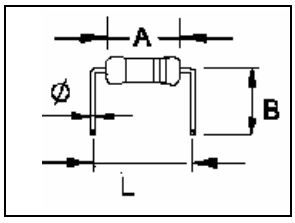
User's Guide –
Manual Taped Axial Lead Former HRFT-301U/S

A. Brief introduction for HRFT-301U and HRFT-301S, Manual taped axial lead former,

1. A hand crank unit with compact and solid design to form and cut the taped axial lead components. 1,000 pieces per minute working capacity are possible in this high production efficient model; With advantage of easy maintenance, adjustment and simple operation procedure.



2. HRFT-301, Standard model, The best structure.

   B=3.6~15(mm), ØW=0.35~1.00mm
   L=A+2.4+ØW(Minimum Pitch),
   for example
   A=3.6mm ØW=0.5
   5+2.4+0.5=6.5mm=L(Adjustable Pitch between 6.5mm~40mm)
3. HRFT-301, Slim model, for small pitch requirement. It's not suitable for lead wire over Ø0.8. The structure is same as standard model except more thinner forming wheel .

   B=3.6~15(mm), ØW=0.35~Ø0.8
   L=A+1.2+ØW(Minimum Pitch),
   for example
   A=3.6mm ØW=0.5
   5+2.4+0.5=5.3mm=L (Adjustable Pitch between 5.3mm~40mm)

4. This model is for cutting and bending the taped(boxed or reeled) axial lead components only. Such as resisters. Diodes, conductors etc.
5. The bench clamp is included in the package which will help to fix the machine to the side of the bench or working table.
6. The Pitch gauge is available which is optional in ordering（Ref. Sketch E63）

B. Operation instructions

1. **Adjusting procedure**
   a) Releasing theC27screw then adjusting the forming wheels of C21&C22 until reaching the required pitch.(The pitch is equal to two distance of forming wheel with the wire diameter), Don't forget to tight the screws released.
   b) Adjusting the cutting distance by moving both the C25&C26 Cutting wheel after releasing the screw C28. The Cutting discs C29 & C30 will be moved synchronously by the action. The distance between forming wheels(C21&C22) and cutting wheels(C25 &C26) is the lead length after forming. Both side of lead length are to be adjusted independently.
   c) The distance of Bending tool (D34 & D35)are to be adjusted independently by

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both side of the adjusting knobs(D49).

d) Adjusting the pitch of the leads by the bending tool D34 & D35. Don't forget to fix the screws D44 after adjusting . A space of one working wire lead diameter must be maintain in between the forming wheel and bending tool.

e) Placing one components in between the forming wheels C21 & C22, Moving the hand crank slowly to form and cut the components. Re-adjusting is required if unsatisfactory

f) Setting up the Plastic guide B1 & B2 when the adjusting procedure is finished. Adjusting the distance between the plastic guide. Make sure the taped component will be running smoothly in it.

2. Application

a) Feeding：Sliding the taped components into the plastic guide B1 & B2 until the first components is placed in the slot in between the cutting and forming wheels.

b) Cutting / Forming：Moving the hand crank clockwise. The taped components will be cut and formed efficiently.

c) Ejecting：The components will be ejected and fallen into the part's bin by the ejectors B15 in the forming wheels C21 &C22 after formed and cut.

d) Tape Waste：Guiding the tape out the part's bin when moving hand crank to cut and form the parts.

C. Caution:

1. Never knocking the forming wheel C21,C22 or cutting wheels C25 & C26 by steel especially during adjustment. It's easy to damage the sharp edges of the wheel. Adjusting the distance by pulling/pushing the wheels gently .
2. The cutting discs need to be re-grinned or replaced when burr is created or cutting incompletely.
3. The bending tool D34 & D35 is calibrated in set. Replacing it contemporaneously when it is wear off.
4. Replacing the whole set of cutting wheel(C21 & C22)and forming wheel(C25 & C26)when one of them is wear off. Since they are calibrated as one set.
5. Keep the taped components sliding smoothly in the plastic guide B1 & B2 that never too tight to interfere the feeding.
6. The Reel B51 must be installed when processing reel packed components. Assisting the moving of the reel by hand when it is cut and formed .
7. Lubricating the forming shaft C20 and cutting shaft C3 to ensure running freely.

