
PO Box 140008
Dallas, TX 75214
USA
Tel. +1 972 790 1614

E-Mail: sales@streckfuss.com
Internet: www.streckfuss.com

EC Declaration of Conformity **In according to EC Machinery Directive 2006/42/EG** **Appendix II A**

We herewith declare that the machine described hereinafter satisfies the essential safety and health requirements set out in the EC Machinery Directive with regard to its design and construction as well as the type marketed by us.

In case of an alteration of the machine without our agreement this declaration shall become void.

We furthermore point out that for the installation of spare parts only original parts of the company Streckfuss USA may be used.

Description of the machine:	Cutting and forming machine
Machine type:	C 052 B
Machine number:	22.09.1111
Applicable directives:	EC Machinery Directive (2006/42/EG appendix II A) EC Electromagnetic Compatibility Directive (2014/30/EG)
Applied harmonized standards, particularly:	EN ISO 12100:2010 DIN EN 13857

Attachment of the CE label: CE

Place/Date/Signature: Karlsruhe, den 19.10.2021



Managing director

General

1. Notes on Industrial Safety

The following notes on industrial safety have to be specially adhered to:

- The cutting machine C052/B has been constructed according to the current state of the art and conforms to the ESD regulations. Nevertheless, perils may arise from this device if it is used by untrained personnel or for other than the intended purposes.
- **Statement on the Residual Risk**
 1. Danger of electric shock if the switchbox is opened while voltage carrying. Work in and on the electrical equipment may principally only be carried out by qualified electricians.

2. Danger of contusion and shearing during set up operation.

The danger areas are marked with signs.



- Applicable accident prevention regulations have to be adhered to by the user, particularly the
 - DGUV-Regulation 1
- The device may only be operated by trained personnel.
- Any mode of operation which can impair the safety of the device has to be refrained from.
- The user undertakes to operate the device only in perfect condition.
- Unauthorised alterations or variations which impair safety have to be refrained from.
- Safety devices may principally not be dismantled or put out of operation. If it is indispensable to dismantle safety devices for the purpose of tool changes or for maintenance and repair work, the safety device has to be re-installed immediately afterwards.

2. Table of contents

	Seite
General	4
1. Notes on Industrial Safety	4
2. Table of contents	5
3. General description	6
4. Technical data	7
Commissioning	8
1. Installation	8
2. Connecting	8
3. Working with the machine	9
4. Pitch size alteration	9
5. Height dimension alteration	10
6. Working speed	10
Retool	11
1. General comments on the adjustment of the machine	11
2. Change tool	12
3. Adjust tool	14
Faults and their Rectification	15
Maintenance	16
1. Maintenance Plan	16
Spare Parts Catalogue	17
1. Parts- and spare parts list	17
2. Assembly drawing	18
3. Pneumatic diagram	19

3. General description

The Cutting and Bending machine C052/B processes two-lead radial components.

The components are manually fed. The pitch size to be processed runs between 2,5 mm and 25 mm. Due to the V-shaped tool position, these pitch sizes can be continuously used.

Tool sets with stand-off shape or snap-in shape to the outside are available for the C052/B. Of course customer specific bending shapes can also be obtained, if the machine construction allows. Cutting and bending tooling are fix and can only be altered by a corresponding tool exchange.

The cutting length underneath the bending shape is 3 mm. Other dimensions have to be indicated when ordered.

The cutting and bending tooling are made of sophisticated tool steel. The bending shapes are marked with corresponding tooling numbers to grant a compatible exchange of spare tools at any time.

