

# MODEL A075

Streckfuss



## OPERATING INSTRUCTIONS

Serial Number \_\_\_\_\_



# TABLE OF CONTENTS

1.0	GENERAL DESCRIPTION .....
2.0	SETTING UP THE MACHINE.....
3.0	ADJUSTMENTS.....
4.0	OPERATION.....
5.0	PREVENTIVE MAINTENANCE.....
6.0	PARTS LIST.....
7.0	ILLUSTRATED PARTS BREAKDOWN.....
8.0	ELECTRICAL WIRING DIAGRAM.....
9.0	PNEUMATIC DIAGRAM.....

\* Recommended spare parts are indicated on the parts list with a (1) under the "notes" column

## 1.0 GENERAL DESCRIPTION:

The Streckfuss Model AO75 was designed to cut and form the leads of dual-inline package (DIP) type components. Simplicity in design and operation make this machine ideal for fast, accurate preforming of components. A full range of adjustment are provided for versatility in set up and operation, with the exception of periodic cleaning and light lubrication, the AO75 is virtually maintenance free.

## 2.0 SETTING UP THE MACHINE:

- Place the AO75 on a suitable work surface allowing clearance for the input and output component tubes.
- Connect one end of the air hose provided to the air regulator mounted on the back of the machine. Connect the other end to a clean, dry air supply regulated from 60 to 90 PSI.
- Connect the power cord to an approved electrical outlet with service rated at 110 Vac, 15 Amps, 60 Hz.
- Insert a tube of components into the input tube attachment. This is done by pulling upward on the spring-loaded knob at the top of the fixture (Figure 1) while sliding the tube under the retaining plate. Adjust the width of the center guides by turning the adjustment knob located on the right side of the fixture in the direction as needed. The front end of the tube should reach the stop plate on the main block assembly, above the entrance to the guide rails.
- Insert an empty tube into the output tube attachment and adjust in the same manner as the previous step.

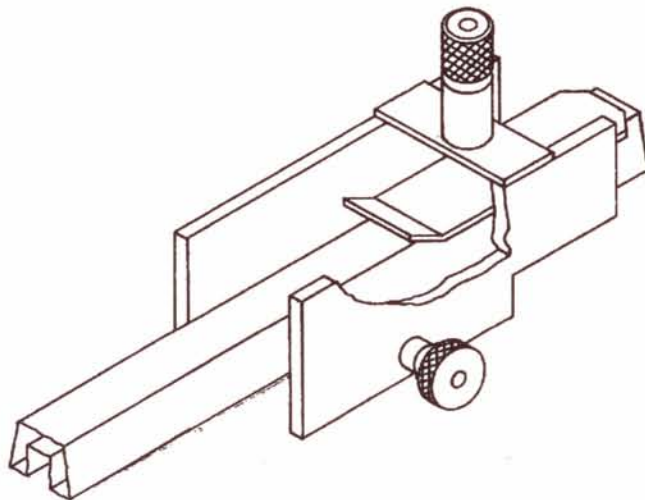


Figure #1

**Note: Some machines may vary from this illustration**

### 3.0 ADJUSTMENTS:

#### Component Pitch Adjustment:

The pitch or lead center-to-center distance is set by turning the pitch adjustment knob located on the right side of the machine (Figure 2) in the direction as needed until the desired setting is obtained. Turning the knob clockwise will increase the lead center-to-center distance and turning the knob counter-clockwise will decrease the distance. To accurately display the pitch adjustment setting, turn the selector switch on the digital display to the number 2 position. The digits in the display represent the measurement in inches.

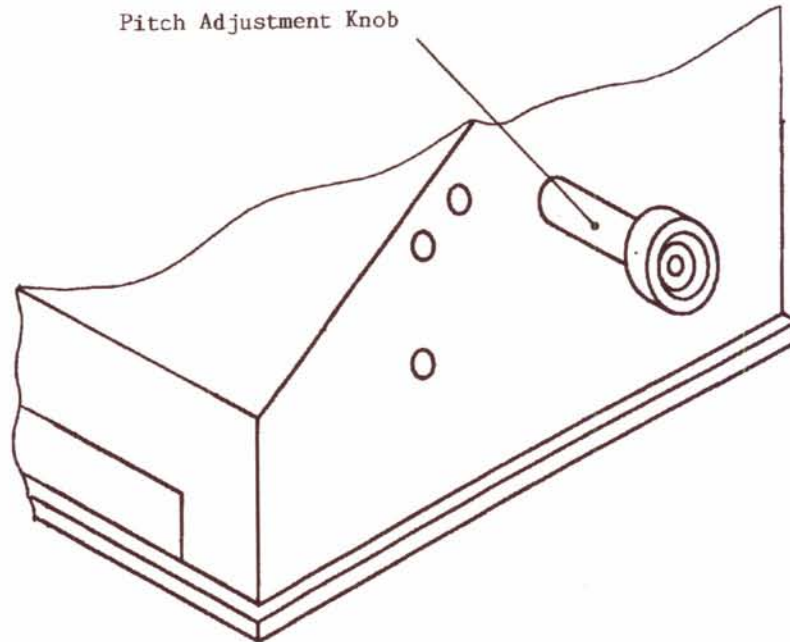


Figure #2

### 3.0 ADJUSTMENTS (cont'd)

#### Lead Angle Adjustment:

To form the angle of the component leads for insertion into a circuit board or socket, the component is guided through two forming bearings located just before the cutting die assemblies. (Figure 3)  
This adjustment is done with the following steps:

- Loosen the locking setscrew located on the side of the eccentric mounting block.
- Turn the eccentric located on top of the mounting block in the direction as needed to obtain the lead angle desired. Turning the eccentric adjusts the position of the forming bearing in relation to the component guide rails. If the forming bearings are adjusted too close to the guide rails the component will not pass through this section.
- Retighten the locking set screw while holding the screwdriver, for the eccentric adjustment, in place to prevent movement.

NOTE - This adjustment works in conjunction with the component pitch adjustment to form the lead angle.

