

AUTOMATIC SCREW FEEDER 自動螺絲供給機

Operating Instruction 使用說明



Thanks for purchasing this product.
The product is electrical automation equipment.
Please strictly abide by the use of norms.
Please read the manual before using the machine, and
keep it safely. In case of any insurmountable problems,
please contact the dealer.



警告

WARNING

謝謝您選購本產品！

本產品屬於電氣自動化設備，請嚴格遵守使用規範。
使用之前請仔細閱讀此說明書，閱讀之後請妥善保管。
如遇任何不能解決的問題，請聯系經銷商。

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Characteristics

1. Adjustable for a wide range.

The rail can be adjusted freely to suit many kinds of screws, like M1.0-M5.0 standard screw (1.0 1.2 1.4 1.7 2.0 2.3 2.6 3.0 3.5 4.0 5.0), special screw, 1:1 short screw, filling piece screw and so on.

2. Working smoothly.

The screws movement and fall down inside the bucket all the screws will be cleared if not enter the rail and enter the next circle, screws will never be blocked, the check point will not vibrate.

3. Working speed adjustable

Feeding system and drive system independent control, set the time delay freely to adjust the feed speed, suits many kinds of works.

4. Simple operation

Even novices can operate freely, whether metric specifications or british specifications, all easily to understand.

5. Can increase productivity significantly

It is unnecessary to target the screw cap, compared to screw plate, each screw can save 1.4 seconds, productivity increased by 4 times!

6. Statistical function (partial models)

When the settings achieved, the machine will automatic alarm and cycle, it is very clear to see with digital display panel.

7. Automatic alarm function

When non-normal condition occurs, the machine can automatic alarm.

8. The volume is exquisite, does not occupy the space.

螺丝机特点

1. 可調型，適用範圍廣

軌道可自由調節，廣泛適用多種類型和長度的螺釘，如M1.0-M5.0標準螺絲（1.0 1.2 1.4 1.7 2.0 2.3 2.6 3.0 3.5 4.0 5.0），特殊螺絲，1:1短螺絲、帶墊片螺絲等。

2. 運轉流暢

螺絲在滾筒內運動，凡是未進入軌道的螺絲，都會被清除到滾筒內，進入下個循環，無卡螺絲現象，取點位置不會前後抖動。

3. 工作速率可調

送料與振動驅動獨立控制，可自由設定理想的延時停止時間，以調節螺絲送料速度快慢，適合多種作業。

4. 操作簡單

即使生手也能馬上學會，操作方法不管是公制規格還是英制規格，皆能操作自如，簡單易懂。

5. 可大幅提高生產率

不必對正螺釘頭位置，比起傳統螺絲盤，每顆螺釘可節省1.4秒，生產效率提高4倍！

6. 有計數功能（部分型號）

計數功能自動報警、循環，帶數字顯示面板，一目了然。

7. 有故障報警功能

當非正常情況產生時，螺絲機會自動啟動故障報警裝置。

8. 體積小巧，不占空間

Read these instructions thoroughly for the proper use of this machine. After having read these instructions, keep them in a safe place so that you or the operator can refer to them whenever necessary.

一、Fittings

Instruction manual, 1 copy Screw stopper plate, 2 pieces (1 piece is already attached to the main body) AC adapter, 1 piece 1.2mm trim areas 4 piece of, 0.2 mm trim area 5 pieces (used for adjusting the holding plate) Hexagonal key, 1 piece

二、FOR SAFE USE

Read the following Cautions thoroughly for the safe use of this machine. Keep them in mind during the operation of the machine in order to prevent injuries and damage to property.

Installation Caution:

Install the machine on a level, stable location that can endure its weight and running conditions. If the machine falls down or turns over due to improper installation, injuries or property damage may result.