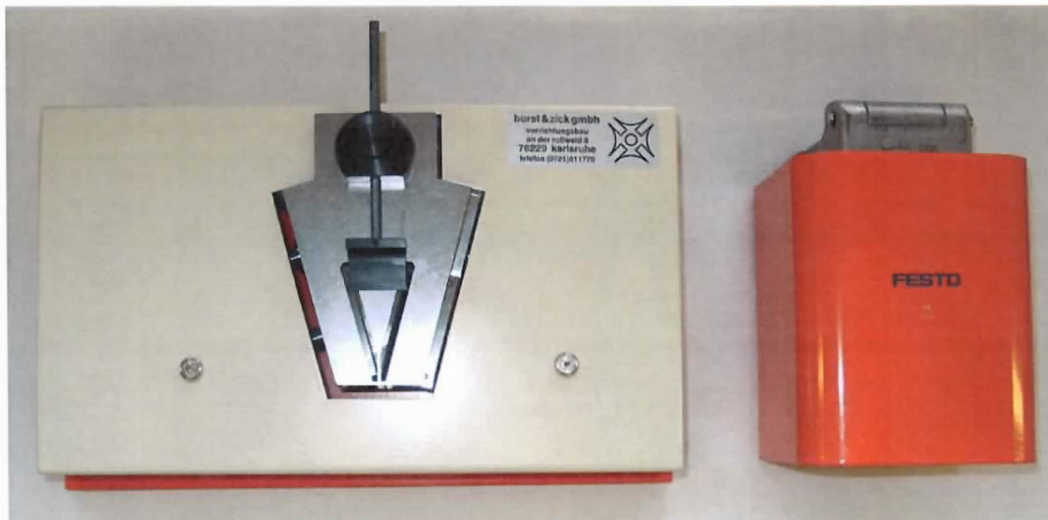


Figure 1

Cutting and bending machine C052/B

4. Technical data

Abmessungen	Length:	350 mm
	Width:	100 mm
	Height:	200 mm
Weight		ca. 8 kg
Compressed air		6 bar
Pitch size	Min.	3,5mm (2,5 mm auf Anfrage)
	Max.	25 mm
Wire Ø		Max. 0,8mm (addicted to the tool)
Cutting length		Standard 3mm (other dimensions on request)
Operating		Via pneumatic foot switch

Commissioning

1. Installation

The machine is delivered fully assembled and installed. Please check the shipment immediately with the help of the delivery note and/or the packing list. In case the consignment is incomplete or if damages have occurred during transport, please inform us immediately.

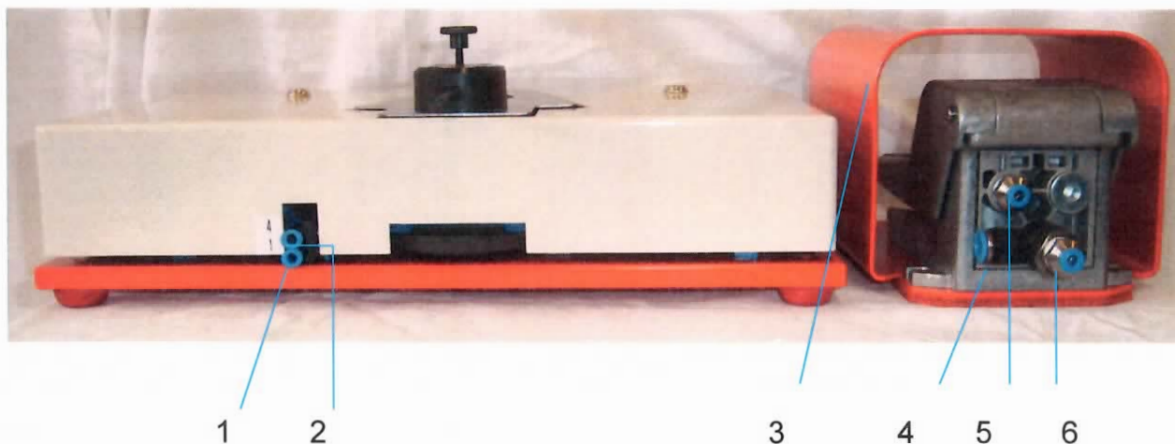
Foot valve and connection hoses are supplied loose and must be connected according to the attached pneumatic plan from local customers. We recommend to install in the supply line a maintenance unit with pressure regulator.

To be set pressure 6 bar.

Place the machine on a stable, level working table and put the foot switch on a comfortable position on the bottom.

