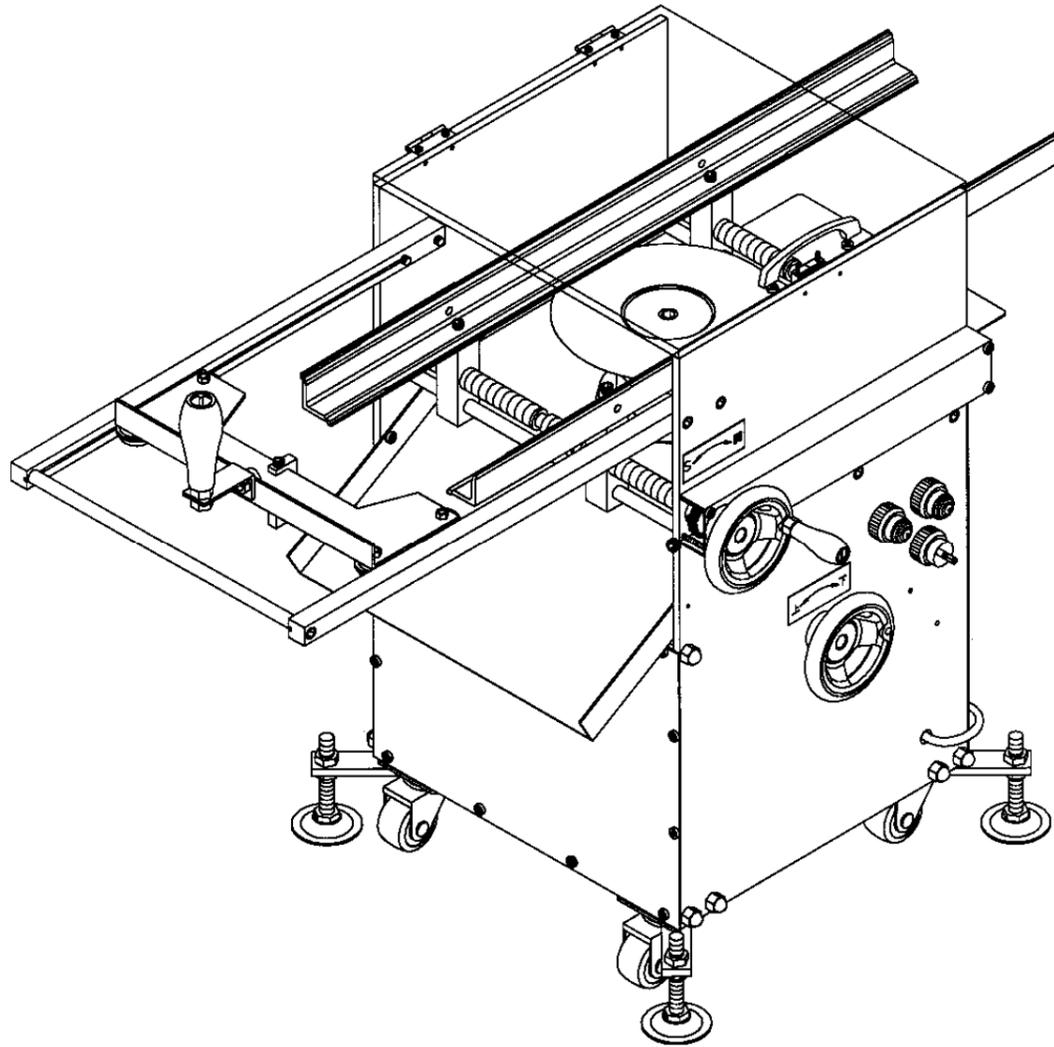


Manual PCB Lead Cutting Machine

KA-8



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KA-8 PCB Lead Cutter User's manual

A. KA-8 Brief introduction

1. The machine is designed to trim the wire leads of PCB assembly after soldering process.
2. The fast turning tungsten carbide blade cuts the wire leads while feeding the PCB one by one to the equipped track manually.
3. For safety, it is absolutely required to push the PCB assembly by handle.
4. This machine is for trimming the wire lead of electronics components only.

B. Spec and application range

1. Tungsten carbide blade: I.D 070mm,for both O.D 0200mm and 0250mm
2. PCB thickness: 0.8mm~2.0mm
3. PCB max width: 400mm(L) * 270mm(width)
4. Voltage: AC110 or 220V 50/60HZ (Note: Please specify in ordering)
5. Main spindle RPM: 4500rpm
6. min. leads height: 0.5mm
7. Main motor HP: 1/2HP

C. Adjustment and set-up the machine

1. Checking careful the power requirement of the machine and connecting to the power source.
2. Adjusting and fixed the 4 sets of shoe screw (41) to lift the 4 castors (45) until properly fixed to position.
3. Widening the tracks (38 . 39) by turning the hand wheel (65) for cutting blade installation.
4. Un-tighten the main spindle fix screw (53). Down the spindle(14) by turning the hand wheel (14).
5. Release the blade cover screw (50) and remove also the blade cover (15),Installing the blade after cleaning the shaft (14). Check the flatness of the blade in place. Tighten the screw while ready.
6. Adjusting the width of track (38.39) according the PCB that going to trim. Sliding / adjusting the PCB in the track until it moves smoothly.
7. Adjusting the cutting height - Raise slowly the spindle (14) by the hand wheel (42) until the blade reaches (38. 39) the tracks with no touching (Ensure by moving the blade). Tighten the main spindle screw (53) when ready.
8. Turn on the power switch (101). The blade is turning in regular cutting speed. Test for.3 minutes to see something improper if any. Trial cutting the PCB after the test.