Please tell us part number that shown in the drawings if ordering spare parts is necessary. Contact us for any unclear or assistant needed. It's our pleasure to serve you at all time.

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Spare Part list HRFT-301U/S Manual Taped Axial Lead former

Part No.	Part Name	Part No.	Part name
A8	Side wall, Right	C21	Forming wheel
A9	Side wall, Left	C22	Forming wheel
A11	Parts bin	C23	Key
A13	Base	C25	Cutting Wheel
A82	screw	C26	Cutting Wheel
A81	Logo	C27	screw
		C28	screw
B1	Left Plastic guide	C29	Cutting disc
B2	Right Plastic guide	C30	Cutting disc
B3	Screw, rail	C31	shaft, Cutting disc
B5	Square bar, plastic guide	D34	bending tool, left
B57	screw	D35	bending tool, Right
B15	ejector	D37	screw
B16	screw	D40	Stop washer
B50	Components	D42	Shaft, bending tool
B51	reel	D44	Screw
B53	shaft, reel	D49	Knob, bending tool
B56	screw	E60	Fixing rod.
C10	crank arm	E61	Clamp
C101	Handle	E62	Nut
C17	base, bearing	E63	pitch gauge
C171	Screw		
C19	Key		
C20	Shaft, forming		
6003	bearing		

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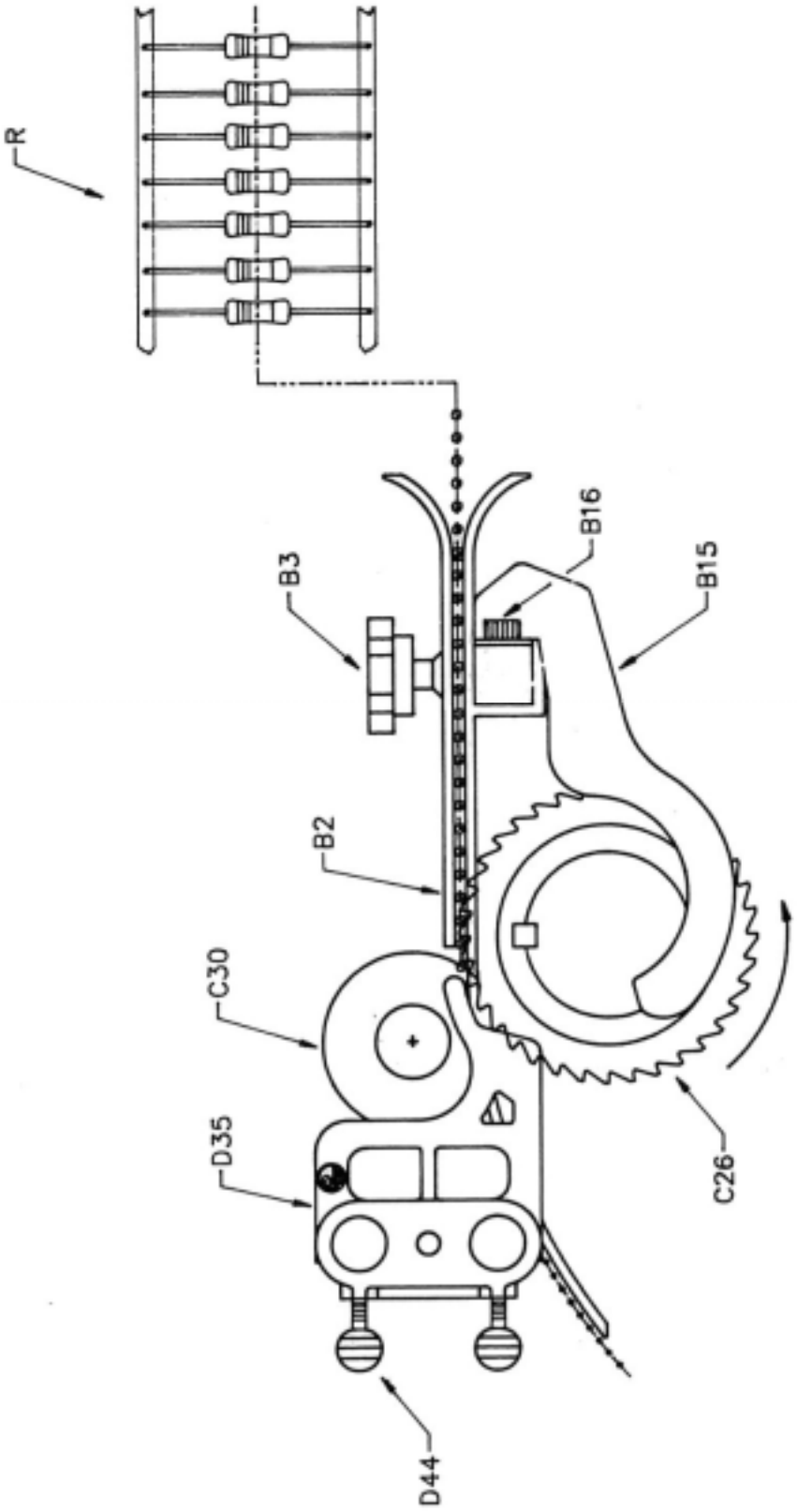

