

OPERATION MANUAL

ASF-1 AUTO SNAP FASTENING M/C



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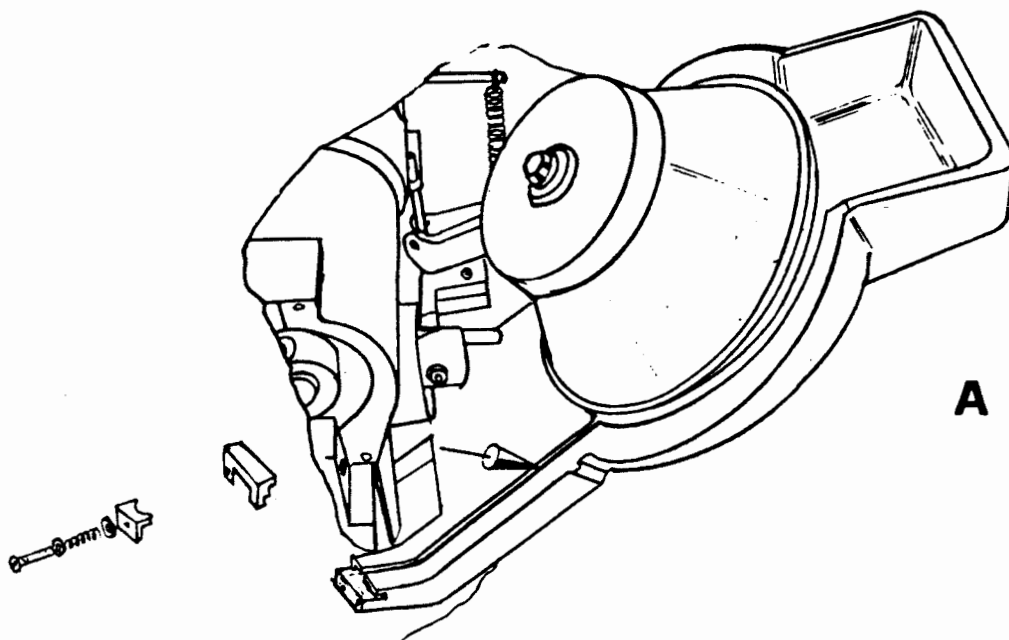
* NOTICE :

FOR SAFETY SAKE PLEASE MAKE SURE TO SHUT OFF THE POWER SWITCH
(SOURCE OFF) WHEN THE MACHINE ARE IN TROUBLE OR UNDER REPAIR.

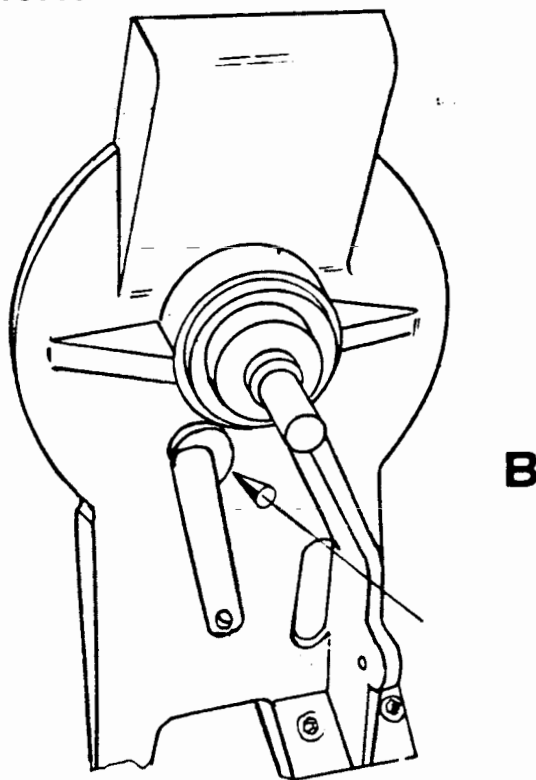
1. Before operation, do clear all the foreign matters and the damaged or distorted buttons in both the left and right hoppers as shown in the Drawing A and B.
2. According to the respective button indicated on the hopper base covers, put the proper buttons into the hoppers.
3. Turn the hoppers to make the buttons dropping into rails until the rails are full with the fallen buttons.
4. Turn on the power source.
5. Step the clutch pedal, by which the upper and lower buttons are pushed to their expected points respectively.
6. Set the article which need to be fastened on the work bench, and then step the clutch pedal again, thus making the upper and lower buttons fixed on the article. When the work bench is not used, turn it to the position as shown in the Drawing "D".
7. Continuously step the clutch pedal, and the work will be going on.
8. Upon completion of the work, just turn off the power source.
9. Pay attention to lubricating the machine everyday.
10. Before off-duty time, cover up the machine with its dust-proof cover to get rid of dust from obstructing the rails.
11. During transporting, please tightly hold the machine handles (as shown at "Y" in the Drawing D) at the same time and make sure the M/C uprightly moved in order to get the M/C free from damage.
12. If any component parts of machine damaged, please show our company the parts series numbers for replacement.

INSTRUCTIONS ON OPERATIONAL REGULATION AND TROUBLESHOOTING

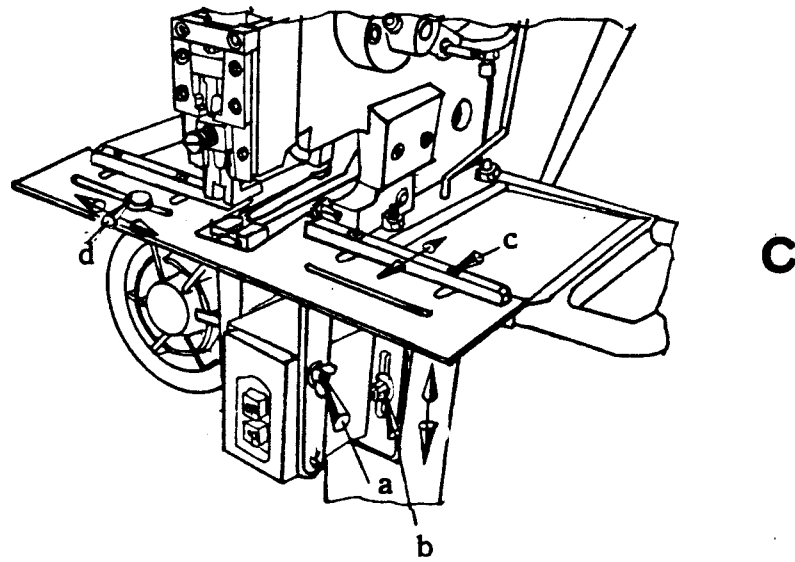
When you clear foreign matters or dust from the hopper rails, please remove the guide block (626) and the stop slide (627) first, and then use a small screw driver covered with clean cloth or rag to clean.



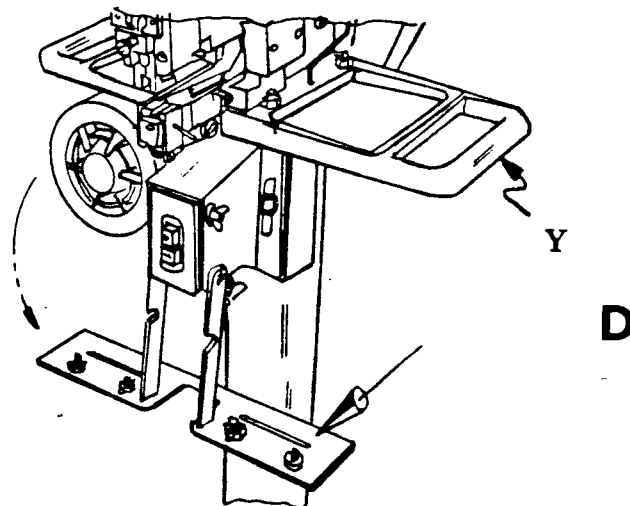
When you clear foreign matters, distorted buttons or change buttons, please remove the spring plate (621) and the plug (620) to undertake the clearing process.



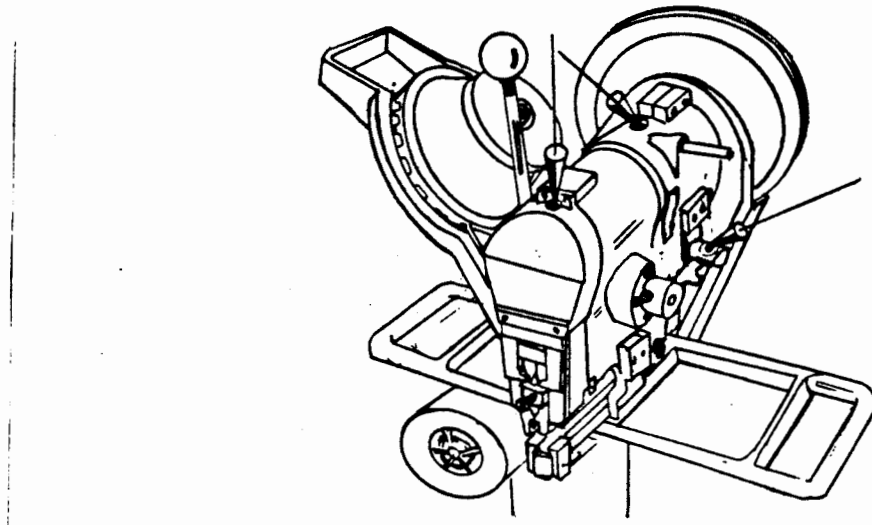
1. After you set the work bench, please tighten the butterfly nut "a".
2. When you want to adjust the height of the work bench, at first, loosen the bolt "b" to move the work bench to a proper position, and then tighten it.
3. If you want to adjust the throat depth, please loosen the bolt "c" to a proper position and then tighten it.
4. When you adjust the gauge between two buttons, please, at first, loosen the positioning bolt as shown in Drawing "D" to the required size, and then tighten the bolt.



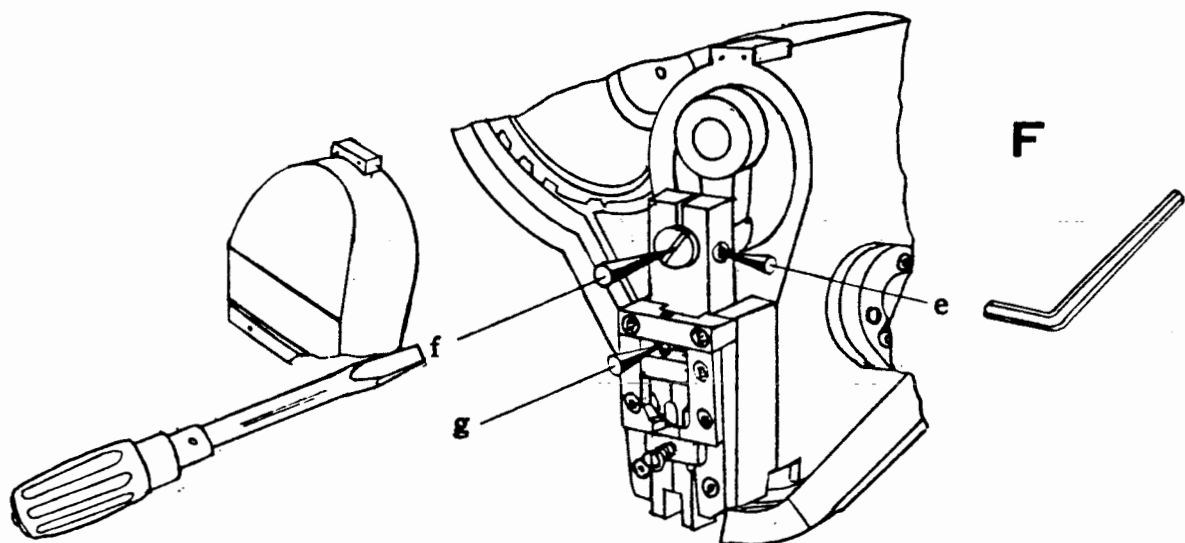
When it is no need to use the work bench, please loosen the butterfly nut (809) as shown in the Drawing "C" to sent down it.



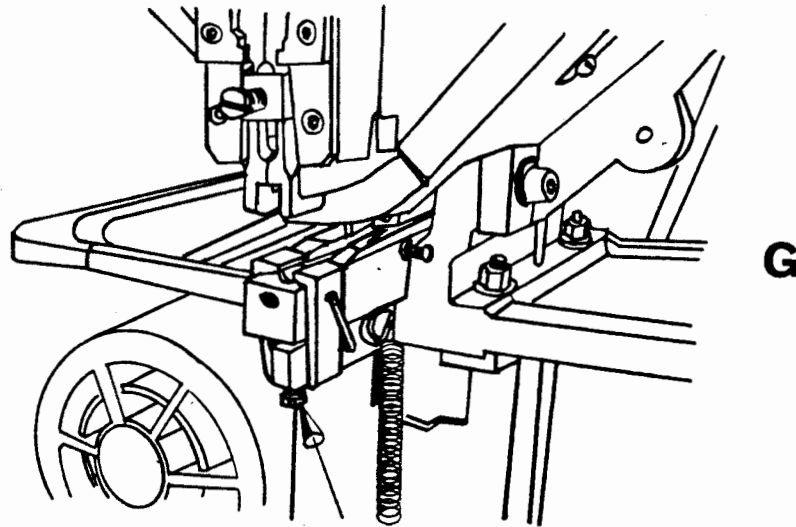
There are three lubricating oil inlets. Please add a little engine oil to lubricate the machine.



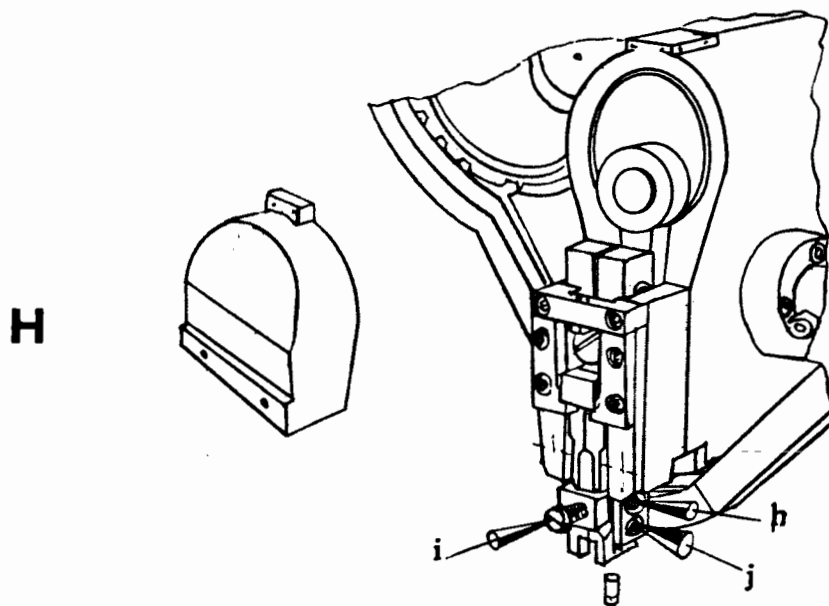
1. Sometimes you get the articles with different thickness. If the gap between the upper and down button is larger than the thickness, the buttons will easily fall or even can't even be fastened. On the other hand, if it is smaller, the buttons will be fastened tightly enough to be distorted or damaged. When it happens, please use a 6 mm. L-type wrench to loosen the round head bolt "e", and then use a screw driver to adjust the eccentric adjustment bar "f" (402) until the upper attaching die (403-1) get the proper gap. NOTICE : Please do remember to fix 'e' screw tightly.
2. It is found that the buttons drop to ground or obstruct when the upper button is fallen between the upper finger. please open the acrylic cover. And then adjust the upper finger by turning the screw "g". NOTICE : When you do the adjustment , please turn off the power source, and step the clutch pedal in order to slowly check it by hand-turning the pulley.



