C036

OPERATING INSTRUCTIONS

May 2002

Serial Number _____

TABLE OF CONTENTS

I. GENERAL DESCRIPTION:

The Streckfuss Model C036 was designed to cut and form the leads of loose and taped axial leaded components with lead diameters ranging from .015" to .052". Unique in design the C036 allows up to five individual forming or bending dies to be installed in the machine at one time.
Form configurations are quickly interchanged by simply adjusting the position of the tooling dies on the machine. A full range of precision adjustments are provided for versatility in set up and with the wide selection of tooling dies available the C036 is ideal for applications where fast, accurate pre-forming of components is a must.

II. SETTING UP THE MACHINE:

1. Place the C036 on a suitable work surface with the control unit located next to it. The work surface selected should be sturdy enough to support the weight of the machine.

2. Connect the two plugs coming from the right side of the machine into the two connectors located on the back of the control unit.

   NOTE - The plugs and connectors are polarized for correct orientation.

3. Connect the power cord coming from the back of the control unit to an approved electrical service rated at 110 Vac, 15 Amps, 60 Hz.

III. CALIBRATION:

1. Loosen the clutch knob (figure 2, item A) and turn the motor drive knob (figure 2, item B) until the pressure wedge plate is at it's uppermost stroke position.

2. Remove the four cap nuts (figure 1, item F) securing the pressure wedge plate using the 17mm open end wrench provided. Disconnect the plug for the counter switch assembly. Remove the pressure wedge plate and set aside taking care not to damage the counter switch plunger.

   NOTE - The four precision washers located under each corner of the pressure wedge plate should remain on the shafts to avoid misplacing.

3. Loosen the two black knobs (figure 1, item D) securing the body diameter adjustment. Using the "T" wrench provided turn the body diameter adjustment (figure 2, item C) until the dial indicator (figure 1, item O) reads 3.0mm.

4. Grasp the upper belt guide at the unload end of the machine and swing upward toward the load end of the machine allowing access to the die sets. Loosen the locking set screw (figure 1, item K) on each of the die sets using the 3mm balldriver provided. Loosen the lock (figure 3, item A) on each of the die position multidials (figure 1, item H).

5. Position each of the dies approximately one inch away from the lower belt guide by turning the multidials counter-clockwise. Place the calibration tool provided in the guide slot in front of the die being calibrated. Advance that die toward the lower belt guide by turning the appropriate multidial clockwise until the calibration tool lightly contacts both the die and lower belt guide as shown in figure 4.

   NOTE - The calibration tool should have a medium feel between the die and lower belt guide. Over adjusting will cause the lower belt guide to deflect resulting in a false calibration.

III. CALIBRATION: (con't)

6. Tighten the locking set screw on the die being calibrated to secure the die in place. Loosen the set screw (figure 3, item B) on the multidial for the die being calibrated using the .035" hex key provided.

   NOTE - Die position multidials on some models use a .048" four flute spline wrench provided.

7. Turn the multidial in either direction until 10.0 is displayed in the window as shown in figure 3. Tighten the set screw on the multidial and loosen the locking set screw on the die. Reposition the die away from the lower belt guide and remove the calibration tool.

8. Repeat steps 4 through 7 for all dies being calibrated.

9. Lower the upper belt guide, verify the four precision washers are in place, install the pressure wedge plate and secure in position with the four cap nuts. Reconnect the plug for the counter switch assembly. Retighten the two black knobs located on the left side of the machine to secure the body diameter adjustment.

   NOTE - Calibration of the die sets should be performed after every 40 hours of operation.

IV. ADJUSTMENTS:

1. Die Position Adjustment

Loosen the locking set screw (figure 1, item K) on each of the die sets being used with the 3mm balldriver provided. Loosen the lock (figure 3, item A) on each of the die position multidials (figure 1, item H) for those dies. Adjust the position of the dies by turning the multidial in the direction as needed until the desired setting is obtained. Tighten the locking set screw and multidial lock when finished.

NOTE - The travel of the die should be toward the lower belt guide upon reaching the desired setting on the multidial.

2. Lead Diameter Adjustment

Loosen the four screws (figure 5, item A) securing the component body guides (figure 5, item B) using the 2.5mm hex key provided. Select the appropriate gauge plate and place under the component body guides as shown in figure 5. The gauge plate should be positioned up to but not on top of the lower transport belt. Seat the component body guides on the gauge plate by applying a light amount of pressure to the top of the guides. Secure the guides in position with the four screws and remove the gauge plate.

NOTE - Two gauge plates are provided with the machine. One at .025" thickness and one at .040" thickness.

3. Body Length Adjustment

Place a component into the feed attachment with the leads under the component body guides. Turn the body length adjustment knob (figure 5, item C) in the direction as needed until the components move freely through the component body guides.

NOTE - Excessive play between the component body and the body guides may result in the component being off center.

IV. ADJUSTMENTS: (con't)

4. Body Centering Adjustment

Center the component body on the lower transport belt by loosening the two set screws (figure 5, item D) using a 2mm hex key. This allows the entire feed assembly to move to the right or left. Position the feed assembly in the direction as needed until the component is centered on the lower transport belt.

5. Body Diameter Adjustment

Measure the component body diameter to determine the the adjustment setting. Loosen the two black knobs (figure 1, item D) securing the body diameter adjustment. Using the "T" wrench provided turn the body diameter adjustment (figure 2, item C) until the dial indicator (figure 1, item O) reaches the desired setting.

NOTE - The dial indicator graduation is in millimeters.

6. Pressure Wedge Adjustment

Loosen the locking nut (figure 1, item J) using the 10mm wrench provided. Position the pressure wedge (figure 1, item L) as needed until the desired result is obtained. On the forming dies positioning the pressure wedge closer to the transport belt will increase the exaggeration of the form. Positioning the pressure wedge away from the transport belt will decrease the exaggeration of the form. On the bending dies positioning the pressure wedge closer to the transport belt will "overbend" the lead angle beyond 90 degrees. Positioning the pressure wedge away from the transport belt will "underbend" the lead angle less than 90 degrees.

7. Upper Transport Belt Pressure Adjustment

Feed enough components into the machine to fill the belt. Loosen the thumb screws (figure 1, item M) securing the upper belt pressure adjustment knobs (figure 1, item A). Turn the adjustment knob at the load end of the machine in the direction as needed until the spring loaded posts are approximately .050" - .100" above the support flange on either side of the upper transport belt. Turn the adjustment knob at the unload end of the machine in the direction as needed until the spring loaded posts lightly contact the support flange on either side of the upper transport belt.

V. OPERATION:

After making the adjustments as described in section IV for the component selected for forming the C036 is ready to operate. Refer to figure 6 for details of the control unit.

1. Turn the power switch to the "1" position.
2. Enter the desired count into the digital counter.
3. Close the plexiglass hood and verify the finished component bin is in place.
4. Turn the safety switch bypass (key switch) to the vertical position.
5. Turn the speed control knob to the minimum position.
6. Depress the start button once and adjust the speed control knob to the desired operating speed.

VI. PREVENTIVE MAINTENANCE:

Daily - Remove all scrap leads and dust particles from the machine with a brush or a controlled, light blast of air.

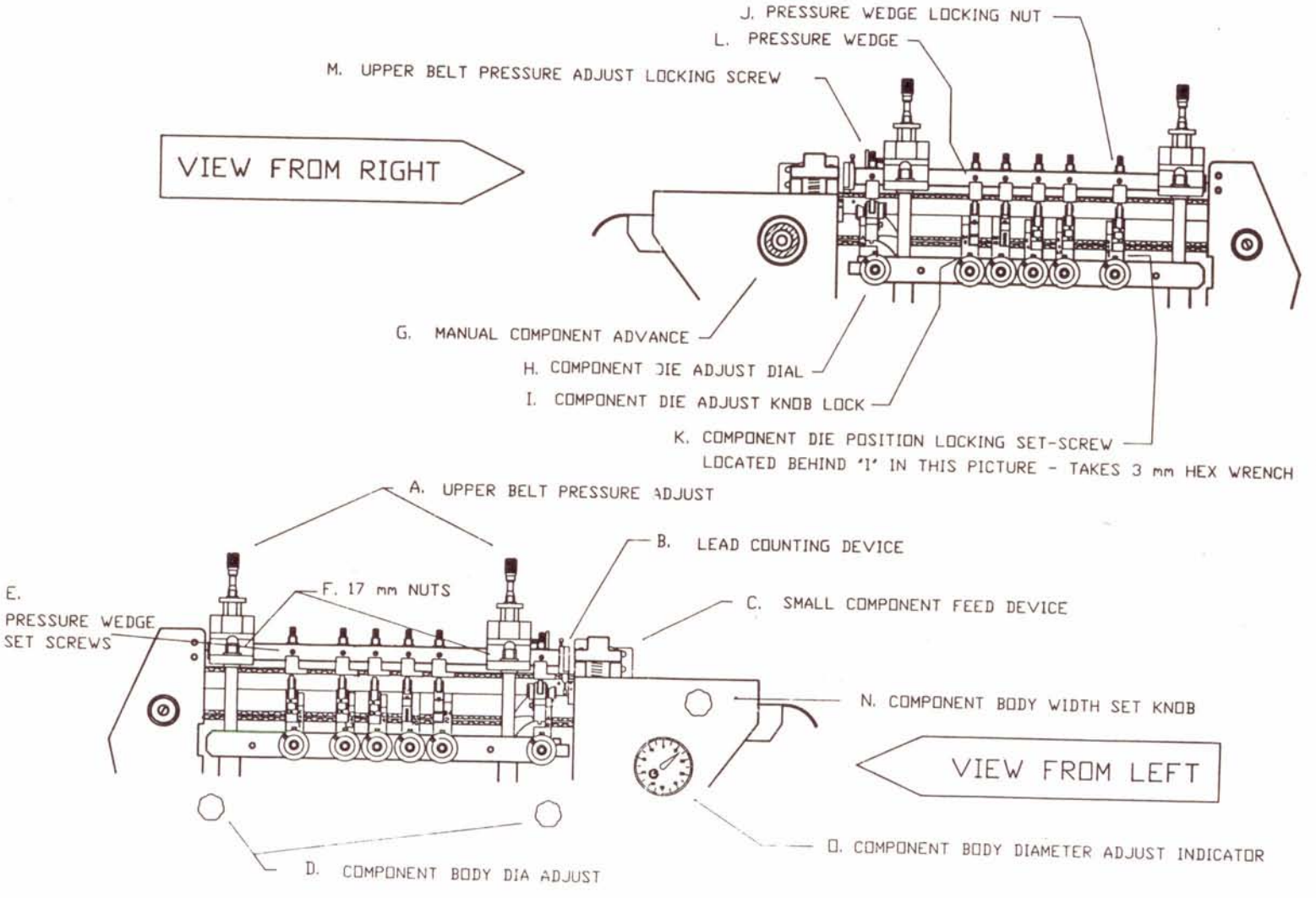
Weekly - Remove the tooling die sets, clean thoroughly and relubricate guide slots and lead screws using a light amount of 10w oil.
Check for wear.

Monthly - Remove the covers from the base of the machine and clean all scrap leads and dust particles from the interior.

Remove the scrap guides and apply a light amount of 10w oil to the cams.

Inspect both the upper and lower transport belt for wear.