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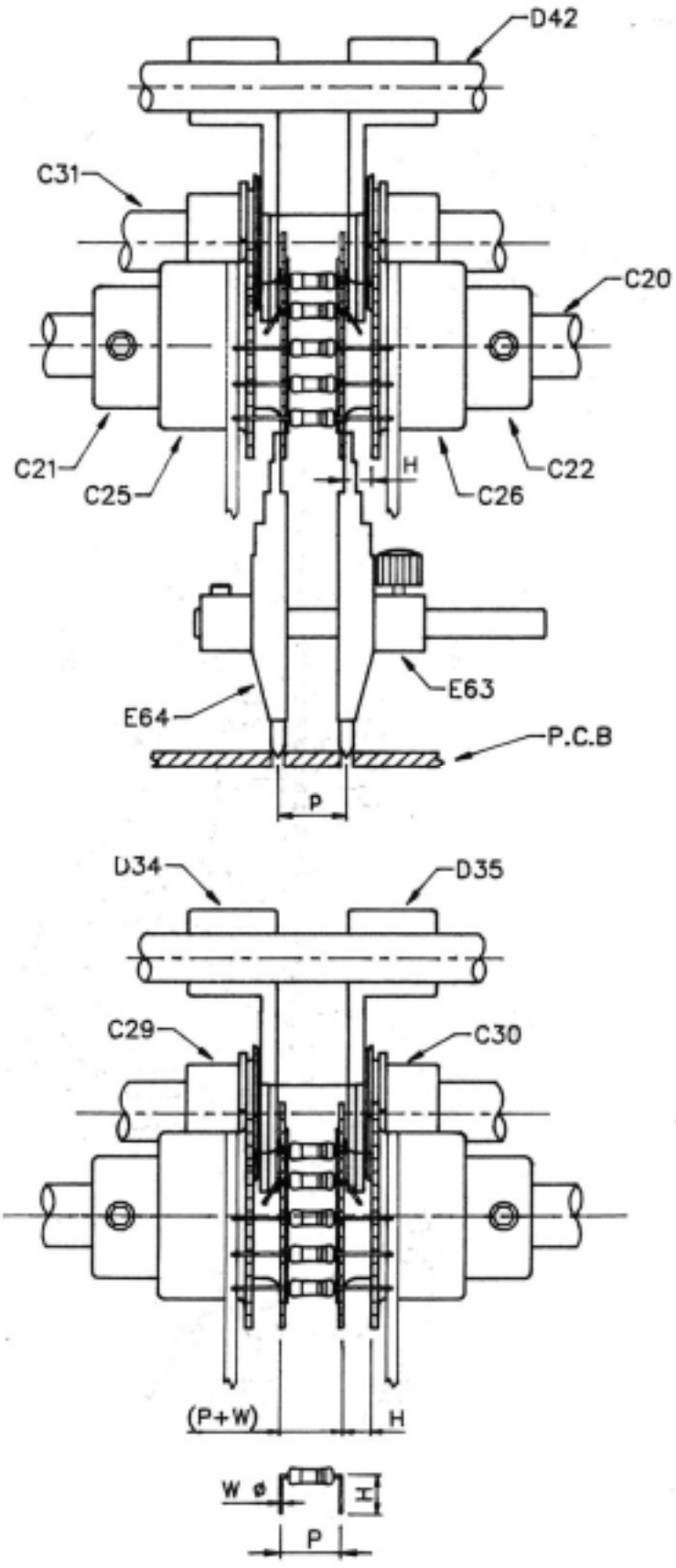