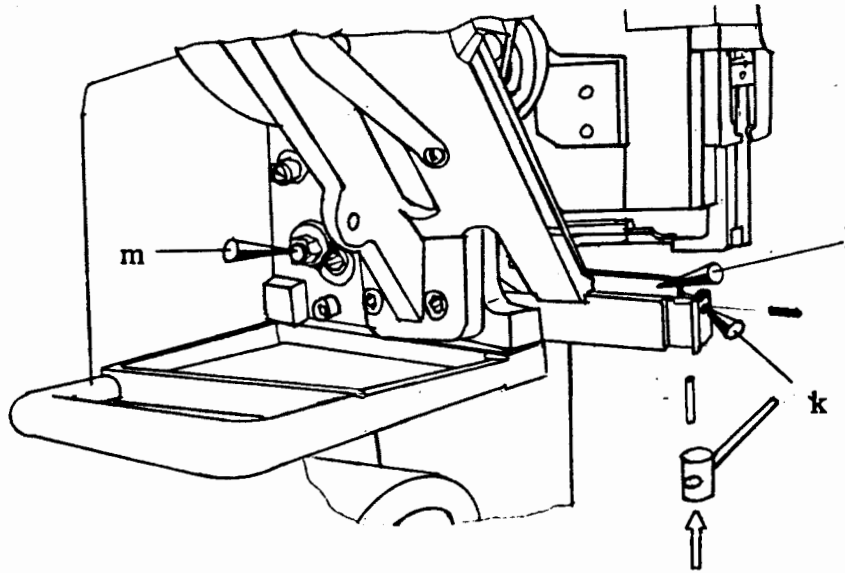
When the down button is easily obstructed or to drop, please move the lower fingers to the proper position by adjusting the bolt shown as the Drawing "G". NOTICE : When you do the adjustment, please do turn off the power source, and step the clutch pedal in order to slowly check it by hand-turning the pulley.



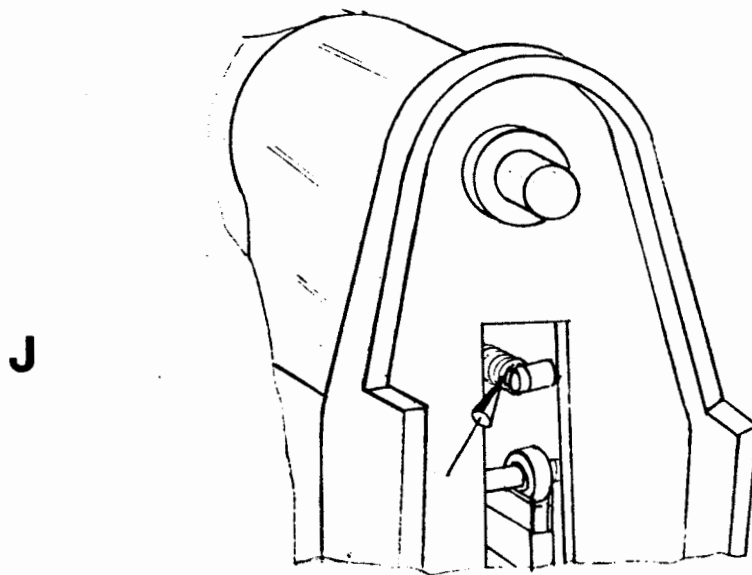
1. When you find the buttons can't get through the article well or the upper and down buttons can't be fastened straightly to the center, please do the adjustment as the behind steps. Firstly, turn off the power source. Secondly, step the clutch pedal and turn the pulley by hand to make the upper finger (407) to get down to the lowest place slowly. Thirdly, loosen the screw "h" (NOTICE : Hold the eccentric adjustment bar to avoid it coming out.) Finally, turn screw "i" to adjust the upper finger (407) on the proper position, and then tighten screw "h".
2. When the upper finger gets up to the different points, please clean the oil stain between the slopes.
3. If you need to change the upper attaching die, please loosen screw "j" to do it.



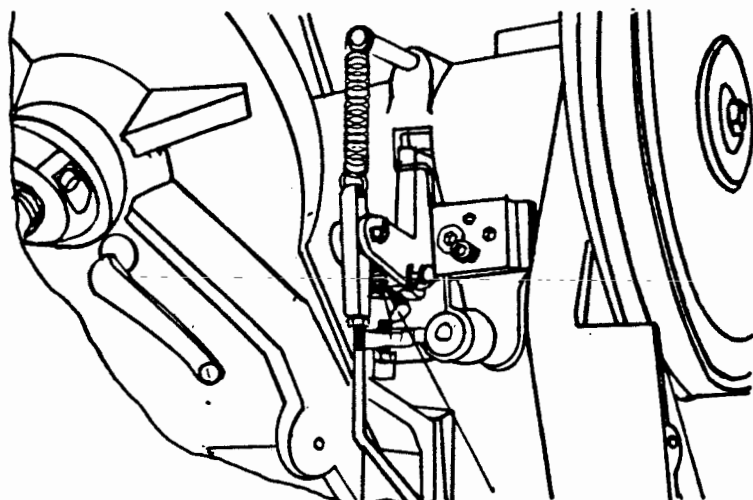
1. When you find the distorted button cap occurred, please loosen the screw "k" to take it out with a wooden hammer.
2. When you find the pusher "l" can't have the snap to the right position, please check the rubber tube inside "m" and the spring shown on the Drawing "J" whether they are worn out. If you want to check the above pusher, please turn off the power source, and step the clutch pedal in order to slowly check it by hand-turning the pulley.



When you find the spring are worn out, you have to change a new one. Take the belt base (320) and pulley and pulley (316) away to change it. NOTICE : Don't lose the pin (315).

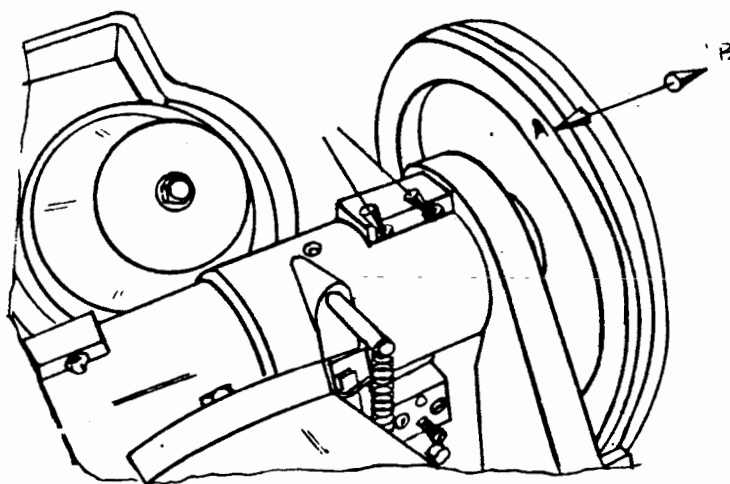


If the clutch (308) is out of order, please check the spring shown as below whether it is worn out.



K

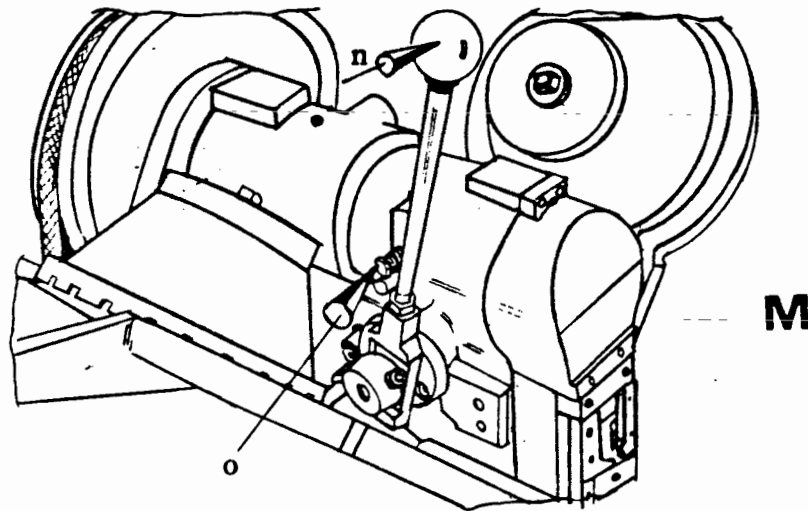
After you have checked the above spring and have found it is all right, the clutch still can't run or there are still some noise during process. At the moment, please loosen these two screws, and strike with a wooden hammer according to the direction of the "A --- B" arrow.



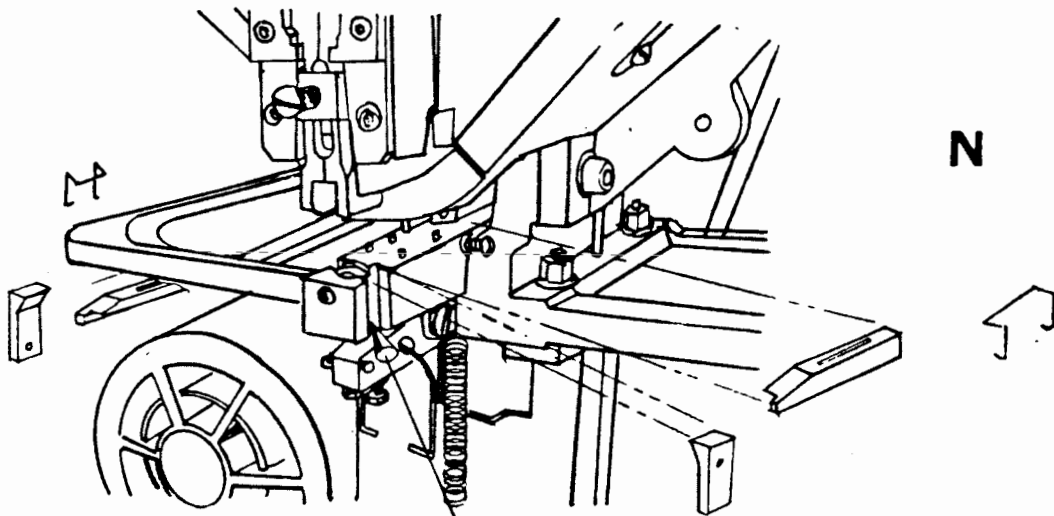
L

The pusher (205) is obstructed during process, please pull the handler "n" to clear the button.

When the buttons are easily dropped out, please turn off the power source, and step the clutch pedal in order to slowly check it by hand-turning the pulley. If they come out too quick to be hold due to pusher, please tighten screw "o" a little. NOTICE : 1. Just a little, or the motor can't run the pulley. 2. The new machine should be done this step after operating 6 days.

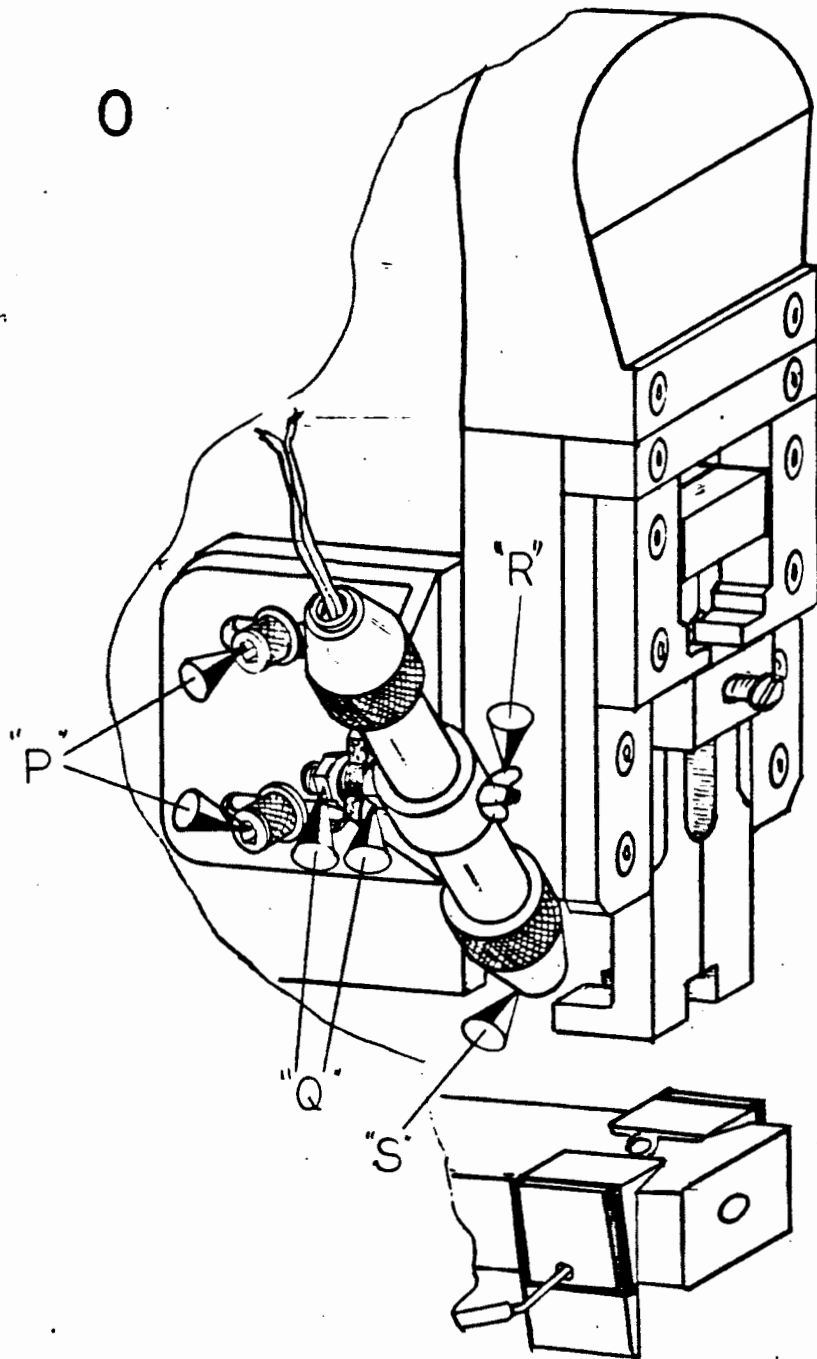


Take away the spring slip (217, 218 and 213) to clean the lower fingers (211, 212) and guide blocks (214, 215) every day.