FIGURE 1


J. PRESSURE WEDGE LOCKING NUT
L. PRESSURE WEDGE
M. UPPER BELT PRESSURE ADJUST LOCKING SCREW
VIEW FROM RIGHT
G. MANUAL COMPONENT ADVANCE
H. COMPONENT DIE ADJUST DIAL
I. COMPONENT DIE ADJUST KNOB LOCK
K. COMPONENT DIE POSITION LOCKING SET-SCREW
LOCATED BEHIND 'I' IN THIS PICTURE - TAKES 3 mm HEX WRENCH
A. UPPER BELT PRESSURE ADJUST
B. LEAD COUNTING DEVICE
E.
PRESSURE WEDGE
SET SCREWS
F. 17 mm NUTS
C. SMALL COMPONENT FEED DEVICE
N. COMPONENT BODY WIDTH SET KNOB
VIEW FROM LEFT
O. COMPONENT BODY DIAMETER ADJUST INDICATOR
D. COMPONENT BODY DIA ADJUST

VII. FIGURES:

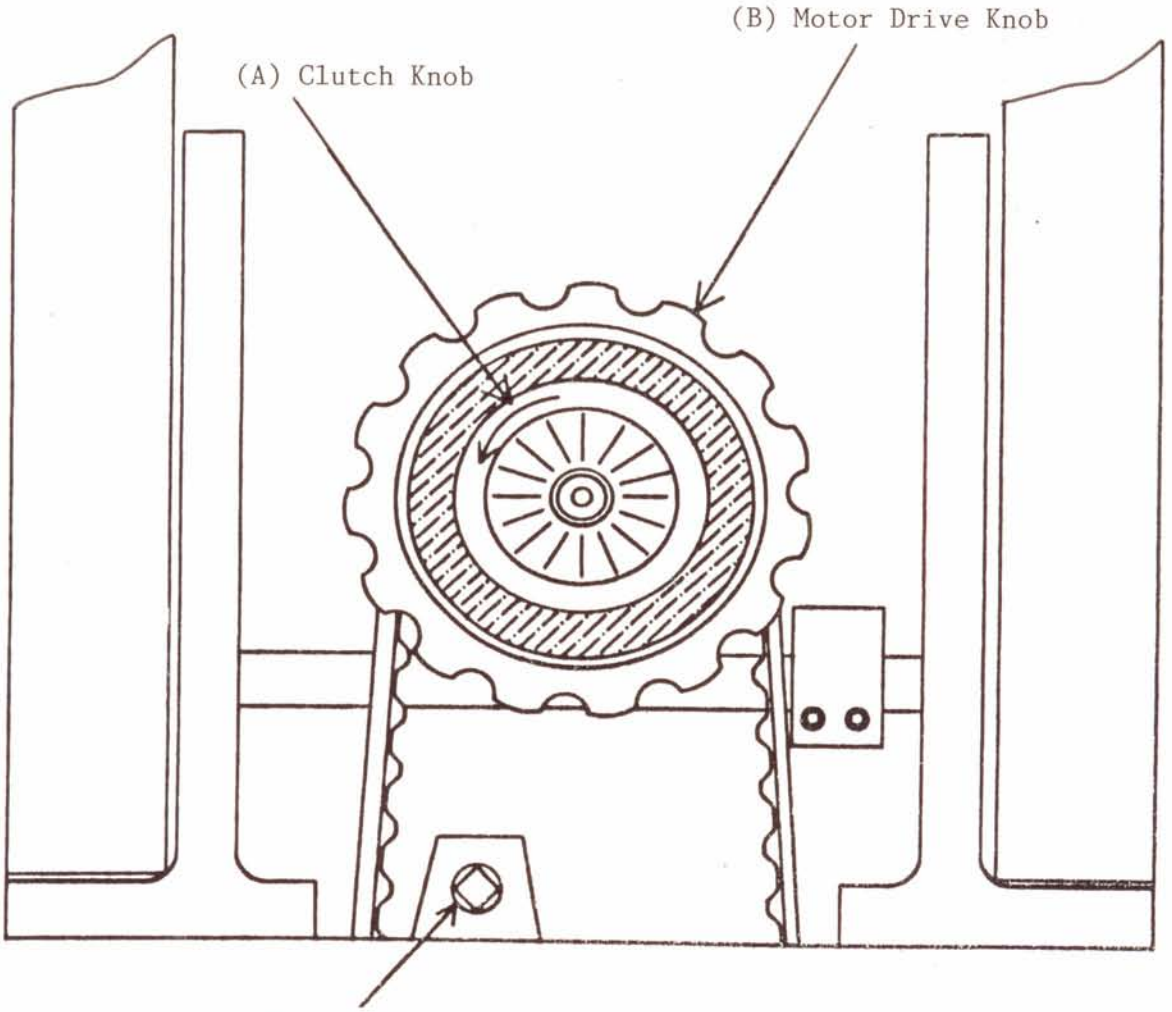


Figure 2

VII. FIGURES: (con't)

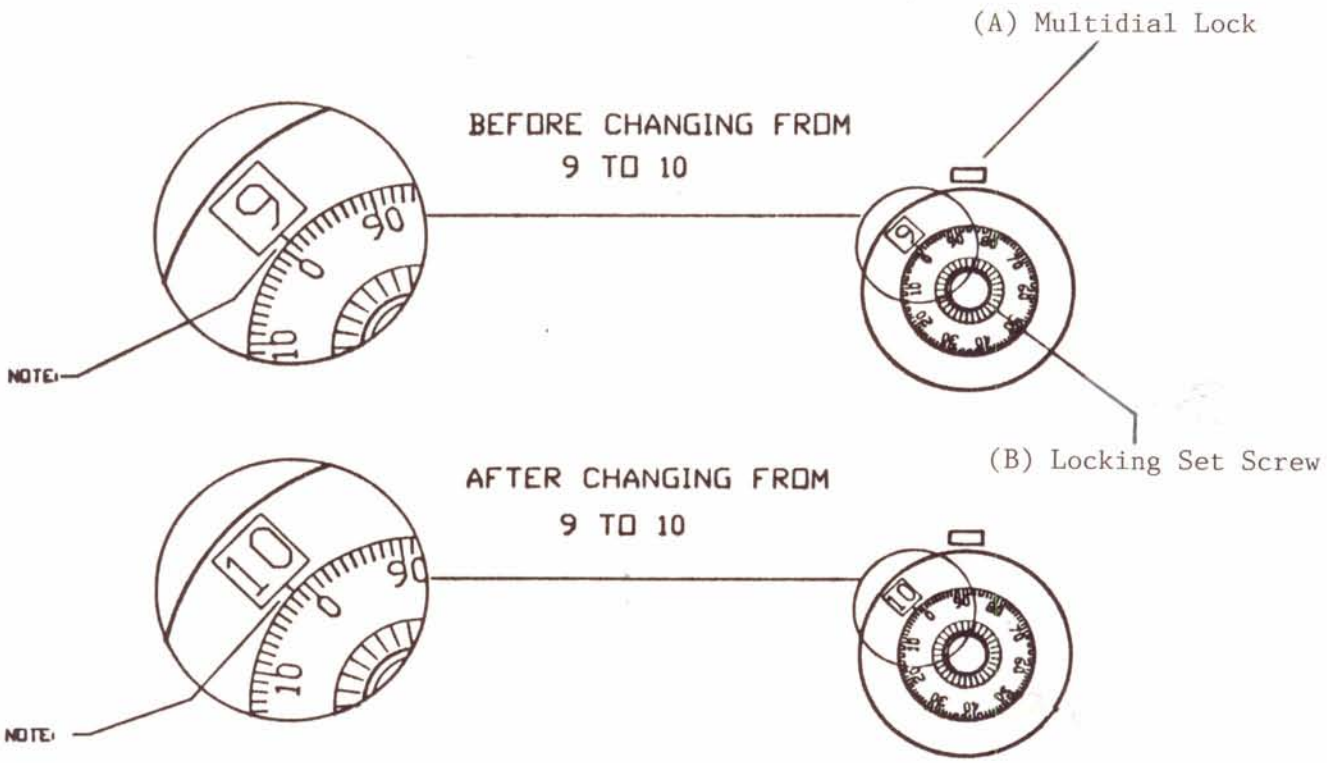


Figure 3

VII. FIGURES: (con't)

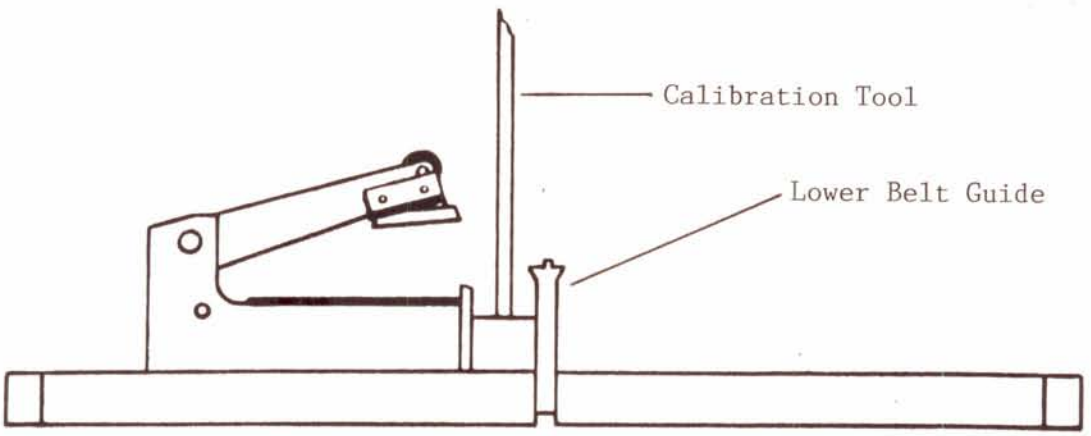


Figure 4

VII. FIGURES: (con't)

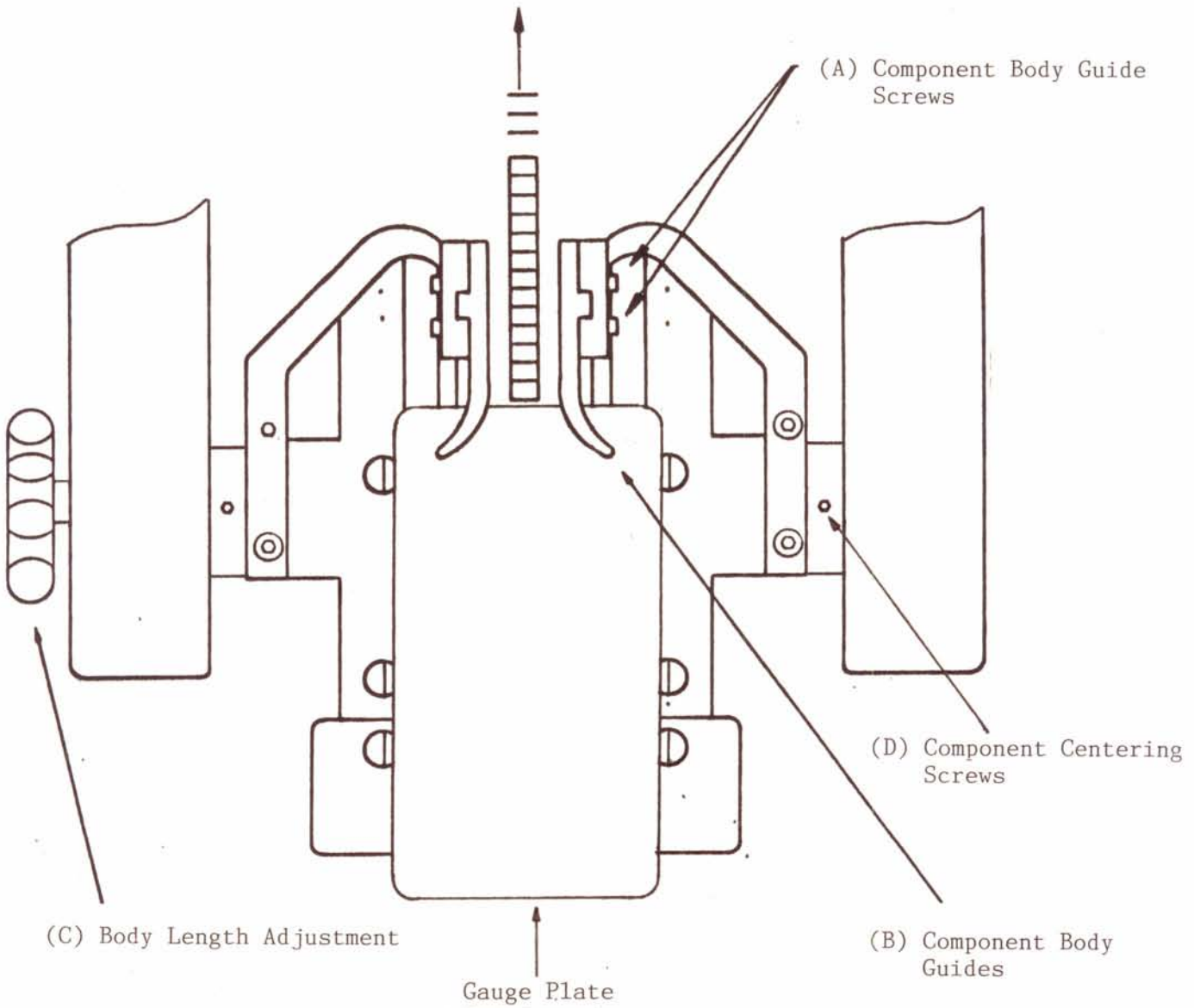


Figure 5

VII. FIGURES: (con't)

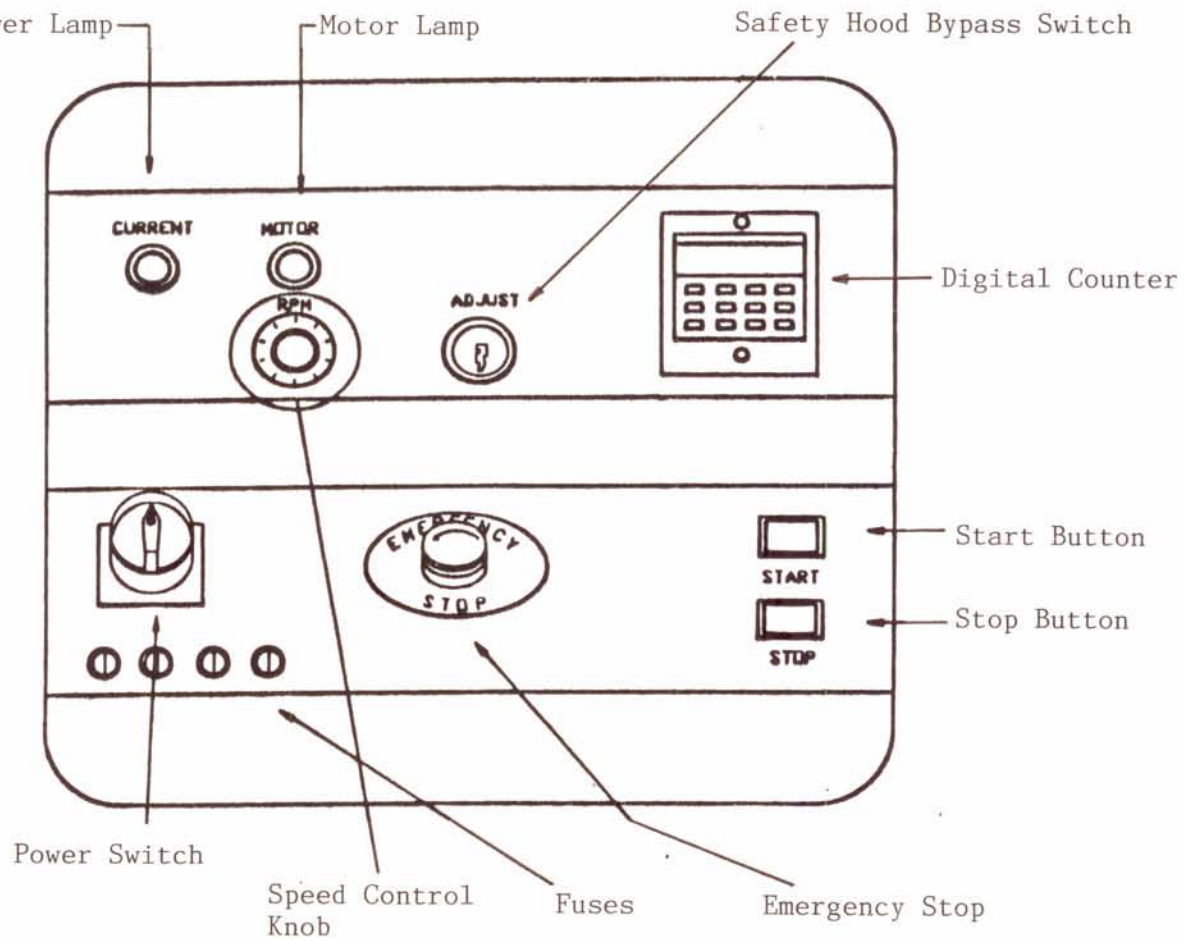


Figure 6

VIII. DIE POSITION FORMULAS:

The following formulas are given to provide a practical method for determining the approximate position of the dies during forming based upon the component and it's application on the circuit board.

Variables used in the formulas are defined as follows:

CL = Cut Length
MH = Mounting Height
(Protrusion + PCB Thickness + Stand Off + Heat Sink)
BD = Body Diameter
R = Inside Bend Radius Required By Specifications
LD = Lead Diameter
LS = Lead Span (Center to Center or Pitch)
BR = Actual Bend Radius Of The Die
SF = Shrink Factor Used For MIL Stress Relief Bends
PR = Protrusion

Actual Bend Radius (BR) For Each Bending Die:

C4	.015"	C4/1.3	.030"
C4ai	.015"	C4ai/1.3	.030"
C4M1	.015"		

Shrink Factor (SF) Used For MIL Stress Relief Bends:

Lead Diameter	Shrink Factor
.015"	.160"
.020"	.155"
.025"	.150"
.030"	.145"

Multidial Graduation:

Dial Setting	Distance In Inches
0	.000"
10	.005"
20	.010"
30	.015"
40	.020"
50	.025"
60	.030"
70	.035"
80	.040"
90	.045"
1.00 (One Revolution)	.050"

VIII. DIE POSITION FORMULAS: (con't)

Cut Length Formula:

CL = 2(MH+1/2BD-.429(R+1/2LD)+1/2LS)+.429(R-BR)+SF

Die Position Formulas:

Die #	Thin Belt (C036/7.5)	Thick Belt (C036/10)
AR/AL	= 10CL-3.0	= 10CL-3.5
B42	= 10CL-20PR-3.42	= 10CL-20PR-3.82
B42S	= 10CL-20PR-3.42	= 10CL-20PR-3.82
B1	= 10CL-20PR-5.56	= 10CL-20PR-TBD
B2	= 10CL-20PR-5.56	= 10CL-20PR-TBD
B3	= 10CL-20PR-5.56	= 10CL-20PR-TBD
B4A	= 10CL-20PR-4.72	= 10CL-20PR-TBD
B5A	= 10CL-20PR-4.72	= 10CL-20PR-TBD
BS1	= 10CL-20PR-6.62	= 10CL-20PR-7.22
BS2	= 10CL-20PR-6.62	= 10CL-20PR-7.22
BSM1	= 10LS-10LD-3.76	= 10LS-10LD-4.76
C4	= 10LS-10LD-2.72	= 10LS-10LD-3.12
C4/1.3	= 10LS-10LD-2.72	= 10LS-10LD-3.12
C4M1	= 10LS-10LD-2.72	= 10LS-10LD-3.12
C4ai	= 10LS-10LD-3.80	= 10LS-10LD-4.20
C4ai/1.3	= 10LS-10LD-3.80	= 10LS-10LD-4.20

VIII. DIE POSITION FORMULAS: (con't)

Examples for using the die position formulas: (C036/7.5)

Component is a 1/4 watt resistor with a Flush Mount Snap In form.

Die Sets Needed:

AR/AL
B42
C4

Variables:

PCB Thickness		.062"
Protrusion		.060"
Mounting Height	(MH)	.122"
Body Diameter	(BD)	.090"
Lead Diameter	(LD)	.025"
Inside Bend Radius	(R)	.025"
Lead Span	(LS)	.500"
Bend Radius Of Die	(BR)	.015"

Cut Length Calculation:

CL = 2(MH+1/2BD-.429(R+1/2LD)+1/2LS)+.429(R-BR)+SF
= 2(.122+.045-.429(.025+.012)+.250)+.429(.025-.015)+0.0
= 2(.122+.045-.015+.250)+.004
= .804 +.004
= .808

Die Position Calculations:

AR/AL = 10CL-3.0
= 8.08-3.0
= 5.08

C4 = 10LS-10LD-2.72
= 5.00-.250-2.72
= 2.03

B42 = 10CL-20PR-3.42
= 8.08-1.2-3.42
= 3.46

Die Position Multidial Settings:

AR/AL = 5.08 B42 = 3.46 C4 = 2.03

VIII. DIE POSITION FORMULAS: (con't)

Examples for using the die position formulas: (C036/7.5)

Component is a 1/8 watt resistor with a MIL Stress Relief Flush Mount Snap In form.

Die Sets Needed:

AR/AL
B42
BSM1
C4M1

Variables:

PCB Thickness		.062"
Protrusion		.060"
Mounting Height	(MH)	.122"
Body Diameter	(BD)	.065"
Lead Diameter	(LD)	.020"
Inside Bend Radius	(R)	.020"
Lead Span	(LS)	.500"
Bend Radius Of Die	(BR)	.015"

Cut Length Calculation:

CL = 2(MH+1/2BD-.429(R+1/2LD)+1/2LS)+.429(R-BR)+SF
= 2(.122+.032-.429(.020+.010)+.250)+.429(.020-.015)+.155
= 2(.122+.032-.012+.250)+.002+.155
= .784+.002+.155
= .941

Die Position Calculations:

AR/AL = 10CL-3.0
= 9.41-3.0
= 6.41

B42 = 10CL-20PR-3.42
= 9.41-1.2-3.42
= 4.79

BSM1 = 10LS-10LD-3.76
= 5.00-.200-3.76
= 1.04

C4M1 = 10LS-10LD-2.72
= 5.00-.200-2.72
= 2.08

Die Position Multidial Settings:

AR/AL = 6.41 B42 = 4.79 BSM1 = 1.04 C4M1 = 2.08

VIII. DIE POSITION FORMULAS: (con't)

Examples for using the die position formulas: (C036/7.5)

Component is a diode with a Straight Cut 90 degree bend.

Die Sets Needed:

AR/AL
C4/1.3

Variables:

PCB Thickness		.062"
Protrusion		.060"
Mounting Height	(MH)	.122"
Body Diameter	(BD)	.130"
Lead Diameter	(LD)	.040"
Inside Bend Radius	(R)	.060"
Lead Span	(LS)	.500"
Bend Radius Of Die	(BR)	.030"

Cut Length Calculation:

CL = 2(MH+1/2BD-.429(R+1/2LD)+1/2LS)+.429(R-BR)+SF
= 2(.122+.065-.429(.060+.020)+.250)+.429(.060-.030)+0.0
= 2(.122+.065-.034+.250)+.012
= .806+.012
= .818

Die Position Calculations:

AR/AL = 10CL-3.0
= 8.18-3.0
= 5.18

C4/1.3 = 10LS-10LD-2.72
= 5.00-.400-2.72
= 1.88

Die Position Multidial Settings:

AR/AL = 5.18 C4/1.3 = 1.88

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TECHNICAL DATA SHEET

Date: January 7, 1993

Number: TD93001

Subject: C036 Forming Die Adjustment

Instructions:

1. Remove the Die from the machine.
2. Manually operate the die until a dimension of 1.750" is measured from the top of the bearing to the bottom of the die as shown in figure 1.
3. Loosen the locking set screw and turn the adjustment screw in the direction as needed until the applicable gap dimension is measured between the upper and lower die inserts as shown in figure 1.
4. Retighten the locking set screw.
5. Reinstall the die in the machine.