為了正確使用該設備，請仔細閱讀說明書，讀完這些操作說明後將它保存在一個安全的地方，以便你或者操作者需要時，隨時可以查閱並遵照說明操作。

一、附件



說明書1份



螺絲擋料鉤2件（其中一件已經安裝在機器上）



直流電源



1.2調整片 4片、0.2調整片 5片（用于調整軌道間隙）



內六角扳手一個

二、安全使用

為安全使用此機器請仔細閱讀完下列注意事項

機器安裝

安裝此機器要在一個水準、穩定且能夠承受機器重量和進行條件的位置上安裝，如果非正常安裝操作，將會導致機器非正常關閉或者落下，甚至人身受傷或財產損失。

操作環境

不要在有易燃或腐蝕性氣體環境下操作此機器，在這種環境下使用此機器是非常危險的，不要在溫度很大的環境下操作此機器

Operating Enviroment

Caution: Do not operate this machine where flammable or corrosive gas is present. It is extremely dangerous to use this machine under such circumstances. Do not operate this machine in environments of high humidity.

AC adapter

Caution: Do not use any other AC adapter other than the recommended accessory.

Rail

Caution: Do not damage nor oil the rail. Suitability of screws

Caution: Do not use oily screws, dirty screws or any screw other than those prescribed.

Screw removal

Caution: Do not exert excessive or impactive force when removing the screws.

When machine is not in use

Caution: Be sure to unplug the AC adapter from the wall outlet during closing hours and if the machine will be left unused for any extended period of time.

Emergency

Caution: Stop operation and unplug immediately whenever you sense abnormalities or anomalies during the operation of this machine, such as a pungent odor. Turn off the power switch and disconnect the AC adapter from the receptacle. Continued operation may cause fire, electric shock, malfunction or injury. Immediately contact the dealer from which you purchased the machine.

Servicing

Caution: Do not attempt to repair, disassemble or modify this machine except where specified by this manual. Consult your dealer for service and repair of this machine.

电源适配器

請使用本機附帶的電源，不要使用別的電源适配器。

軌道

注意：不要損壞和潤滑軌道。

適用的螺絲

注意：不要使用有油漬的螺絲，臟螺絲或其他任何一款規定外的螺絲。

取螺絲時

注意：用電批取螺絲時不要過度用力或給予較大的衝擊力。

當機器不工作時

注意：如果休息或者長時間不工作時，請將電源拔出。

緊急處理

注意：當你在操作機器過程中發現有異常現象，譬如刺耳的聲音時，請立即停止機器運行，關掉電源開關，切斷适配器連接。如果繼續進行可能會導致失火、短路、性能失效或其他損壞。所以出現上述情況請及時與供應商聯系。

售後服務

注意：不要試圖自行拆分、修理機器尤其是說明書中特別提到的部分。有問題時請聯系你的供應商，請求售後服務並進行維修。

三、ADJUSTMENT AND CHECKS BEFORE USE

Before use, check if components suited to the screws are fixed to the body. The rail is $\phi 1.0$ to $\phi 5.0$ depending on the nominal diameter. It is determined by a discriminating seal affixed on a rail front cover. There are two kinds of passage plates, namely one for $\phi 1.0$ to $\phi 1.7$ and one for $\phi 2.0$ to $\phi 3.0$. It is determined by a discriminating seal affixed on a passage window.

1. Attaching a rail to a main body

First, loosen the fixing screw and thrust the rail until it stuck at end as shown in the picture. Then, tighten the fixing screw as before.

2. Quantity of screws thrown in

If too many screw are thrown in, orientation and transfer of the screw will be seriously affected.

3. Check/adjustment of the brush

Check the height of the brush. As in the picture on the right, set the brush to an approximately level position. Ensure that the edge of the brush is grazing the screw's head. If the height of the brush is either too low or too high, orientation and transfer of these screws will be seriously affected. If adjustment is necessary, adjust it by loosening the brush height adjusting screw.

Note: Always unplug the AC adapter from the wall outlet before making any adjustments to avoid injury.

4. Check/adjustment of the holding plate
Check the position of the holding plate. Ensure that the gap between the head of the used screw in the rail groove and the holding plate is approximately 0.2mm to 1 mm. If there is no gap, the screw gets caught. If the gap is too large, the screw overlaps or juts out. If adjustment is necessary, adjust it up or down by loosening the bit guide bracket attaching screw.