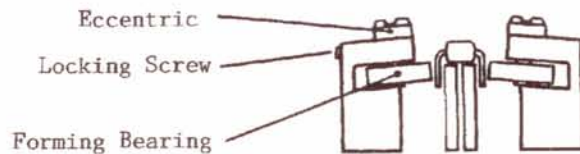


Figure #3

### 3.0 ADJUSTMENTS (cont'd)

#### Component Body Thickness Adjustment:

Located in the upper left corner of the machine is a surface block, gauge foot and adjustment knob as shown in figure 4. Turning the adjustment knob raises and lowers the entire transport assembly in relation to the component guide rails. This adjustment is done with following steps:

- Raise the transport assembly high enough to place a component upside down on the surface block.
- Lower the transport assembly until the gauge foot lightly contacts the component body.
- Located on the shaft to the right of the adjustment knob is a collar with a thumbscrew . Loosen the thumbscrew and raise the collar as needed to secure the transport assembly in position. Tighten the thumbscrew when the collar is set.

NOTE - For correct adjustment it is necessary to assure the linear bearings are positioned so the transport assembly is fully seated

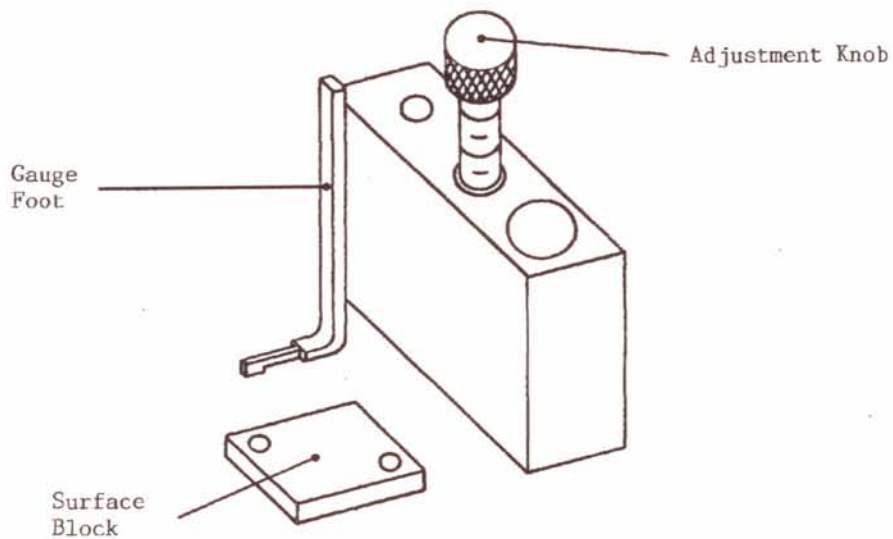


Figure #4

### 3.0 ADJUSTMENTS (cont'd)

#### Lead Length Adjustment:

This adjustment is done by raising or lowering the cutting die assembly in relation to the component guide rails. Each cutting die assembly is adjusted independently from the other by means of an adjustment knob. Figure 5 shows the adjustment knobs which are located on either side of the machine.

- To adjust the left side lead length, turn the selector switch on the digital display to the number 1 position. Loosen the locking nut and turn the adjustment knob on the left side of the machine in the direction as needed until the desired setting is obtained. Tighten the locking nut to prevent movement.
- To adjust the right side lead length, turn the selector switch to the number 3 position. Loosen the locking nut and turn the adjustment knob on the right side of the machine in the direction as needed until the desired setting is obtained. Tighten the locking nut to prevent movement.

NOTE - The cut point of the component lead is referenced from the bottom of the component body.

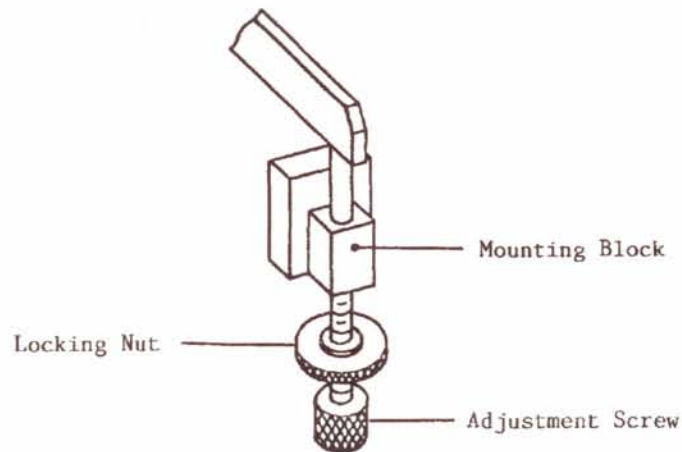


Figure #5

## 4.0 OPERATION

After making all the adjustments described in section 3.0, the machine is ready to form components. Check the gauge on the air regulator located on the back of the machine to verify that the machine is being supplied with 60-90 PSI. To feed the components into the machine, lift the rear end of the full tube which will tip the front end downward to the entrance of the guide rails. Gravity will then assist the components down the guide rails and into the transport belt. Turn the main switch located on the front panel to 1 or on. Rotate the speed control knob to 0 then press the start button. Gradually rotate the knob to reach the speed desired. The transport belt will cycle the components through the forming and cutting assemblies. The components will slide into the exit tube after being processed. When the exit tube is full press the stop button and replace the full tube with an empty one. Insert a full tube at the input and press start to resume operation.

## 5.0 PREVENTIVE MAINTENANCE:

- Daily - Clean all scrap leads from the machine with a brush. An acid or flux brush will do the task. Check belt for wear or debris.
  
- Weekly - Remove the back panel from the machine and clean all scrap leads from the inside. Apply a light amount of 10w oil to all bearings, shafts and the cutting die tracks. Check the cutting dies for wear.