D. Operation steps

- 1 Backward the push handle (32).
- 2 Feeding the PCB to the U slot in between the tracks of (38.39). Pushing the PCB manually forward by the handle.
- 3 Return the push handle (32) -> 2nd PCB as previous description to the position -> push forward the PCB to proceed the trimming operation.
- 4 Feeding 3rd PCB to the tracks and pushing the 2nd PCB. The 4th PCB → pushing the 3rd . The 5th PCB → pushing the 4th and so on
- 5 Measuring the height of cutting for the first PCB, Re-adjusting if necessary.
- 6 Pre-cut the irregular wire leads to lengthen the life of blade such as too hard material or diameter over 02mm.
- 7 Cutting more near to solder joints the better trimming quality will get. Such as the height of solder is in 0.5mm from the board and the best cutting height will be within 1mm over the solder joint. Keep cutting height within 1.5mm from end of lead to board will be the best.
- 8 The wire lead will possible tilt if the cutting height over 2.5mm from the board.

E. Waste cleaning

1. A waste can is suggested to place in beneath the chute 31 to collect the waste.
2. Cleaning first the chip or residues on the screw rod before adjusting the tracks.
3. Cleaning daily the machine especially the chip or leads after cutting.

F. Maintenance

1. Lubricate the 4 rollers in the push handle (32) to ensure moving smoothly.
2. Lubricate and cleaning the screw rods (6.7) and guide rod (8).
3. Cleaning the blade recess on the spindle (14) and blade cover in every blade replacement.
4. Lubricate the spindle bracket (11) and spindle bushing (13) to ensure height adjustment function.

G. Trouble shootings

- Adjusting the parallel of tracks

1. Adjusting the tracks (38 . 39) while the front/rear distance is not the same.
2. The track's open/close is by the synchronous motion of screw rod (6 . 7) that move by the chain 44.
3. The screw rod (6 . 7) will move in the same time while turning the hand wheel and the track (38. 39) will

open /close also.

4. It is necessary to adjust the parallel if any one of the screw rods is not move while turning the hand wheel (65).
5. The main reason to cause the un-parallel tracks is because of chip or residues block the screw rods.

Adjustment steps

1. Two chain wheel (28) locate beside the screw rod (7.8) which move by the chain (44)
2. Release two screws (68) on the chain wheel and keep the alien-key on the screw socket to prevent the moving of chain wheel (28).
3. The front screw and front of track moving only while turning the hand wheel. Adjusting until the track is parallel as required. Tighten the screws released.
4. The mentioned parallel adjustment is in the principle of one fix and one move.

Parallel between blade and tracks

1. The height of the wire leads will be different after cutting if un-parallel between the track and blade.
2. The parallel between cutting blade and the tracks can be adjusted by spindle bracket (11).
3. Adjust the parallel by four down side screws (51) on the spindle bracket (11) and 8 up side screws (52).
4. Underlay with a sheet of material such as name card if minor variance only. It is a quick solution for minor adjustment.

H. Service and technical support

1. Please copy the sketch on the manual that unclear or question.
2. Descript the question and contact us by Fax. We'll reply you very soon.
3. For spare parts requirement, please ordering by fax in which specified part number or indicate by sketch.
4. Welcome your inquiry for any question if unclear

Maintenance and technical support.

Please copy the sketch on the manual for further questions. For spare parts requirement, please ordering by fax in which specified part number or indicate by sketch. Welcome your inquiry for any question if unclear!