三、使用之前的機器調整和檢查

使用之前先檢查軌道寬度和壓板高度是否適合螺絲，軌道 $\phi 1.0$ — 5.0 取決於放入的螺絲的直徑。

1. 檢查軌道安裝

首先，鬆開固定好的螺絲，將導軌推到如圖所示的地方卡住，然後將螺絲像以前一樣固定好。



2. 放入螺絲的數量

不要一次性放入太多的螺絲，否則會影響到螺絲的移動方向和傳送速度。

3. 刷子的檢查/調整

檢查刷子的高度

如右圖所示，將刷子安裝在一個近似水準的位置，確保刷子的邊緣可以刷到螺絲的頭部。如果刷子的高度太高或太低，都將會嚴重地影響到螺絲的移動。

如果需要調整，那就先鬆開毛刷的螺絲來適當調整刷子的高度。

要點：為了避免損壞機器，調整機器前請把電源拔出。



5. Easily adjust it by using the 0.35 mm gauge plate. Loosen the bit guide bracket attaching screw. Insert the gauge from the top between screws on the rail and the holding plate. Tighten the bit guide bracket attaching screw when the holding plate is touching the front and the back of the gauge equally.

Caution: Match the center of the holding plate out let and the rail center may be necessary. If not, adjust it by loosening the attaching screw.

6. Check/adjustment of the rail
Check the physical relationship of the stopper and sensor. Ensure that the rail is fixed so that "A" portion of the stopper is 0 mm to 0.5 mm ahead of the sensor optical axis. If adjustment is necessary, adjust it back and forth by loosening the rail attaching screw.

7. Check/adjustment of the bit guide
Check the position of the bit guide. Adjust the bit guide to a proper position where a user can easily take screws. Actually pull up screws a few times to adjust it. Adjust it by loosening the attaching screws. Caution: The rail adjusted according to the physical relationship with the sensor as on the last page, so basically the rail is not adjusted here.

8. Adjustment of the bit guide
First, loosen the bit guide attaching screws for the bit guide on the right and left, and match the drive bit on the center of bit guide. Adjust the bit guide as a bit moves smoothly and tighten the loosened screws back.

9. Check/adjustment of rail vibration
Transfer speed of screws differ according to screw type. This machine can change rail amplitude and adjust the transfer speed. To adjust amplitude, loosen an amplitude fixing screw at the rear of this machine and turn the amplitude adjusting screw at the bottom of the machine. Viewing it from the bottom, if turned clockwise, the amplitude become larger, and if turned counter clockwise, the amplitude becomes smaller.

If you make the amplitude too large in order to speed up the transfer, it may become difficult to pull up screws. So, adjust it to appropriate amplitude for the type of screw being used. After adjustment, be sure to tighten the amplitude fixing screw on the rear of the machine.

4. 導向槽的檢查

確保從導向槽出來的螺絲頭部和壓板之間的間隙在0.2~1mm之間。如果沒有間隙，螺絲不能正常出來；如果間隙過大，螺絲會重疊；如果需要調整，鬆開導向槽上的螺絲上下調整。

5. 用調整片輕鬆調整壓板間隙

鬆開導向槽的螺絲，塞進調整片輕輕下壓壓板鎖緊螺絲即可，確保壓板在導軌的中間。

6. 軌道的檢查和調整

檢查擋料鉤和感測器的位置，擋料鉤A點和感測器的中心在同一條線上或者超出中心0.5mm。

7. 導向塊的檢查和調整

檢查導向塊的位置
將導向塊調整到使用者可以很容易取得到螺絲的合適位置，在實際調整中多試幾次是否可以輕鬆取到螺絲。

8. 導向槽的調整

鬆開裝導向槽的螺絲或者導向槽右邊導向塊的螺絲左右調整，放下批頭剛好對準螺絲的中心。

9. 軌道振動的檢查和調整

螺絲的傳送速度因螺絲型號不同而不同。此螺絲機根據改變馬達速度來調整螺絲的傳送速度。如果馬達速度使軌道振幅很大，那麼要使螺絲機停下來變會變得比較困難。所以應按照正在使用的螺絲的型號來調整軌道的速度以達到最合適的狀態。

10. 檢查感測器的中心

如果擋料鉤處沒有螺絲，感測器繼續運作，螺絲機就會一直工作，如果有螺絲，感測器每過一段時間停下來。螺絲機對有無螺絲的感應可按照上述提到的方法來調整。如果有必要使用很小的螺絲時，就調整感測器的位置。

10. The machine continues operation if there is no screw at the stopper section, and there are screws machine stops after a certain period of time has passed. The machine has the level of the screw/no screw sensor adjusted by the reference rail on shipment. However a level adjustment of the sensor is necessary when using thin-head screws.