2. Connecting

- To connect the device a compressed air net (6 bar), an air hose PUN 8 X 1,25 and an air hose PUN 4 X 0,75 are required.
- Connect with a hose PUN 4 X 0,75 the connection point 1 of the foot valve and the connection point 1 on the rear of the device.
- Connect with a hose PUN 4 X 0,75 the connection point 4 of the foot valve and the connection point 4 on the rear of the machine.
- Connect with a hose PUN 8 X 1,25 the connection point 1 of the foot valve and the compressed air net.



1. Connecting point 1
2. Connecting point 4
3. Foot valve

5. Air feed
6. Connecting point 4
7. Connecting point 1



Figure 2 - Connection plan

3. Working with the machine

The component to be processed is placed between the tooling jaws with the leads going downwards. The component body rests on the support latch and must contact the feeder slide.

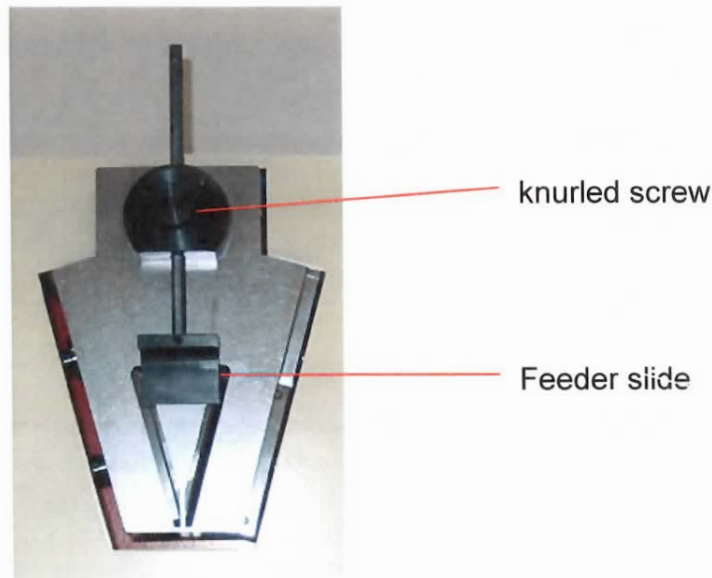
By pressing the foot valve, the cylinder of the right hand forming jaw is activated which forms and cuts the right-hand lead. Immediately afterwards the cylinder of the left-hand forming jaw is activated which forms and cuts the left-hand lead accordingly. The spring loaded support (support latch) and the timely offset forming of the right and left forming jaw grant a corresponding stress relief.

After the forming process the component can be lifted and put aside.

4. Pitch size alteration

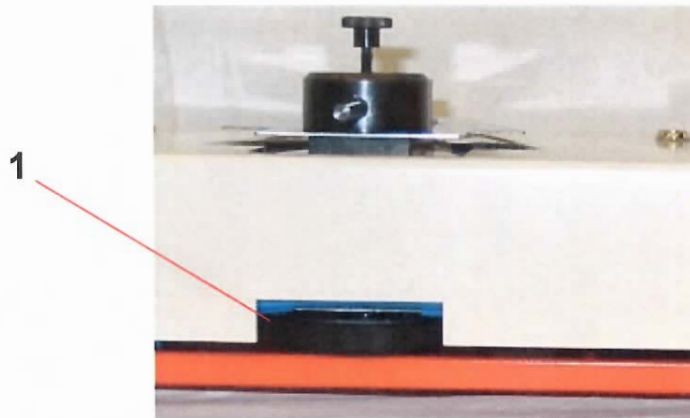
The device enables the processing of components with a pitch size from 2,5 mm to 25 mm. The adjustment can easily be executed.

1. Unscrew the knurled screw.
2. Adjust the feeder slide to the required dimension.
3. Tighten the knurled screw



5. Height dimension alteration

In order to adjust the distance between bending bead and component body, turn the knurled screw at the rear of the device.



1. Knurled screw for height adjustment

Abb. 3

Rear side from the machine with height adjustment

6. Working speed

The cycle of the device is set at its best by means of the cylinder exhaust chokes.

Please do not alter.