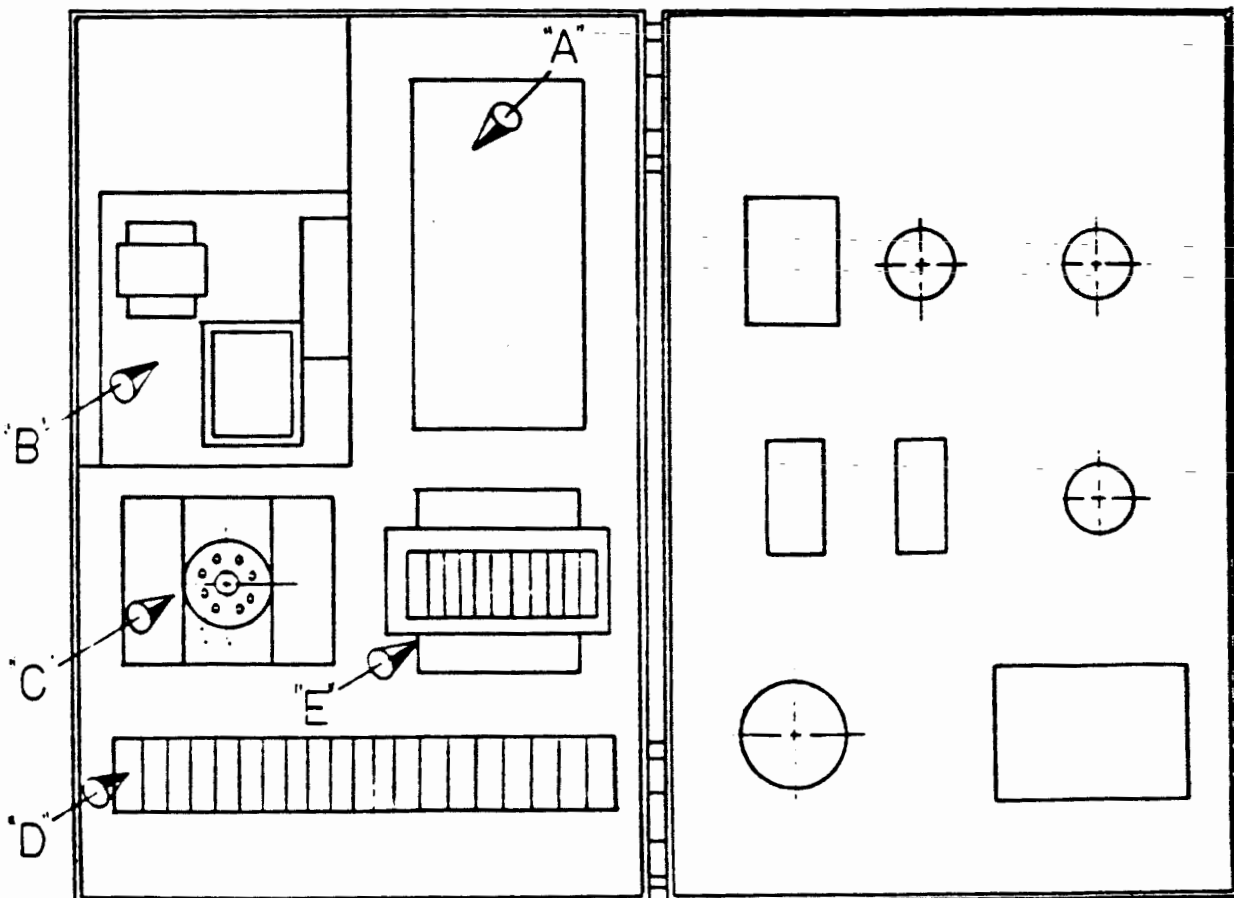
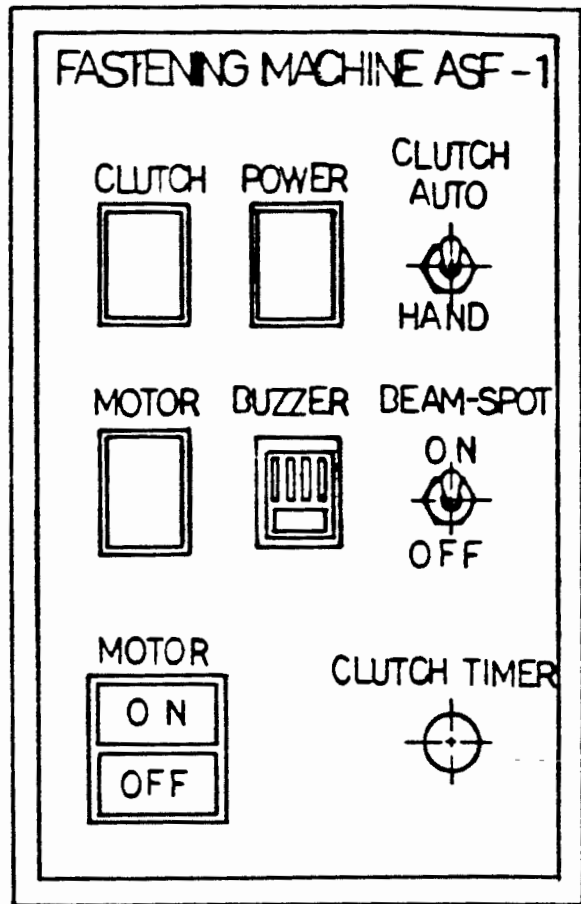
BEAM SPOT

- P. FRONT & REAR ADJUSTER
- Q. RIGHT & LEFT ADJUSTER
- R. UP & DOWN ADJUSTER
- S. FOCUS ADJUSTER



- A MAGNETIC S.W
- B TIMER S.W
- C TOUCH S.W
- D TERMINAL BOARD
- E TRANSFORMER

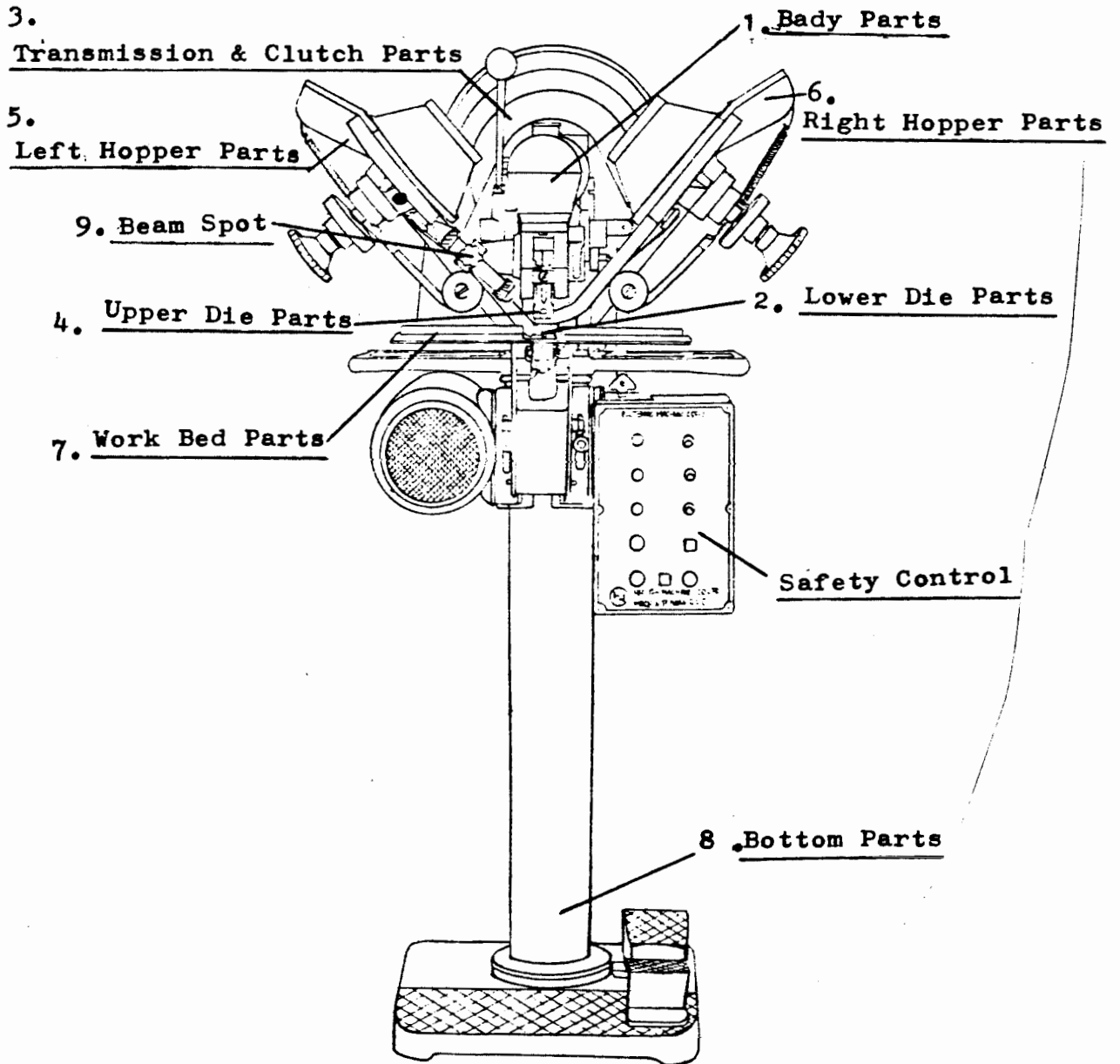
- * POWER SOURCE: SINGLE PHASE
240V 50HZ
- * MOTOR: 1/3 HP
- * MAGNETIC: 3 KGS



零件部品目錄

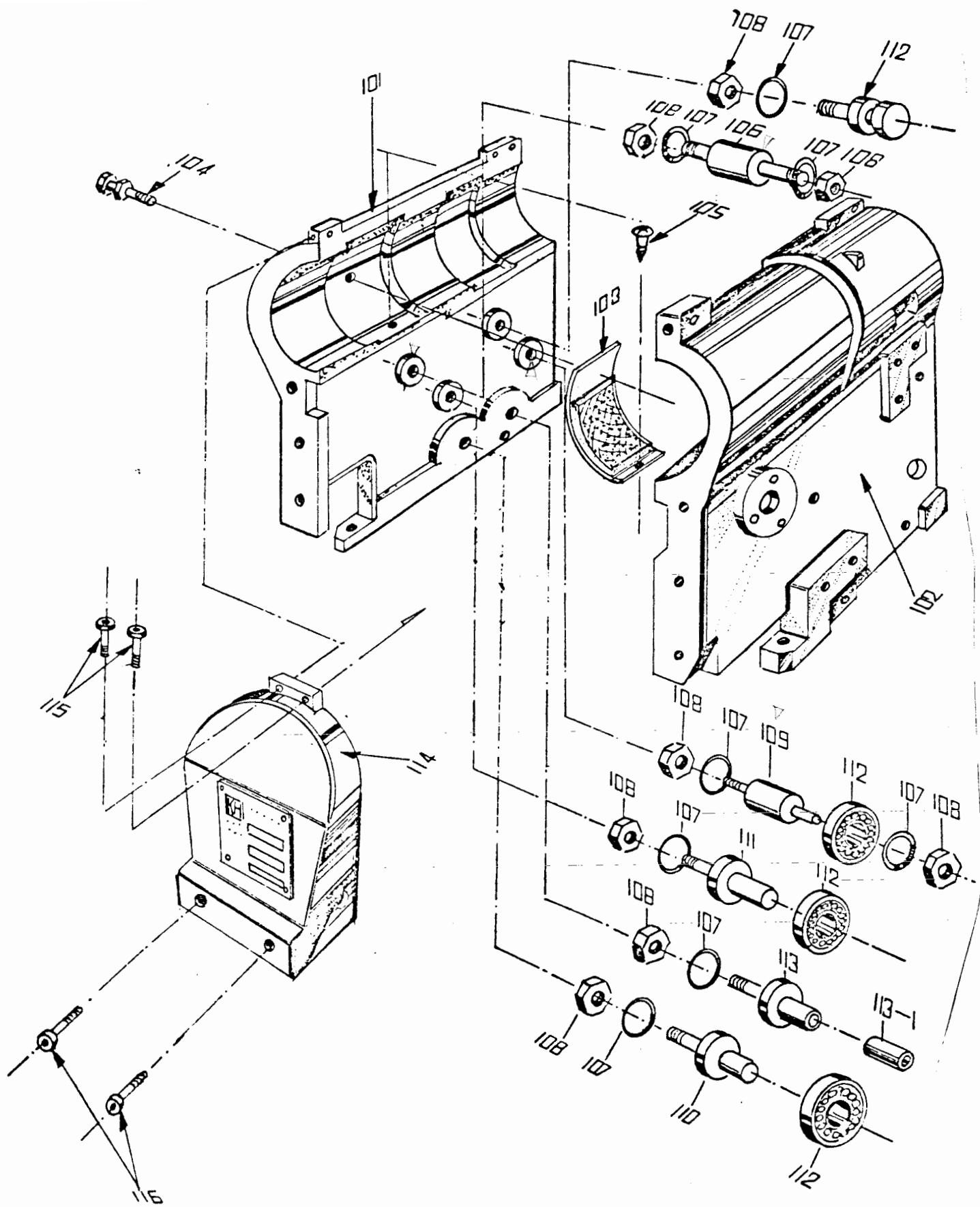
PARTS LIST

號	號	名	稱
ASSEMBLY NO.			DESCRIPTION
1:101 ~ 116		Body Parts	機體零件
2:201 ~ 231		Lower Die Parts	下模零件
3:301 ~ 314		Transmission & Clutch Parts	傳動及離合器零件
4:401 ~ 419		Upper Die Parts	上模零件
5:501 ~ 529		Left Hopper Parts	左料斗零件
6:601 ~ 649		Right Hopper Parts	右料斗零件
7:701 ~ 706		Work Bed Parts	工作床零件
8:801 ~ 839		Bottom Parts	底座零件
9:901 ~ 913		Beam Spot	聚光燈部位



