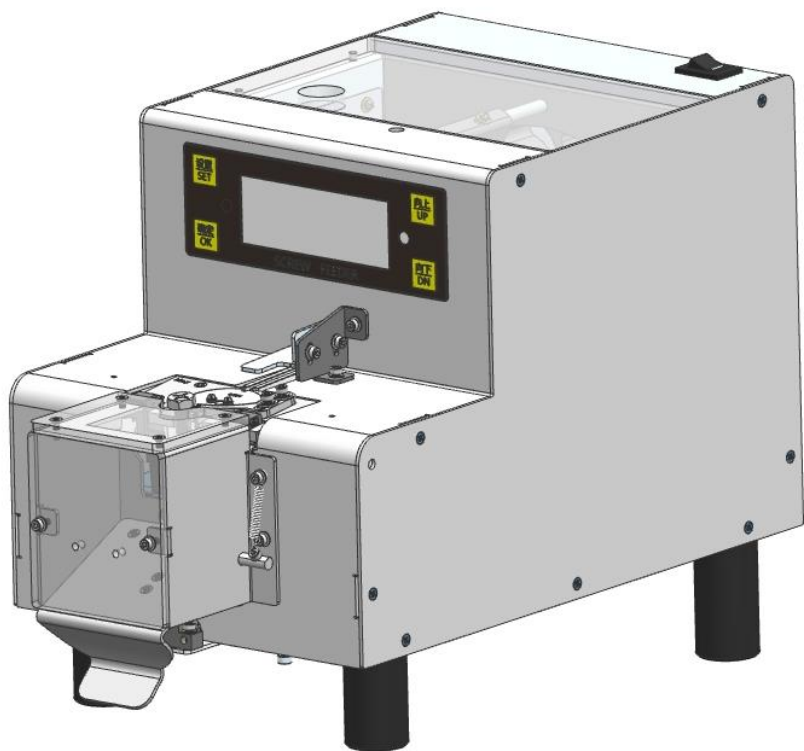


# 大型转盘式精密螺丝点数机

## 使用说明书



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## 安全警告



## Safety precaution

1. 不可拆卸 AC 电源适配器，因为有触电、火灾或故障的危险。不要损坏、修改或更换电源线。不要把重物放在电线上。
2. 不要拉扯电缆，因为它可能会造成电源短路，而导致火灾或触电的危险。
3. 不要用湿手接触电源适配器，因为它会引起触电。
4. 使用电源为 AC110V~240V，切勿使用超载电源，不要修改或改动这台设备，因为这可能引起火灾或者触电危险。
5. 不可在危化品/气体附近操作机器，因为可能引起火灾爆炸的危险。
6. 当你发现过热、冒烟、刺鼻气味或其它不正常情况时，立即停止操作机器，从电源插座拔下电源适配器，因为可能有火灾或电击的危险。联系经销商，对该机器进行检查和修理。
7. 在雷雨天气时，停止操作机器并关闭电源，从电源插座拔下电源适配器，如附近有闪电和雷声，请远离机器，不要触摸电源适配器；在打雷停止时，确认安全的情况下，检查机器，如果有任何异常，请联系经销商处理。
8. 本产品属于电器自动化设备，请严格遵守使用规范。使用之前请仔细阅读此说明书；如遇任何不能解决的问题，请联系经销商。

1. Do not disassemble the AC power adapter as there is a risk of electric shock, fire or malfunction. Do not damage, modify or replace the power cord. Do not put heavy objects on the wires.
2. Do not pull on the cable as it may cause a short circuit in the power supply, which may result in fire or electric shock.
3. Do not touch the power adapter with wet hands as it can cause electric shock.
4. Use AC110V~240V power supply. Do not use overload power supply. Do not modify or change this equipment as this may cause fire or electric shock.
5. Do not operate the machine near hazardous chemicals/gases as it may cause fire or explosion hazard.
6. When you notice excessive heat, smoke, pungent odor, or other abnormal conditions, immediately stop operating the machine and unplug the power adapter from the power outlet as there is a risk of fire or electric shock. Contact your dealer to inspect and repair the machine.
7. In the thunderstorm, stop operating the machine and turn off the power. Unplug the power adapter from the power outlet. If there is lightning and thunder nearby, please stay away from the machine and do not touch the power adapter. When the thunder stops, check the machine in safe situation and contact the dealer for any abnormalities.
8. This product belongs to electrical automation equipment. Please strictly abide by the application specifications. Please read this manual carefully before use; if you have any problems that cannot be solved, please contact your dealer.