Retool

1. General comments on the adjustment of the machine

- Secure the automat, in case of modification or service-work on it, against a non-purpose
- Switch off compressed air
- Please make sure that all screws will be tighten again, after having finished the settings although this is not explicitly mentioned in the following text.
- The machine is equipped to the length by the factory. To prevent damage, setting changes must be carried out carefully by means of existing instruction by qualified personnel.



2. Change tool

1. Secure the machine as described in point 1.
2. Turn the height adjustment completely upwards using the knurled screw and remove the height adjustment (see Fig. 5).
3. Unscrew and remove the protection. See Fig.5, 2 Allen screws.
4. Attention a plastic pad on the left and right. Must not be forgotten later when reinstalling. (see Fig.6).
5. Unscrew and remove the middle jaw, left bending jaw (with knife) and right bending jaw (with knife) (see Fig. 6).
6. Screw on the new tool set.
7. Set the tool as described in point 3.
8. Mount the protection, do not forget to put the plastic underlay under it.
9. Install height adjustment.

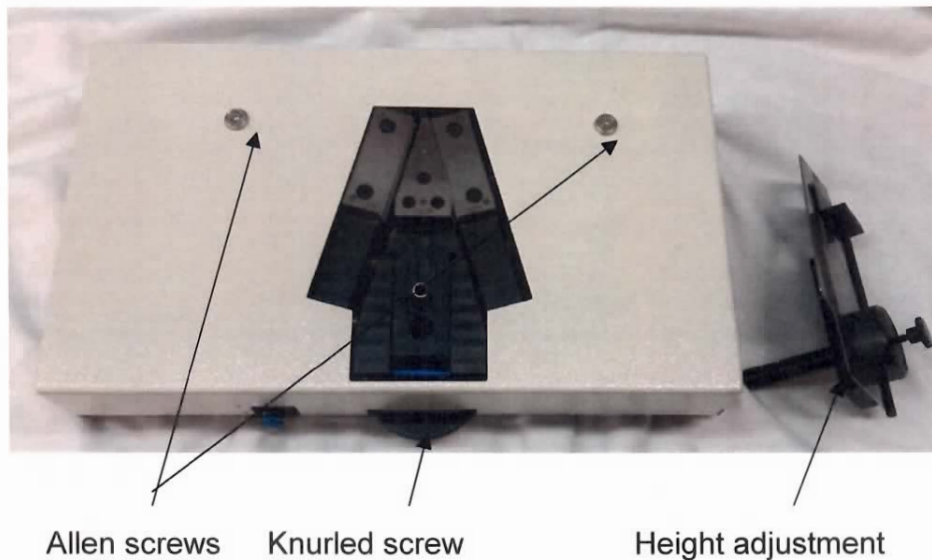


Fig. 4
Protection, Height adjustment



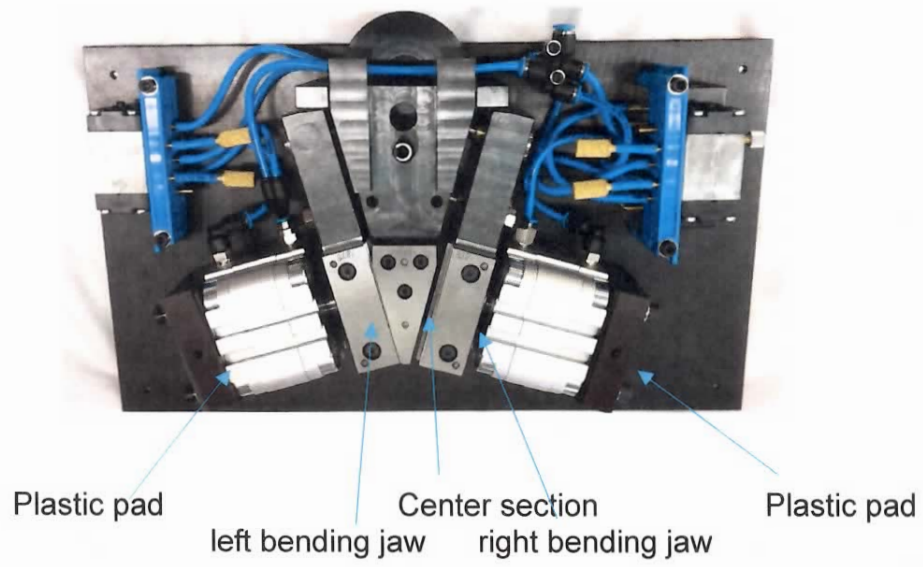


Fig. 5
Tool kit

3. Adjust tool

1. Secure the machine as described in point 1.
2. Turn the height adjustment completely upwards using the knurled screw and remove the height adjustment (see Fig. 5).
3. Unscrew and remove the protection. See Fig.5, 2 Allen screws.
4. Attention a plastic pad on the left and right. Must not be forgotten later when reinstalling (see Fig.6).