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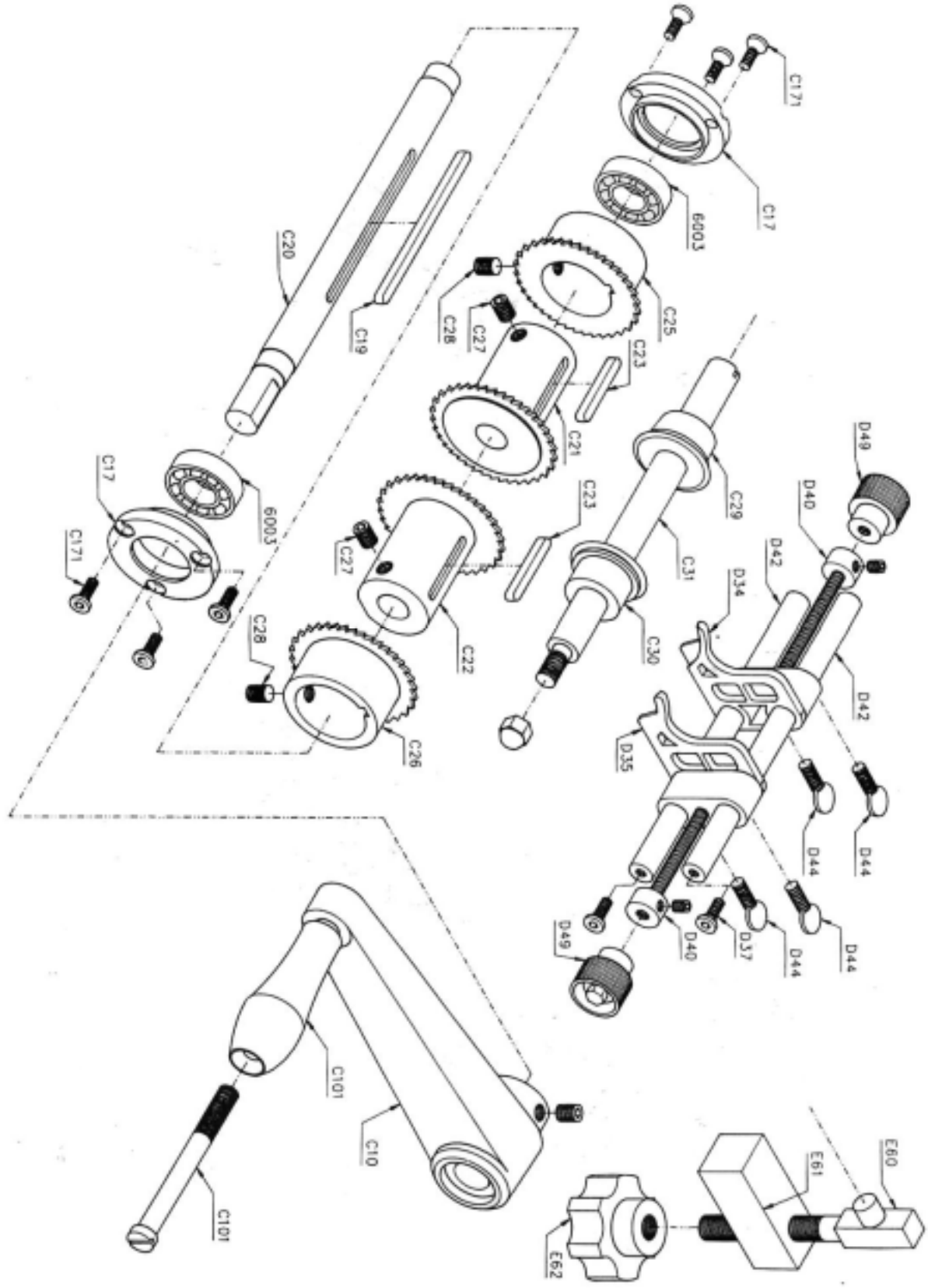