Part List

Part No.	Part name	Figure	Part No.	Part name	Figure
1	Right wall	Fig-4	51	Screw - Spindle	Fig-2
2	Left wall	Fig-5	52	Screw - Spindle bracket	Fig-2
3	Middle frame	Fig-2	53	screw - Spindle bushing	Fig-2
4	Support sq bar	Fig-5	54	Belt - triangle	Fig-3
5	Castor fix rod	Fig-5	55	Motor	Fig-3
6	Front screw rod	Fig-5	56	Screw	Fig-3
7	Rear screw rod	Fig-5	57	Nut -	Fig-3
8	Sliding rod	Fig-5	58	Nut - support	Fig-3
9	track left base	Fig-5	59	Nut - main screw	Fig-3
10	Track right base	Fig-5	60	Nut - hex bar	Fig-3
11	Main spindle bracket	Fig-2	61	Screw - motor pully	Fig-3
12	Bearing cover	Fig-2	62	Screw - motor pully	Fig-3
13	Spindle bushing	Fig-2	63	Screw - handle	Fig-4
14	Blade shaft	Fig-2	64	Nut -handle	Fig-4
15	Blade cover	Fig-2	65	Hand wheel -track	Fig-4
16	Motor pully	Fig-3	66	Screw - hand wheel	Fig-4
17	Shaft pully	Fig-3	67	Screw - chain cover	Fig-4
18	Blade lift bracket	Fig-3	68	Screw - chain wheel	Fig-4
19	Lift bracket shaft	Fig-3	69	Bearing - 6304	Fig-2
20	Lift bracket screw	Fig-3	70	Bearing 28mm dia	Fig-5
21	Cover	Fig-3	71	Screw	Fig-5
22	Hex spacer bar	Fig-3	72	Screw - fix motor	Fig-5
23	Screw- blade lift	Fig-3	73	Screw- middle from	Fig-5
24	Left triangle bracket	Fig-3	74	Screw - castor	Fig-5
25	Right triangle bracket	Fig-3	75	Nut -Motor	Fig-5
26	Push handle square R	Fig-6	76	Nut	Fig-5
27	Push handle round sh	Fig-6	77	Screw - track	Fig-6
28	Chain wheel	Fig-4	78	Screw - push handle	Fig-6
29	Push handle	Fig-6	79	Screw - castor	Fig-6
30	Roller	Fig-6	80	Nut - rollor	Fig-6
31	Waste chute	Fig-6	81	Push handle	Fig-6
32	Push handle bracket	Fig-6	82	Screw - push handle	Fig-6
33	Push handle frame	Fig-6	83	Nut -push handle	Fig-6
34	Chain cover	Fig-4	84	Screw	Fig-6
35	Front cover	Fig-6	85	Nut	Fig-6
36	Rear cover	Fig-4	86	Screw	Fig-6
37	Outlet holder	Fig-4	87	Screw	Fig-6
38	Left track	Fig-6	88	Screw - Chute	Fig-6
39	Right track	Fig-6	89	Screw	Fig-6
40	Shoe screw bracket	Fig-5	90	Hinge -Acylic cover	Fig-7
41	Shoe screw bracket	Fig-7	91	Acylic cover	Fig-7
42	Spindle Hand wheel	Fig-4	92	Handle	Fig-7
43	Handle hand wheel	Fig-4	93	Door closer (M)	Fig-7
44	Chain	Fig-4	94	Door closer (F)	Fig-7
45	Castor	Fig-5	95	Screw	Fig-7
46	Tungsten carbide blad	Fig-2	96	Screw	Fig-7
47	Bearing - 6205	Fig-2	97	Screw	Fig-7
48	Spindle fix screw	Fig-2	98	Nut	Fig-7
49	Screw	Fig-2	99	Rad lamp	Fig-7
50	Screw - Blade cover	Fig-2	100	Green lamp	Fig-1
			101	On /Off switch	Fig-1