5. First set a tool side using a component.
6. Place the component between the bending jaw and the middle section (see Fig.7).
7. Push the cylinder forward by hand and adjust with the grub screw. Then counter this with the nut (see Fig.7).
8. Push the cylinder backwards by hand and adjust the other side.
9. Mount the protection, do not forget to put the plastic underlay under it.
10. Install height adjustment.

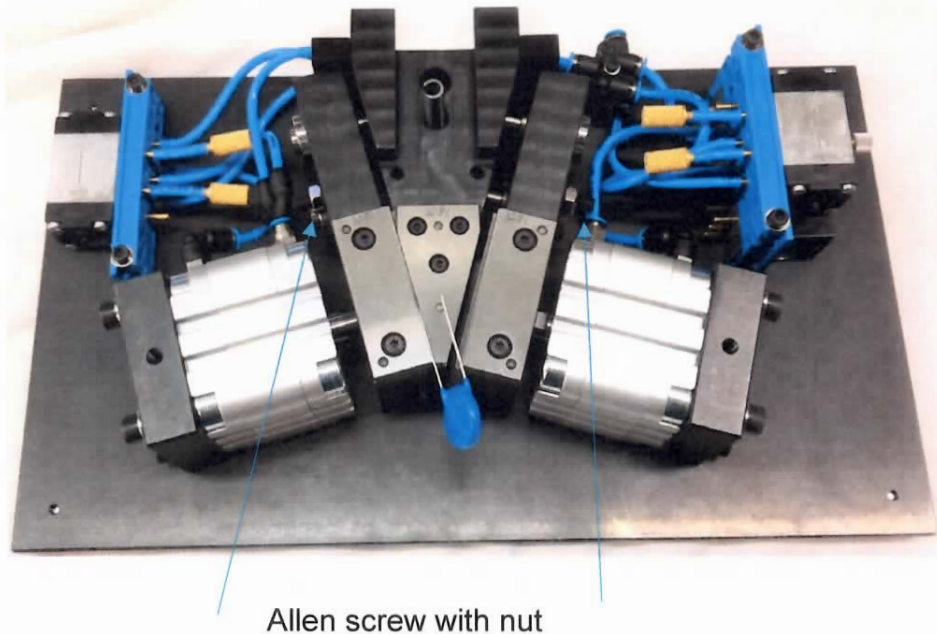


Fig. 6
Tool setting



Faults and their Rectification

Caution: All maintenance and repair work may only be performed by qualified and trained personnel!



If used properly, the machine will function virtually without trouble. If, contrary to expectation, faults should occur, please inform your supplier first.

Your contact: **Streckfuss USA, Tel. +1 972 790 1614, sales@streckfuss.com**

The type of fault discussed consequently can be taken down in the following table with the description of causes and measures for the correction of the faults.

Type of fault	Cause	Measures

Maintenance

1. Maintenance Plan

	Interval				Task
	d	w	m	y	
Machine, general	X				By using vacuum cleaner or a brush clean the device of waste leads and other garbage.
Tools		X			Check the tools for tin structure and if it is necessary, clean it without damaging the tools.
All moving parts		X			Clean and lightly oil no grease

d = daily
 w = weekly
 m = monthly
 y = annually

Caution: All maintenance and repair work may only be performed by trained specialists!

Caution: No grease may be used for lubricating moving and sliding parts. Use thin lubricants only such as oil spray.