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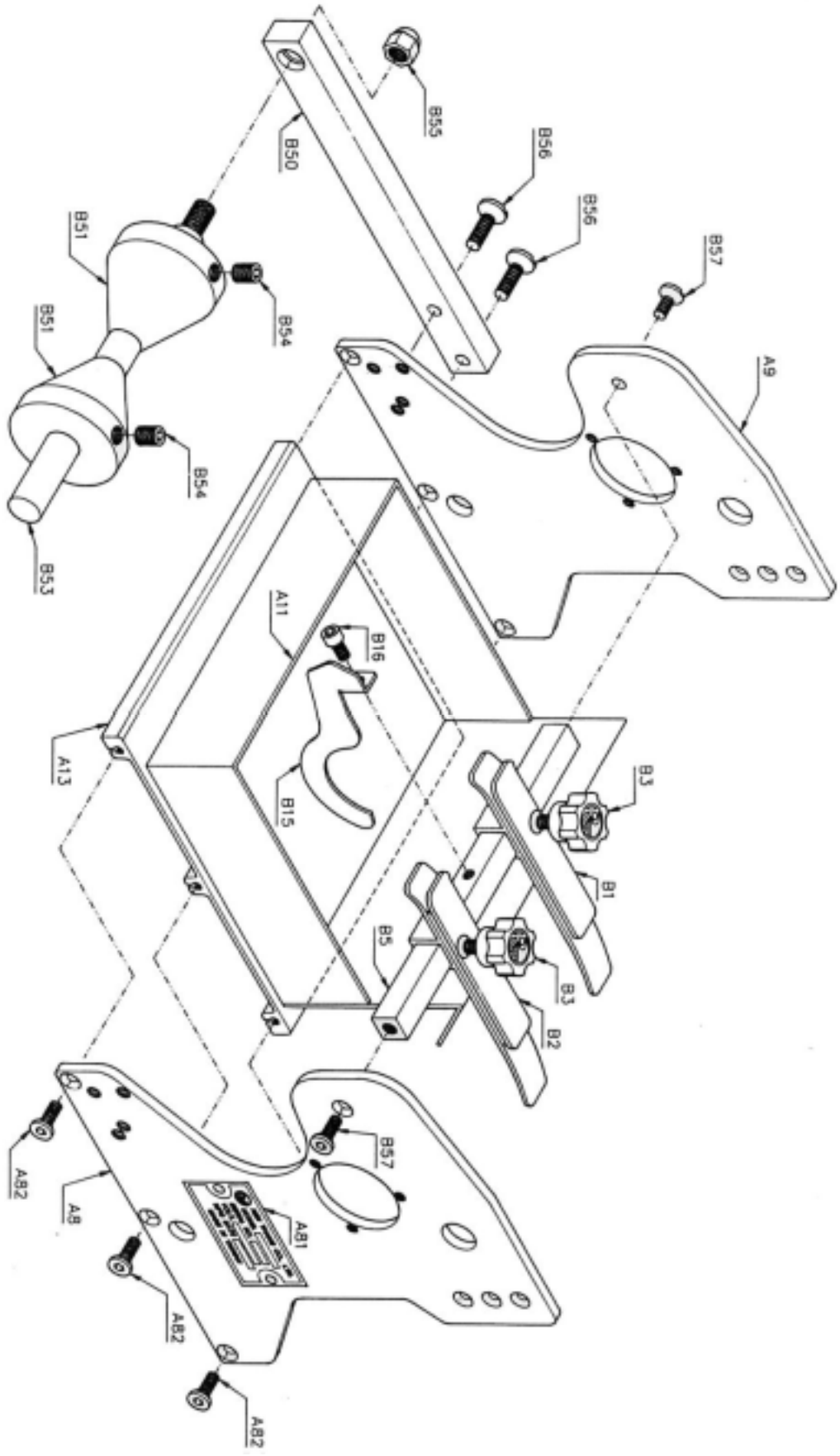