Note: For die sets with lead diameter rating less than .032" gap dimension is .025"
For die sets with lead diameter rating greater than .032" gap dimension is .040"

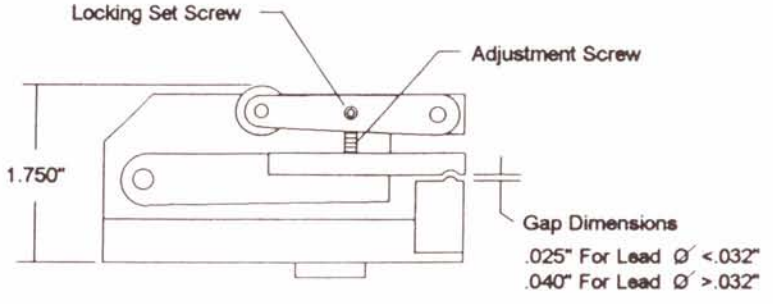

Figure 1

IX. TROUBLE SHOOTING GUIDE:

1. Body Diameter Adjustment

Too High

Too Low

2. Pressure Wedge Adjustment (Bending Dies)

Overbend

Underbend

3. Pressure Wedge Adjustment (Forming Dies)

More Exaggerated

Less Exaggerated

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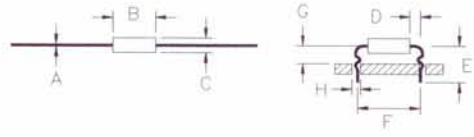
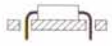
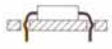
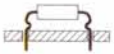
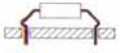
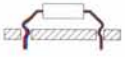
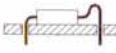
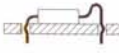
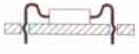
C036 & C036/MP Standard Forms



Form Shape	Description	Cutting Dies	Forming Dies		Bending Dies		Dimensions (inch)							
							A	B (max)	C (max)	D (min)	E (max)	F (min)	G (min)	H
	Straight Cut 90 Degree	AL/AR			C4		.015-.030	1.40	.310	.040	.400	.300		.030-.045
		AL/AR			C4/1.3		.030-.050	1.40	.310	.080	.400	.350		.045-.060
	Flush Mount Snap In	AL/AR	B42		C4		.015-.030	1.40	.310	.040	.400	.300		.030-.045
		AL/AR	B42S		C4/1.3		.030-.050	1.40	.310	.080	.400	.350		.045-.060
	Inside Stand Off	AL/AR	B4A		C4ai		.015-.030	1.40	.310	080	.400	.350	.120	.030-.045
		AL/AR	BS1		C4ai/1.3		.030-.050	1.40	.310	.080	.400	.350	.220	.045-.060
	Outside Stand Off	AL/AR	B5A		C4		.015-.030	1.40	.310	.040	.400	.300	.120	.030-.045
		AL/AR	BS2		C4/1.3		.030-.050	1.40	.310	.080	.400	.350	.220	.045-.060
	45 Degree Stand Off	AL/AR	F1		C4		.015-.023	1.40	.310	.080	.400	.350	.080	.030-.040
		AL/AR	F2		C4		.023-.030	1.40	.310	.110	.400	.400	.130	.040-.050
		AL/AR	F3		C4/1.3		.030-.050	1.40	.310	.140	.400	.460	.180	.050-.060
	Inside Stand Off Snap In	AL/AR	B1		C4ai		.015-.023	1.40	.310	.080	.400	.350	.120	.030-.040
		AL/AR	B2		C4ai		.023-.030	1.40	.310	.080	.400	.350	.120	.040-.050
	Outside Stand Off Snap In	AL/AR	B1S		C4		.015-.023	1.40	.310	.040	.400	.300	.120	.030-.040
		AL/AR	B2S		C4		.023-.030	1.40	.310	.040	.400	.300	.120	.040-.050
	45 Degree Stand Off Snap In	AL/AR	F1K		C4		.015-.023	1.40	.310	.080	.400	.350	.080	.030-.040
		AL/AR	F2K		C4		.023-.030	1.40	.310	.110	.400	.400	.130	.040-.050
		AL/AR	F3K		C4/1.3		.030-.050	1.40	.310	.140	.400	.460	.180	.050-.060
	Single MIL Stress Relief	AL/AR	BSM1		C4	C4M1	.015-.030	1.40	.310	.040/.110	.400	.350		.030-.045
		AL/AR	BSM3		C4/1.3	C4M3	.030-.050	1.40	.310	.080/.210	.400	.470		.045-.060
	Double MIL Stress Relief	AL/AR	BSM1		C4M1		.015-.030	1.40	.310	.110	.400	.400		.030-.045
		AL/AR	BSM3		C4M3		.030-.050	1.40	.310	.210	.400	.600		.045-.060
	Single MIL Stress Relief With Snap In	AL/AR	B42	BSM1	C4	C4M1	.015-.030	1.40	.310	.040/.110	.400	.350		.030-.045
		AL/AR	B42S	BSM3	C4/1.3	C4M3	.030-.050	1.40	.310	.080/.210	.400	.470		.045-.060
	Double MIL Stress Relief With Snap In	AL/AR	B42	BSM1	C4M1		.015-.030	1.40	.310	.110	.400	.400		.030-.045
		AL/AR	B42S	BSM3	C4M3		.030-.050	1.40	.310	.210	.400	.600		.045-.060
	Surface Mount	AL/AR	D1				To Specification							

Additional Form Shapes And Custom Parameters Are Available Upon Request

Streckfuss USA, Inc.

C036 Lower Belt Replacement Procedure

C036 Operators Manual is needed for this procedure. Parts can be located by (item/drawing #) in the operators manual.

1. Remove metal covers on both sides of the upper part of the machine to expose the belt advance ratchet (item 89/dwg. 12.3).
2. Remove scrap lead chutes on both sides.
3. Remove the pressure plate assembly (dwg. 12.1). When removing this, make sure that the precision washers (item 15/dwg. 12.1) remain on the guide shafts (item 16/dwg. 12.1).
4. Remove all the forming and cutting tools from the machine.
5. Remove the tooling plate assembly (items 28&29/dwg. 12.2)
6. Remove the guide rails (item 114/dwg.12.3), guide plates (item 112/dwg. 12.3) and the entrance guides (item115/dwg. 12.3). When removing the guide plates you may have to use the body diameter adjustment to allow the plates to slide out freely.
7. Remove the belt advance ratchet (item 89/dwg. 12.3).
8. Loosen the setscrews on the lower rear end sprocket (item 69/dwg. 12.3). Remove the shaft (item 70/dwg. 12.3) and the sprocket from the machine.
9. Before removing the lower belt guide (item 75/dwg. 12.3), measure the distance between the lower belt guide and the guide shafts(item 16/dwg. 12.1). Take one measurement from the guide rail to the front shaft and one from the guide to the rear shaft. See attached. Record these dimensions, they should be the same.
10. To remove the lower belt guide (item 75/dwg. 12.3), first remove the screws (item 74/dwg. 12.3) which fasten the guide rail onto the support plate (support plate is not numbered). After all four screws # 74(front & rear) are removed, the rear plate should slide out to one side. Once the rear
11. plate is out , the guide rail can be removed. to replace the belt.
    NOTE: If you do not have access to screws you may have to lower the main cam shaft with the body diameter adjustment. (pg. 8/fig. 2)
12. Loosen the set collars (item 77/dwg. 12.3), right and left, on the upper drive shaft (item 78/dwg. 12.3)
13. Loosen the front-end belt sprockets (items 80&86/dwg. 12.3).
14. The upper and lower drive shafts (items 54&78/dwg. 12.3) are attached to the drive gear assembly (items 51-53/dwg.12.3). Pull the drive gear assembly to the left-hand side, which should in turn slide the shafts out of the way.
15. After replacing the belt, re-install all the parts in the opposite order
16. When replacing the lower belt guide make sure the dimensions recorded in step 9 are kept, to prevent problems with alignment once the machine has been reassembled.

17. Adjust the component dwelling point by using the belt advance ratchet (item 89/dwg. 12.3). See attached.

Streckfuss USA, Inc.

C036 Upper Belt Replacement Procedure

C036 Operators Manual is needed for this procedure. Parts can be located by (item/dwg.#) in the operators manual.

1. Remove the pressure plate assembly (dwg. 12.1).

2. Remove the upper belt leveling block (item 58/dwg. 12.3).

3. Remove the spring retaining block (item 55/dwg. 12.3).

4. Loosen the set collar (item 77/dwg. 12.3) on the right-hand side.

5. Slide the bearing (item 84/dwg. 12.3) and the bearing nest (item 62/dwg. 12.3) to the left, along the shaft.
   The belt can be removed by turning the belt advance ratchet (tem 89/dwg. 12.3) while guiding the belt off
   the rear belt sprocket (item 63/dwg. 12.3).

6. Replace the belt by turning the same knob and guiding the belt onto the belt guide and sprocket.

7. Re-install all the parts in the opposite order.

X. PARTS LIST:

Item No.	Description	Part Number	Qty
1	Counter Switch Assembly	P-C036-098	1
2	Counter Plunger	P-C036-104	1
3	Pressure Wedge (Left)	P-C036-035	6
4	Pressure Wedge (Right)	P-C036-034	6
5	M6 Flat Washer	P-C036-032	12
6	M6 Hex Nut	P-C036-033	14
7	M5x30mm FPSSS	P-C036-038	12
8	Pressure Wedge Bar (Right)	P-C036-048	1
9	Pressure Wedge Bar (Left)	P-C036-061	1
10	Pressure Bar Connection Bridge	P-C036-040	2
11	M6x22mm SHCS	P-C036-069	8
12	Upper Belt Pressure Assembly	P-C036-005	2
13	M10 Dome Nut	P-C036-012	4
14	M10 Flat Washer	P-C036-049	8
15	Precision Washer Set (Top)	P-C036-094	1
16	Guide Shaft	P-C036-041	4
17	Pressure Bolt	P-C036-108	4
18	Spring	P-C036-013	4
19	M5x16mm Brass Tip Thumb Screw	P-C036-113	2
20	Pressure Bolt Guide	P-C036-101	2
21	M4x12mm SHCS	P-C036-123	8
22	Pressure Bolt Connection Plate	P-C036-124	2
23	Pressure Adjustment Screw	P-C036-039	2
24	Safety Hood Locking Screw	P-C036-126	2
25	Safety Hood Locking Bracket	P-C036-127	2
26	M4x10mm SHCS	P-C036-128	12
27	M4 Flat Washer	P-C036-129	4
28	Tooling Die Plate (Left)	P-C036-130	1
29	Tooling Die Plate (Right)	P-C036-131	1
30	M5x12mm SHCS	P-C036-132	11
31	Reinforcement Bearing Block	P-C036-103	1
32	Reception Post	P-C036-093	12
33	Die Position Lead Screw	P-C036-043	12
34	Lead Screw Retaining Plate	P-C036-133	2
35	M4x6mm SHCS	P-C036-134	18
36	Coupling Post	P-C036-044	12
37	Multidial Plate Set	P-C036-135	1
38	Die Position Multidial	P-C036-010	12
39	M5x30mm SHCS	P-C036-136	4
40	Stand Off	P-C036-137	4

X. PARTS LIST: (con't)

Item No.	Description	Part Number	Qty
41	M6 Hex Nut (0.75 Thread)	P-C036-045	12
42	Dowel Pin (2.5mmx10mm)	P-C036-138	4
43	Bearing (NK 6/10)	P-Bearing-002	6
44	Dowel Pin (6mmx20mm)	P-C036-139	1
45	Body Length Adjustment Knob	P-C036-140	1
46	M5 Hex Nut	P-C036-141	2
47	Lead Screw Bushing	P-C036-071	2
48	Body Length Lead Screw	P-C036-111	1
49	Transport Bow Plate	P-C036-142	2
50	Transport Slide Set	P-C036-099	1
51	Drive Gear	P-C036-065	2
52	Intermediate Gear	P-C036-077	2
53	Gear Plate Set	P-C036-066	1
54	Lower Belt Drive Shaft (Front)	P-C036-143	1
55	Spring Retaining Block	P-C036-144	2
56	Spring	P-C036-073	2
57	Upper Belt Guide	P-C036-063	1
58	Upper Belt Leveling Block	P-C036-145	1
59	M3x12mm SHCS	P-C036-146	2
60	M3x16mm SHCS	P-C036-147	2
61	M6x25mm FPSSS	P-C036-148	2
62	Bearing Nest	P-C036-149	2
63	Upper Belt Sprocket (Rear)	P-C036-007	1
64	Dowel Pin (8mmx20mm)	P-C036-150	1
65	Sprocket Retainer Set (Rear)	P-C036-151	1
66	Dowel Pin (3mmx20mm)	P-C036-152	2
67	M4x22mm SHCS	P-C036-153	1
68	M4x25mm SHCS	P-C036-154	2
69	Lower Belt Sprocket (Rear)	P-C036-155	1
70	Lower Belt Drive Shaft (Rear)	P-C036-156	1
71	Bearing (6001 ZZ)	P-Bearing-017	6
72	Bearing Washer	P-C036-157	3
73	M5x12mm FHMS	P-C036-158	3
74	M5x8mm SHCS	P-C036-159	4
75	Lower Belt Guide	P-C036-067	1
76	M4x16mm SHCS	P-C036-160	1
77	M10 Collar	P-C036-064	2
78	Upper Belt Drive Shaft (Front)	P-C036-161	1
79	Feeding Teeth Set	P-C036-003	1
80	Upper Belt Sprocket (Front)	P-C036-006	1
81	Lead Screw Nut Set (Left)	P-C036-046	1
82	M3x5mm OHMS	P-C036-162	8
83	Lead Screw Nut Set (Right)	P-C036-058	1
84	Bearing (NK 10/12)	P-Bearing-005	4
85	Sprocket Retainer Set (Front)	P-C036-163	1