Parameters

Screw head: Suits each tape of screw (Lmax=10mm)
 Output speed: 2 screw / s
 Input voltage: DC 15V/1200mA
 Product size: 180mmx125mm x150mm (L*W*H)
 Net weight: About 2.5 kg
 Accessories: Operational Guidelines, DC power supply (input 180-220V, output DC15V/1200mA) inward hexagonal key

螺丝机参数

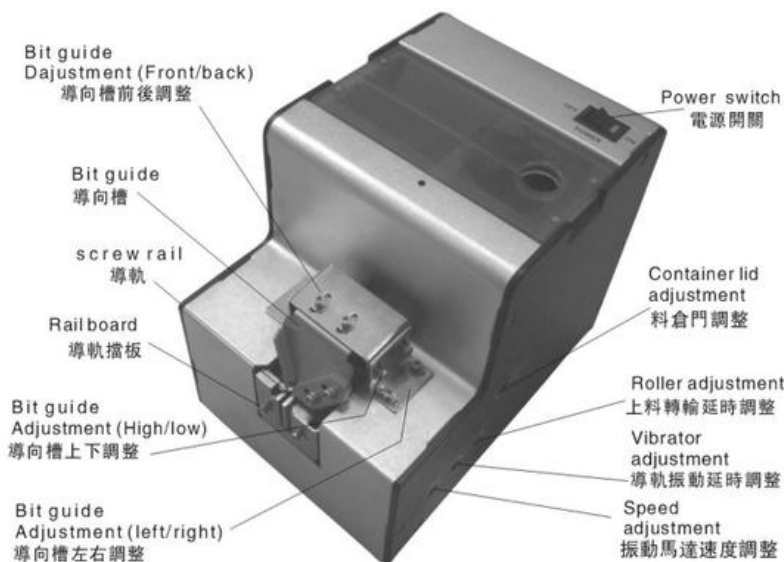
螺釘頭：適合各種型號螺絲 (最長L=10mm)
 輸出速度：2粒/秒
 輸入電壓：DC 15V/1200mA
 產品尺寸：180mmx125mmx150mm (長x寬x高)
 淨重：約2.5kg
 附帶配件：操作指南，直流電源 (輸入180-220V，輸出DC 15V/1200mA) 內六角扳手

常見故障處理方法

Fault solution

Description of parts and functions

部件及功能描述



(construction: Statistical function machine increase number-display panels and number-adjust keys, the other parts of the same.)

(注：帶計數功能螺絲機在此外形上增加數字顯示面板和數量調節鍵，其他部分相同)

Fault	Reasons	Solution
No power	1. Power supply is damaged 2. Switch damage 3. DC socket is problem	Check for update
Indicator lit but the machine does not work	1. Sensor located in wrong location or was blocked 2. The power cord motor is broken 3. Working parts of the machine are blocked (gear eccentric)	1. Check or adjust 2. Re-welding 3. Remove them from the machine
Screw was blocked in rail	Rail gap, platen or brush Position is wrong	Check and adjust
Screw leak out from material container	The apron of material container located in wrong location	Adjust the apron position
Keep vibrating and no stop	1. Feeding delay is too long 2. Sensor located in wrong location 3. Screw is not in the right position	Check and adjust Sensor is not in the right position
Screw transportation is too slow	1. Feeding speed is slow 2. delay time is too short 3. The gap of the rail is not suitable 4. The rail touches the board 5. No gap between rail and front board 6. There are dropped Screws between vibratory motor and bottom board	1. Adjust the motor speed 2. Increase the feeding delay 3. Adjust 4. Adjust the gap 0.5~1mm 5. Adjust the gap 0.5~1mm 6. Remove the dropped screws