## 螺丝机特点

### 1. 适用范围广

广泛适用多种类型和长度的螺钉，如 M2.0-M6.0 标准螺丝，特殊螺丝，短螺丝、自攻螺丝、带垫片螺丝等。

### 2. 运转流畅

螺丝在滚筒内运转，凡是未按正确方向进入轨道的螺丝，都会掉落到滚筒内，进入下个循环，无卡螺丝现象。

### 3. 工作效率可调节

送料与振动独立控制，可自由设定理想的延时时间，齿轮上料转盘与四分度取料圆盘独立控制，可依不同螺丝而自行设定运行速度，以调节螺丝上料及分料速度快慢，适合多种作业。

### 4. 可大幅提高生产效率

螺钉自动分度至取料口位置，无需人工校正便可直接取料，生产效率大幅提高。

### 5. 有计数功能

计数功能自动报警、循环、带数字显示面板。

### 6. 有故障报警功能

当非正常情况发生时，螺丝机会自动启动报警装置。

## 使用须知

为了正确使用该设备，请仔细阅读说明书，请完成这些操作后妥善保管此说明书，以便有需求时，随时可以查阅并遵照说明操作。

## Features of screw feeder

### 1. Wide range of applications

It's widely applicable to many types and lengths of screws, such as M2.0-M6.0 standard screws, special screws, short screws, self-tapping screws, screws with washers, etc.

### 2. Smooth operation

The screw runs in the drum. Any screw that does not enter the track in the correct direction will fall into the drum and enter the next cycle without a screw getting stuck.

### 3. Adjustable work efficiency

Independent feeding and vibration control, the ideal delay time can be set freely, the gear feeding turntable and the four-division reclaiming disc are independently controlled, and the running speed can be set according to different screws to adjust the screw feeding and the feeding speed. It's suitable for a variety of operations.

### 4. Greatly improved productivity

The screw is automatically indexed to the position of the reclaiming port, and the material can be directly taken without manual correction. As a result, the production efficiency is greatly improved.

### 5. Counting function

The counting function automatically alarms, cycles, and has a digital display panel.

### 6. Fault alarm function

When an abnormal situation occurs, the screw feeder automatically activates the alarm device.

## usage notice

In order to use the device correctly, please read the manual carefully. Please keep this manual in good condition after you complete these operations, so that you can check and follow the manual whenever you need it.

一. 附件 (Accessories)