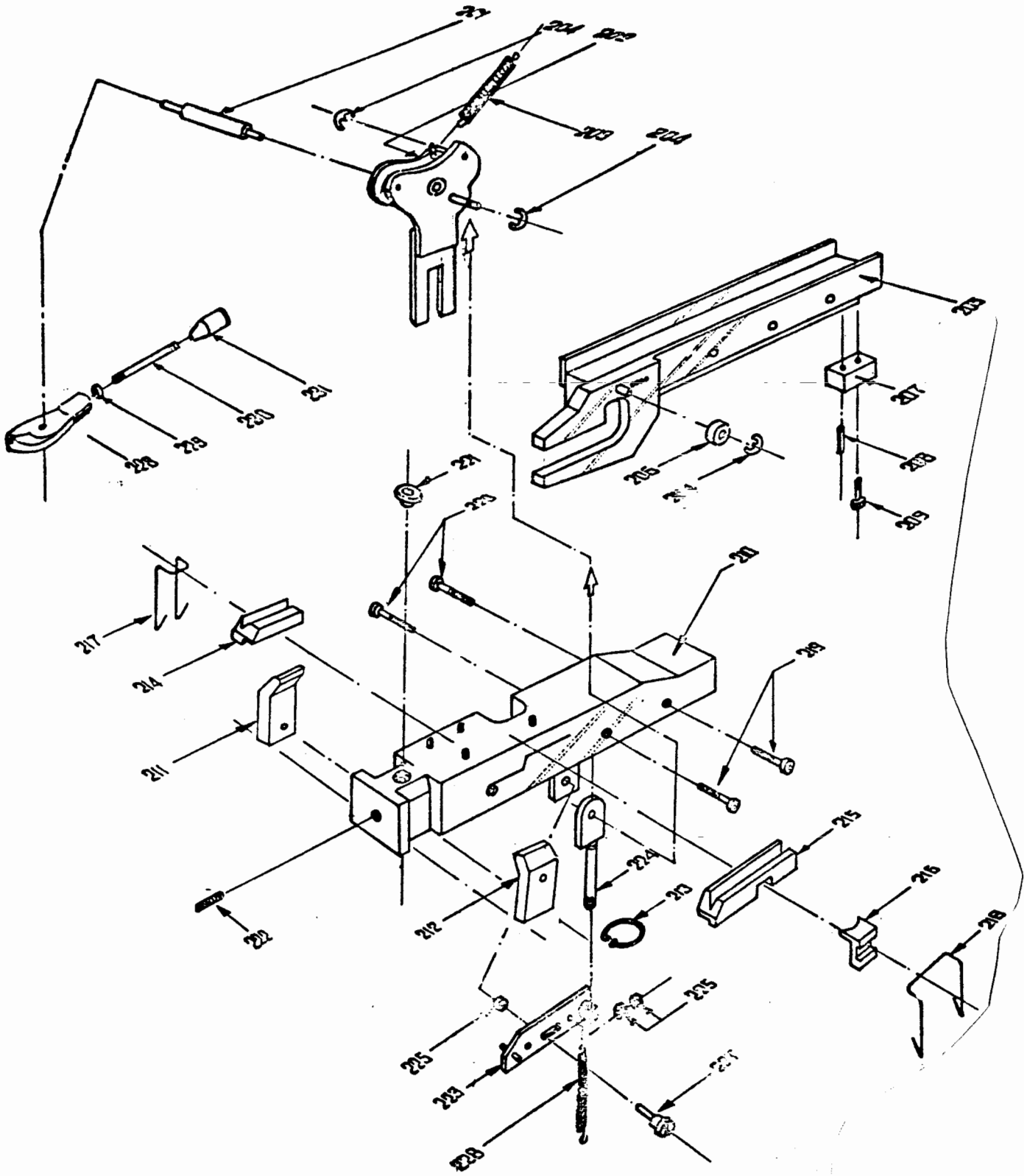
機體部品
BODY PARTS

編 號	數 量	名 稱
CATALOG NC	QUANTITY	DESCRIPTION
101	1	Left body 左車體
102	1	Right body 右車體
103	1	Brake band 剎車帶
104	1	1/4" x 2" Hexagon head bolt & nut 六角螺絲附螺母
105	1	3/16" x 3/8" Raised head bolt 十字頭螺絲
106	1	Through bolt 雙頭螺桿
107	8	Washer 墊圈
108	8	3/8" Nut 螺母
109	1	Eccentric adjustment bar 偏心調節桿
110	1	Eccentric adjustment bar 偏心調節桿
111	1	Eccentric adjustment bar 偏心調節桿
112	3	Bearing 軸承
113	1	Eccentric adjustment bar 偏心調節桿
113-1	1	Rubber tube 橡皮套管
114	1	Cover & Mark
115	2	5/32" x 3/4" Round head bolt 圓頭螺絲
116	2	3/16" - 1 3/4" Round head bolt 圓頭螺絲



下模座部品
LOWER DIE PARTS

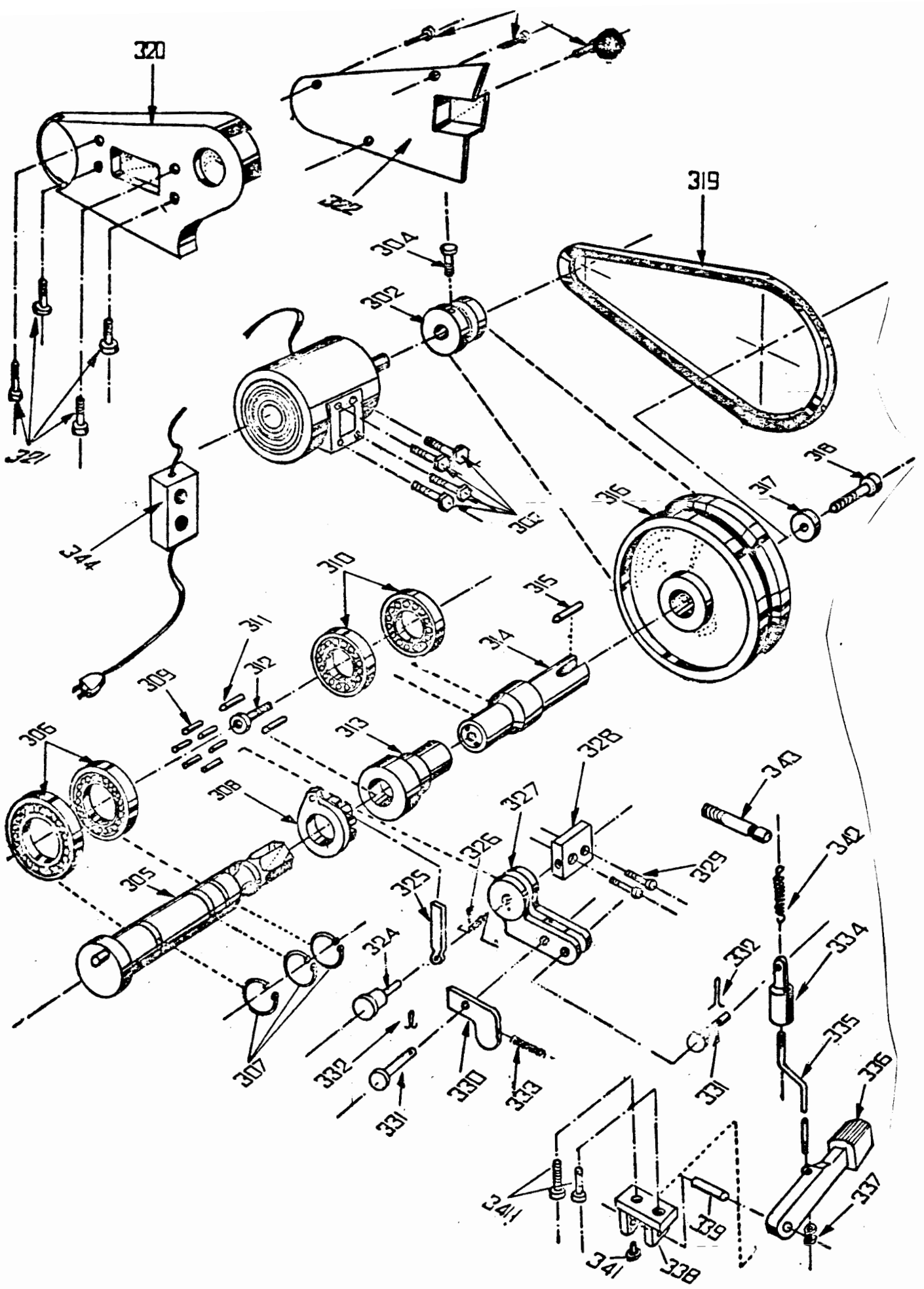
編 號	數 量	名 稱
CATALOG NO.	QUANTITY	DESCRIPTION
201	1	Through ^{roller} bolt 雙頭螺桿 <i>THROUGH ROLLER BOLT</i>
202	1	Pusher arm 搖臂
203	1	Spring 彈簧
204	3	Snap ring 扣環
205	1	Pusher 送料桿
206	1	<i>COLLAR</i> 軸環
207	1	Tie plate 固定塊
208	1	Spring pin 彈簧梢
209	1	3/16" x 1" Round head bolt 圓頭螺絲
210	1	Lower die base 下模座
211	1	Left lower finger 左下扣夾
212	1	Right lower finger 右下扣夾
213	1	Spring clip 彈簧夾
214	1	Left guide block 左導塊
215	1	Right guide block 右導塊
216	1	Stop slide 控制塊
217	1	Spring slip 彈簧夾
218	1	Spring slip 彈簧夾
219	2	5/16" x 3/4" Round head bolt 圓頭螺絲
220	2	5/16" x 3/4" Round head bolt 圓頭螺絲
221	1	Lower attaching die 下模
222	1	1/4" Set bolt 止付螺絲
223	1	Lower finger base 下鈕扣夾座
224	1	Link rod 連桿
225	3	1/4" Nut 螺母
226	1	Spring 彈簧
227	1	Bolt 螺栓
228	1	Handle base 手柄座
229	1	3/8" Nut 螺母
230	1	Handle lever 手柄
231	1	Handle head 手柄頭



傳動及制動部品

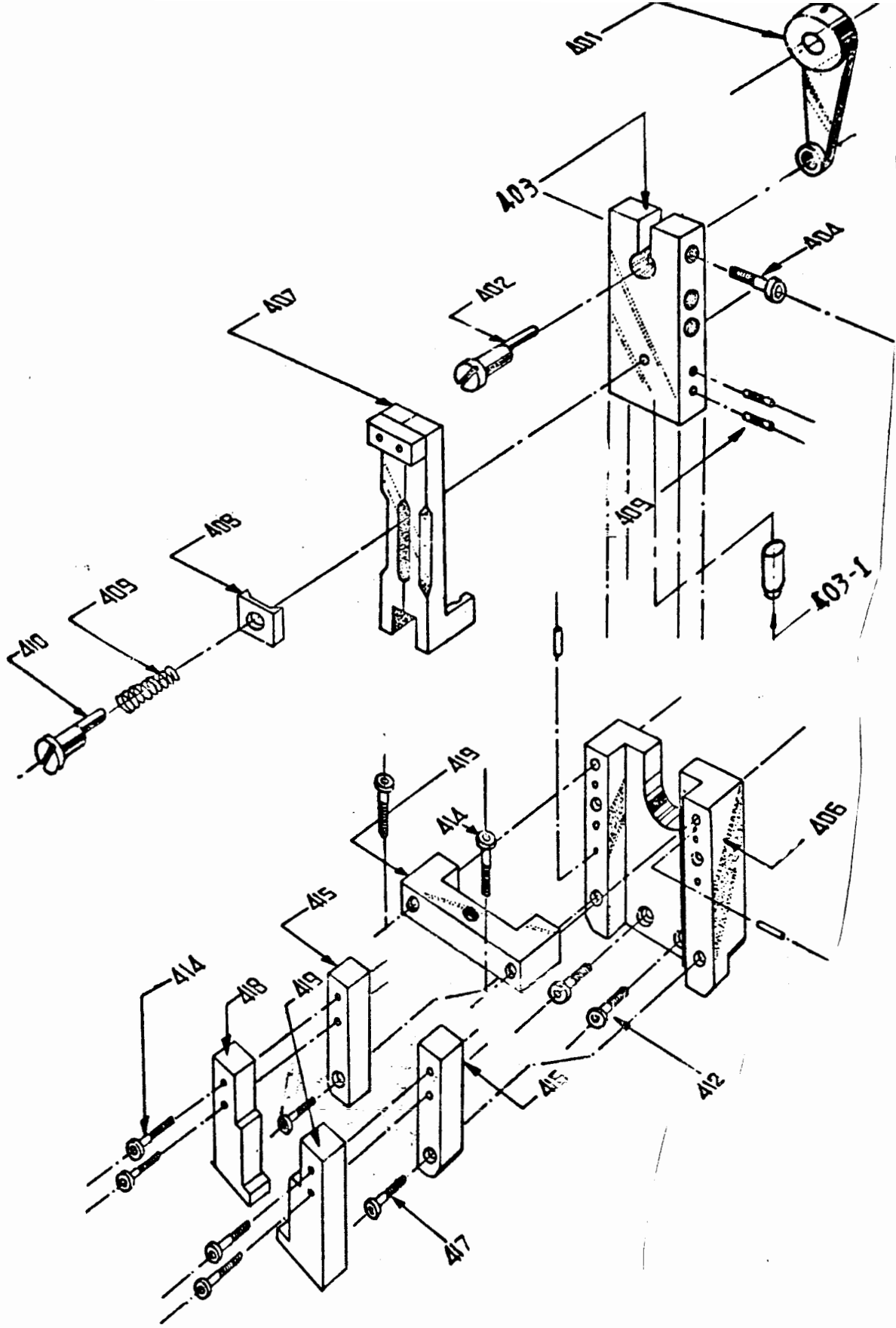
TRANSMISSION & CLUTCH PARTS

編 號	數 量	名 稱	
CATALOG NO.	QUANTITY	DESCRIPTION	
301	1	Motor 馬達	
302	1	Bolt puller 皮帶輪	
303	4	5/16" x 1/2" Hexagon head bolt 六角螺絲	
304	1	1/4" x 1/2" Round head bolt 圓頭螺絲	
305	1	Crank shaft 曲柄軸	
306	2	Bearing 軸承	
307	3	Snap ring 扣環	
308	1	Clutch 離合器	
309	6	10.20 m/m x 9.50 m/m Roller bearing 滾子	
310	3	Bearing 軸承	
311	2	Shank of rivet 鉚釘桿	
312	1	5/16" x 1" Round head bolt 圓頭螺絲	
313	1	Cone clutch 錐型離合器	
314	1	Coupling 聯結器	
315	1	Pin 梢子	
316	1	Belt pulley 皮帶輪	
317	1	Washer 墊圈	
318	1	5/16" x 1" Round head bolt 圓頭螺絲	
319	1	V-belt V型皮帶	
320	1	Belt case 皮帶輪外箱	
321	4	1/4" x 1/2" Round head bolt 圓頭螺絲	
322	1	Belt cover 皮帶輪外箱蓋	
323	3	3/16" x 1/2" Flat head bolt 平頭螺絲	
324	1	Bolt 栓子	
325	1	Clutch shoe 剎車塊	
326	1	Spring 彈簧	
327	1	Clutch block base 剎車座	
328	1	Square washer 墊塊	
329	2	5/16" x 1" Round head bolt 圓頭螺絲	
330	1	Control block 控制塊	
331	2	Link pin 梢子	
332	2	Open pin 開尾梢	
333	1	Spring 彈簧	
334	1	Clutch level 連桿	
335	1	Clutch pedal 離合踏板	
336	1	Clutch pedal 離合踏板	
337	2	1/4" Nut 螺母	
338	1	Pedal base 踏板座	
339	1	Link pin 梢子	
340	2	1/4" x 1" Hexagon head bolt 六角螺絲	
341	1	5/32" x 5/8" Round head bolt 圓頭螺絲	
342	1	Spring 彈簧	
343	1	Spring hook 彈簧鉤	
344	1	Motor Switch 馬達開關	



