Metainance

1： Metainance：

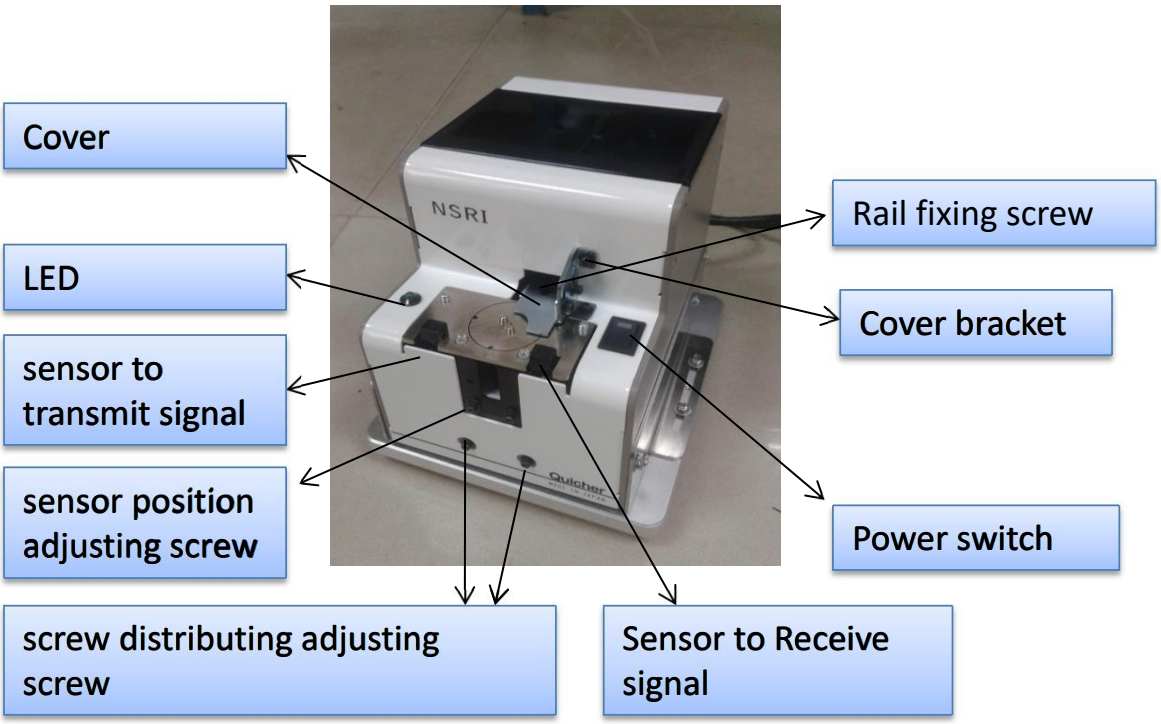
- 1：Regularly clean vaccum generator and it's filter(every month) .
- 2. Regularly check and replace cabon brush of screw driver(every month)
- 3：Regularly clean vaccum nozzle of screw diver(every week).
- 4：Regularly clean screw feeder and lubricate it(every 3 month) .
- 5：Regularly clean machine and lubricate x/y axis guide rail (every 6 month).
- 6：Regularly check screw of machine and tighten it .(every 6 month)。