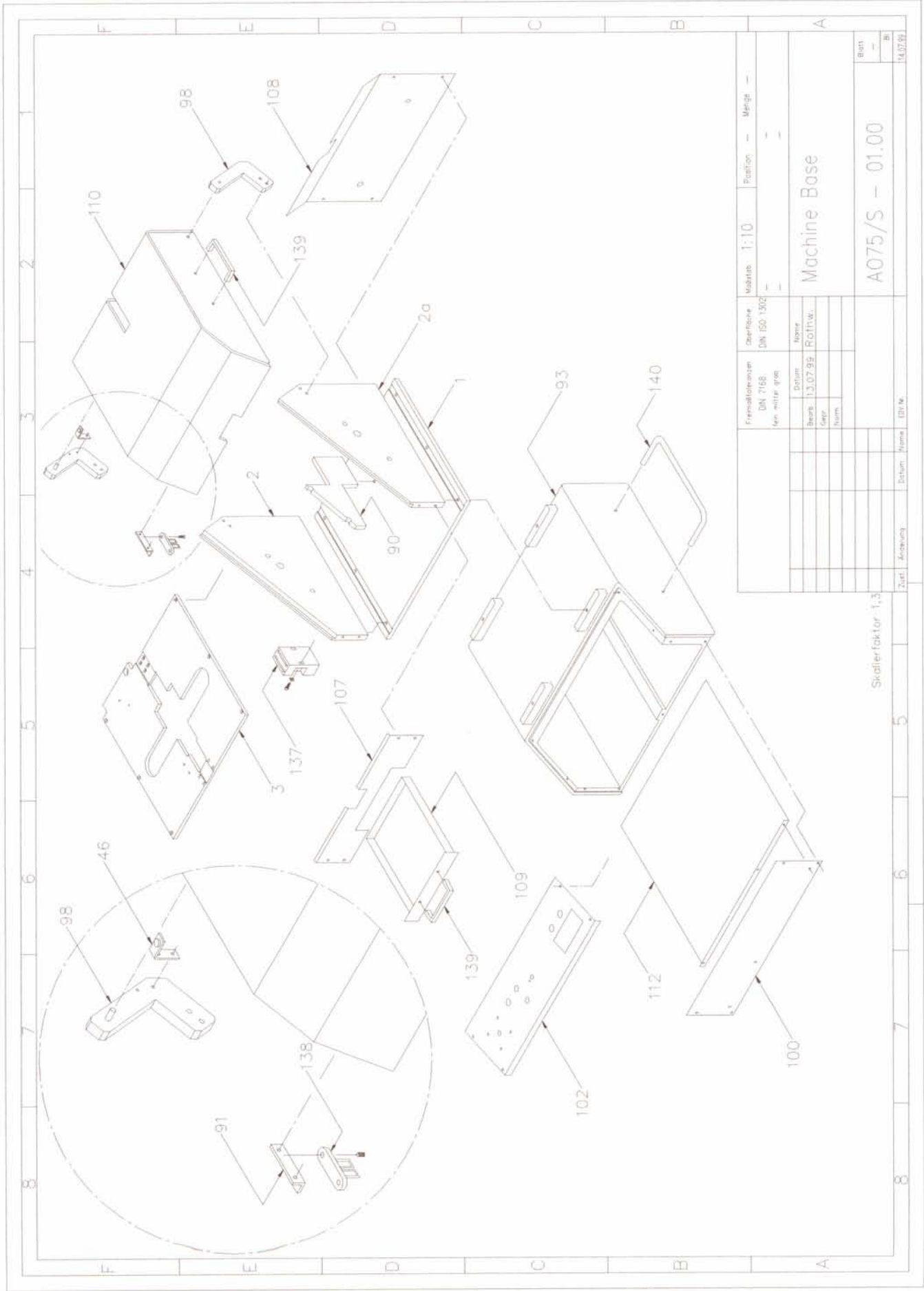


Dwg #	Item #	Part Number	Description	Qty	Notes
01.00	1	P-A075S-001	Base Plate	1	
01.00	2	P-A075S-002	Left Side Plate	1	
01.00	2	P-A075S-003	Right Side Plate	1	
01.00	3	P-A075S-004	Deck Plate	1	
01.00	46	P-A075S-005	Stop Angle	1	
01.00	90	P-A075S-006	Support Plate	1	
01.00	91	P-A075S-007	Angle Bracket	1	
01.00	93	P-A075S-008	Electrical Cabinet	1	
01.00	98	P-A075S-009	Hood Bracket (Specify Left/Right)	2	
01.00	100	P-A075S-010	Front Panel	1	
01.00	102	P-A075S-011	Control Panel	1	
01.00	107	P-A075S-012	Front Panel	1	
01.00	108	P-A075S-013	Back Panel	1	
01.00	109	P-A075S-014	Scrap Tray	1	
01.00	110	P-A075S-015	Acrylic Safety Hood	1	
01.00	112	P-A075S-016	Chassis	1	
01.00	137	P-A075S-017	Safety Switch (AZ 15 zvr)	1	
01.00	138	P-A075S-018	Key for Safety Switch	1	
01.00	139	P-A075S-019	Handle (10501-003)	2	
01.00	140	P-A075S-020	Handle (GN 425-235)	2	
02.00	6	P-A075S-021	Main Block Assembly	1	
02.00	20	P-A075S-022	Block	1	
02.00	31	P-A075S-023	Block	1	
02.00	32	P-A075S-024	Lower Guide Block	1	
02.00	33	P-A075S-025	Gauge Block	1	
02.00	35	P-A075S-026	Motor Mount	1	
02.00	36	P-A075S-027	Motor Mount	1	
02.00	38	P-A075S-028	Guide Block	1	
02.00	39	P-A075S-029	Pressure Plate	1	
02.00	40	P-A075S-030	Mounting Bracket	2	
02.00	49	P-A075S-031	Bushing	1	
02.00	60	P-A075S-032	Post	1	
02.00	61	P-A075S-033	Post	1	
02.00	63	P-A075S-034	Pulley Shaft	1	
02.00	64	P-A075S-035	Bearing Bushing	2	
02.00	65	P-A075S-036	Threaded Bushing	1	
02.00	67	P-A075S-037	Geneva Mechanism Shaft	1	1
02.00	68	P-A075S-038	Geneva Mechanism	1	1
02.00	69	P-A075S-039	Indexing Wheel	1	1
02.00	71	P-A075S-040	Indexing Wheel Shaft	1	1
02.00	72	P-A075S-041	Belt Pulley	1	
02.00	73	P-A075S-042	Belt Pulley	1	
02.00	74	P-A075S-043	Timing Cam	1	
02.00	75	P-A075S-044	Spacer	1	