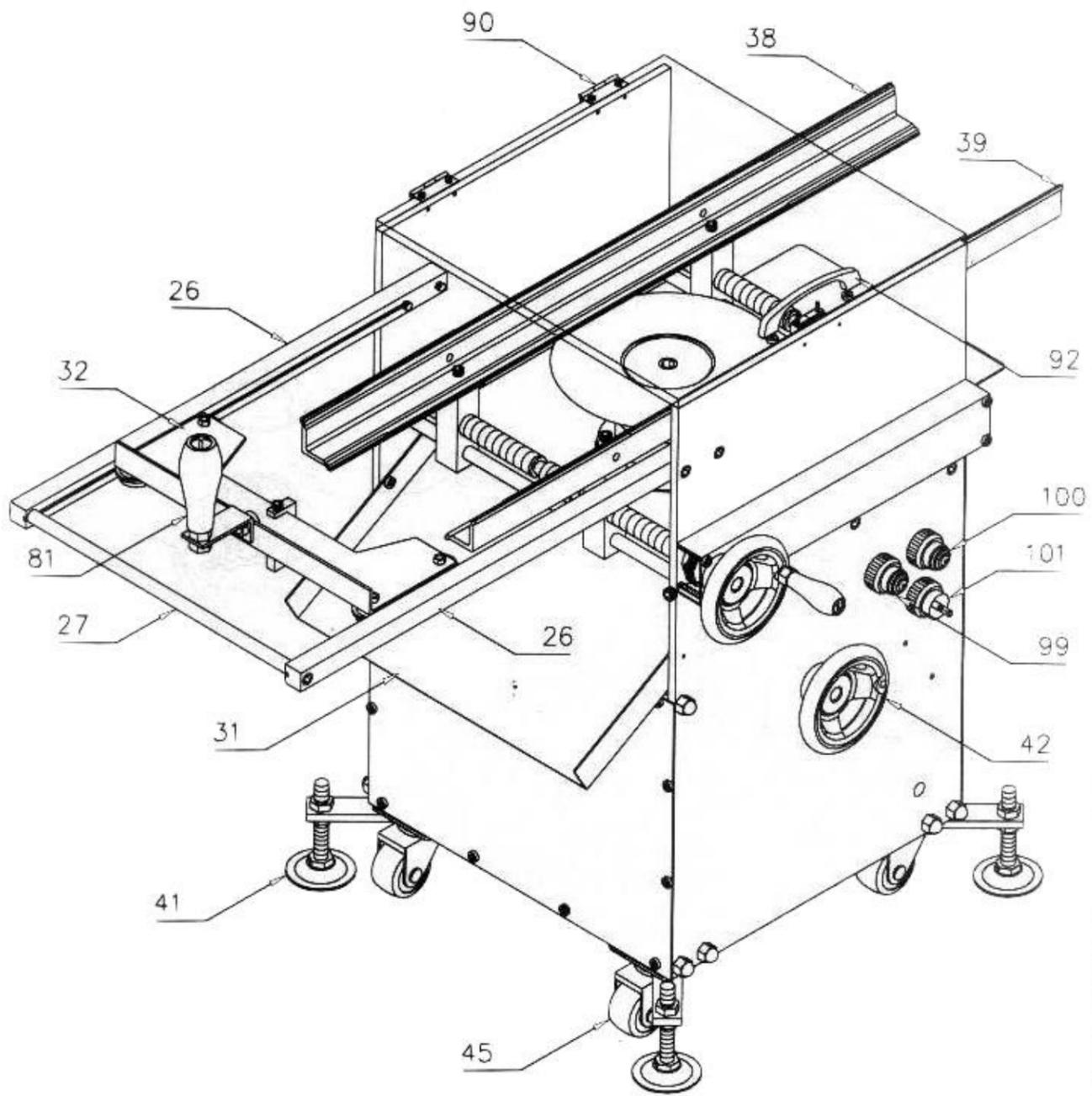


FIG-1

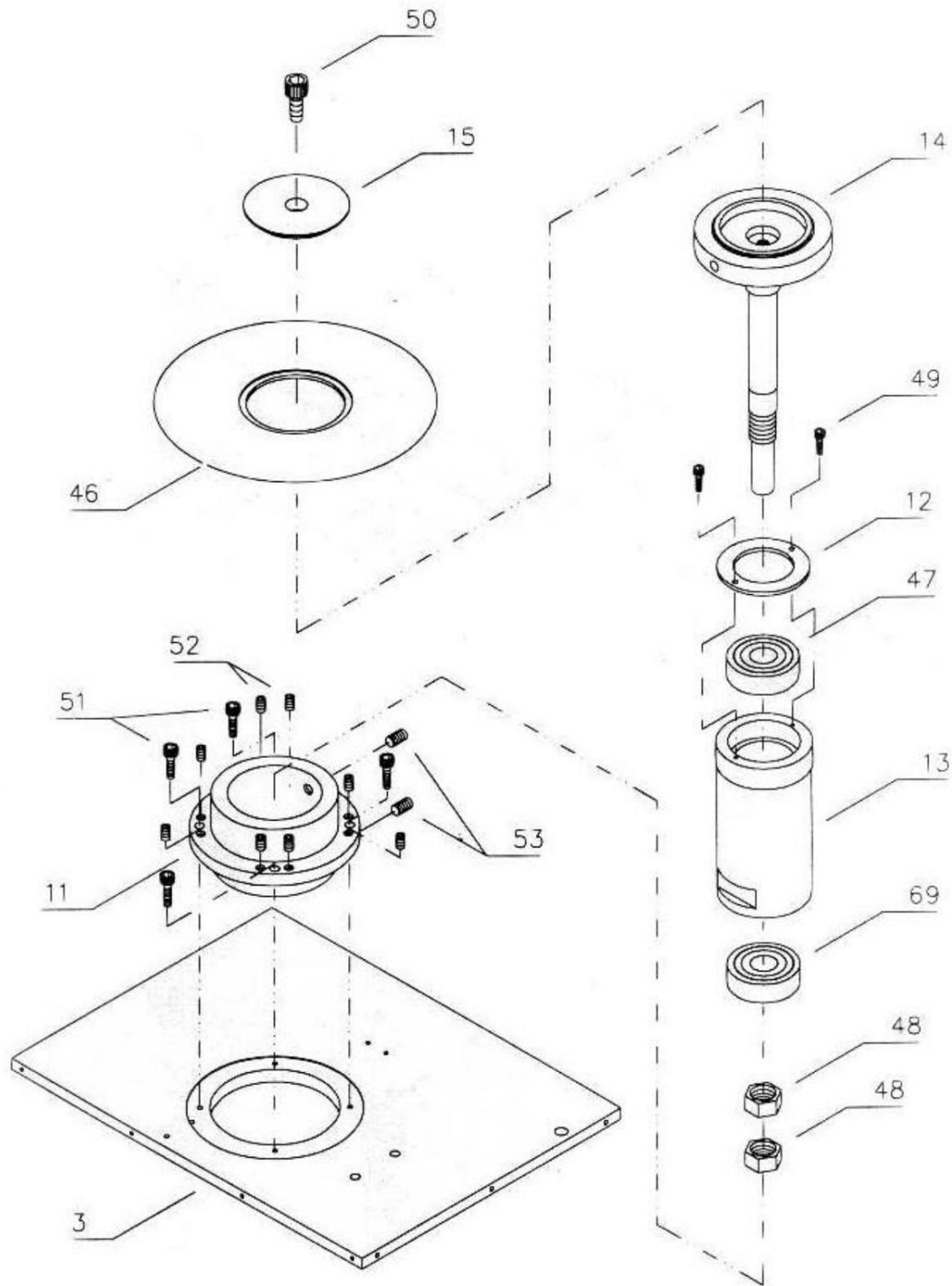


FIG-2

