

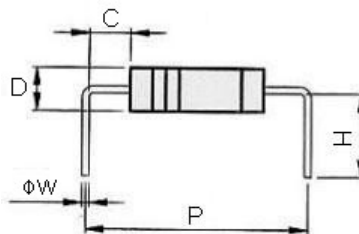


Manual Axial Lead Trimmers/Formers JF-100U/S

The JF-100U/S manual lead former/cutters offer economical solutions for through hole components assembling. Models are available for standard and slim lead forming at this time. The machines are easy to setup with simple adjustments for component size, form dimensions, pitch, and cut length.

1. Model U and Model S

- Optimized design for easy operation and long life, up to 1000 parts per minute processing speed.
- Model A is for standard lead forming.
 $H = 3.6 \sim 15 \text{ mm}$, $\Phi W = 0.35 \sim 1.00$
 Leads distance can be computed as:
 $L = P + 2.4\text{mm} + \Phi W$
 For examples, if $A = 3.6\text{mm}$, $\Phi W = 0.5\text{mm}$, leads range will be $3.6+2.4+0.5=6.5\text{mm}$.
 Leads range is 6.5mm to 40mm.
- Model S is for slim lead forming. The bending gear is not as strong as on model A, not suitable for lead diameter greater than 0.8mm. It works better for bending point close to the component body. The only difference from Model A is that its bending gear is thinner.
 $H = 3.6 \sim 15 \text{ mm}$, $\Phi W = 0.35 \sim 0.8\text{mm}$
 Leads distance can be computed as:
 $L = P + 1.2\text{mm} + \Phi W$
 For example, if $A = 3.6\text{mm}$, $\Phi W = 0.5\text{mm}$, leads range will be $3.6+1.2+0.5=5.3\text{mm}$.
 Leads range is from 5.3mm to 40mm.



	S Model	U Model
P	3.6-40mm	3.6-40mm
H	3.6-15mm	3.6-15mm
C	0.6mm Min	1.2mm Min
D	1.5-8mm	1.5-8mm
ΦW (diameter)	ø0.35 - ø0.8mm	ø0.35 - ø1.0mm

- These machines are for horizontal placed through hole components only (taped components, like resistors, capacitors, diodes, inductors, etc.). They can be used for trimming or forming or both.
- Pitch gauge is optional.

2. Adjustment and Operation

I. Adjustment

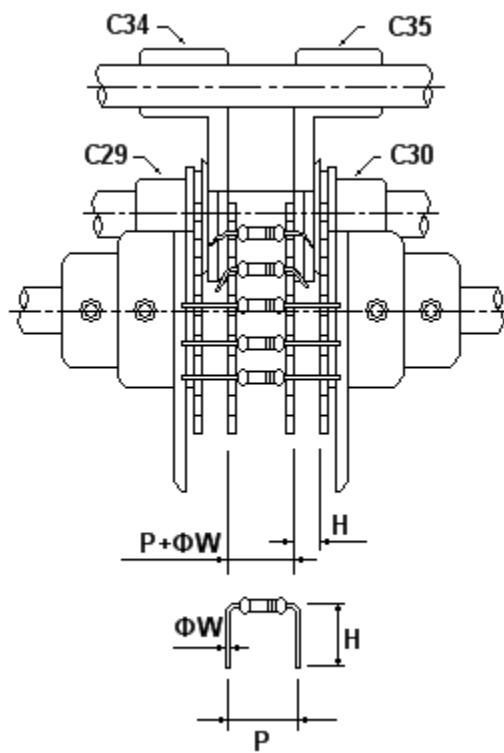
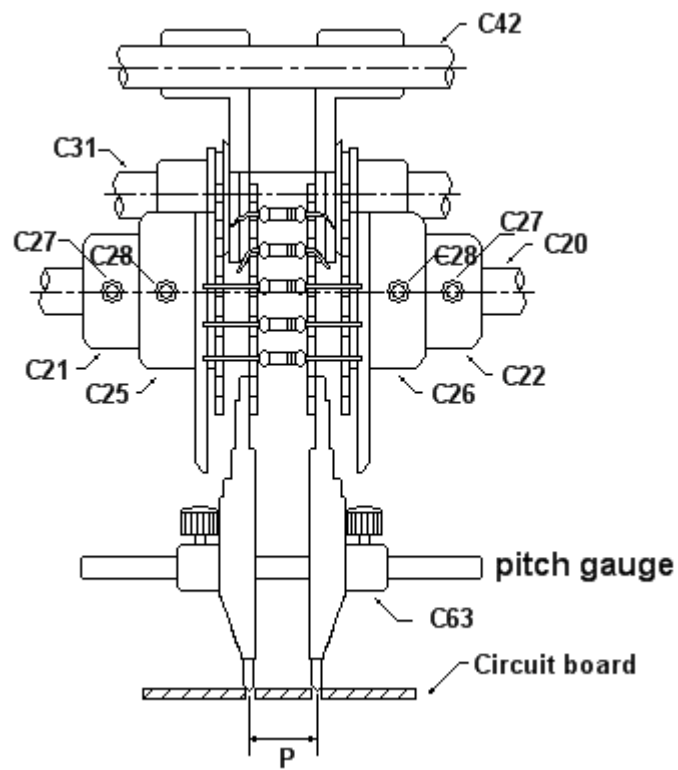
- Loose knob C27, move forming gears C21 and C22 to the desired positions. The lead pitch will be the distance between the two forming gears plus lead diameter. Tighten C27 after adjusting.
- Loose knob C28, move cutting gears C25 and C26 to the desired position. Cutting knives C29 and C30 follows the movement of C25 and C26. Distances of C21 to C25 and C22 to C26 are the lead lengths. The two lead lengths must be adjusted separately.
- Adjust forming knife bases C34 and C35 by turning C49 (not shown on the drawing, the knobs are located at both sides with long screws connecting to C34 and C35). The two knife bases have to be adjusted separately.
- Tighten C44 (that are four allen-headed bolts) to fix the positions of C34 and C35. Distances between C34 and C21, C35 and C22, have to be approximately the size of the lead diameter.
- Test by using a single component placed between C21 and C22, and turning the machine handle to process it.
- If satisfied with the adjustment, mount the plastic rails B1 and B2 to let the tape go through freely(make it a little bit loose).