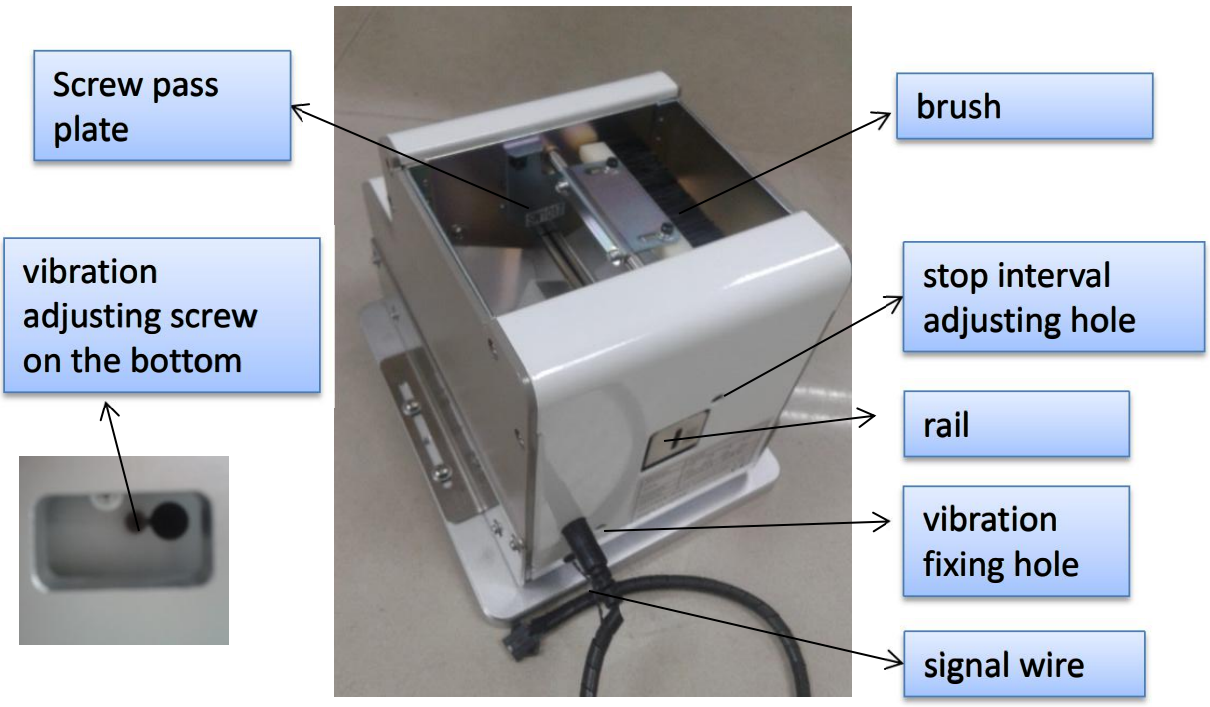
Notice：

- 1： Use correct voltage, the voltage range should not exceed ±10V of rated volage.Machine should be earthed properly in order to avoid injuring due to electric leakage.
- 2：Be sure to power off machine ,pull out plug and air hose before clean and metain machine .Non operating personnel be close to machine, to avoid danger.
- 3：Check the torque of screw driver is suited for production,use torque meter for adjustment.

2. Screw feeder adjustment：

1. Screw feeder structure:





2. Screw feeder adjustment：

1, Brush adjustment

after loading screw, power on screw driver and adjust brush to near rail .

& Adjust brush height to make brush just touch screw on the rail.

2, Adjust screw pass plate

& Ajust screw pass plate height to make it a light higher than screw cap.

3, Adjust sensor position

When screw is between sensor ,the screw feeder shoud stop , LED lamp is on ,when the sensor do not detect the screw , the screw diver will continue to rotate ,LED lamp is off.

& Adjust sensor position by adjusting screw of sensor position to make sure it will run as above status；

4, Rail and distributing plate adjustment（important）

as image1-01， rail should have clearance from distributing plate,when distributing plate rotate,if without clearance it will cause screw stuck and abnormal feeding .

& Loosen fixing screw of rail；

& Ajust rail positon；

& Fix rail；

& Loosen fixing screw of distributing plate, adjust it to the positon as below image:；

& Fix distributing plate.