Dwg #	Item #	Part Number	Description	Qty	Notes
02.00	76	P-A075S-045	Retaining Washer	1	
02.00	87	P-A075S-046	Bushing	1	
02.00	88	P-A075S-047	Adjustment Knob	1	
02.00	89	P-A075S-048	Adjustment Shaft	1	
02.00	92	P-A075S-049	Transport Belt	1	1
02.00	101	P-A075S-050	Angle Plate	1	
02.00	111	P-A075S-051	Stop Plate	1	
02.00	120	P-A075S-052	Shaft (Ø 10 x 105)	1	
02.00	121	P-A075S-053	Shaft (Ø 10 x 70)	1	
02.00	124		Radial Ball Bearing (608-ZZ)	4	1
02.00	126	P-A075S-054	Linear Bushing (N-10v)	12	
02.00	127		Needle Bearing (NK-8/12)	1	1
02.00	130	P-A075S-055	Motor Coupling	1	1
02.00	131	P-A075S-056	Timing Microswitch	1	1
03.00	4	P-A075S-057	Angle Bracket	2	
03.00	7	P-A075S-058	Pitch Adjustment Block (Specify Left/Right)	2	
03.00	8	P-A075S-059	Guide Rail Mount (Specify Left/Right)	2	
03.00	10	P-A075S-060	Guide Rail Set	1	
03.00	11	P-A075S-061	Eccentric Block (Specify Left/Right)	2	
03.00	12	P-A075S-062	Cutting Assembly Block (Specify Left/Right)	2	
03.00	13	P-A075S-063	Cutting Die Set	2	1
03.00	14	P-A075S-064	Shear Block Set	2	1
03.00	15	P-A075S-065	Cut Length Lever	2	
03.00	16	P-A075S-066	Cutting Die Cover Plate	4	
03.00	34	P-A075S-067	Cut Length Adjustment Threaded Block	2	
03.00	41	P-A075S-068	Guide Rail Bridge Set	2	1
03.00	45	P-A075S-069	Cutting Die Drive Bar	2	1
03.00	50	P-A075S-070	Pitch Adjustment Shaft	1	
03.00	51	P-A075S-071	Threaded Bushing (Left)	1	
03.00	52	P-A075S-072	Threaded Bushing (Right)	1	
03.00	53	P-A075S-073	Bushing	2	
03.00	54	P-A075S-074	Pitch Adjustment Knob	1	
03.00	55	P-A075S-075	Eccentric	2	
03.00	56	P-A075S-076	Cut Length Adjustment Knob	2	
03.00	57	P-A075S-077	Cut Length Locking Nut	2	
03.00	58	P-A075S-078	Spring Pin	4	1
03.00	62	P-A075S-079	Cutting Die Drive Eccentric (Specify Left/Right)	2	
03.00	99	P-A075S-080	Angle	2	
03.00	122	P-A075S-081	Shaft (Ø 10 x 50)	4	
03.00	123	P-A075S-082	Shaft (Ø 10 x 370)	2	
03.00	125		Radial Ball Bearing (605-ZZ)	2	1
03.00	126	P-A075S-083	Linear Bushing (N-10v)	8	
03.00	128	P-A075S-084	Ball Cage (Ø 10 x Ø 14 x 38)	4	
03.00	129	P-A075S-085	Outer Race (Ø 14 x Ø 20 x 33)	4	

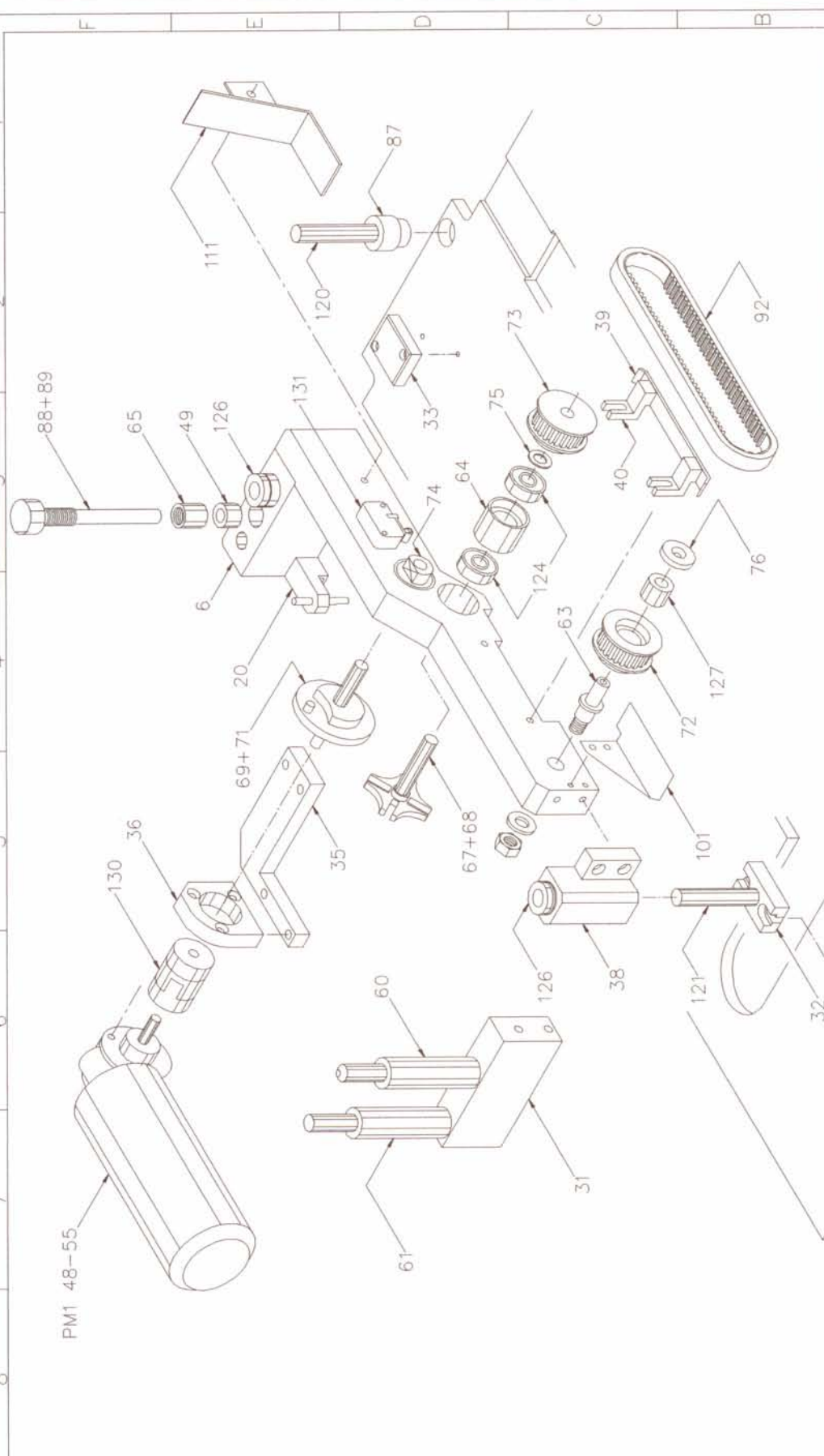
Dwg #	Item #	Part Number	Description	Qty	Notes
03.00	132	P-A075S-086	Ball Plunger (M5 x 12)	8	<sup>1</sup>
03.00	133	P-A075S-087	Rotary Cylinder (DSR-16-180-P)	2	
03.00	134	P-A075S-088	Collar (10mm)	6	
04.00	27	P-A075S-089	Side Plate	2	
04.00	28	P-A075S-090	Guide Rail (Specify Left/Right)	4	
04.00	29	P-A075S-091	Deck Plate	2	
04.00	30	P-A075S-092	Retaining Plate	2	
04.00	44	P-A075S-093	Clamp	4	
04.00	58	P-A075S-094	Spring Pin	1	
04.00	77	P-A075S-095	Guide Shaft	4	
04.00	78	P-A075S-096	Adjustment Shaft	2	
04.00	79	P-A075S-097	Shaft	2	
04.00	80	P-A075S-098	Guide Sleeve	2	
04.00	81	P-A075S-099	Knob	2	
04.00	82	P-A075S-100	Guide Bushing	8	
04.00	83	P-A075S-101	Threaded Bushing (Specify Left/Right)	4	
04.00	84	P-A075S-102	Knob	2	
04.00	94	P-A075S-103	Bracket	1	
04.00	95	P-A075S-104	Spring Pin	1	
04.00	96	P-A075S-105	Left Side Plate	1	
04.00	97	P-A075S-106	Right Side Plate	1	
04.00	135	P-A075S-107	Spring	1	
04.00	136	P-A075S-108	Spring (D-42/4/4)	2	
05.00	17	P-A075S-109	Plate	2	
05.00	18	P-A075S-110	Bracket	1	
05.00	19	P-A075S-111	Plate	2	
05.00	59	P-A075S-112	Adjustment Pin	1	
05.00	141	P-A075S-113	Linear Potentiometer (H20-10)	3	
05.00	142	P-A075S-114	Spacer	2	