X. PARTS LIST: (con't)

Item No.	Description	Part Number	Qty
86	Lower Belt Sprocket (Front)	P-C036-164	1
87	Belt Advance Plate	P-C036-165	1
88	Bearing (NKI 12/16)	P-Bearing-024	1
89	Belt Advance Ratchet	P-C036-166	1
90	Spring	P-C036-167	1
91	Shoulder Bolt	P-C036-168	1
92	Advance Pawl	P-C036-085	1
93	M4x6mm PHMS	P-C036-169	1
94	M3x8mm SHCS	P-C036-170	1
95	Backlash Pawl	P-C036-171	1
96	External Retaining Ring (8mm)	P-C036-172	1
97	M8 Flat Washer	P-C036-173	1
98	Pawl Mount	P-C036-174	1
99	Suspension Arm	P-C036-175	1
100	Spring	P-C036-074	1
101	Pivot Pin	P-C036-176	1
102	Thrust Bar Set	P-C036-177	1
103	Brass Spacer	P-C036-178	1
104	Pivot Pin	P-C036-179	1
105	Transport Bow Assembly	P-C036-100	1
106	Slide Block (Right)	P-C036-180	1
107	Slide Retainer Set (Right)	P-C036-072	1
108	Slide Block (Left)	P-C036-181	1
109	Slide Retainer Set (Left)	P-C036-076	1
110	M4x5mm OHMS	P-C036-182	6
111	Guide Bracket	P-C036-070	2
112	Guide Plate Set	P-C036-068	1
113	M4x8mm FHMS	P-C036-223	4
114	Tape Feed Attachment	P-C036-083	1
115	Entrance Guide Set	P-C036-183	1
116	Bearing (NK 8/12)	P-Bearing-004	1
117	Support Bridge	P-C036-107	2
118	Spring	P-C036-014	4
119	Bearing Bridge	P-C036-184	2
120	Dowel Pin (6mmx30mm)	P-C036-185	2
121	M5x18mm SHCS	P-C036-186	4
122	Bushing	P-C036-042	8
123	Support Cam Set	P-C036-187	1
124	Stroke Cam Set	P-C036-017	1
125	Cam Shaft	P-C036-188	1
126	Bearing Box	P-C036-082	2
127	Thrust Bearing (51 102 J9)	P-Bearing-015	2
128	Drift Key (Short)	P-C036-189	1
129	Belt Advance Cam	P-C036-190	1
130	Drift Key (Long)	P-C036-191	1

X. PARTS LIST: (con't)

Item No.	Description	Part Number	Qty
131	Bearing (625 ZZ)	P-Bearing-012	1
132	Shoulder Bolt	P-C036-192	1
133	Dowel Pin (6mmx25mm)	P-C036-193	2
134	Post	P-C036-194	2
135	Belt Advance Lever	P-C036-195	1
136	Belt Advance Cam Follower	P-C036-196	1
137	M4x20mm SHCS	P-C036-197	2
138	Clutch Pad	P-C036-019	1
139	Friction Disk	P-C036-198	1
140	Motor Drive Knob	P-C036-199	1
141	Clutch Knob	P-C036-200	1
142	Motor Belt Sprocket	P-C036-109	1
143	Motor Belt (T10/660)	P-C036-997	1
144	Spacer	P-C036-201	1
145	Belt Advance Drive Shaft	P-C036-202	1
146	Spring	P-C036-203	1
147	Post	P-C036-204	2
148	Dial Indicator (2406-08)	P-C036-205	1
149	Dial Indicator Mount	P-C036-206	1
150	M5x16mm HHCS	P-C036-207	1
151	Dial Indicator Actuator	P-C036-208	1
152	Dowel Pin (3mmx28mm)	P-C036-209	1
153	Pin Holder	P-C036-210	1
154	Worm Screw	P-C036-057	2
155	Worm Screw Shaft	P-C036-055	1
156	Worm Gear Spacer Set	P-C036-051	1
157	Worm Gear	P-C036-056	2
158	Worm Gear Shaft	P-C036-081	2
159	Stroke Bridge	P-C036-106	1
160	M10 Hex Nut	P-C036-211	4
161	Radial Star Grip	P-C036-125	2
162	Main Frame	P-C036-212	1
163	Linear Bearing (12mmx43mm)	P-C036-001	4
164	Brass Spacer	P-C036-213	8
165	Bearing (1202)	P-Bearing-013	2
166	Shaft Nut (M12x1.0 Thread)	P-C036-214	2
167	Linear Bearing (12mmx36mm)	P-C036-002	4
168	Spring	P-C036-047	1
169	Spring Pin	P-C036-215	1
170	Precision Washer Set (Bottom)	P-C036-095	1

X. PARTS LIST: (con't) - Items Not Shown

Description	Part Number	Qty
Loose Feed Attachment	P-C036-004	1
Adjustment Tool Set	P-C036-011	1
Spring Set (Complete)	P-C036-015	1
Rubber Foot	P-C036-018	4
Power Switch	P-C036-020	1
Counter Microswitch (V4T7)	P-C036-021	1
Key Switch	P-C036-023	1
Power Lamp Socket & Lens	P-C036-024	1
Fuse Holder	P-C036-025	4
Plexiglass Safety Hood	P-C036-031	1
Guide Plate Eccentric	P-C036-062	2
Speed Control PCB (WDR 2.40.3)	P-C036-075	1
Intermediate Gear Shaft	P-C036-078	2
Stop Switch	P-C036-086	1
Start Switch	P-C036-087	1
Rectifier (B40 C3700/2200)	P-C036-088	1
Safety Hood Switch (CR1 KR2)	P-C036-089	1
Safety Hood Switch Cover	P-C036-090	1
Motor (OCGS732TE)	P-C036-091	1
Belt Advance Ratchet Assembly	P-C036-110	1
Motor Mount Shaft	P-C036-116	1
Cable Set	P-C036-117	1
Calibration Tool (Standard)	P-C036-119	1
Calibration Tool (Military)	P-C036-120	1
Transformer (110v-24v)	P-C036-122	1
Emergency Stop Switch	P-C036-216	1
Digital Counter	P-C036-217	1
Motor Lamp Socket & Lens	P-C036-220	1
Bearing Set (Complete)	P-C036-221	1
Pressure Wedge Stud (M6x25mm)	P-C036-224	12
M5 Dome Nut	P-C036-225	4
Lower Transport Belt (7.5)	P-C036-995	1
Upper Transport Belt (7.5)	P-C036-996	1
Lower Transport Belt (10)	P-C036-998	1
Upper Transport Belt (10)	P-C036-999	1

X. PARTS LIST: (con't)

Cutting Tool

Item No.	Description	Part Number	Qty
12.5.1	Spring (12.5.1)	P-C036-037	2
12.5.2	Spring Roll Pin (2mmx18mm)	P-C036-230	2
12.5.3	Dowel Pin (4mmx20mm)	P-C036-080	2
12.5.4	Cutting Tool Base (Left)	P-C036-060	1
	Cutting Tool Base (Right)	P-C036-231	1
12.5.5	M6x18mm CPSSS	P-C036-054	2
12.5.6	Dowel Pin (6mmx24mm)	P-C036-193	2
12.5.7	Cutting Lever (Left)	P-C036-036	1
	Cutting Lever (Right)	P-C036-084	1
12.5.8	Upper Scrap Guide (Left)	P-C036-232	1
	Upper Scrap Guide (Right)	P-C036-233	1
12.5.9	M3x10mm SHCS	P-C036-234	4
12.5.10	Hammer (Left)	P-C036-235	1
	Hammer (Right)	P-C036-236	1
12.5.11	M3 Flat Washer	P-C036-050	4
12.5.12	Upper Cutting Blade Insert Set	T-C036-002	1
12.5.13	Bearing (624 ZZ)	P-Bearing-011	2
12.5.14	Dowel Pin (4mmx10mm)	P-C036-097	2
12.5.15	M3x5mm SHCS	P-C036-237	4
12.5.16	Lower Scrap Guide (Left)	P-C036-059	1
	Lower Scrap Guide (Right)	P-C036-238	1
12.5.17	M3x8mm FHMS	P-C036-239	4
12.5.18	M3x5mm FHMS	P-C036-240	4
12.5.19	Lower Shear Block Insert Set	T-C036-003	1

X. PARTS LIST: (con't)

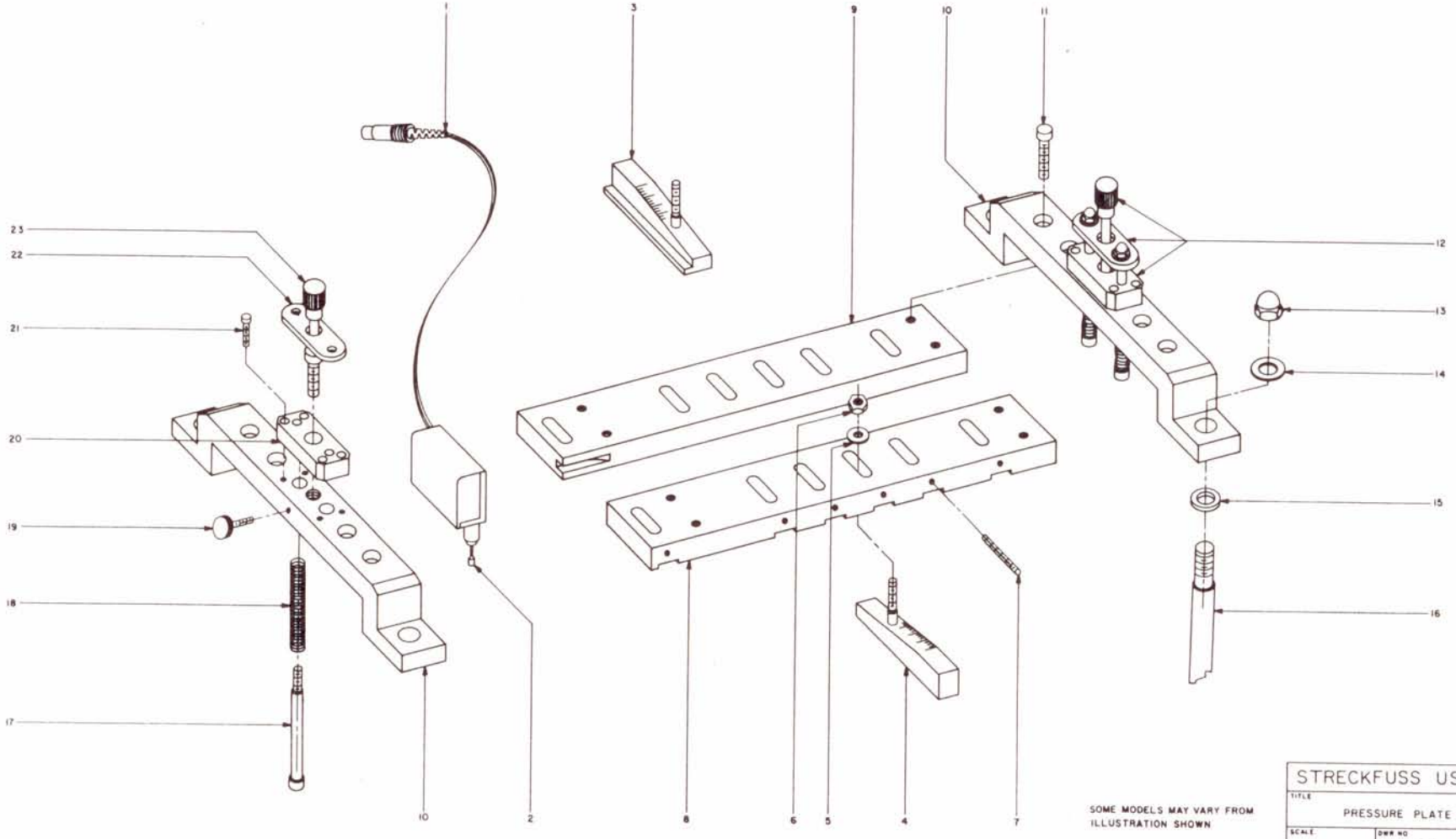
Forming Tool

Item No.	Description	Part Number	Qty
12.6.1	Forming Tool Base	P-C036-241	2
12.6.2	Spring (12.6.2)	P-C036-105	2
12.6.3	Lower Anvil Insert Set	Upon Request	1
12.6.4	M3x10mm SHCS	P-C036-234	4
12.6.5	Dowel Pin (5mmx22mm)	P-C036-242	2
12.6.6	M5x16mm CPSSS	P-C036-243	2
12.6.7	Upper Forming Lever	P-C036-244	2
12.6.8	M3x3mm FPSSS	P-C036-245	2
12.6.9	Upper Die Insert Set	Upon Request	1
12.6.10	Lower Forming Lever	P-C036-246	2
12.6.11	M3x8mm LSHCS	P-C036-247	4
12.6.12	Dowel Pin (4mmx10mm)	P-C036-097	2
12.6.13	Dowel Pin (6mmx24mm)	P-C036-193	2
12.6.14	Bearing (624 ZZ)	P-Bearing-011	2
12.6.15	M6x18mm CPSSS	P-C036-054	2