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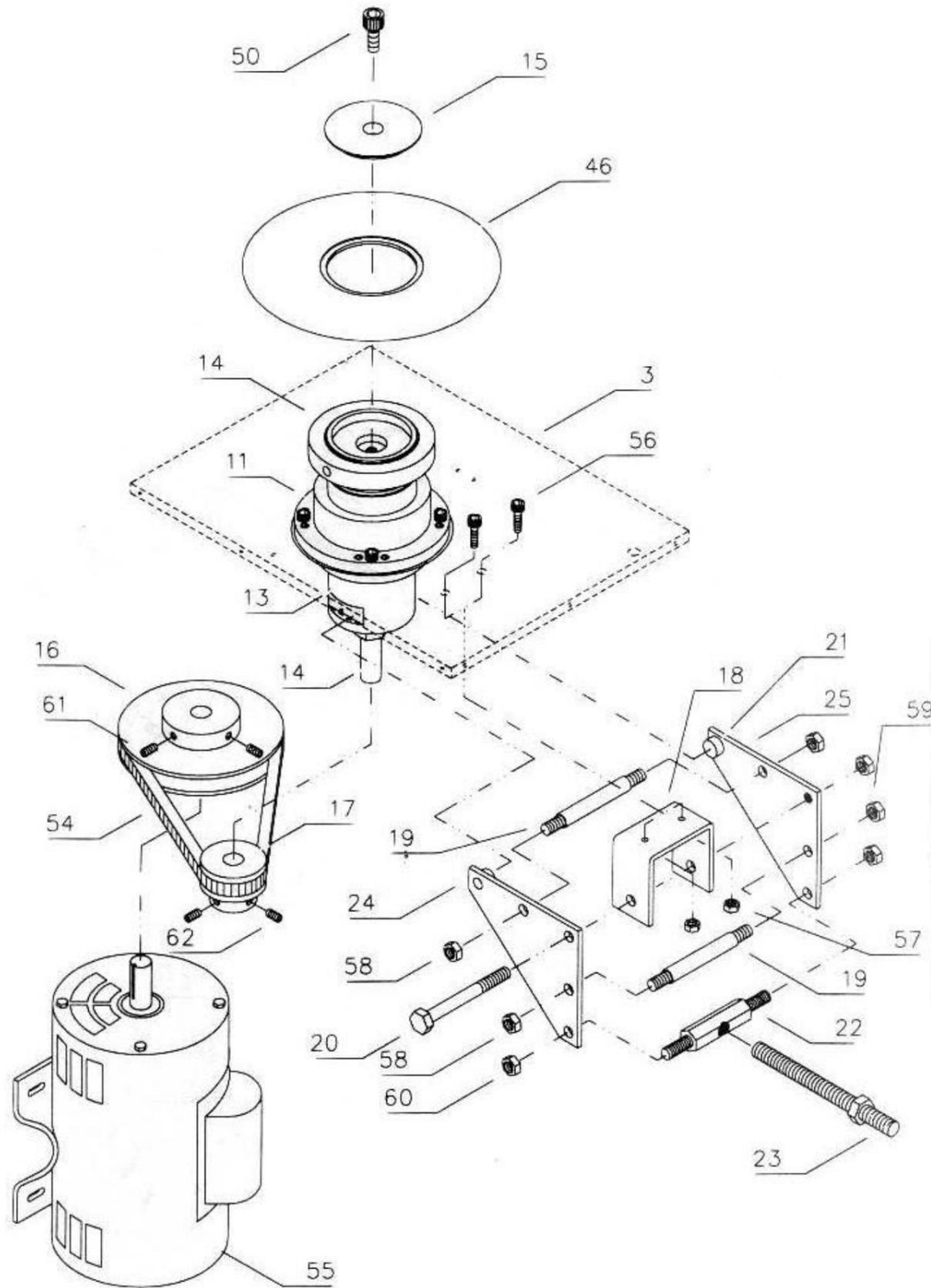