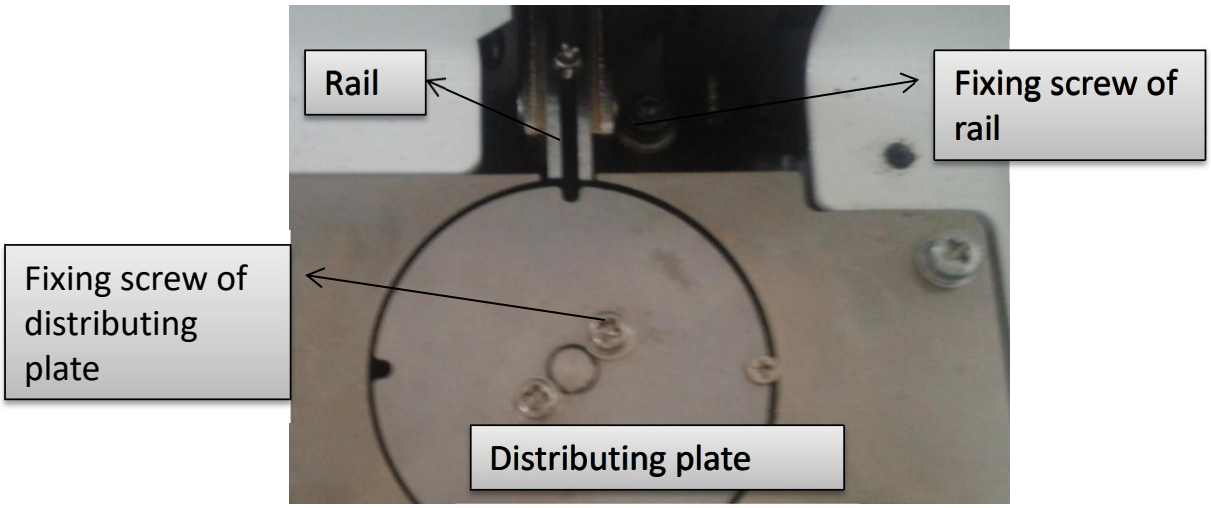


图1-01

2. Screw feeder adjustment：

5, Vibration adjustment

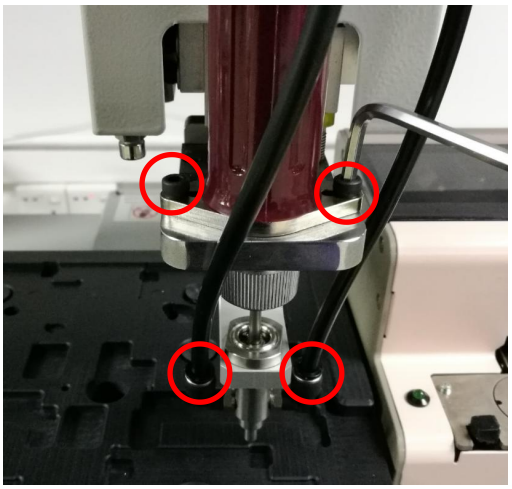
- Vibartion speed is adjustable .
- Loosen the vibration fixing screw(on the back of feeder)
- Adjust the screws of vibration (on the bottom of feeder) , rotate clockwise to increase vibration , anti

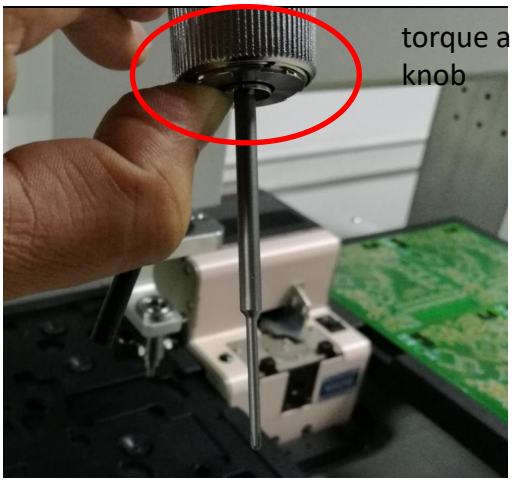
  clockwise to decrease vibration.
- Adjust to suitable speed , the rail can not hit the distributing plate .
- Tighten the screws of vibration .

3. Screw driver adjustment and maintenance：

1. Choose suitable driving head and nozzle according to screw size.
2. Driving head replacement:

Remove the driving head fixing screw and air hose ,pull out driving heading .

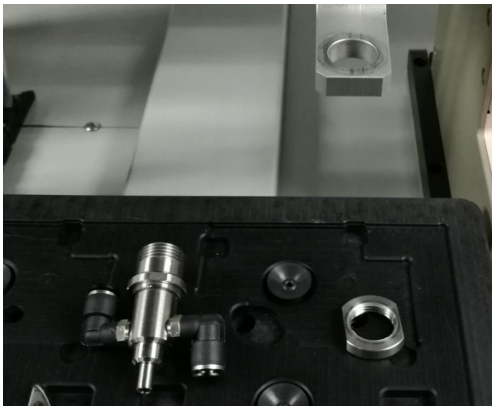




Torque adjustment: turn the torque adjusting knob clockwise and anticlockwise to adjust torque.

3.Nozzle replacement:

Remove the nozzle fixing screw to take out the nozzle , replace it with a new nozzle chosen.



3. Screw driver adjustment and maintenance：

3. Carbon brush of screw driver replacement:

Remove the 2 fixing screw of carbon brush on each side of screw driver , take out them,replace it with new one

Common Failure And Troubleshooting

1:Can not pick up screw and miss driving。

1. Check if there are screws inside feeder .
2. Check if vaccum is normal or not , if not , please clean or replace vaccum filter .
3. Check if the picking position has changed or not, if changed , enter other setting and set the picking positon again.
4. Check if the sensor lamp is on or not when there is screw between sensor.if sensor lamp is off , please adjust sensor position to proper position.

2: Loose screw driving 。

1：Check if driving torque is suitable or not and ajust torque with torque meter.
2：Check if driving speed is too slow or not , set correct driving speed .
3：Check if driving position has changed or not , ajust the driving position.

firstly pull up the knob then turn it for torque adjustment.

Common Failure And Troubleshooting

3： Screw float

Check the program if the screw driving height is suitable for actual driving height ,then set the correct height valve.

Check if the screw driving speed is suitable or not , set correct driving speed.

4： Screw position offset。

Check if the coordinate is correct and correct it .

5： Machine frozen

--： Check is program and parameter setting is correct or not ,reset it and restart machine.

--： Check if power supply is normal or not .