Bending Tool

Item No.	Description	Part Number	Qty
12.7.1	Bending Tool Base (Left)	P-C036-248	1
	Bending Tool Base (Right)	P-C036-249	1
12.7.2	Lower Anvil Insert Set	Upon Request	1
12.7.3	M3x10mm SHCS	P-C036-234	4
12.7.4	Clamping Lever	Upon Request	2
12.7.5	Dowel Pin (4mmx10mm)	P-C036-097	2
12.7.6	Bearing (624 ZZ)	P-Bearing-011	2
12.7.7	Upper Die Insert Set	Upon Request	1
12.7.8	Dowel Pin (3mmx10mm)	P-C036-250	4
12.7.9	Spring (12.7.9)	P-C036-251	2
12.7.10	Dowel Pin (2mmx10mm)	P-C036-252	2
12.7.11	Dowel Pin (6mmx24mm)	P-C036-193	2
12.7.12	Bending Lever	Upon Request	2
12.7.13	Spring (12.7.13)	P-C036-253	2
12.7.14	Spring (12.7.14)	P-C036-254	2
12.7.15	Brass Spacer	P-C036-255	2
12.7.16	Dowel Pin (2mmx16mm)	P-C036-256	2
12.7.17	Spring Pin	P-C036-053	2

NOTE - When Ordering Forming & Bending Tool Parts Please Specify The Number Stamped In Orange On The Tool. I.E. - B42, BSM1, C4, C4/1.3



SOME MODELS MAY VARY FROM ILLUSTRATION SHOWN

STRECKFUSS USA INC		
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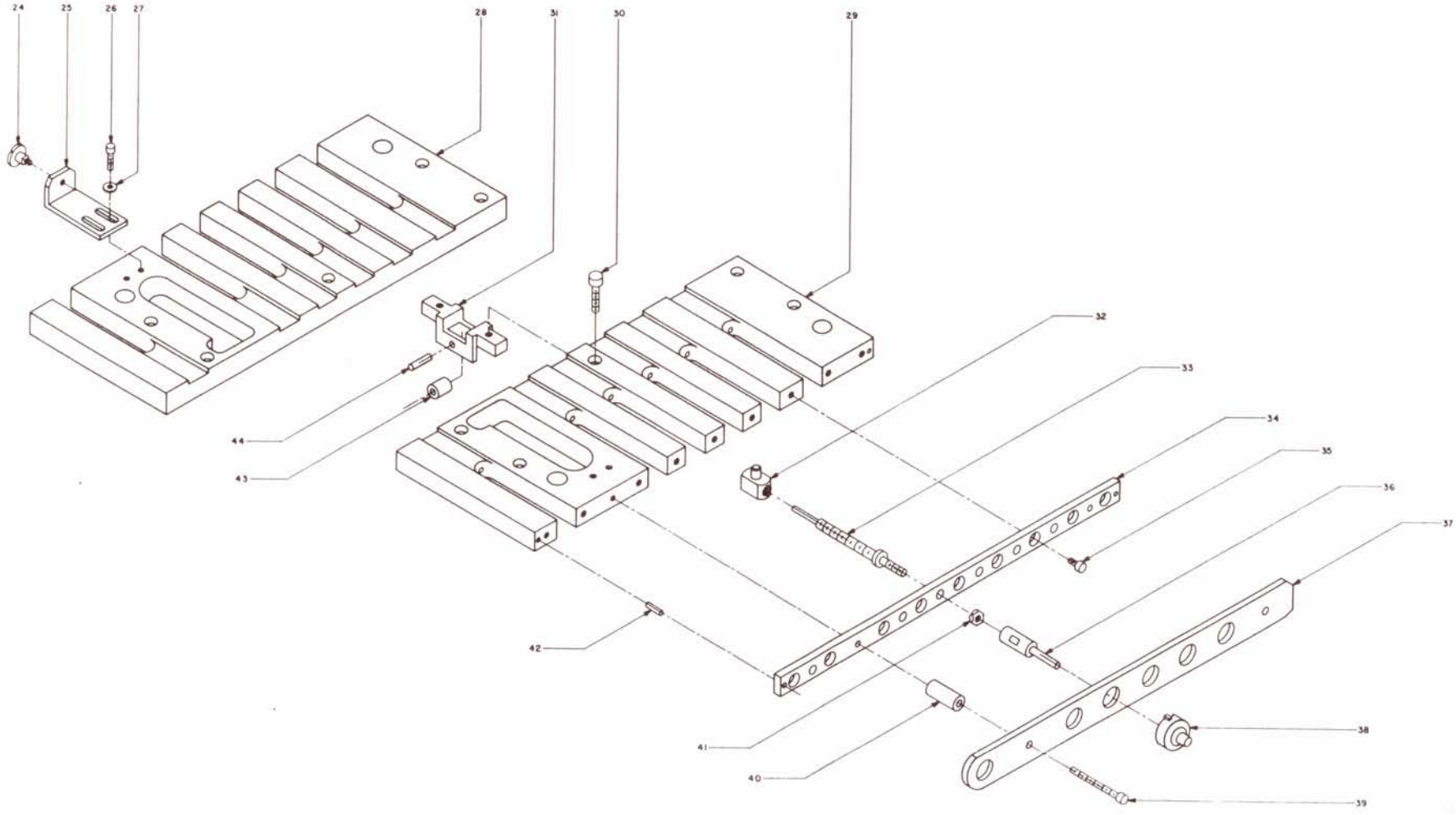
SCALE	DWG NO: 121	MODEL: C036
DRAWN BY: R. VITOVSKY	DATE: 10-30-90	APPROVED BY



SOME MODELS MAY VARY FROM ILLUSTRATION SHOWN

STRECKFUSS USA INC		
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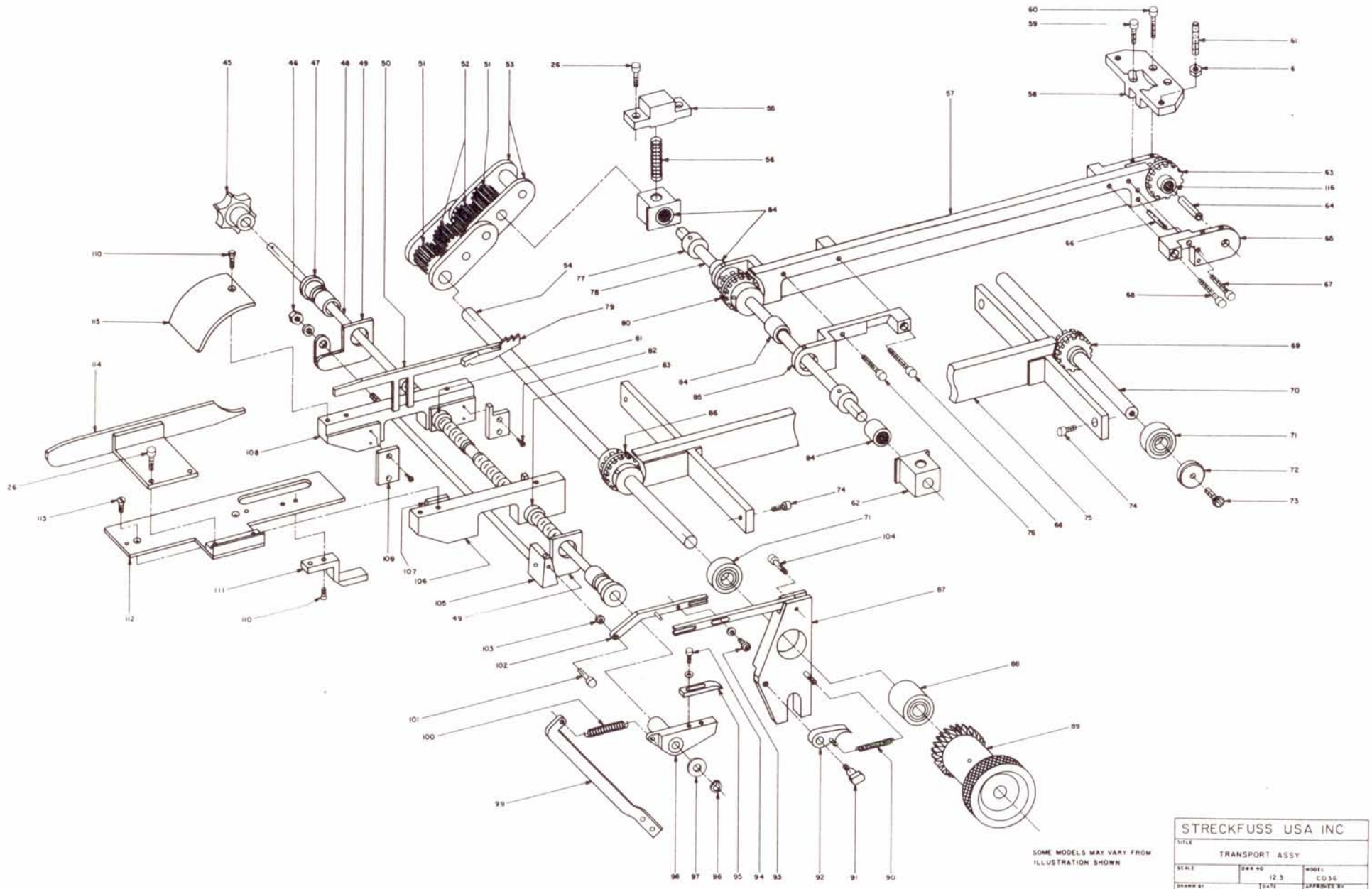
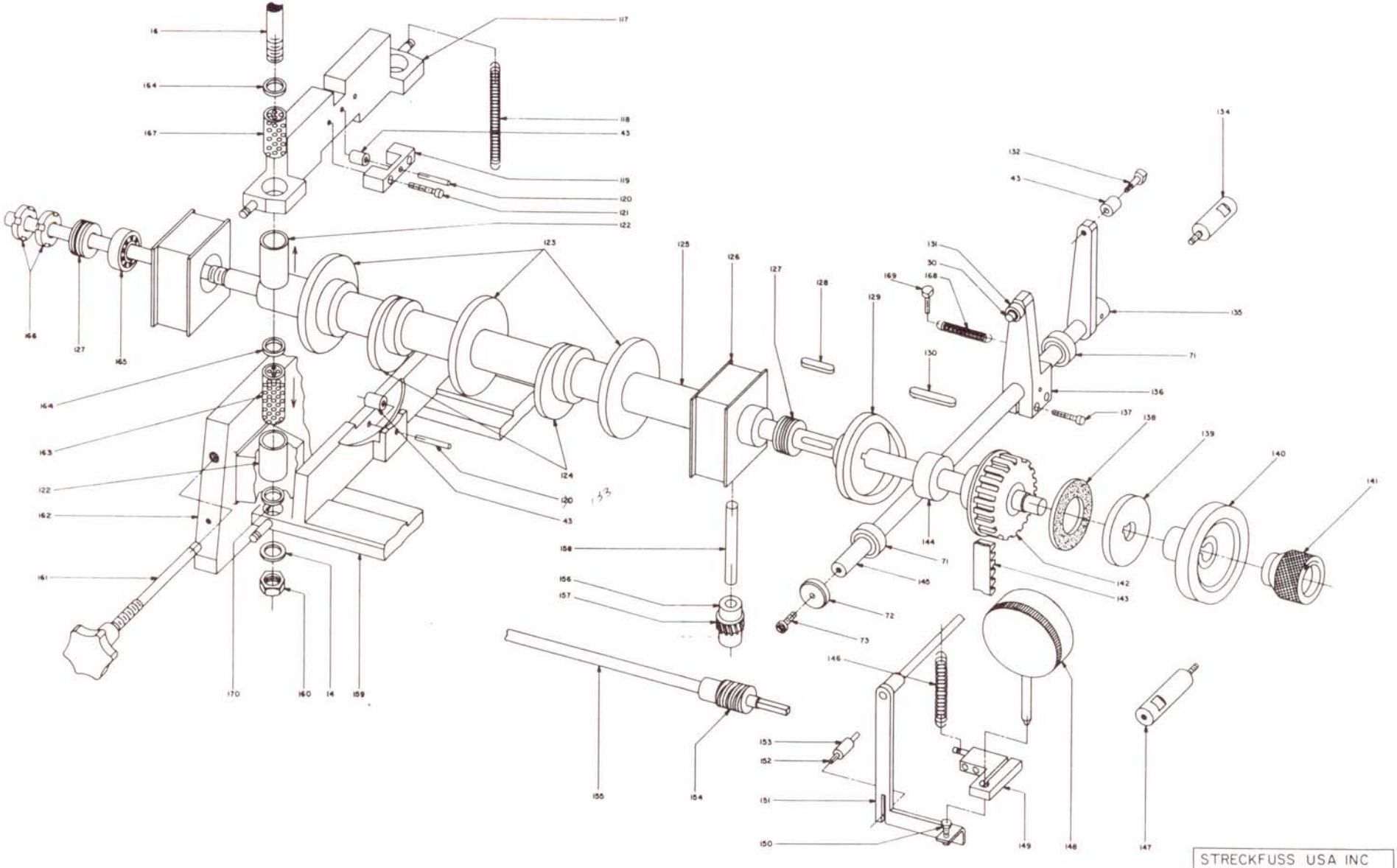
DRAWN BY: R VITOVSKY	DATE: 10-30-90	APPROVED BY