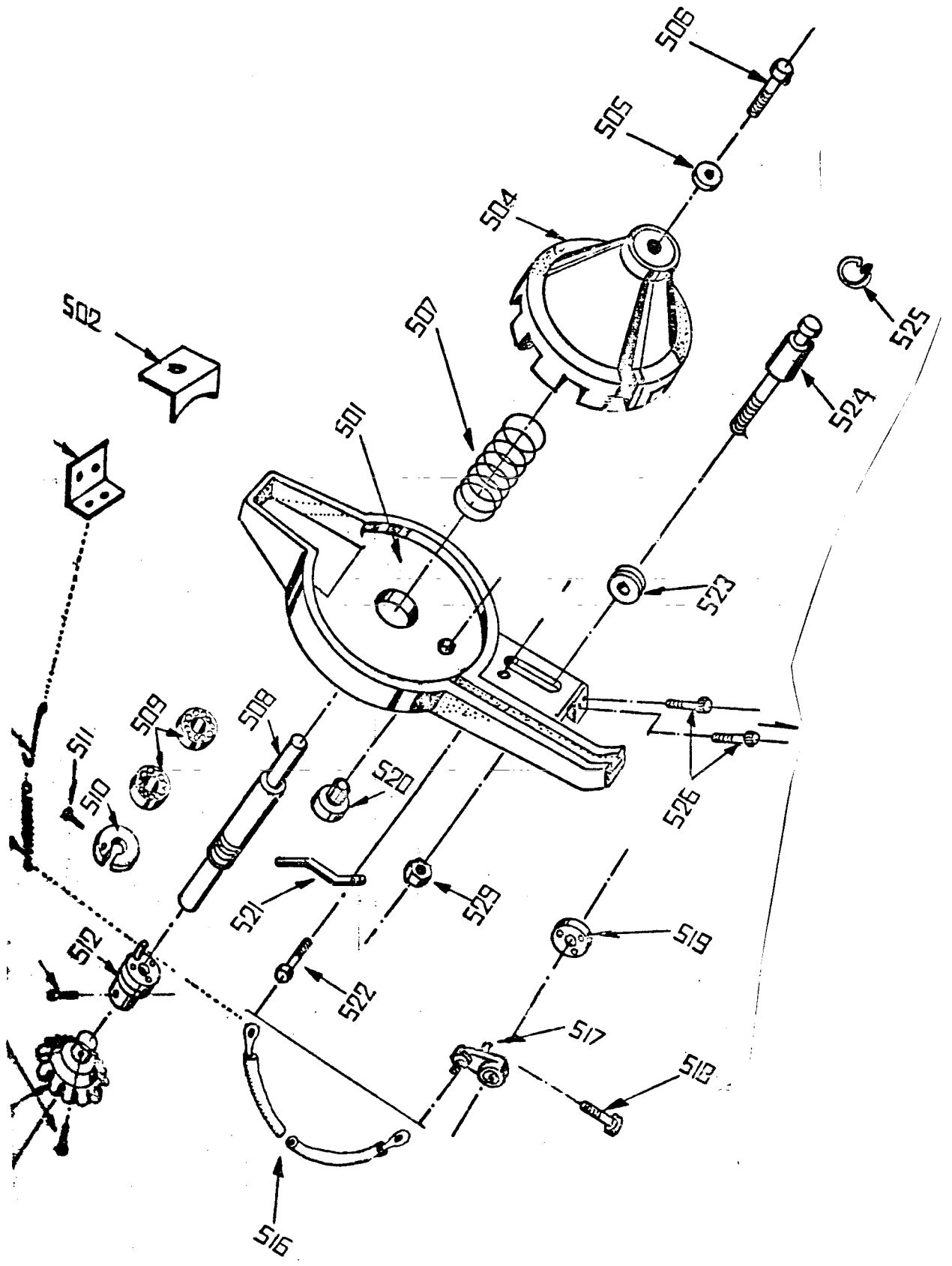
上模座部品
UPPER DIE PARTS

編 號	數 量	名 稱
CATALOG NO.	QUANTITY	DESCRIPTION
401	1	Link rod 連桿
402	1	Eccentric adjustment bar 偏心調節桿
403	1	Upper die base 上模座
403-1	1	Upper attaching die 上模
404	1	5/16" x 1" Round head bolt 圓頭螺絲
405	2	1/4" x 3/8" Set bolt 止付螺絲
406	1	Upper die guide 上模軌道
407	1	Upper finger 上扣夾
408	1	Set block 壓塊
409	1	Spring 彈簧
410	1	Eccentric adjustment bar 偏心調節桿
411	2 <i>SPRING</i>	pin 彈簧梢
412	2	1/4" x 1/2" Round head bolt 圓頭螺絲
413	1	Adjustment base 調節座
414	4	3/16" x 3/4" Round head bolt 圓頭螺絲
415	1	Left set plate 左上夾止板
416	1	Right set plate 右上夾止板
417	2	3/16" x 1/2" Round head bolt 圓頭螺絲
418	1	Left upper set plate 左壓板
419	1	Right upper set plate 右壓板



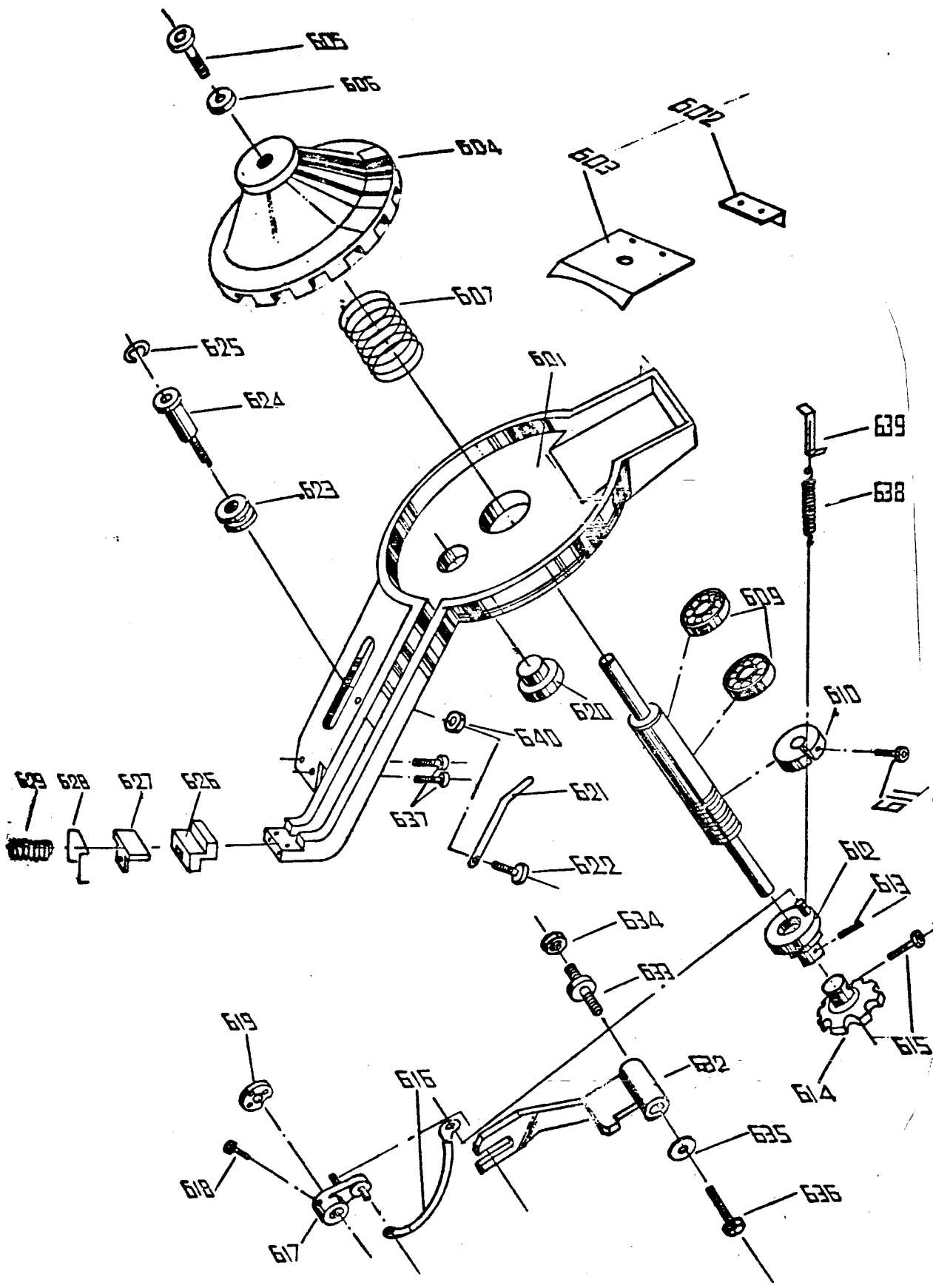
左選料部品
LEFT HOPPER PARTS

編 號 CATALOG NO.	數 量 QUANTITY	名 稱 DESCRIPTION
501	1	Left hopper base 左選料座
502	1	Hopper cover 選料蓋
503	1 <i>chuke</i>	Chute 活葉
504	1	Hopper 選料斗
505	1	Washer 墊圈
506	1	5/16" x 1" Left handed thread 左牙六角螺絲
507	1	Compression spring 壓簧
508	1	Spindle 軸心
509	2	Bearing 軸承
510	1	Collar 軸環
511	1	1/4" x 7/8" Round head bolt 圓頭螺絲
512	1	Free wheel 飛輪
513	1	1/4" x 1/2" Set bolt 止付螺絲
514	1	Handle 手把
515	1	1/4" x 1/2" Round head bolt 圓頭螺絲
516	1	Rope 拉線
517	1	Link Drum 搖桿
518	1	1/4" x 1/2" Round head bolt 圓頭螺絲
519	1	Washer 墊圈
520	1	Plug 塞子
521	1	Spring plate 彈簧壓片
522	1	1/4" x 1/2" Round head bolt 圓頭螺絲
523	1	Pully 皮帶輪
524	1	Bolt 螺栓
525	1	Snap ring 扣環
526	2	3/8" x 1 1/4" Round head bolt 圓頭螺絲
527	1	Spring 彈簧
528	1	Spring hook 彈簧鉤
529	1	1 1/4" Nut 螺母



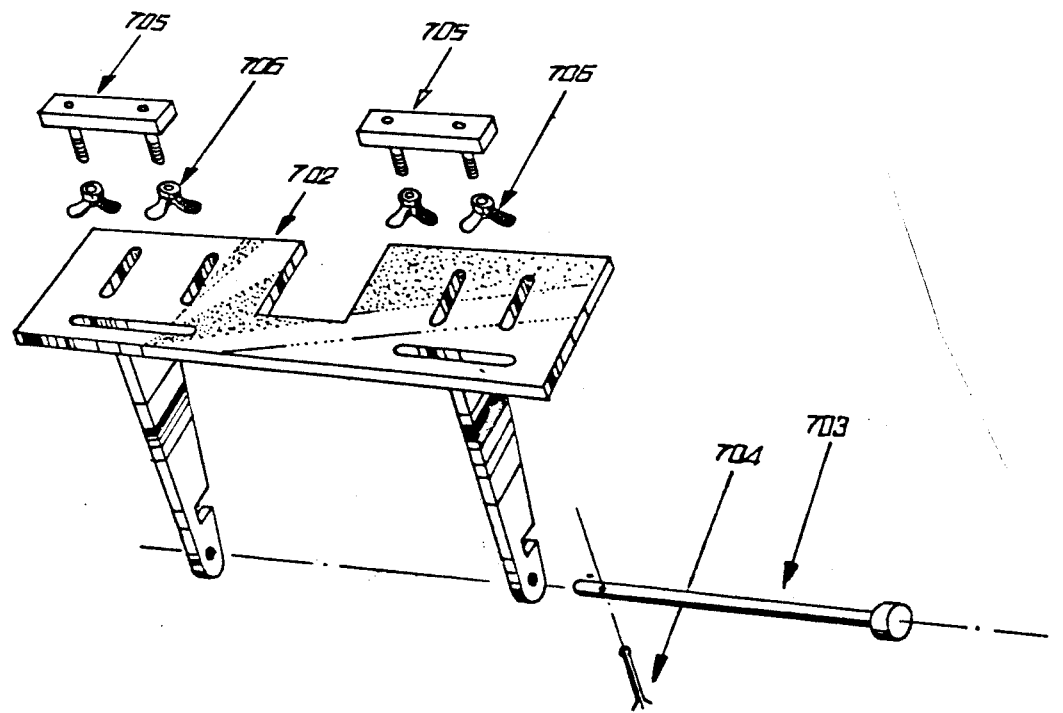
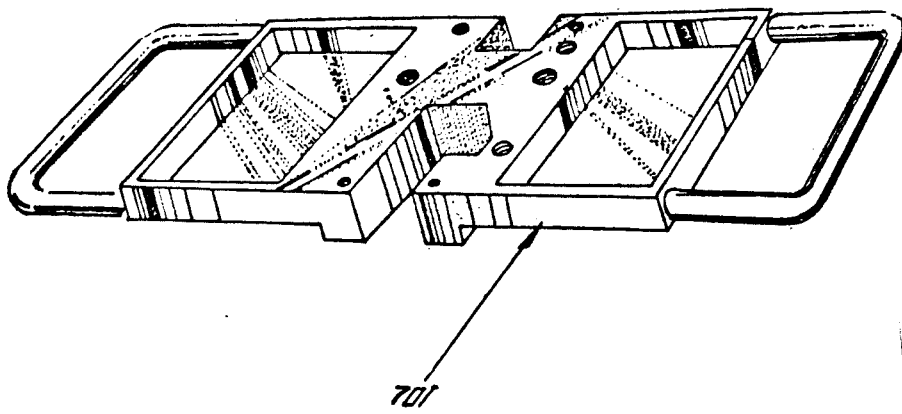
右選料部品
RIGHT HOPPER PARTS

編 號 CATALOG NO.	數 量 QUANTITY	名 稱 DESCRIPTION
601	1	Right hopper base 右選料座
602	1	Hopper cover 選料蓋
603	1	Churke 活葉
604	1	Hopper 選料器
605	1	5/16" x 3/4" Round head bolt 圓頭螺絲
606	1	Washer 墊圈
607	1	Spring 壓簧
608	1	Spindle 軸心
609	2	Bearing 軸承
610	1	Collar 軸環
611	1	1/4" x 7/8" Round head bolt 圓頭螺絲
612	1	Free wheel 飛輪
613	1	1/4" x 1/2" set bolt 止付螺絲
614	1	Handle 手把
615	1	1/4" x 1/4" Round head bolt 圓頭螺絲
616	1	Rope 拉線
617	1	Link draw 搖桿
618	1	1/4" x 1/2" Round head bolt 圓頭螺絲
619	1	Washer 墊圈
620	1	Plug 塞子
621	1	Spring Plate 彈簧壓片
622	1	1/4" x 1/2" Round head bolt 圓頭螺絲
623	1	Pully 皮帶輪
624	1	Bolt 螺栓
625	1	Snap ring 扣環
626	1	Guide block 導塊
627	1	Stop slide 止塊
628	1	Spring clip 彈簧夾
629	1	Spring 彈簧
630	1	Pipe 管子
631	1	1/8" x 5/8" Bolt 螺絲
632	1	Link draw 搖桿
633	1	Bolt 螺栓
634	1	Nut 螺母
635	1	Washer 墊圈
636	1	5/32" x 3/8" Round head bolt 圓頭螺絲
637	2	3/8" x 1 1/4" Round head bolt 圓頭螺絲
638	1	Spring 彈簧
639	1	Spring hook 彈簧鈎
640	1	1/4" Nut 螺母