<sup>1</sup> Recommended Spare Part



Freigelegene DIN 7168 für alle 1:10		Oberfläche DIN ISO 1302		Maßstab 1:10		Position -- --		Mengt -- --	
Datum 13.07.99		Name Rothw.		Machine Base					
Blatt 01		Gepr. Norm		A075/S - 01.00					
Zust. Änderung		Datum Name		Blatt -- --					
IDI Nr.		14.07.99		B					

Skalierfaktor 1,3



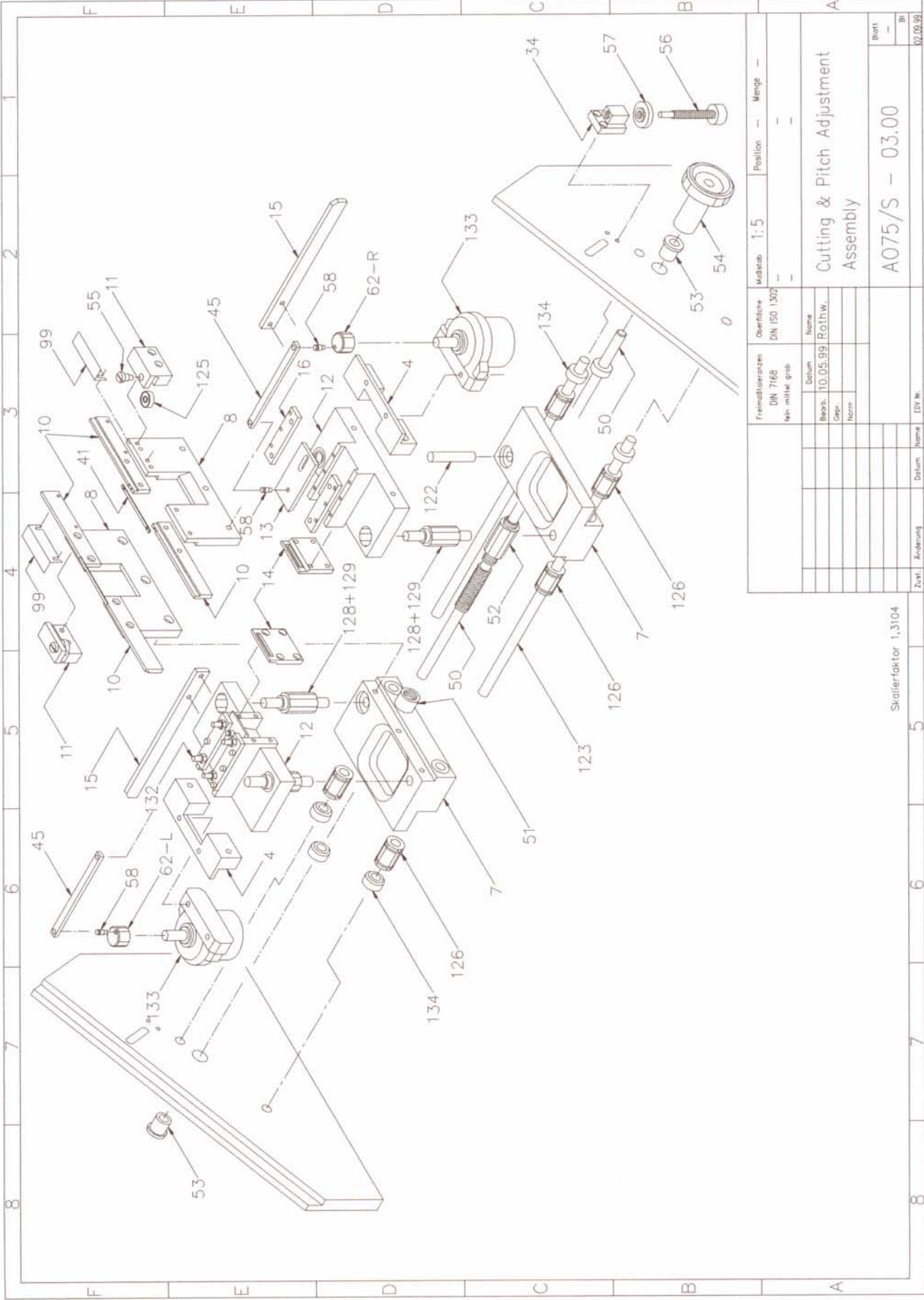
Freivaldierungen: DIN 7168 fein mittel grob	oberflächliche DIN ISO 1302	Maßstab 1:2.5	Position — Menge —
Name Rothw.		Transport Assembly	
Datum 19.04.99		A075/S - 02.00	
Bezt. Gepr. Norm.		Blatt —	
Zust. Änderung		Datum Name EDV-Nr.	