故障	原因	處理方法
螺絲機沒電	1. 電源壞 2. 開關壞 3. DC插座壞	檢查更新
電源燈亮機器不工作	1. 出口感測器沒對好位置或物品擋住 2. 馬達電源線斷 3. 螺絲機活動部件被卡住 (偏心輪處, 齒輪處)	1. 檢查或調整 2. 重新焊接 3. 清除活動部件異物
料道卡螺絲	刷子高低、料道間隙、壓板位置未調好	檢查後做相應調整
料倉漏螺絲	料倉擋板上下左右位置未調整好	調整擋板位置
出口一直振動不停	1. 直振送料延時太長 2. 出口感測器位置不合適 3. 擋料鉤尾部沒在感測器感測範圍內	做相應調整
出螺絲太慢	1. 送料供料速度慢 2. 延時時間短 3. 導軌間隙調整不合適 4. 擋板頂住導軌 5. 導軌與前板處無間隙 6. 振動電機與底板之間有異物	1. 調長送料供料延時 2. 調整馬達速度 (SPEED) 3. 做相應調整 4. 調整間隙 (0.5~1毫米) 5. 調整間隙 (0.5~1毫米) 6. 清除異物

Operations

1. Adjusts parameter suitable (the methods will be told next).
2. Open the lid, pours into groups the bolt for the material stock.
3. Turn on the power button, put the electric screwdriver head into guide slot, down along the guide slot, pull out the screw bolt go straight.

使用方法

1. 調整好適合的參數（調整方法見下面）。
2. 打開倉蓋，將螺絲釘成批倒入供料室。
3. 打開電源，把批頭放入批頭導向槽處，順着導向下滑，然後朝面前拉出螺絲釘即可。

调节方法

Adjustment methods

调节方法

1. 料道調節



Release the screw on cover with hexagon wrench, pull out rail.

用內六角扳手鬆開料道擋板上一顆螺絲，拉出導軌



One end by adjusting the location of the three screws to adjust the track width. the other side by increase or reduce the number of small pieces to adjust the gap, in order to adapt to different sizes of screws. After adjustment locking screw.

一端通過調整三個螺絲的位置來調整軌道寬窄，另一端通過加減小片來調整間隙，以此來適應不同大小的螺絲，調好後把螺絲鎖緊。



Adjustment tools
調節工具



Adjust the brush position according to the screw size. Under normal circumstances, after the former high-low

根據螺絲大小調整刷子高低位置，一般情況下調整為前低後高

2. Speed adjustment

(1) Characteristics of motor speed:

2. 速度調整

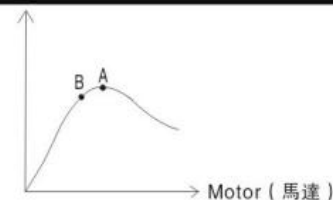
(1) 振動馬達速度 (SPEED) 特性：
Guide (V導軌)



Speed adjustment buttons
速度調節鍵



The graph for motors speed and rail speed.



馬達速度和導軌速度關係

(2) Roller delay adjustment:
when the screw is large or not conducive to access to rail, increase the roller delay, in contrast reduce it.

(2) 上料轉輪延時 (ROLLER) 調整：
當螺絲較大或螺絲外形不利進入導軌槽時，將轉輪延時調長，反之螺絲較小時調短。

(3) Guide vibration delay adjustment:
The same, when the screw is large or not conducive to access to rail, increase the roller delay in contrast reduce it.

(3) 導軌振動延時 (VIBRATION) 調整：
同樣，螺絲較大或外形不利進入導軌槽時，將振動延時調長，反之，螺絲較小時調短。

In order to check screw more easier, you need to pay attention to the following five-point

1. The Bit guide slot and the Bit guide rail must be a central line, and the guide slot must suppress the Screw cap.
2. The Bit guide slot "v" around the trough place position must be appropriate, take just exposed the cross slot of screw cap as suitably.
3. Suggested that keep the electric screw driver revolving to take the bolt, like this will more labor-saving.
4. Every two months, moving parts should be added the appropriate lubricants, in order to maintain the normal operation.
5. When troubles appeared, such as screw struck, abnormal alarm, unpleasant smell emanated, you should stop using and turn off the power immediately. Check the problems and adjust it. If you are unable to resolve the fault, please contact the dealer.