SOME MODELS MAY VARY FROM ILLUSTRATION SHOWN
STRECKFUSS USA INC
TITLE
TRANSPORT ASSY
SCALE
DWG NO
12.3
MODEL
C036
DRAWN BY
R VITOVSKY
DATE
10-30-90
APPROVED BY



SOME MODELS MAY VARY FROM ILLUSTRATION SHOWN

STRECKFUSS USA INC		
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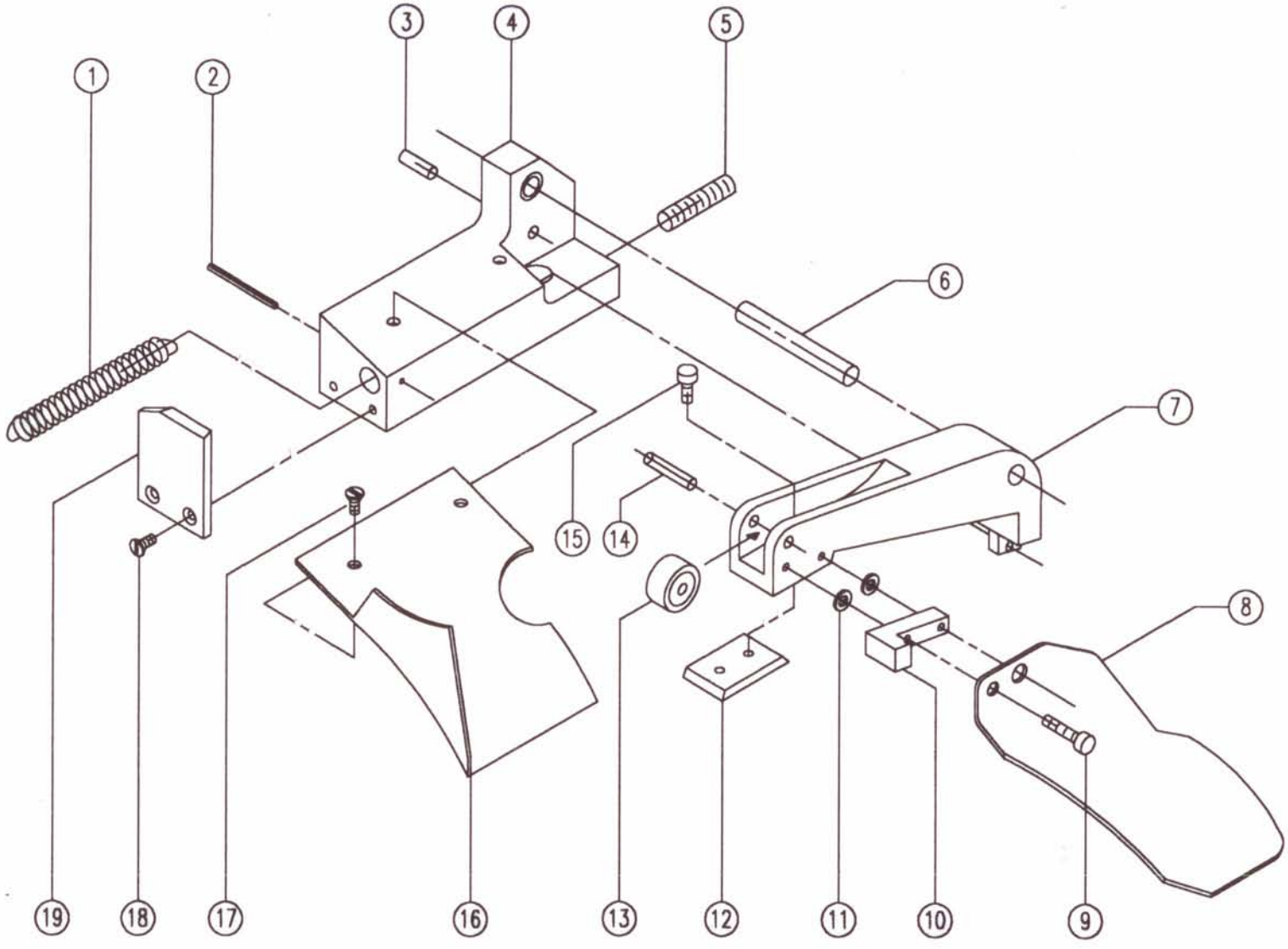
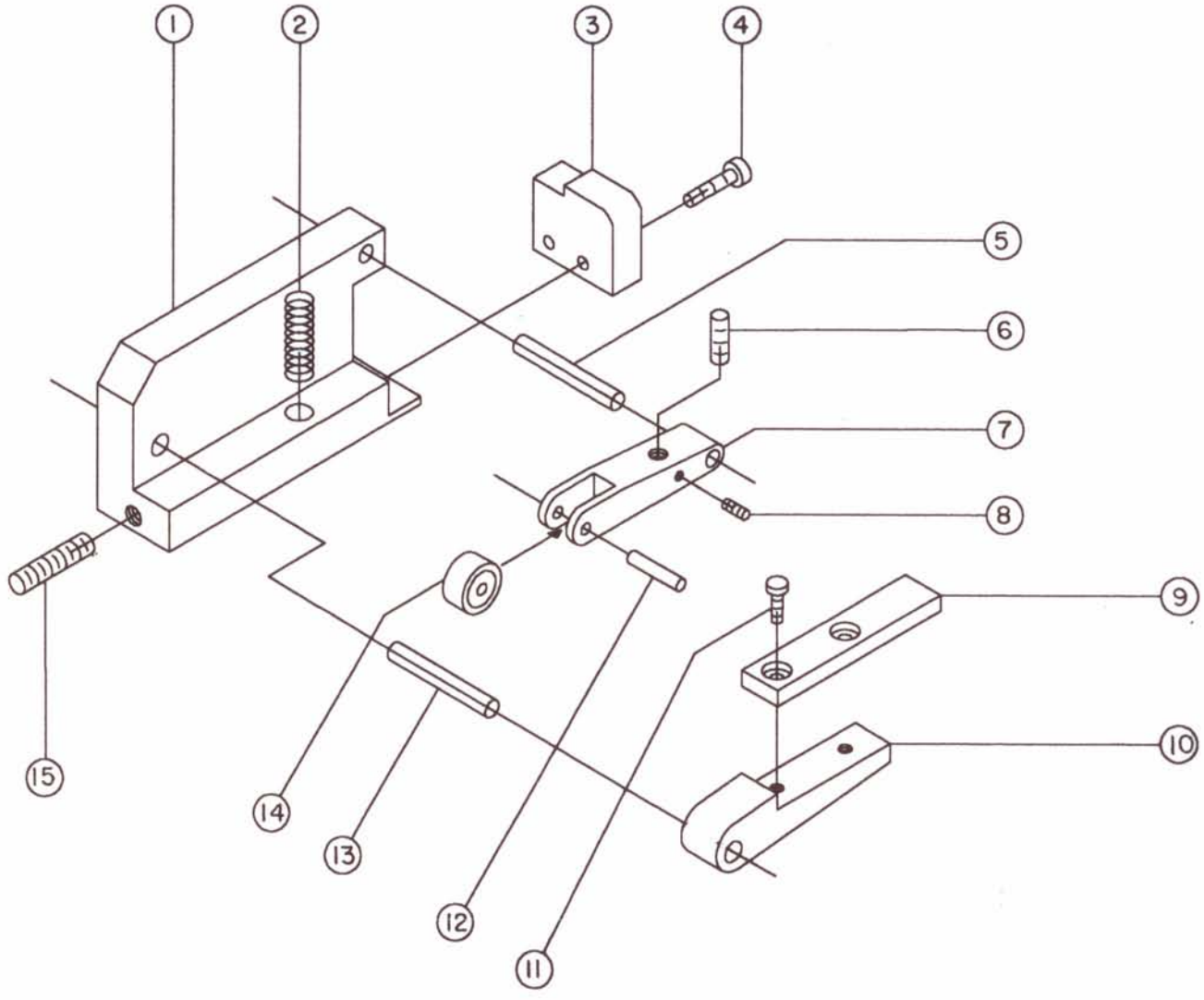
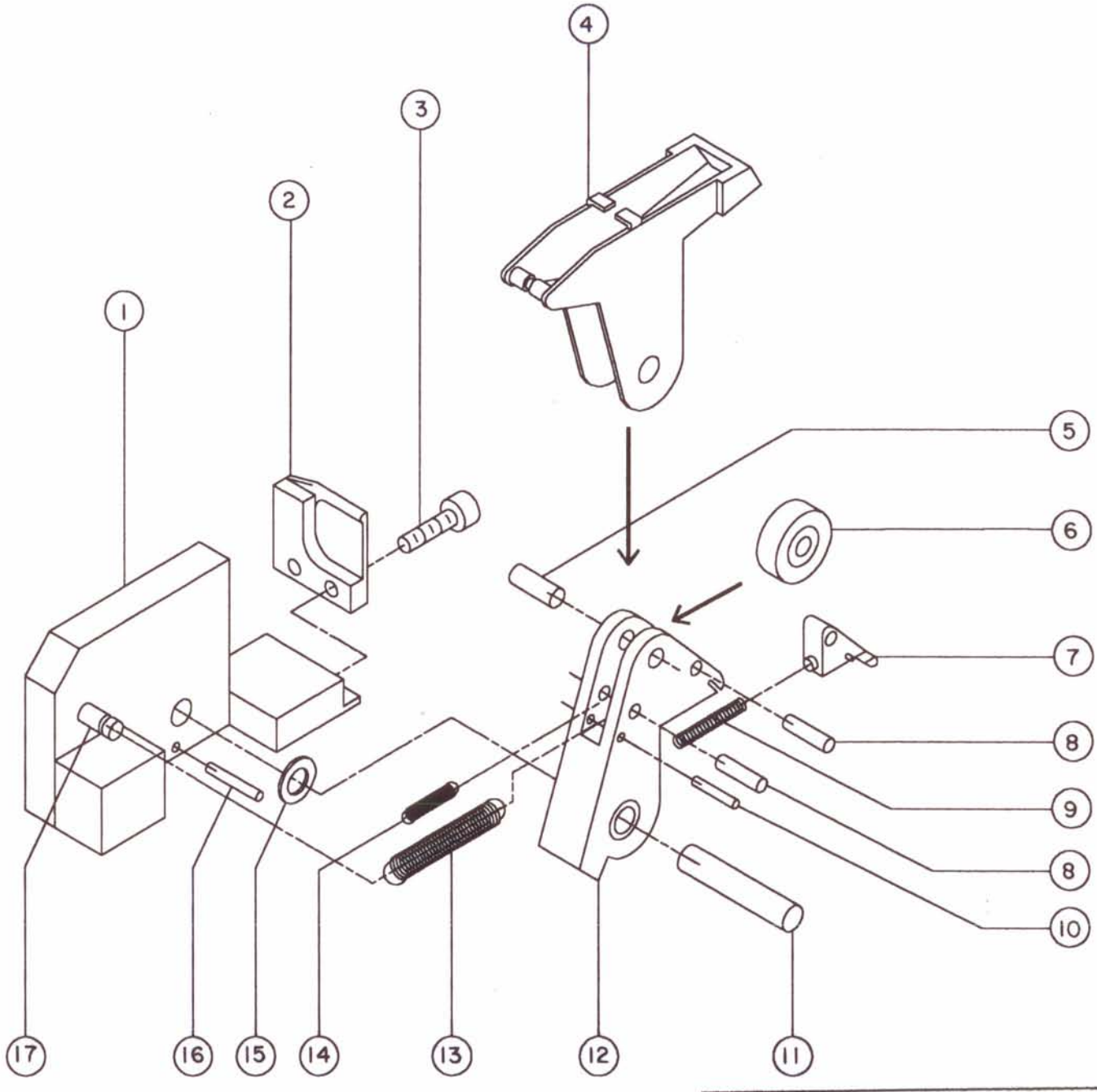
SCALE	DWG NO: 12 4	MODEL: C036
DRAWN BY: R VITOVSKY	DATE: 10 30 90	APPROVED BY