1 2 3 4 5 6 7 8

F E D C B A

8 7 6 5 4 3 2 1

F E D C B A



Freiwilligenzeichen DN 7168 kein mittel grob		Oberfläche DN ISO 1302		Maßstab: 1:5		Position		Menge	
Datum		Name		-		-		-	
Beob.: 10.05.99		RoHw.		-		-		-	
Gepr.				-		-		-	
Norm				-		-		-	

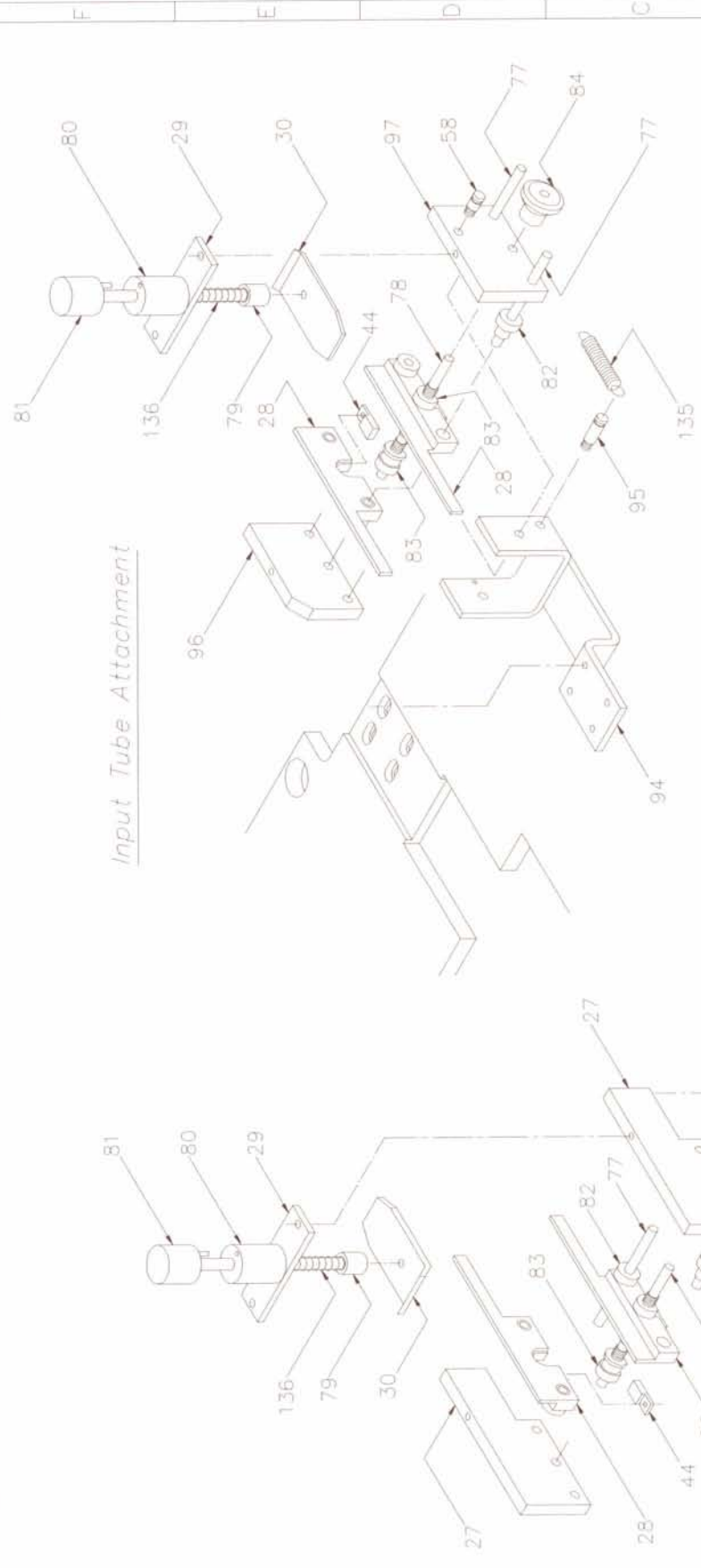
Cutting & Pitch Adjustment  
Assembly

Skalierfaktor 1,3104