FIG-3

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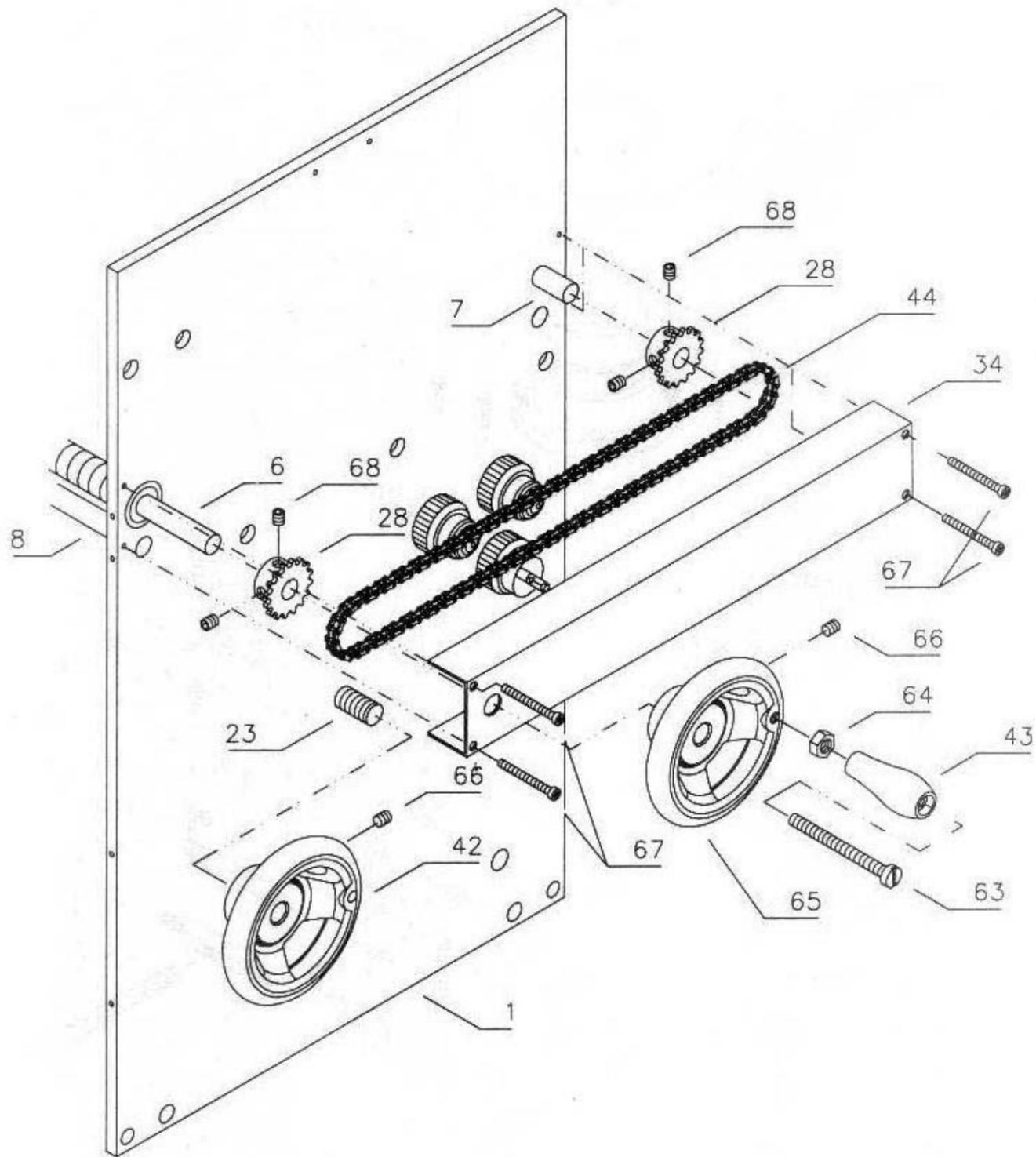