為了使取螺絲更輕鬆，還需注意以下五點：

1. 導向槽必須與導軌對中，並且導向槽必須將螺絲帽壓住；
2. 導向槽 "V" 槽處前後位置必須合適，以剛好露出螺帽十字槽為宜；
3. 建議使電批旋轉着取螺絲，這樣將會更省力。
4. 運動部件每隔兩個月應適當加潤滑油，以使運轉正常。
5. 當出現卡螺絲、報警器異常報警、產生難聞的氣味等異常情況時，應立即停止使用，關掉電源，檢查調整。如遇自己不能解決的故障，請聯系經銷商維修。

The electric control part is composed of digital tubecounters and circuit board, circuit board setting method is as follows: press the function key (the SET key), and keep 3 seconds, digital tube digital flicker, into the first layer function table, and then pressing the button or decrease key, set digital to the required quantity, the set range is 0-9999

Press the STE key and hold for 3 seconds, flashing LED, to enter the second level menu, press the key or keys to change increase decrease digital,1 of which are automatic working mode -- that is set to reach the number after the buzzer alarm sound, and automatic zero, to a new operating cycle (in this way point machine no practical significance); 2 is the manual working mode -- that is to set the volume, buzzer alarm sound, and stop feeding, wait for the operator to manually by pressing SET key reset, can be cleared and continue to the next operating cycle;3 is a continuous count without alarm mode, the counter will always count on.

Press the SET key and hold for 3 seconds, digital tube flicker, into the third layer function table, digital tube display is the first stage number

Press the SET key and hold for 3 seconds, digital tube flicker, into the fourth layer function table, digital tube display is included in the second stage of the vertical vibration of the vibration frequency, the vibration motor second stage speed. This explanation is as follows: the two stage speed feed is to satisfy the accurate count, if only one stage of feeding, when the feeding to the set number, although feeding stop screw, but because of inertia will continue to come out some material, so that at the accurate counting. Thus, the program can set two stage feeding, to set the discharging quantity is 10, then the counter first set to 9, second to 10, when the screw is achieved 9, the program automatically into the fourth layer function table set straight vibration frequency, the n track of the screw slow up, reaching 10, the buzzer alarm and stop feeding. When the artificial press reset button, start feeding, starting a new cycle.

Press the SET key and hold for 3 seconds, flashing LED, to enter the fifth level menu,1 of which is set to reach the number after the buzzer alarm sound,0 do not alarm. At this point, the program was set to end

电控部分由数码管计数器和电路板组成,电路板设定方法如下:按下功能键(SET键),并保持3秒,数码管数字闪烁,进入第一层功能表,然后按增加键或减少键,设置数位至需要的数量,其设定范围是0-9999;

再次按下STE键并保持3秒,数码管闪烁,进入第二层菜单,按下增加键或减少键改变数字,其中1是自动工作模式——即到达设定数量后蜂鸣器报警一声,并自动复零,继续新的一个工作循环(此方式在点数机上没有实用意义);2是手动工作模式——即到达设定数量后,蜂鸣器报警一声,并停止供料,等待操作者手动按下SET键复位,方可清零并继续下一个工作循环;3是连续计数而不报警的工作模式,计数器将一直计数下去。

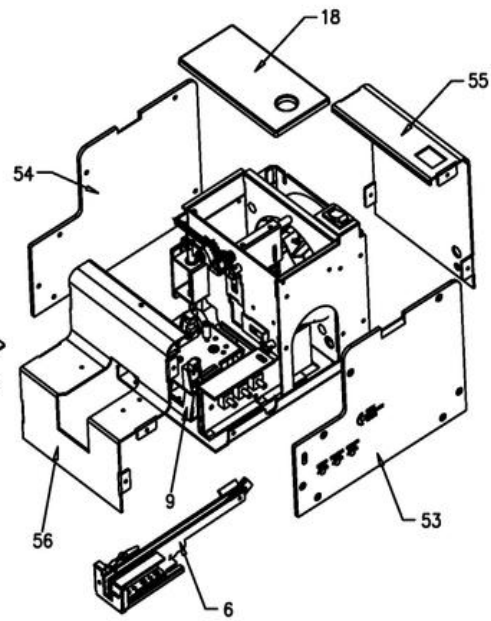
再次按下SET键并保持3秒钟后,数码管闪烁,进入第三层功能表,数码管显示的是第一阶段数量;