说明书一份  
One copy of the manual



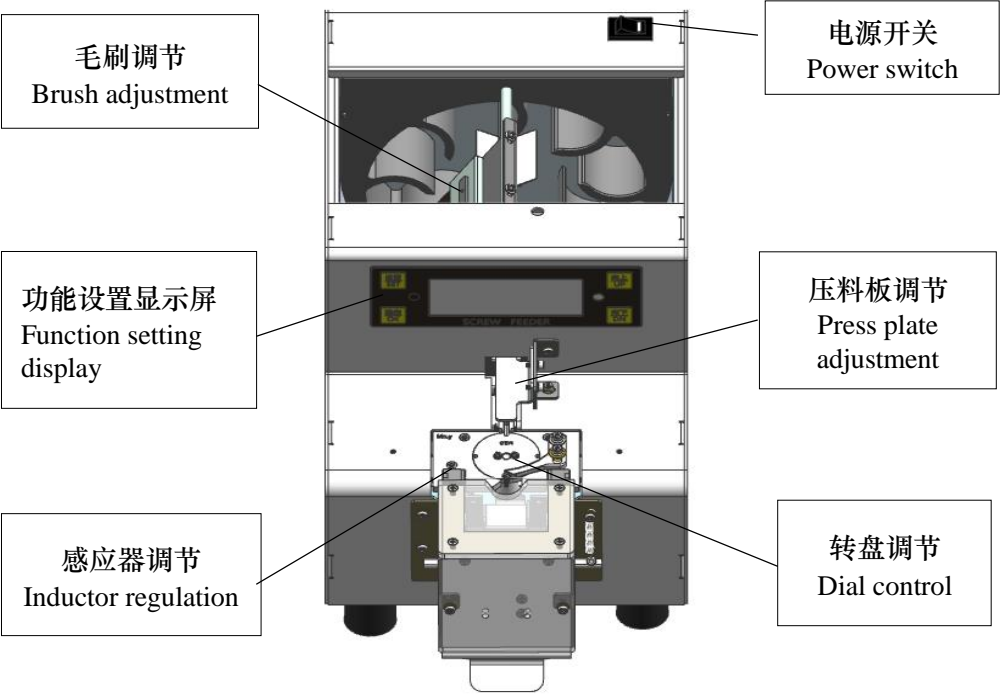
DC15V 电源适配器  
DC15V power adapter



内六角扳手  
Inner hexagon spanner

二. 主功能参数描述

II. Main function parameter description



输入电压: AC110V-240V 50/60HZ

输出电压: DC15V 1.5A

输出速度: 1 颗/秒  $\pm 0.3s$ .

产品尺寸: L329mm\*W173mm\*H230mm

净重: 约 5.3kg

适合螺丝: M2.0—M6.0

最大螺长:  $L \leq 25.0mm$

### 三. 安全使用

#### 1. 电源适配器

请使用本机附带的 DC15V 标配电源, 严禁使用其它电源适配器。

#### 2. 轨道

不要敲击轨道, 无需添加任何润滑剂在轨道上。

#### 3. 螺丝

不要使用有油污的螺丝, 脏螺丝或者其他任何一款规定以外的螺丝。

#### 4. 取螺丝

用电批或吸嘴取螺丝时不要过度用力或者给予较大的冲击力。

#### 5. 当机器不工作时

如果休息或者长时间不工作时, 请将电源拔出。

#### 6. 紧急处理

当你在操作机器过程中发现有异常现象, 譬如刺耳的声音时, 请立即停止机器运行, 关闭电源开关, 切断电源适配器连接。如果继续进行可能会导致失火、短路、性能失效或其他损坏。所以出现上述情况请及时与经销商联系。

#### 7. 售后服务

不要试图自行拆分, 修理机器尤其是说明书中特别提到的部分。有问题时请联系经销商, 请求售后服务并进行检修。

Input voltage: AC110V-240V 50/60HZ

Output voltage: DC15V 1.5A

Output speed: 1 pc/ sec  $\pm 0.3s$ .

Product size:

L329mm\*W173mm\*H230mm

Net weight: about 5.3kg

Suitable screws: M2.0—M6.0

Maximum screw length:  $L=25.00mm$

### III. Safe usage

#### 1. Power adapter

Please use the DC15V standard power supply supplied with this device. It is strictly forbidden to use other power adapters.

#### 2. Track

Don't hit the track. It's not required to add any lubricant on the track

#### 3. Screw

Do not use oily screws, dirty screws or any other screws other than those specified

#### 4. Take the screw

Do not use excessive force or give a large impact force when using the electric screwdriver or the nozzle to take the screw.

#### 5. When the machine is not working

If the machine is resting or not working for a long time, please unplug the power supply.

#### 6. Emergency treatment

When you find an abnormal phenomenon, such as a harsh sound, in operation, stop the machine immediately, turn off the power switch, and disconnect the power adapter. Failure to do so may result in fire, short circuit, performance failure, or other damage. Therefore, please contact the supplier in time in case of above situation.