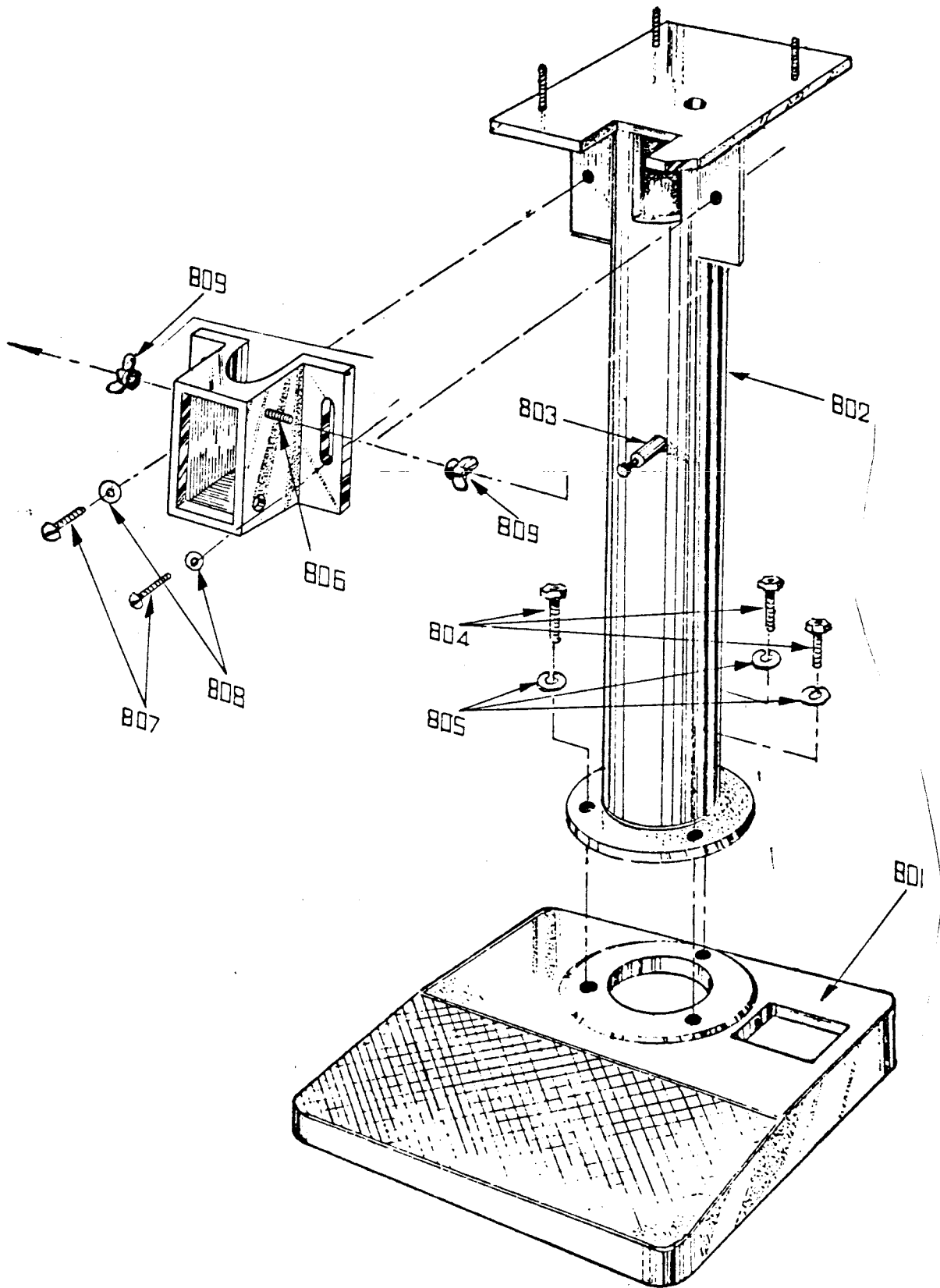
. 工作台部品
WORK BED PARTS

番 號 CATALOG NO.	數 量 QUANTITY	名 稱 DESCRIPTION
701	1	Bed 床台
702	1	Work Bed 工作台
703	1	Pin 梢
704	1	Open Pin 開尾梢
705	2	Adjustment plate 調節片
706	4	1/4" Butterfly nut 蝶型螺母



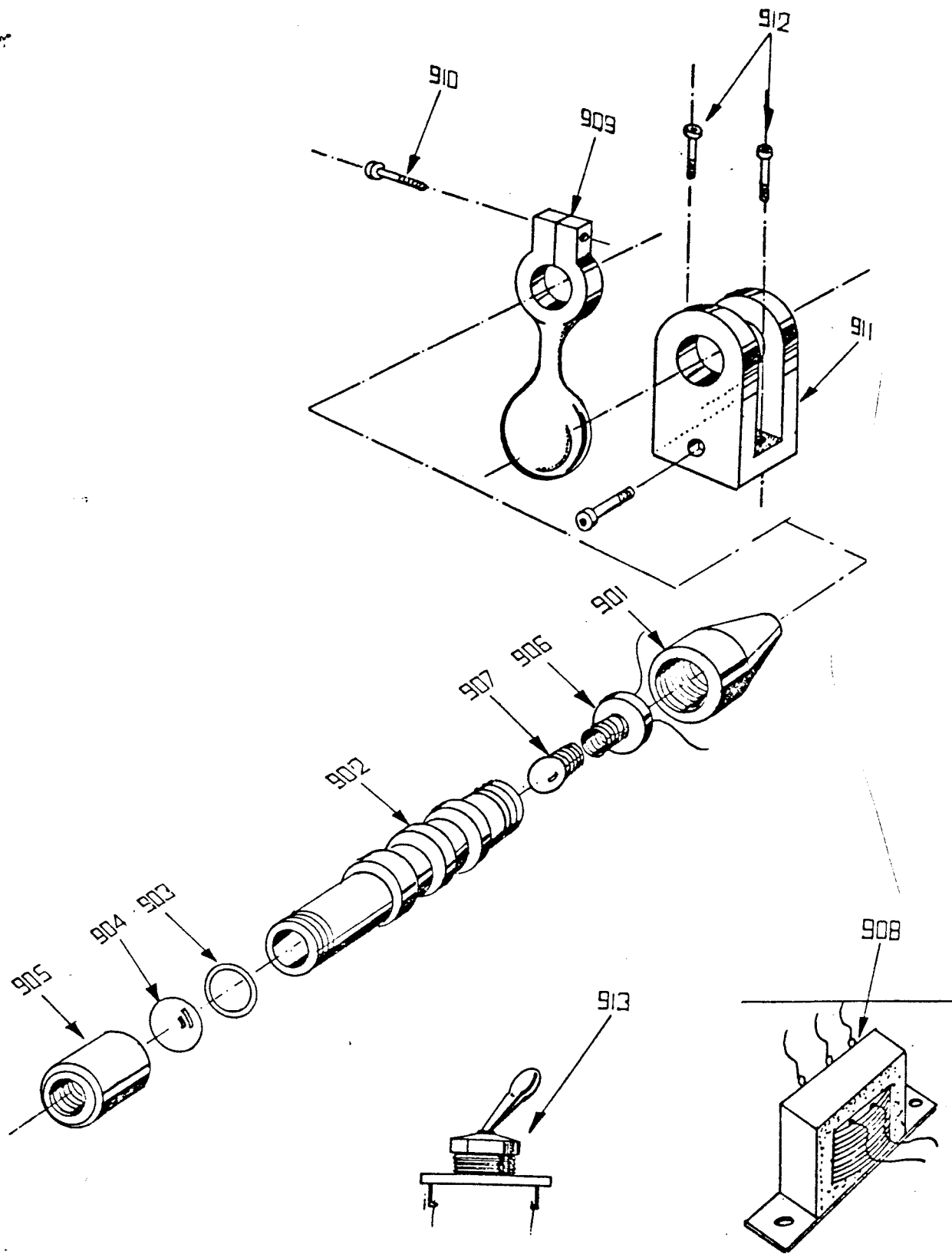
底座部品
BOTTOM PARTS

圖號 CATALOG NO.	數量 QUANTITY	名稱 DESCRIPTION
801	1	Bottom body 底座
802	1	Column 柱
803	1	Spring hook 彈簧鈎
804	3	3/8" x 1" Hexagon head bolt 六角螺絲
805	3	Washer 墊圈
806	1	Switch base 開關座
807	2	1/4" x 1/2" Bolt 螺絲
808	2	Washer 墊圈
809	2	Butterfly nut 蝶型螺母



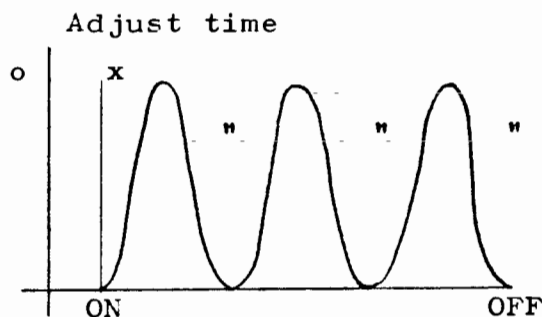
聚光燈部品
BEAM SPOT PARTS

編 號 CATALOG NO.	數 量 QUANTITY	名 稱 DESCRIPTION
901	1	Lamp base 燈座
902	1	Radiator 散熱管
903	1	Washer 墊圈
904	1	Condenser 聚光片
905	1	Condenser head 聚光頭
906	1	Socket 接頭
907	1	Lamp 燈炮
908	1	Transformer 變壓器
909	1	Spider 絡頭
910	1	3/16" x 3/8" Round head bolt 圓頭螺絲
911	1	Spider base 絡頭座
912	2	1/4" x 1/4" Round head bolt 圓頭螺絲
913	1	Light switch 開關



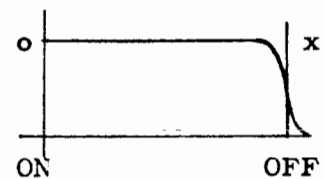
1. Voltage is AC1Ø 240V 60HZ.
2. Motor controller is electromagnetic switch with the bearing guards.
3. Green wire is for you to connect your earth wire.
4. This machine is completely automatic controlled, the procedures are as follows :
 - a. To start the motor - Press "Motor On" to start the machine, and "Motor Off" to stop the machine, But when the micro switch stops, (when the Acrylic Cover is opened), the motor will stop automatically.
 - b. Foot Switch - There are 2 kinds; "Auto" or "Hand".
 - * When you adjust to be "Auto", you have to know in advance the speed of setting buttons you need, then adjust the "Clutch Timer", the machine therefore will be automatic and continual set the buttons as your requested speed.
 - * When you adjust to be "Hand", and if adjust the "Cluth Timer" to be on zero (0), then the machine will set the buttons one by one.
 - * You may also adjust the "Cluth Timer" to be your ideal speed, then the machine will be automatically set the buttons as your ideal speed, then stop automatically afterwards.

(1)Auto:

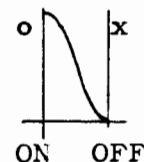


(2)Hand:

continue



(3)Single:

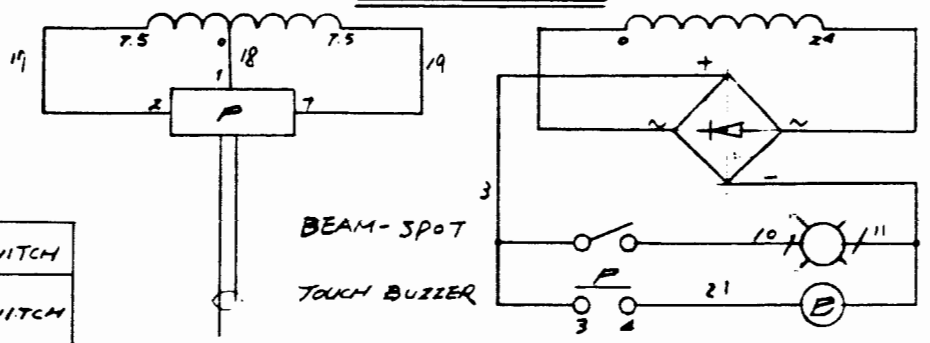
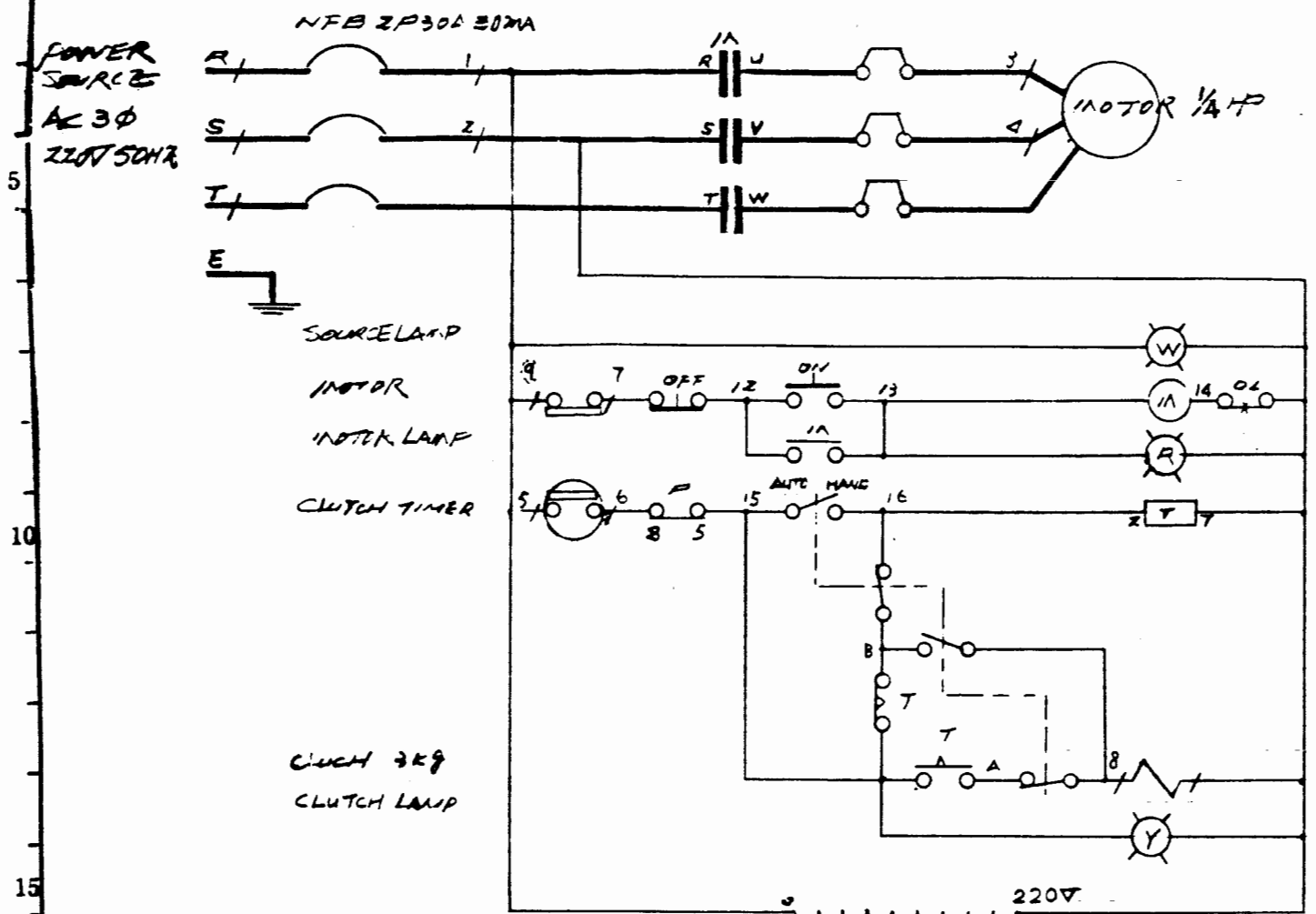


5. Touch Switch : When your fingers touches the "Sensor", the Buzzer then will warn you automatically, but for the safety purposes, please check and adjust your machine before you use it.