FIG-4

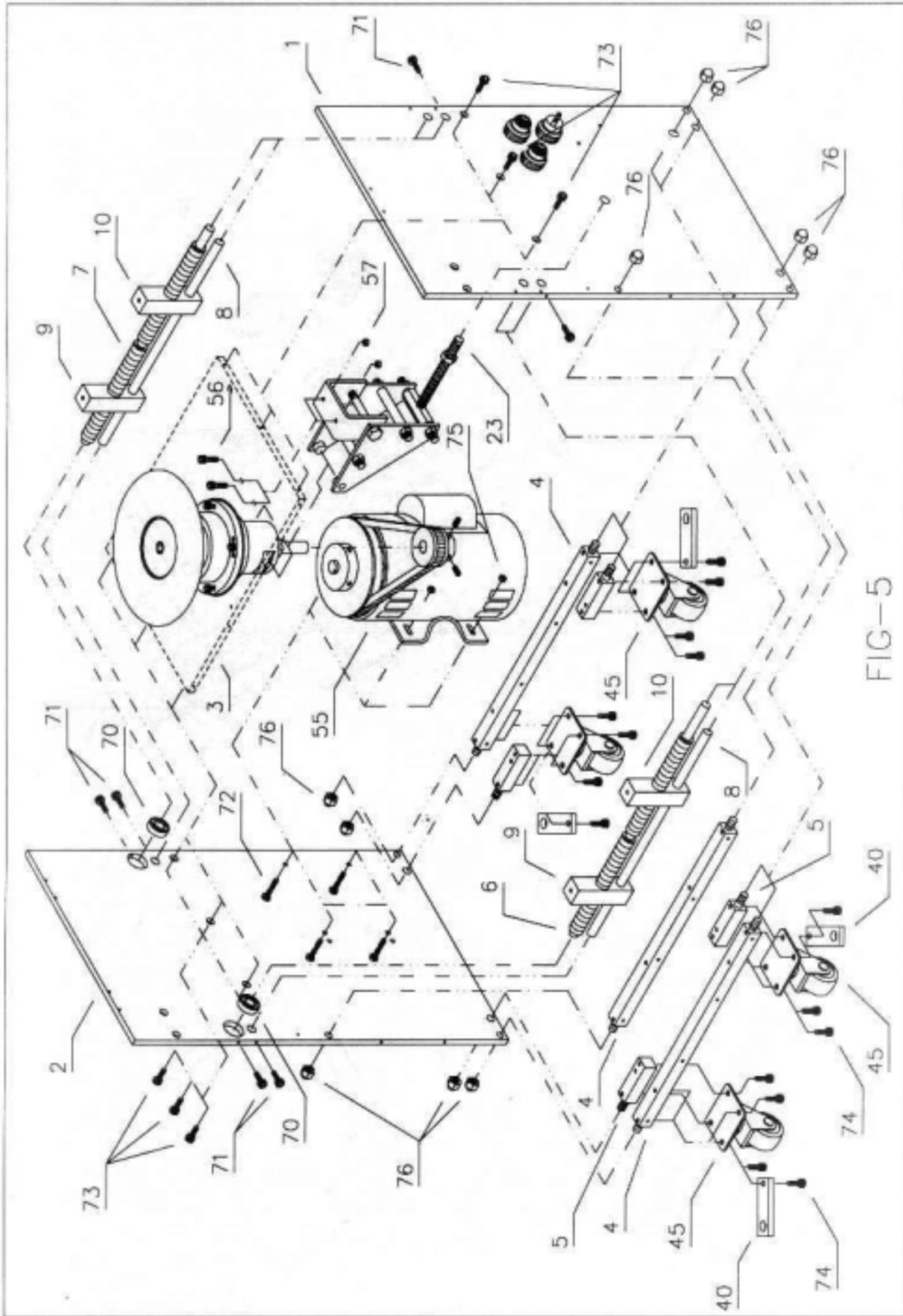


FIG-5

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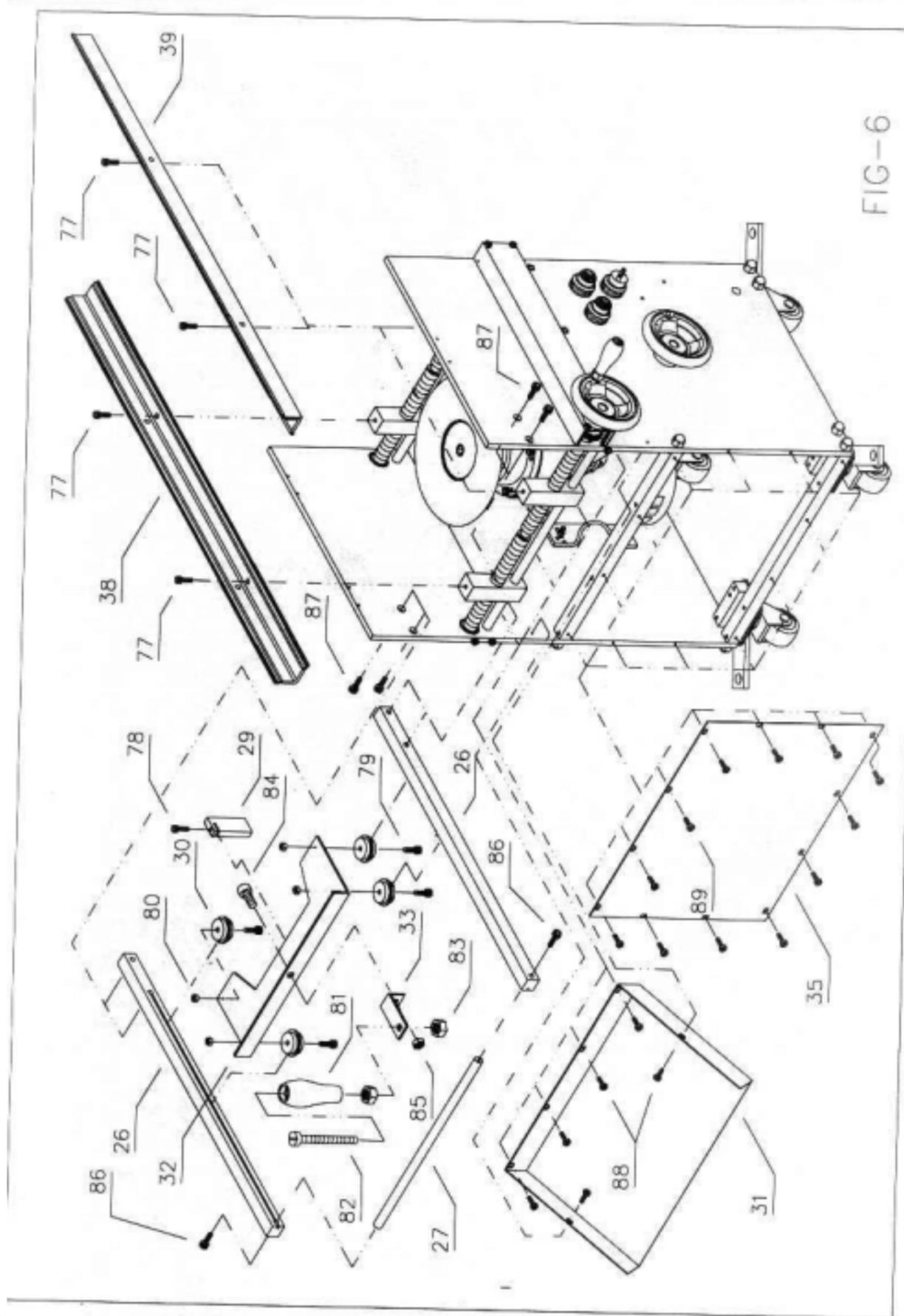