再次按下SET键并保持3秒钟,数码管闪烁,进入第四层功能表,数码管显示的是计入第二阶段的直振的振动频率,即第二阶段振动马达的转速。此项解释如下:之所以用两段速度送料是为了满足计数准确的目的,若只有一个阶段供料,则当供料到设定数量时,虽供料停止,但螺钉会因为惯性会继续出来几个料,使计数不准确。因此,程式裡可以设定两个阶段供料,如要设定出料数量是10个,则把计数器的第一段设定为9个,第二段为10个,当螺钉达到9个时,程式自动转入第四层功能表设定的直振振动频率,则轨道里的螺钉慢速出来,达到10个时,蜂鸣器报警并停止供料。当人工按下重定键后,启动供料,开始新的一个循环。

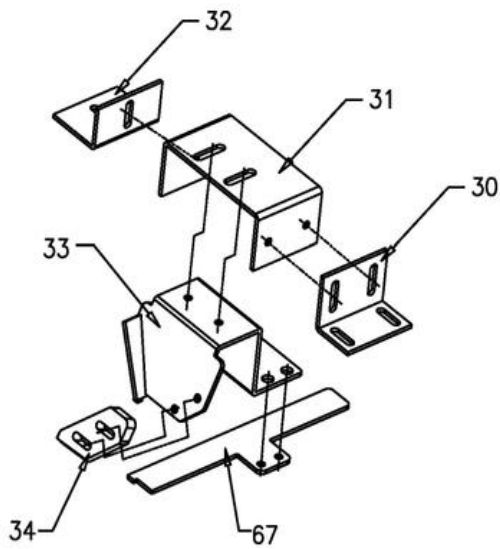
再次按下SET键并保持3秒钟,数码管闪烁,进入第五层菜单,其中1为到达设定数量后蜂鸣器报警一声,0为不报警。至此,程式设定结束。

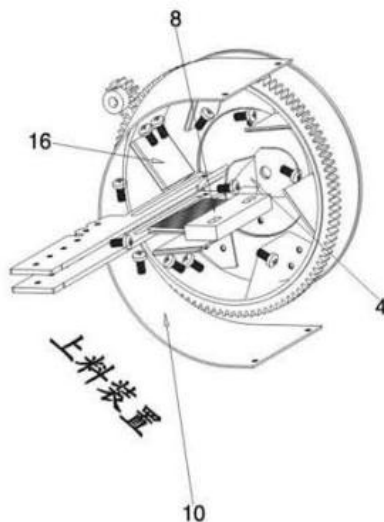
螺丝机的保养

序号	保养部位或组件	保养内容
1	导轨	1.每隔15日用酒精清洗导轨内侧面 2.建议每隔两个月对导轨用退磁器进行退磁
2	料满停机传感器	建议每隔半年对料满停机传感器用酒精擦拭清晰
3	齿轮传动副	对齿轮传动副应每隔三个月加注润滑油
4	传动杆滑动副	对传动杆滑动部位应每个三个月加注润滑油
5	直振	每隔半年对直线输送器的所有螺钉检查有无松动并紧固