Spare Parts Catalogue

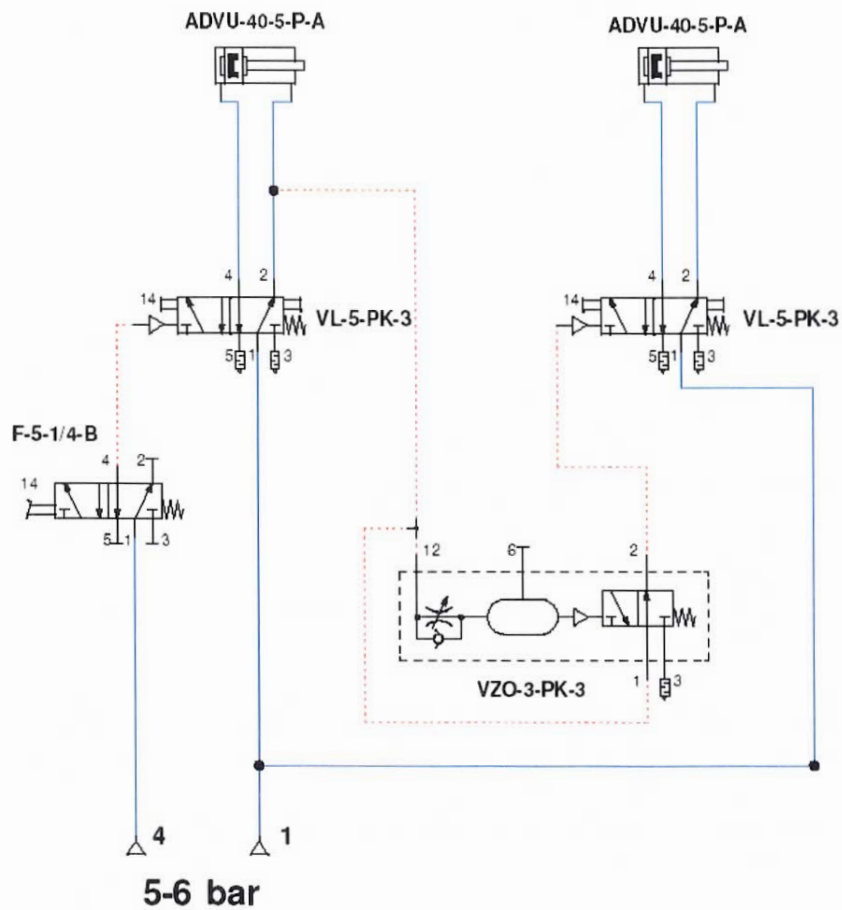
1. Parts- and spare parts list

Pos.	Quant.	Designation	Part- Nr.	Remark
1	1	C052B T.001	Base plate	
2	1	C052B T.002	Tooling holder	
3	1	C052B T.003	Side part tooling holder left	
3a	1	C052B T.003a	Side part tooling holder right	
5	1	C052B T.005	Guidance	
6	1	C052B T.006	Stop	
7	2	C052B T.007	Bending jaw	*
8	1	C052B T.008	Bending jaw middle	*
9	2	C052B T.009	Knife	*
11	1	C052B T.011	Knurled screw	
13	1	C052B T.013	Shaft	
14	1	C052B T.014	Cover	
15	1	C052B T.015	Cover plate	
16	1	C052B T.016	Threaded bolt	
17	1	C052B T.017	Brace	
21	2	C052B T.021	Attachment for cylinder	
30	2	ADVU-40-5-P-A	Cylinder	
31	2	M6x35	Grub screw with nut	
32	1	D-199	Compression spring	
33	2	Ø 10H6x50	Shaft hardened	
34	4	C052B T.034	Steel bushing	
35	4	Ø 10x Ø14x20	Ball bearing cage	
36	2	Ø 10H6x40	Shaft hardened	

*) = recommended spare parts (when ordering please with machine number)

[illegible]

3. Pneumatic diagram



						Anlage	Blatt Nr. 1	Burst & Zick GmbH
						Ort	von 1 Blatt	
Änderung		Datum	Name	Datum	Name	Benennung:		Zeichnungs-Nr.
a				gez	29.10.08	C052 B		
b								
c				gepr.				