FIG-6

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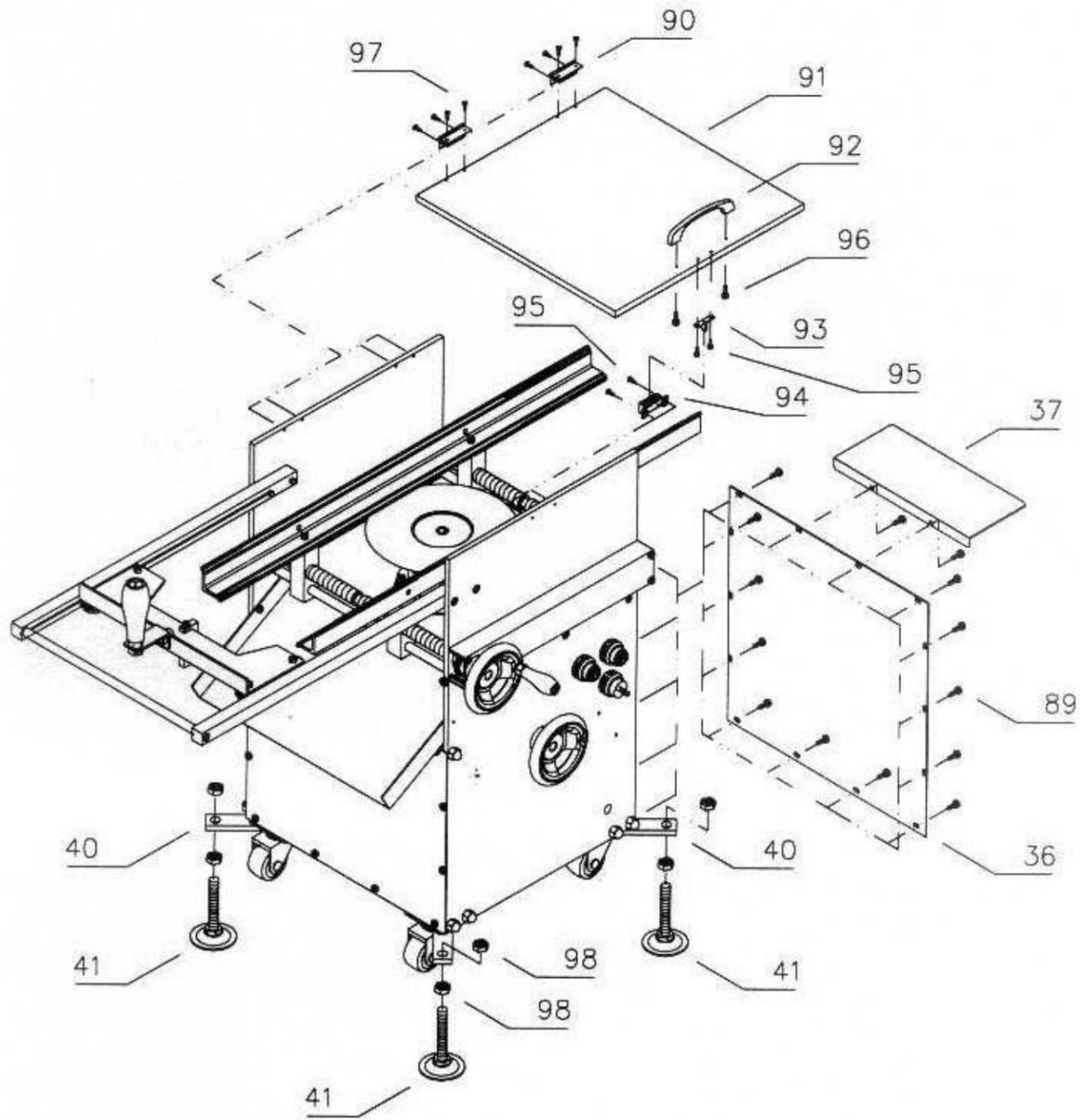


FIG-7