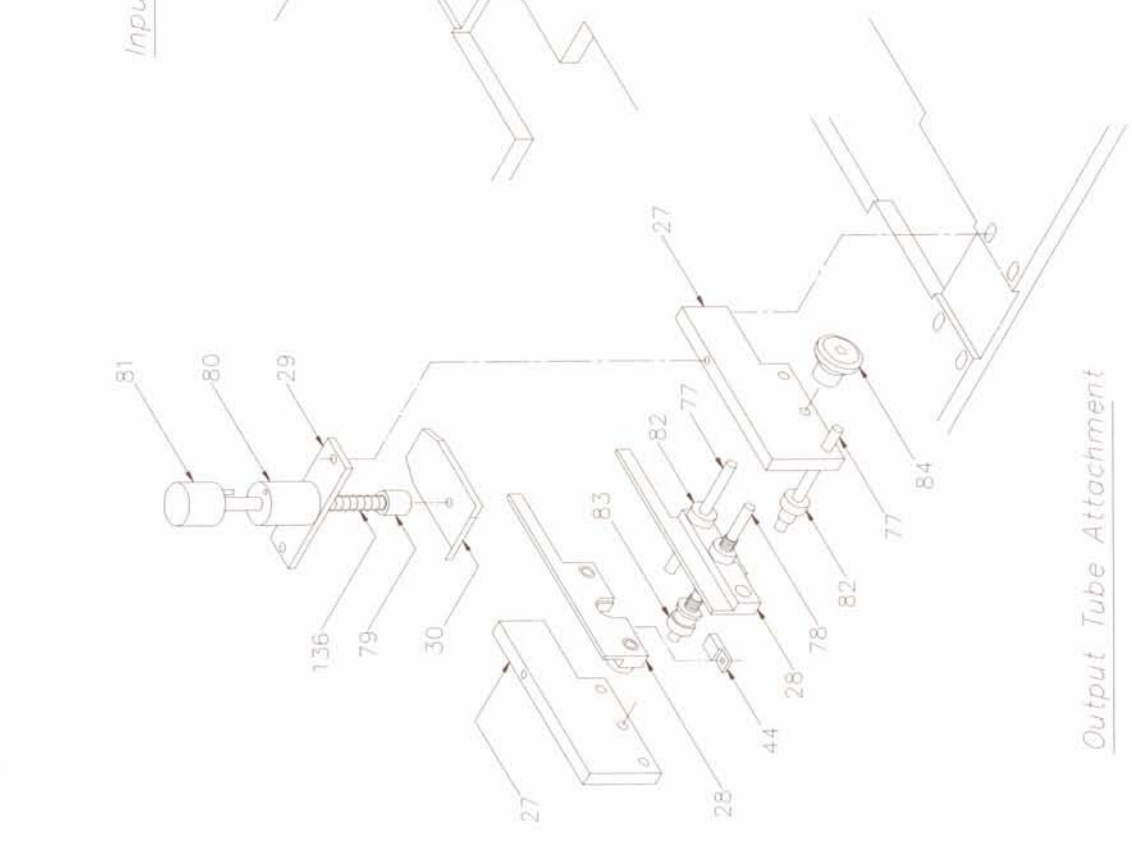
A075/S - 03.00

Best.	
Bl	
Bl	02.09.99

Input Tube Attachment



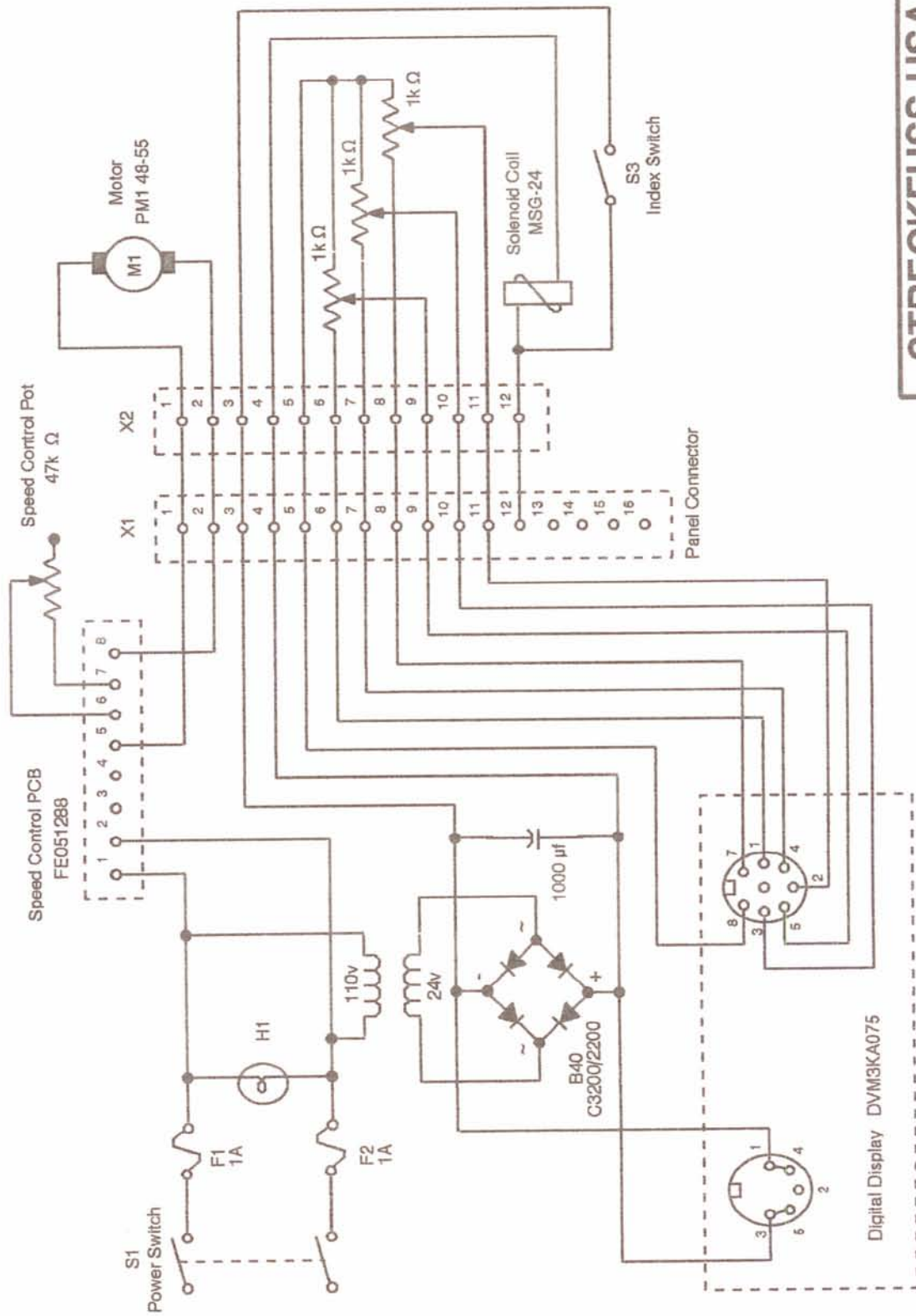
Output Tube Attachment



Freudenberg DM 7168 bei nicht gab.	Öberfl. DM ISO 1002	Maßstab 1:2	Position	Menge	-
Datum 07.07.99 Bezeichnet Politz Name		Tube Attachments			
Zerst. Änderung Datum Name Eig. Nr.		A075/S - 04.00		Blatt - 12.07.99	