(Remarks : Open the switch box, you can adjust the "Induction" freely, but better not adjust it to be too high. On the "Touch Sensor", Please keep it to be clean with no dust or impurities.)

The new modifications are :

1. Touch Sensor.
2. Clutch 3kg.
3. Extra motor controller electromagnetic switch with the bearing guards added.
4. Extra covers added on the outside of all the wires.
5. Buzzer.
6. Clutch Timer.
7. Extra controlled fuse added.



1		LIMIT SWITCH
2		FOOT SWITCH
3		LAMP
4		MAGNETIC SWITCH
5		BUZZER
6		CLUTCH
7		TIMER SWITCH
8		TOUCH SWITCH

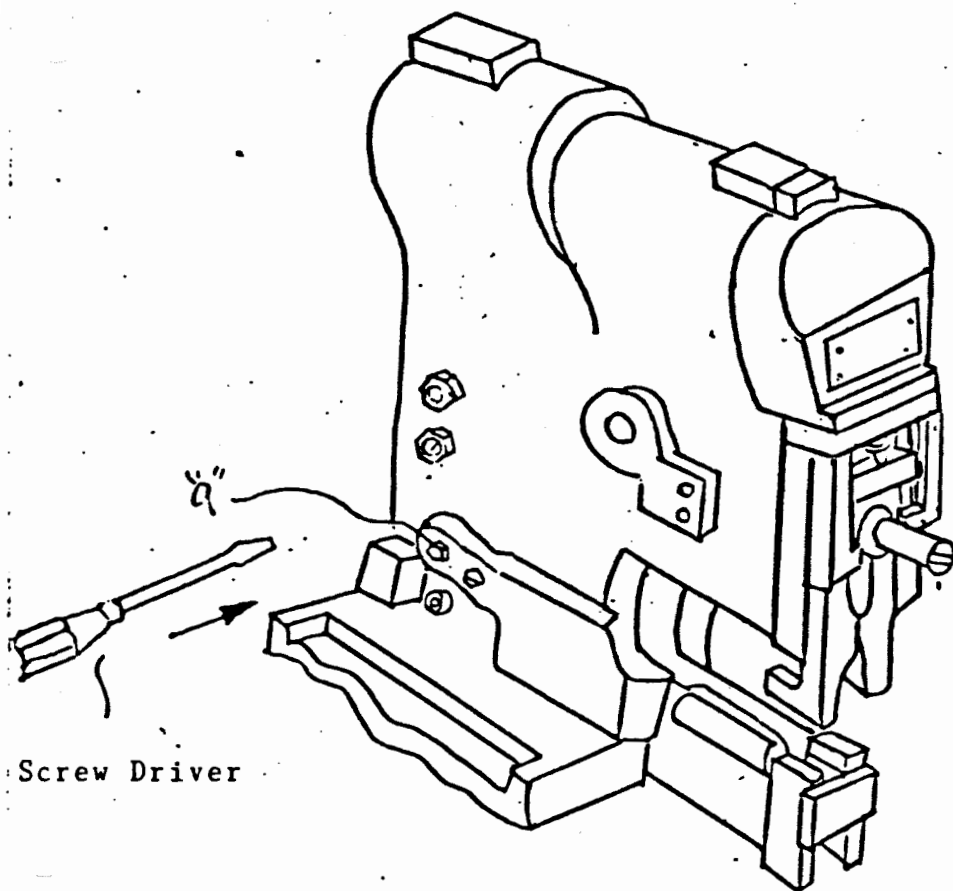
設計	材質	公差
繪圖	比例 / 單位	型式
校核	圖名	圖號

OPERATOR INSTRUCTION
FOR
CONVERSION KITS

C O N T E N T S

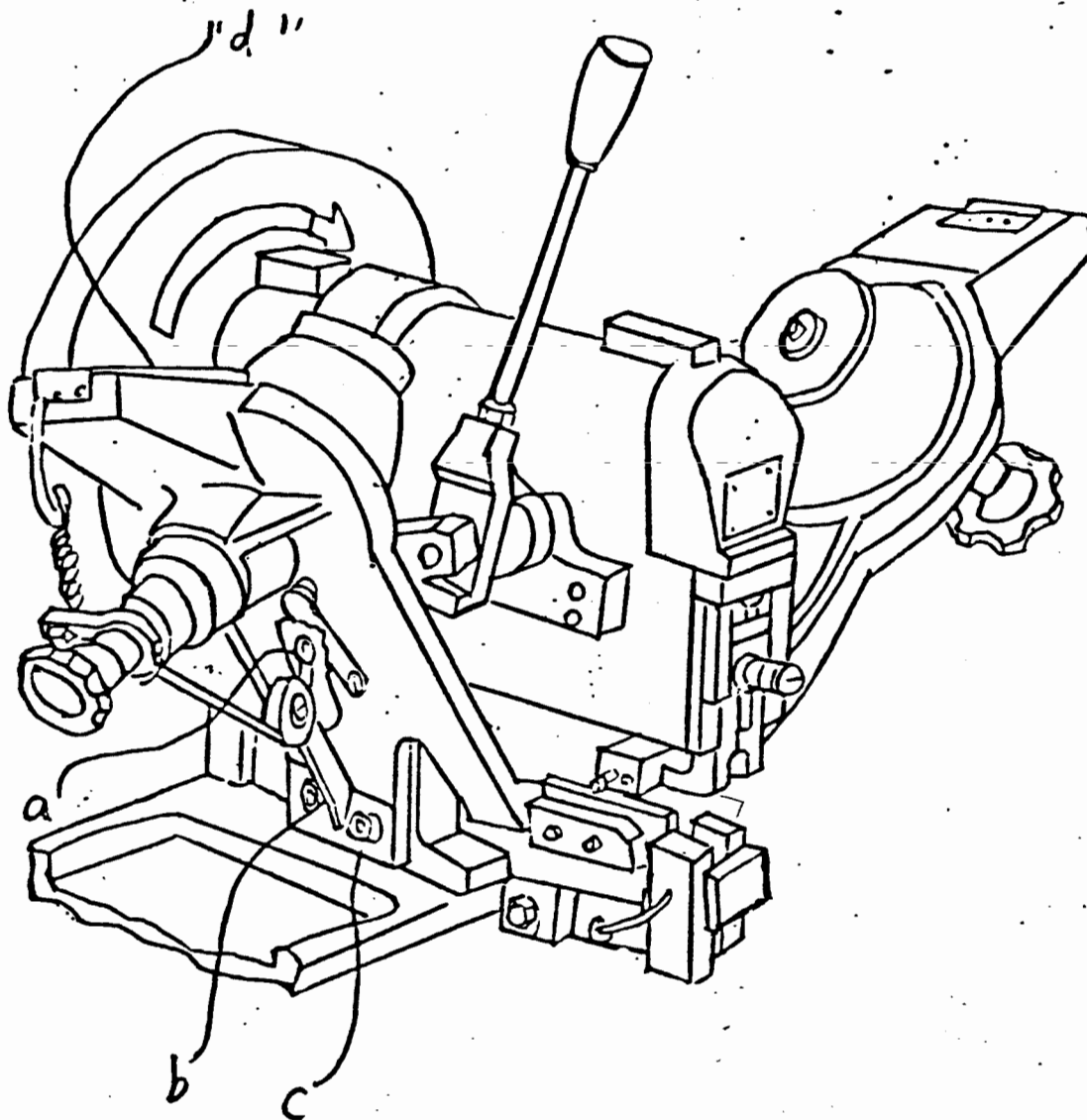
(I)	CHANGE OF HOPPER -----	1
(II)	CHANGE OF PUSHER -----	2-4
(III)	CHANGE OF FINGER AND DIE -----	5-6
(IV)	CHANGE OF LOWER DIE BASE -----	7-9

(II) CHANGE OF PUSHER



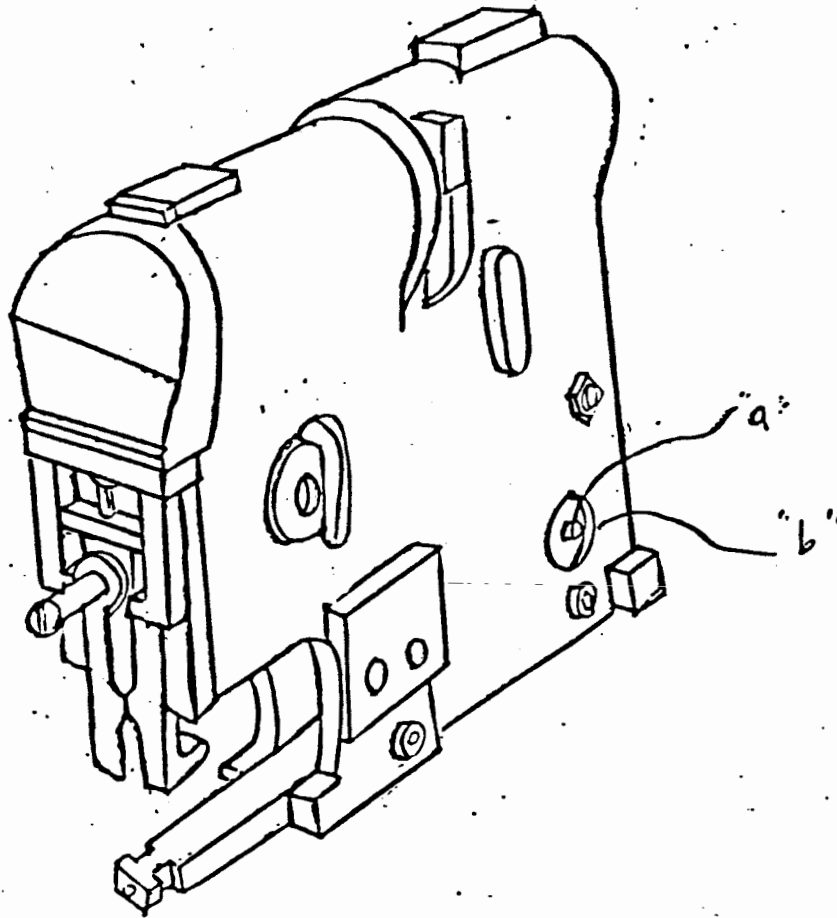
(1) Loosen bolt " a ."

(2) Then use Screw Driver to push bolt " a ." to the other side.



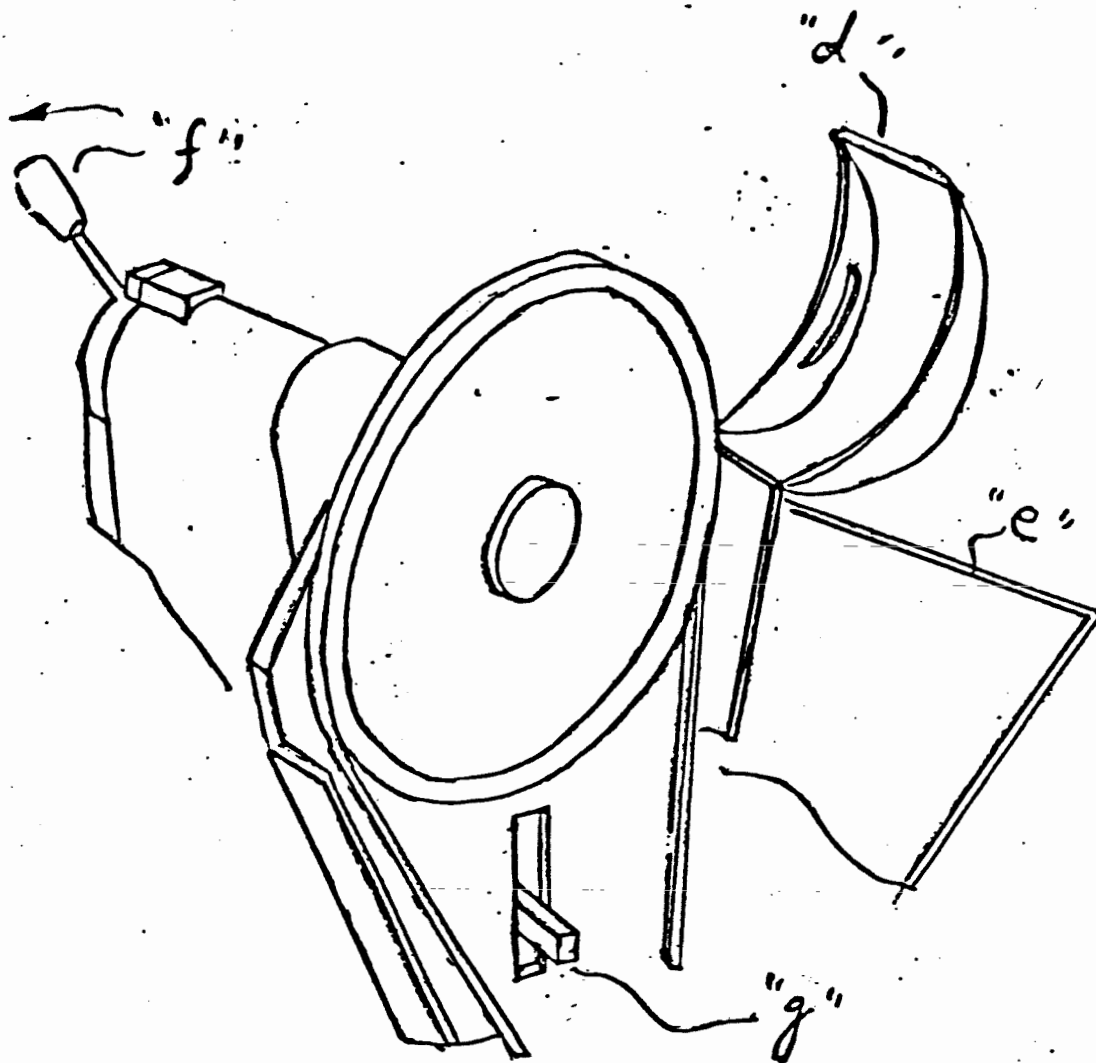
- (1) Take away the Rope (poly-urthane) " a."
- (2) Also take away screws " b " and " c " and hold the hopper "d " by hand at same time. Then, you can take out the hopper.
- (3) If you want to install the hopper back on the machine, please do opposite actions of above.

(II) CHANGE OF PSHER.