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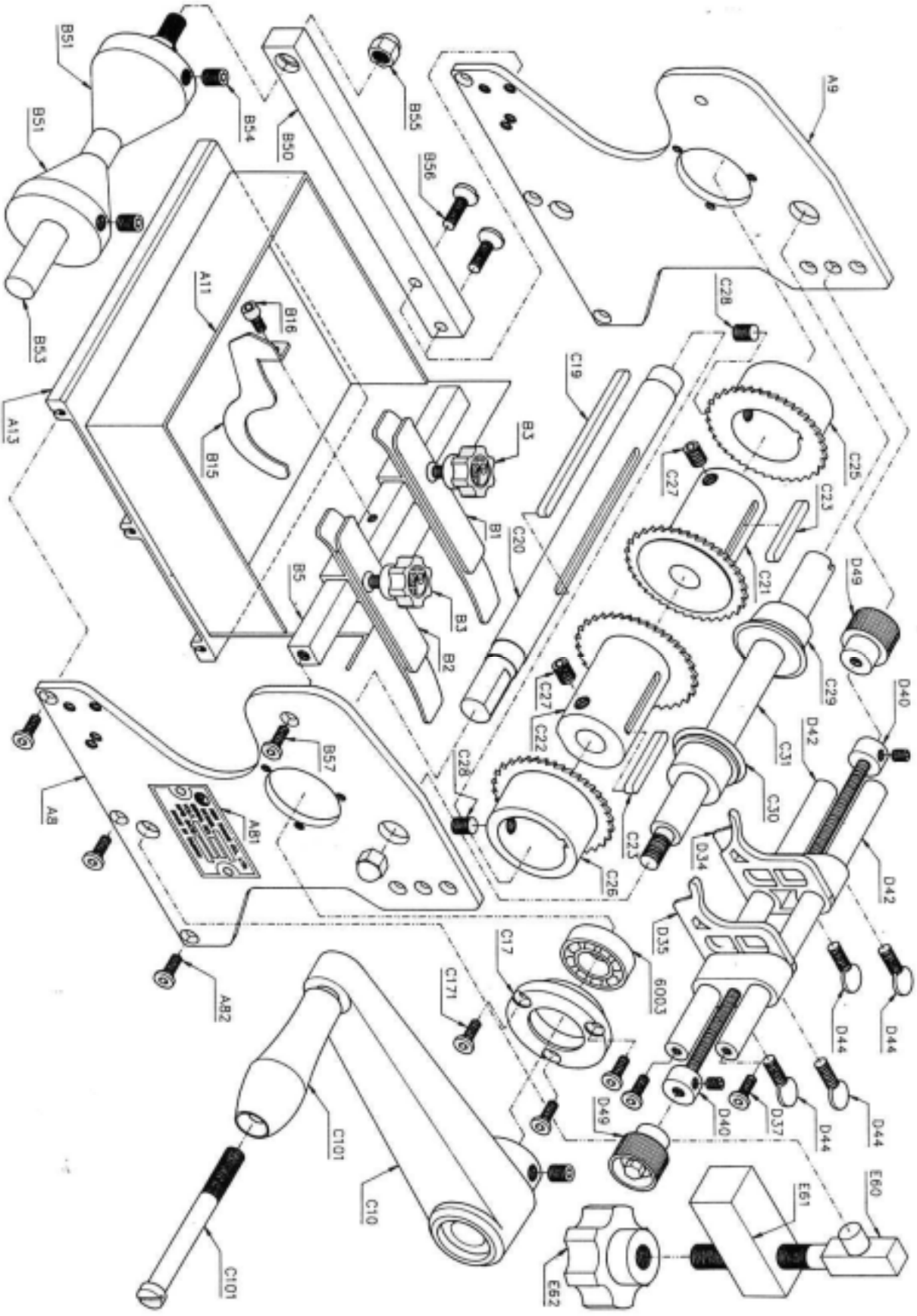