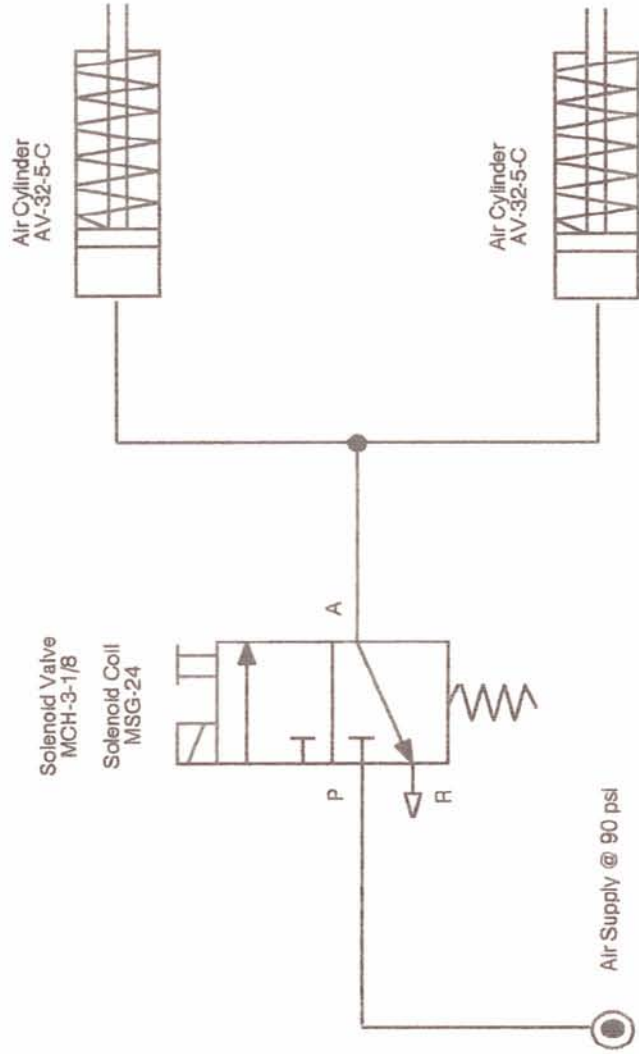




# STRECKFUSS USA, INC.

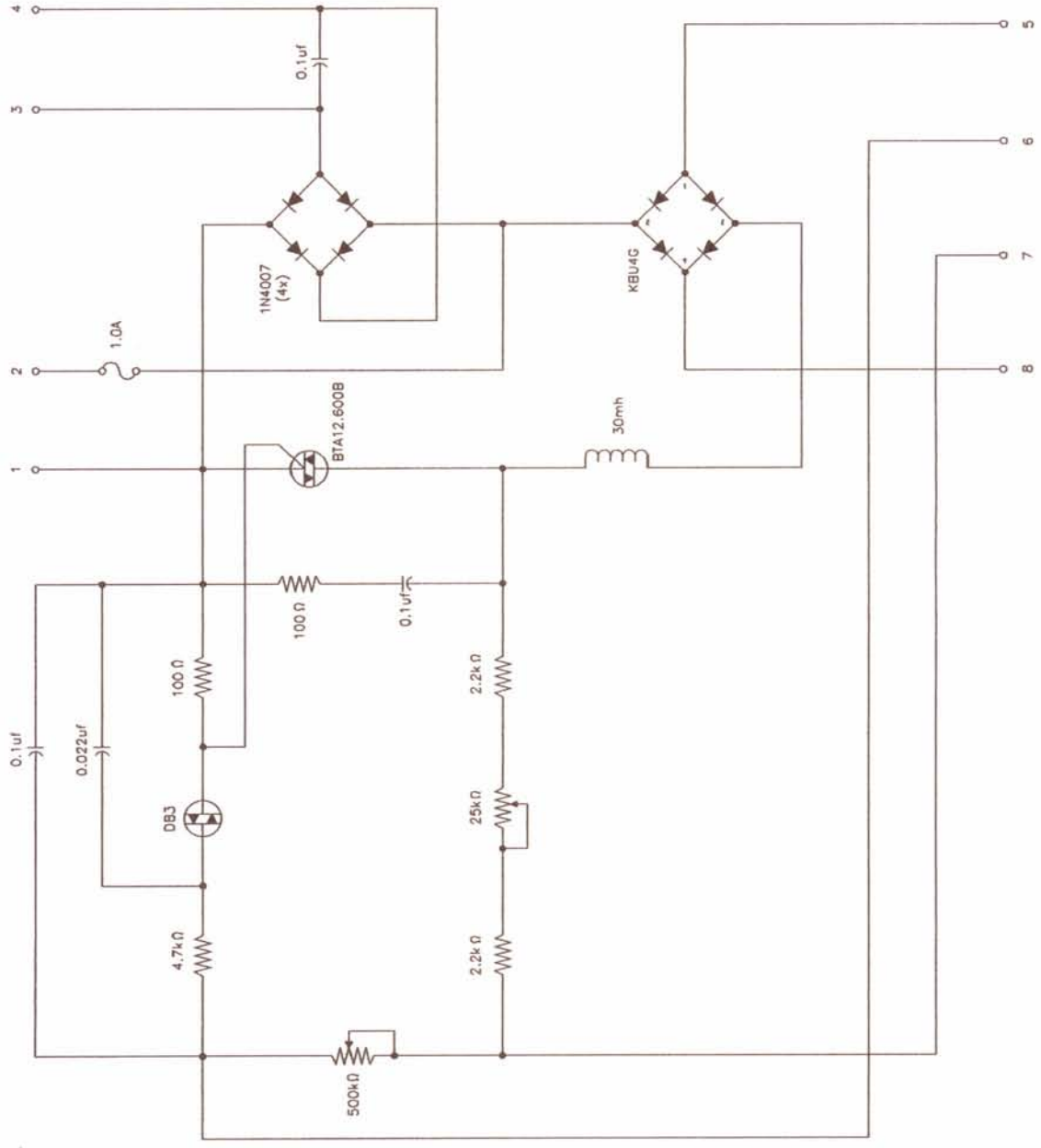
DESCRIPTION		ELECTRICAL WIRING DIAGRAM	
MODEL NO.	A075	DRAWN BY	A. Spinnoff
DRAWING NO.	ED92001	DATE	5/15/92
110 V, 60 HZ, 2.5 KW			

Digital Display DVM3KA075



# STRECKFUSS USA, INC.

DESCRIPTION	PNEUMATIC DIAGRAM		
MODEL NO.	A075	DRAWN BY	<i>A. J. ...</i>
DRAWING NO.	PD92001	DATE	8/15/92



SOME MODELS MAY VARY FROM ILLUSTRATION AS SHOWN

MODEL NO.		DRAWING NO.		SHEET	
FE05128B		510.1		1/1	
DRAWN BY		DATE		REV	
A. SPRINGER		1/95		REV	
TITLE				SPEED CONTROL PCB	
STRECKFUSS USA, INC.					