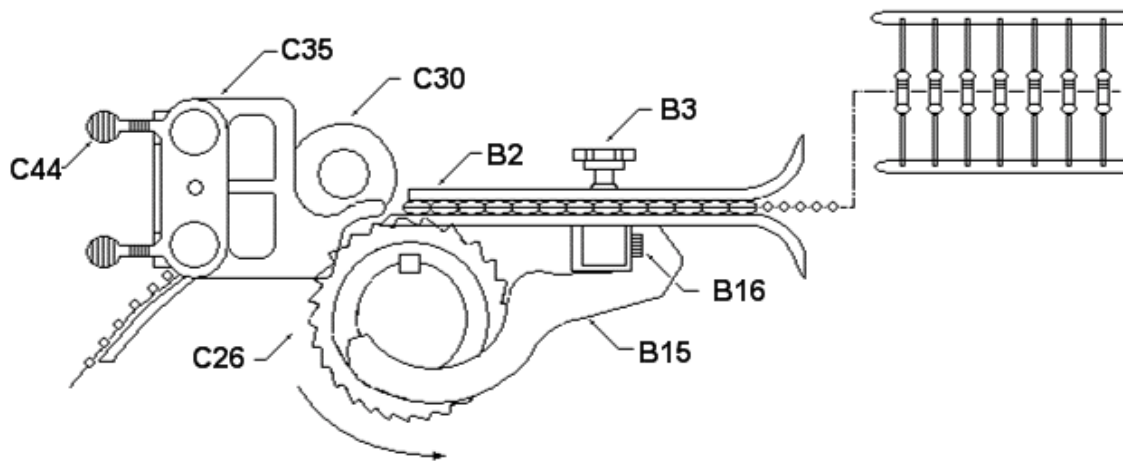
II. Operation

- Tape entry: the taped components get into the machine through rails B1 and B2 and reach forming gears C21 and C22. The tape should be flat between C21 and C22.
- Trimming/cutting: start the machine by rotating handle C10. The component will be cut and bent by C34 and C35.
- Exit: finished components get out of the machine from B15 and fall into collect box A11.
- Cut tape: Tapes on both sides of the components are cut by C29 and C30 and get out of the machine. The operator has to move them out of the way from time to time.

III. Cautions

- Forming gears C21 and C22, cutting gears C25 and C26 are all breakable. They can not be hit on by a hammer when doing the adjustment. The proper way is to push them, either by hand or with some tool.
- Cutting knife will need to be sharpened or replaced after long period of use.
- C34 and C35 are in one piece and need to be replaced together if necessary.
- C21, C22, C25 and C26 are an integrated group and need to be replaced at the same time if necessary.
- The entry rails B1 and B2 should not be too tight, and must not be blocked.
- If the tape is in a roll, it has to be mounted on roll feeder B51. Operator assistance is needed to make it rotate properly.
- Oil shafts C21 and C31 from time to time.





JF-100U/S trimmers/formers parts list

No.	Part	No.	Part
A8	right body	C21	forming gear
A9	left body	C22	forming gear
A11	collect box	C23	flat key
A13	machine base	C25	cutting gear
A82	screw	C26	cutting gear
A91	label	C27	screw
		C28	screw
B1	plastic rail	C29	trimmer knife
B2	plastic rail	C30	trimmer knife
B3	rail screw	C31	trimmer knife shaft
B5	rail shaft	C34	left trimmer knife socket
B57	screw	C35	right trimmer knife socket
B15	exit rail	C37	screw
B16	screw	C40	anti-skip wheel
		C42	forming gear shaft
B51	roll feeder	C44	screw
B53	roll feeder rod	C49	forming gear knob
B56	screw	C60	base tightening rod
C10	rotating arm	C61	fixture
C101	rotating arm handle	C62	tightening nut
C19	flat key	C63	pitch gauge
C20	forming shaft		