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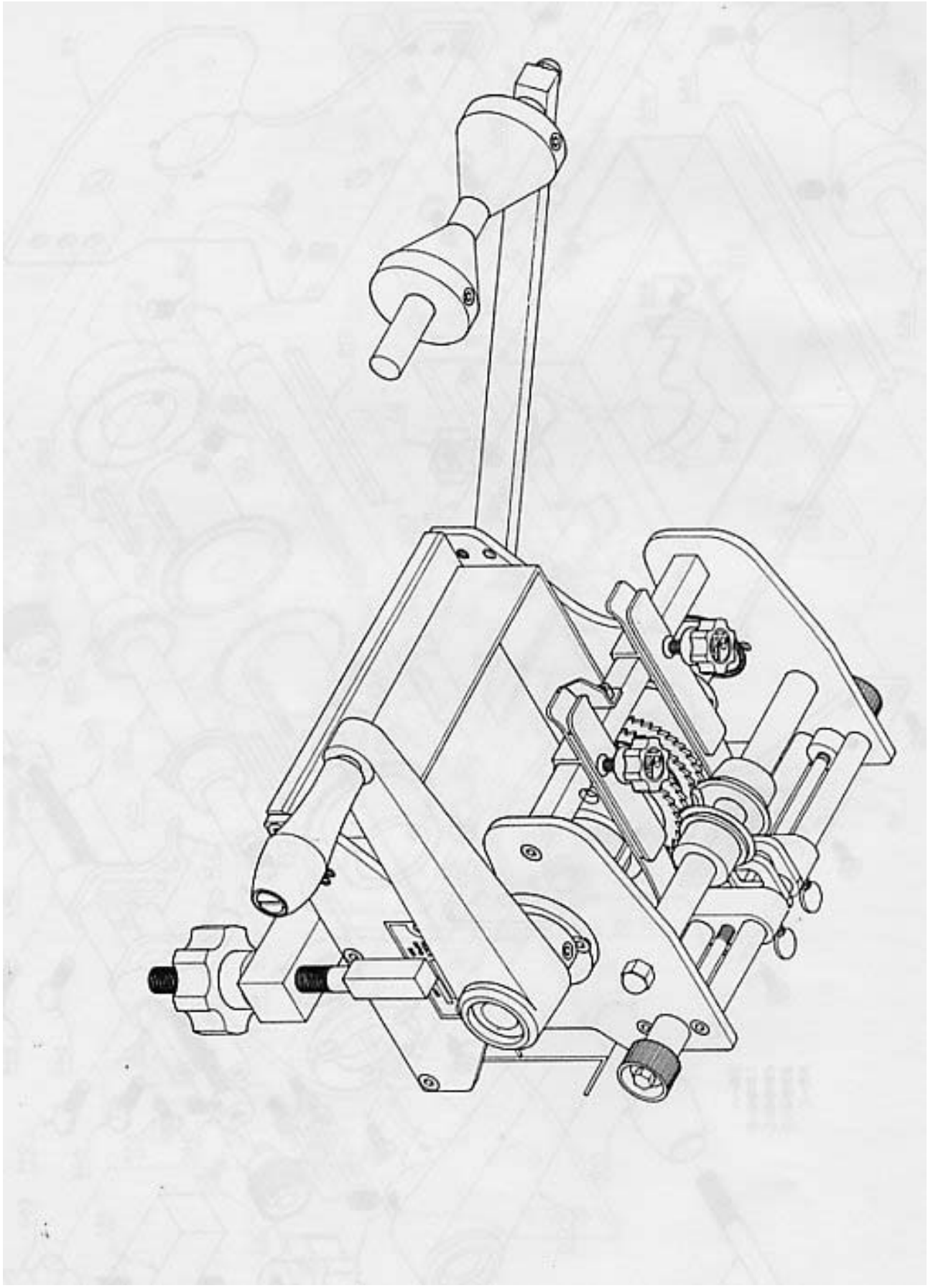

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