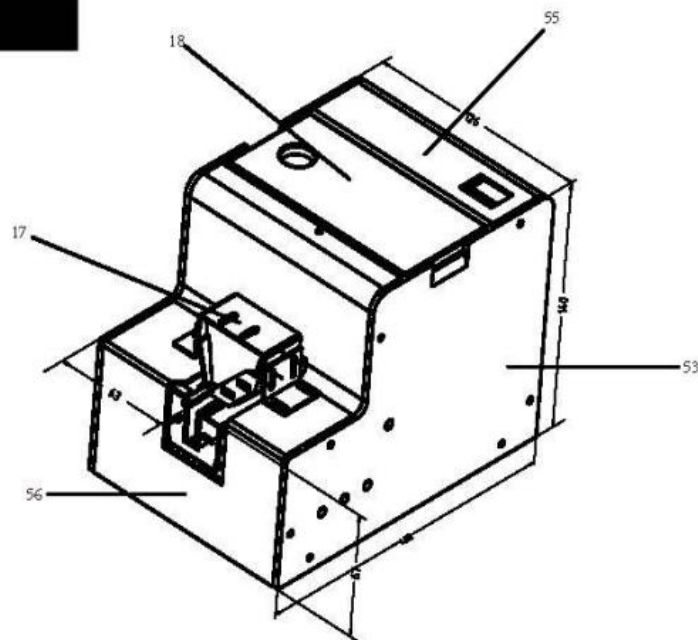


导向槽图/传动装置





外观图



编号	中文名称	英文名称	数量
1	电路板	Circuit board	1
2	底板	Bottom board	1
3	电路板支架	Circuit board holder	1
4	料斗	Transition plate	1
5	推杆	Brush lifter	1
6	导轨组件	Screw rail	1
7	减速电机	Gear motor	1
8	毛刷	Brush	1
9	直振组件	Feeder	1
10	料仓	Container	1
11	电源开关	Power switch	1
12	齿圈	Gear wheel	1
13	中板	Middle board	1
16	拨料片	Screw lifter	6
17	导向槽组件	Bit guide	1
18	盖板	Cover board	1
19	弹片	Stopper spring leaf	1
20	挡料钩	Stopper	2
21	挡料钩安装块	Stopper holder	1
22	导轨安装板	Screw rail holder	1
23	左导轨	left screw rail	1
24	右导轨	Right screw rail	1
25	左出口连接块	Left fixing plate	1
26	右出口连接块	Right fixing plate	1
27	前挡板	Rail board	1
28	导轨安装座	Guide rail frame	1
29	导向块	Guide plack	1
30	导向槽右支架	Right bit guide holder	1
31	桥型支架	Bit guide upper holding plate	1

部件名称表

编号	中文名称	英文名称	数量
32	导向槽左支架	Left bit guide holder	1
33	导向槽	Bit guide	1
34	菱形块	Rhombus plate	1
35	锁杆	Locking screw	1
36	右传感器支座	Right sensor frame holder	1
37	右传感器支架	Right sensor frame	1
38	左传感器支座	Left sensor frame holder	1
39	左传感器支架	Left sensor frame	1
40	偏心轮	Eccentric wheel	1
41	振动电机	Vibration motor	1
42	振动电机安装架	Vibration motor holder	1
43	直振下板	Upper connector of feeder	1
44	直振上板	Bottom connector of feeder	1
45	弹簧片	Spring leaf of feeder	2
46	触发传感器支架	Trigger	1
47	触发传感器	Trigger frame	1
48	左对射传感器	Left sensor	1
49	右对射传感器	Right sensor	1
50	凸轮	Cam	1
51	上挡料板	Screw block plate	1
52	后板	Rear board	1
53	右面板	Right cover	1
54	左面板	Left cover	1
55	后面罩	Rear cover	1
56	前面罩	Front cover	1
57	小齿轮	Little gear	1
58	传动轴支架	Axis holder	1
59	传动轴尼龙套	Nylon tube	1
60	传动轴	Axis	1

部件名称表

编号	中文名称	英文名称	数量
61	减速电机支架	Motor holder	1
62	推杆轴承	Bearing	1
63	毛刷支架	Brush holder	1
64	毛刷摆动杆	Brush oscillating rod	1
65	挡料钩小套	Bush	1
66	扇形齿	Sector gear	1
67	压板	Press plate	1
68	导轨锁片	Rail fixed plate	1
69	调整片1.2mm	Tabs 1.2mm	5
70	调整片0.2mm	Tabs 0.2mm	5
71	小齿轮	Little Gear	1
72	前板尼龙套	Nylon tube	1
73	平垫	Washer	1
74	毛刷锁片	Brush Connecting piece	1
75	拉簧	Extension Spring	1
76	扇形齿衬套	Sector gear tube	1
77	推杆轴承套	Brush lifter tube	1
78	上推杆支架尼龙套	Upper nylon tube	1
79	推杆支架	Brush lifter holder	1
80	下推杆支架尼龙套	Bottom nylon tube	1
81	DC插座	DC socket	1
82	中板轴承	Medium plate bearing	4
83	转轮定位盘	Wheel location plate	1
84	右板	Right board	1
85	左板	Left board	1
86	前板	Front board	1
87	扇形齿安装卡簧	Circlip	1
88	下挡料板	Screw block plate	1
89	橡胶脚垫	Rubber foot	4
90			