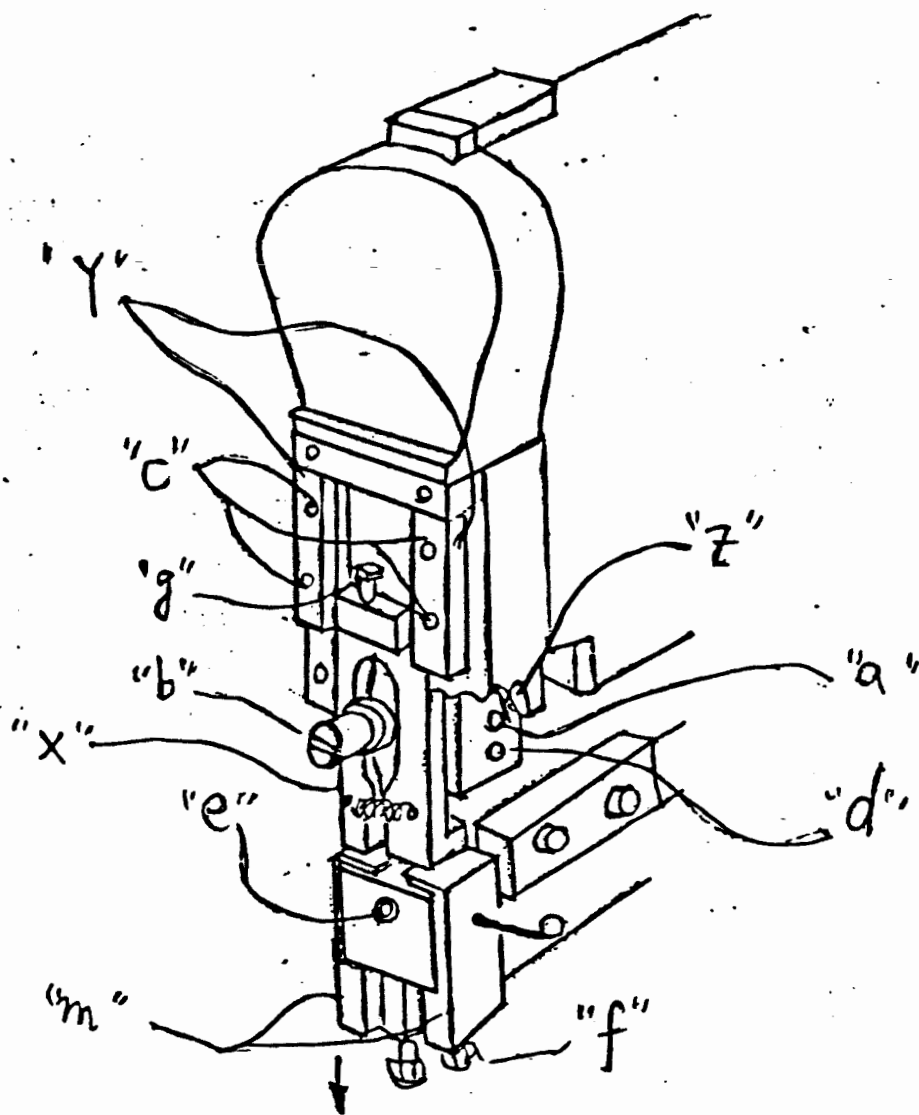
(3) Finally, take out the bolt " a " from the hole " b."

(11) CHANGE OF PUSHER



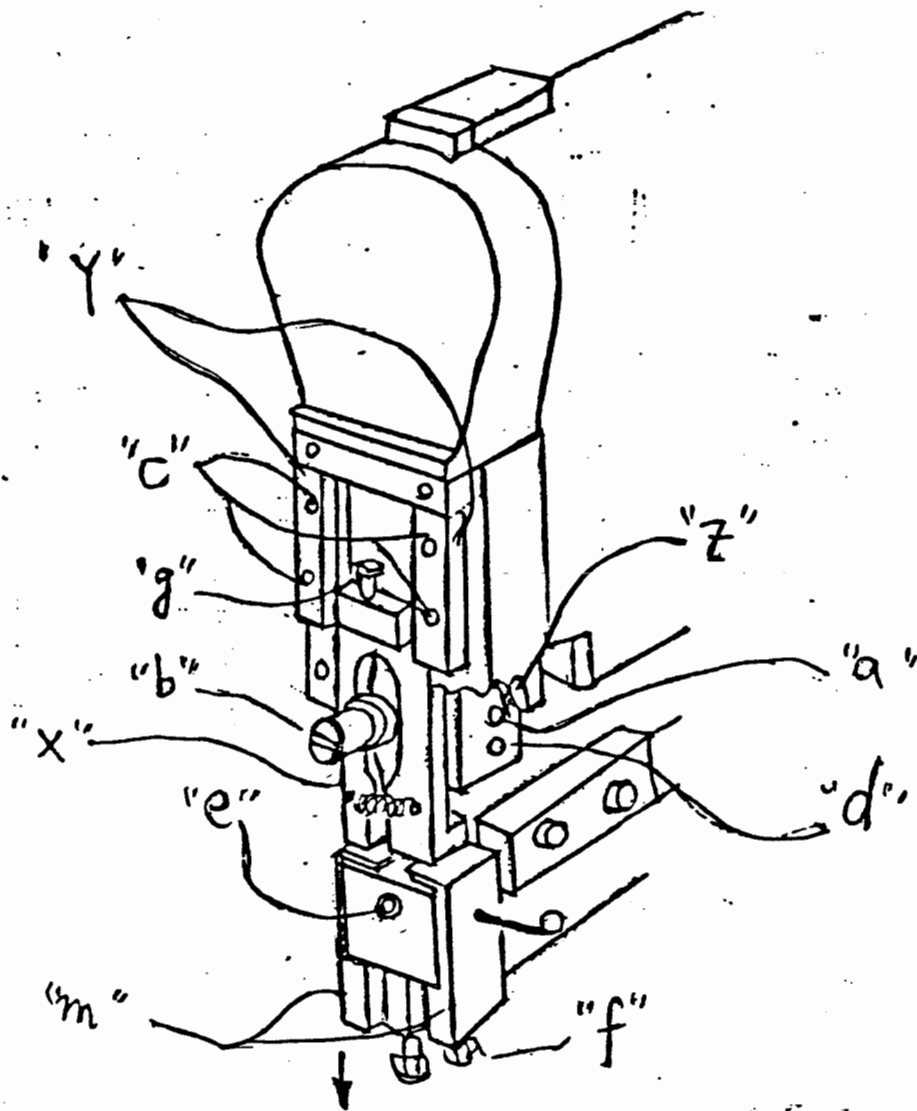
- (4) Open Cover of Belt Pulley " d " and " e."
- (5) Forward the Handle " f " as per the direction of the arrow.
Then you can see the Pusher " g " jut out under the Belt Pulley.
- (6) Finally, take out the Pusher.
- (7) If you want to install the Pusher back on the machine, please do the opposite actions of above.

(III) CHANGE OF FINGER AND DIE



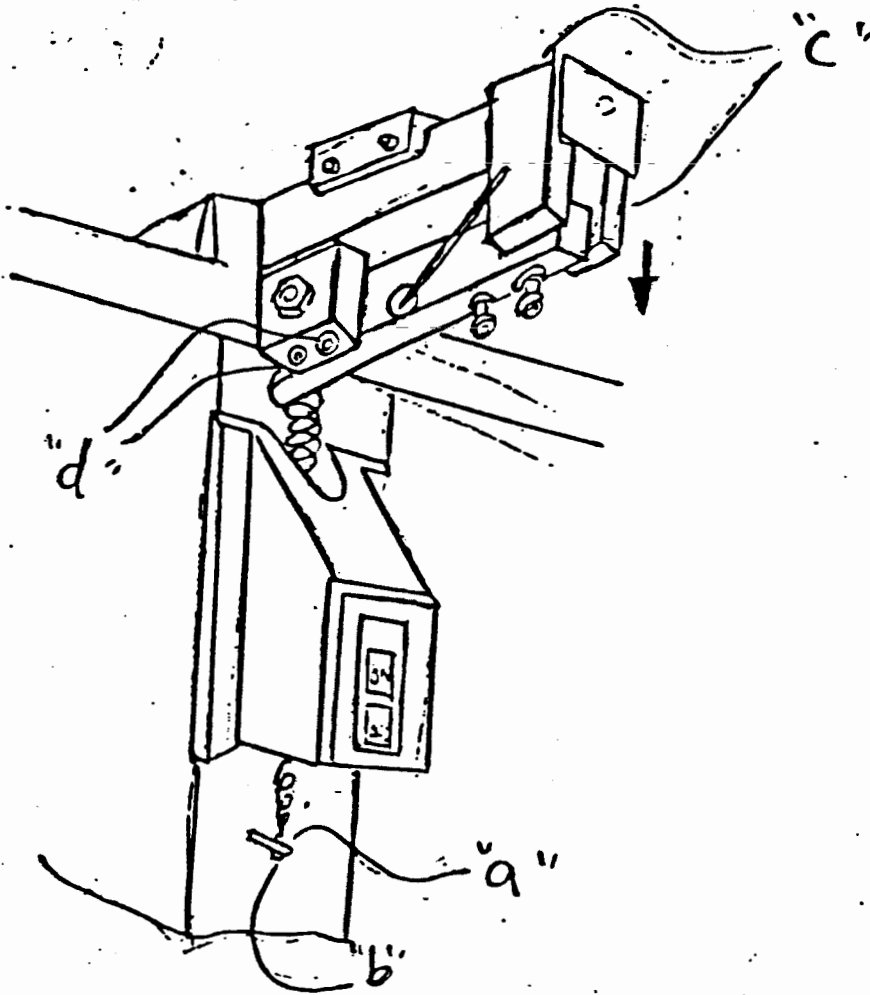
- (1) Open Cover of Belt Pulley, Step the Pedal of Clutch, and then turn Belt Pulley by hand.
- (2) As soon as you see the bolt " a " from the hole of " Z ", please stop to turn the Belt Pulley.
- (3) Loosen the bolt " a " and then take away the Bolt Bar " b."
- (4) Take away bolts " c " (4 pieces) and take away blocks " Y " (2 pieces.) Then, you can take out the Upper Finger " X."
- (5) Press down the Lower Finger " m " as per the direction of arrow. Then, you can take out the Lower Finger.
- (6) If you want to install the lower finger back on the machine, please do the opposite actions of above.

(III) CHANGE OF FINGER AND DIE



CHANGE OF DIE :

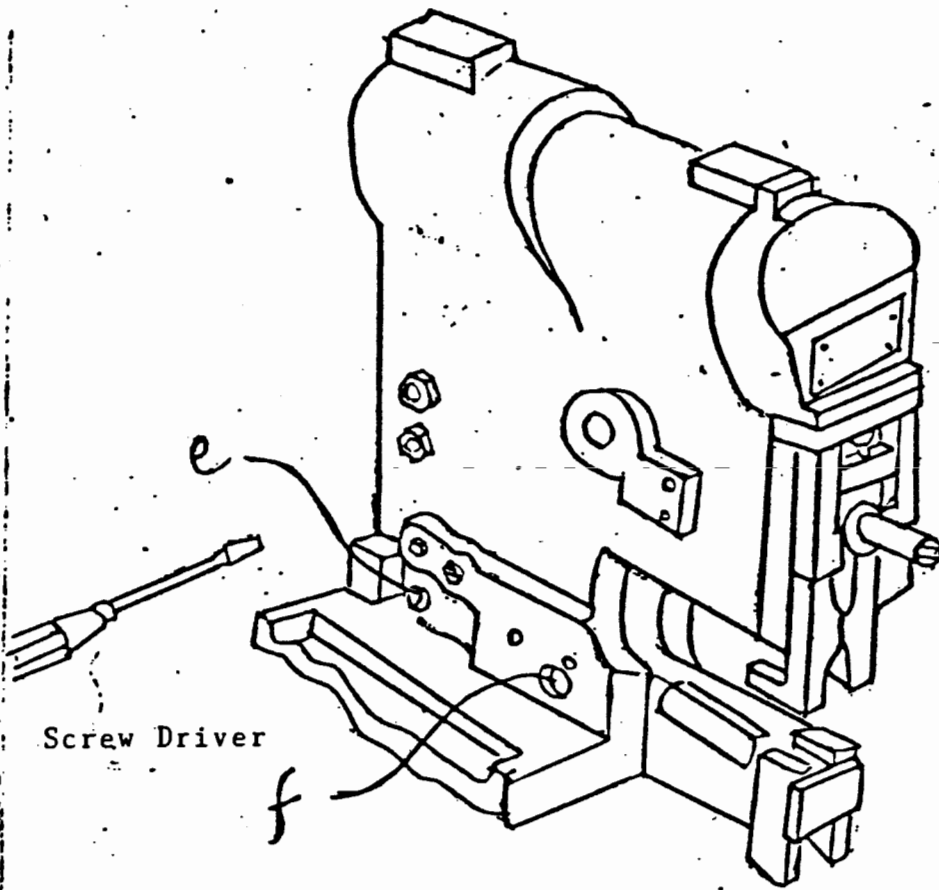
- (1) Loosen bolt " d " and can get the Upper Die.
- (2) Loosen bolt " e " and can get the Lower Die.
- (3) Finally, install new Upper Die and Lower Die and fasten bolts " d " and " e."



NOTE : Before you do following procedures, please take out the Hopper first.

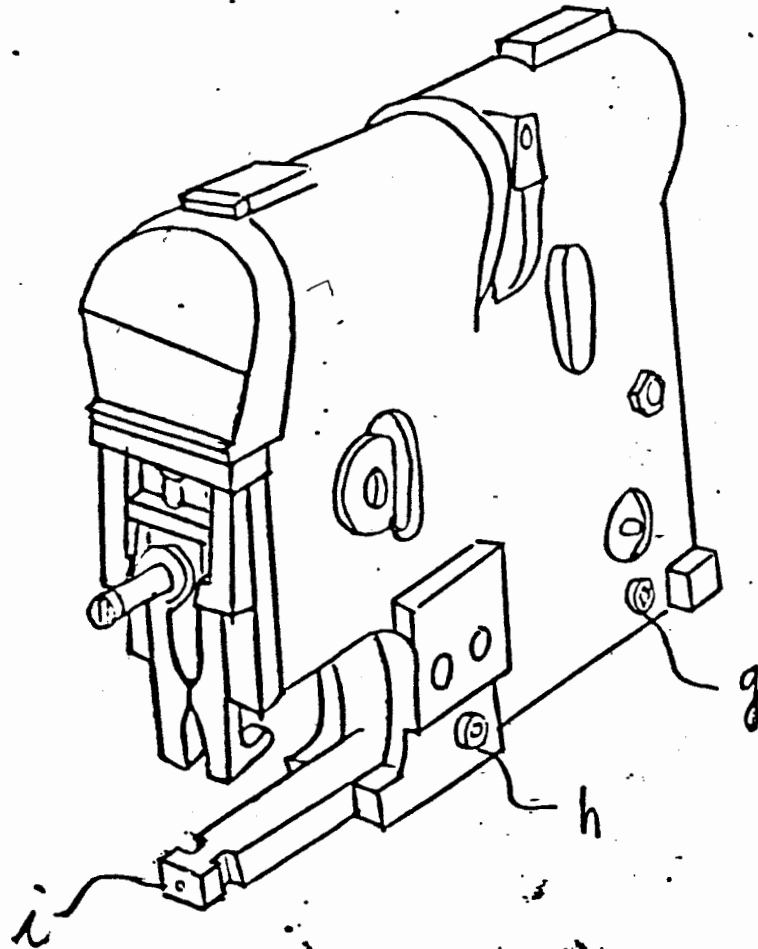
- (1) Take away Spring " b " from the place " a."
- (2) Press down Lower Finger " c " by hand as per the direction of arrow to take out the Upper Finger.
- (3) Take away bolts " d." (2 pieces)

(IV) CHANGE OF LOWER DIE BASE



(4) Take away bolts " e " and " f."

(IV) CHANGE OF LOWER DIE BASE



(5) Take away bolts " g " and " h. "

(6) Take out the Lower Die Base " i " by hand slowly. If the Lower Die Base couldn't been taken out by hand, then please open Cover of Belt Pulley and use wooden hammer to strike out the Lower Die Base lightly.

(7) If you want to install the Lower Die Base back on the machine,