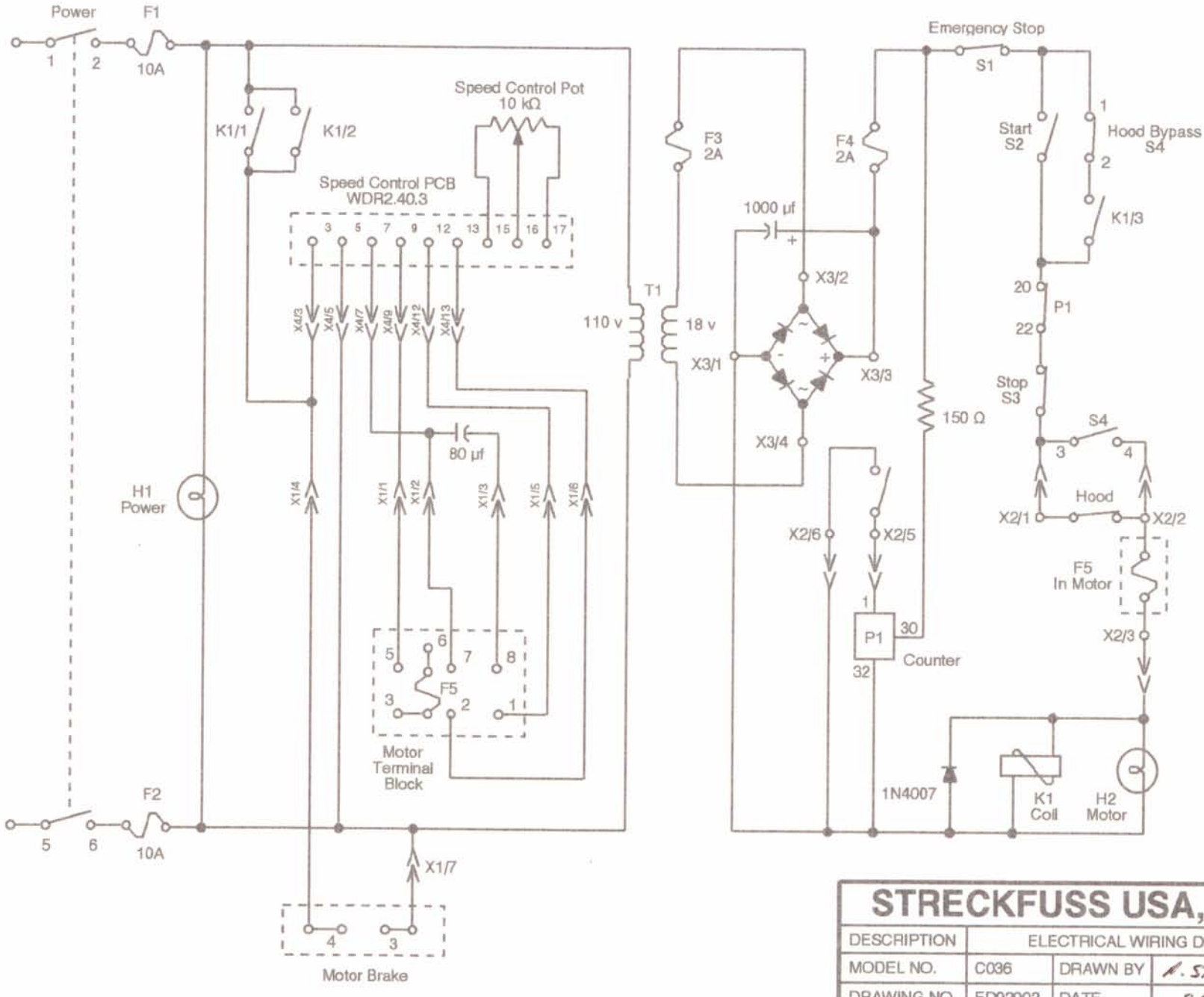
STRECKFUSS USA, INC.					
TITLE	C036 Standard Cutting Tool				
DWG NO.	12.5	BY	RV	DATE	2/1/91
NOTES					



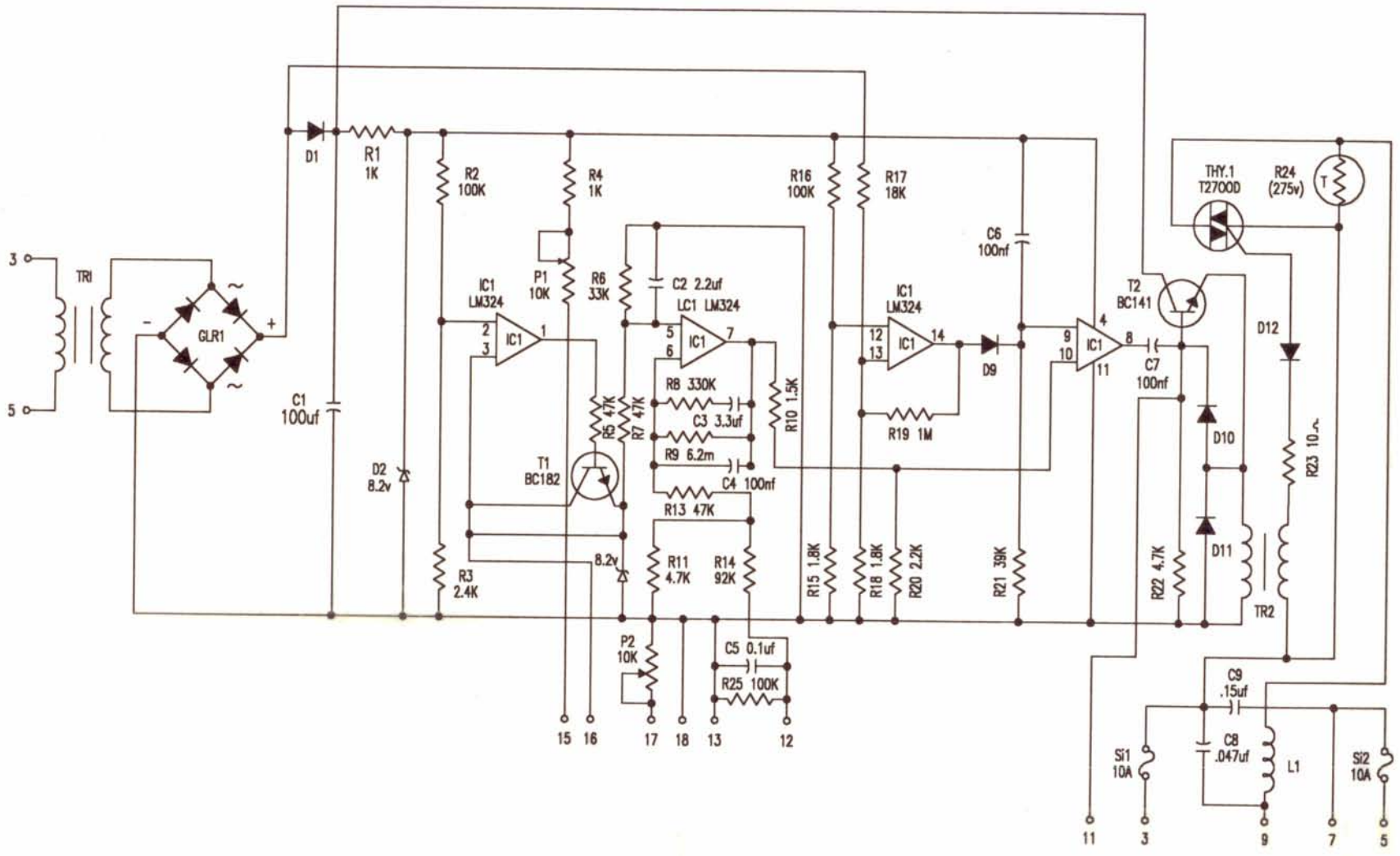
STRECKFUSS USA, INC.					
TITLE	C036 Standard Forming Tool				
DWG NO.	12.6	BY	RV	DATE	9/1/91
NOTES					



STRECKFUSS USA, INC.					
TITLE	C036 Standard Bending Tool				
DWG NO.	12.7	BY	RV	DATE	9/1/91
NOTES					



STRECKFUSS USA, INC.			
DESCRIPTION	ELECTRICAL WIRING DIAGRAM		
MODEL NO.	C036	DRAWN BY	A. Spaniola
DRAWING NO.	ED92002	DATE	8/15/92
110 V, 60 HZ, 2.5 KW			



STRECKFUSS USA, INC.					
TITLE	Speed Control PCB # WDR2.40.3				
DWG NO.	ASGEN.001	BY	RV	DATE	9/1/91
NOTES	110V, 60HZ				

Streckfuss USA, Inc
1401 Capital Ave. # B
Plano, TX 75074

Tel: 972-790-1614 – Fax: 972-881-9199

STRECKFUSS USA INC

RECOMMENDED SPARE PARTS

Model C036/7.5 (Thin Belt)

June 1991

QTY.	DESCRIPTION	PART NUMBER
1 ea.	Spare Parts Kit	P-C036-510
2 ea.	Die Position Multidial	P-C036-010
1 ea.	Spring Set	P-C036-015
2 ea.	Clutch Pad	P-C036-019
1 ea.	Bearing Set	P-C036-221
2 ea.	Upper Transport Belt (7.5)	P-C036-996
1 set	Top Cutting Blade	T-C036-002
1 set	Bottom Shear Block	T-C036-003
1 ea.	Lamp 110v/2w (1.90010.037)	P-Lamp-001
1 ea.	Lamp 24v/2w (1.90010.033)	P-Lamp-002
2 ea.	Fuse 10 amp (GDB 10A)	P-Fuse-010
2 ea.	Fuse 2 amp (GDA 2A)	P-Fuse-003

WHEN ORDERING PARTS PLEASE SPECIFY MACHINE SERIAL NUMBER

NOTE - ALL Screws And Nuts Are Metric.

It is recommended that replacement parts be kept for each tool set in the C036. When calling for part number and price specify the tool number stamped in orange on the tool. (ie - C4, B42)