#### 7. After-sales service

Do not attempt to disassemble it yourself, repair the machine, especially the parts specifically mentioned in the manual. If you have any questions, please contact the supplier, request after-sales service and carry out maintenance.

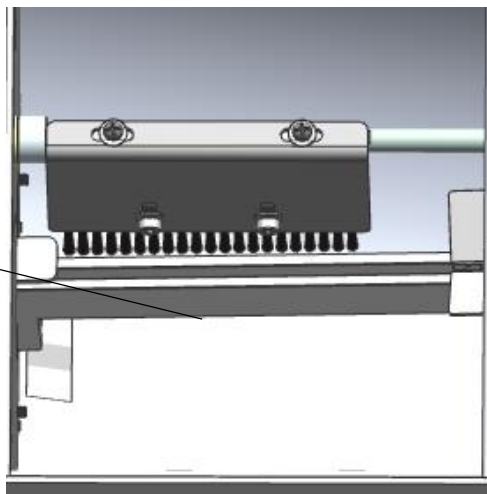
## 使用方法

1. 接通电源，打开电源开关，然后打开料兜盖板，将螺丝钉倒入螺丝点数机料仓内（注意：螺丝不宜倒入太多，倒入螺丝高度不要超过轨道下端面）
2. 螺丝点数机通电后运行，按照螺丝规格型号和使用需求，调整好合适的参数（详见调试方法和显示控制屏功能说明及调试）。
3. 按照设定的螺丝组别和数量，当螺丝运行至分度盘完成点数后，等待取出螺丝，将点数仓活动板按压到底取出螺丝（建议使用合适尺寸的小盒子接住待取出螺丝，避免用手拿螺丝时遗漏），取出螺丝后进入下一组点数循环。

## Usage method

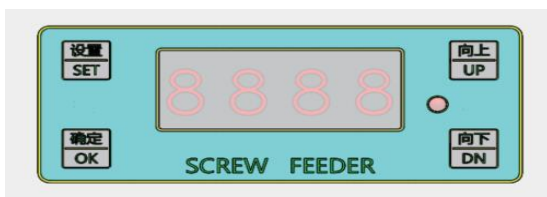
1. Turn on the power supply, turn on the power switch, then open the material cover plate, and pour the screws into the screw counting machine bin (note: the screws should not be poured too much, and the height of the screws should not exceed the lower end of the track)
2. After the screw counting machine is powered on, adjust the appropriate parameters according to the screw specifications and user needs (see debugging method and display control screen function description and debugging).
3. According to the screw group and number set by the user, when the screw runs until the indexing dial finishes counting, wait for the screw to be removed, press the movable board of the counting bin to remove the screw (it is recommended to use a small box of appropriate size to catch the screw to be removed, to avoid missing the screw when holding the screw by hand), remove the screw and enter the next set of counting cycle.

螺丝加料请勿超过  
导轨下端面  
Do not overcharge screws  
Lower face of rail



# 调试方法

## 1. 显示控制屏功能说明及调试



按住“设置”键 3 秒，进入设置界面，再每按下“设置”键进入下个参数设定，显示如下：（“\*\*”代表相关参数）

- |   |                 |
|---|-----------------|
| 1-** 为轨道振动大小调节；                                 | 2-** 为上料速度调节；   |
| 3-** 为分度转盘速度调节；                                 | 4-** 为轨道振动延时调节； |
| 5-** 为上料转盘延时调节；                                 |                 |
| 6-** 为异常报警延时调节（6-00 表示报警关闭，6-01 表示报警打开）         |                 |
| 7-** 为计数功能设置（7-01 表示计数打开，7-00 表示计数关闭）           |                 |
| 8-** 电源器输出 DC12v 或 15v 切换                       |                 |
| 9-** 为单组或多组点数组别调节（可设置 01-10 组点数组别）              |                 |
| 01**.....10**为各对应点数组别螺丝数量设定调节（螺丝数量设定范围 01-99 颗） |                 |

### 例如：设置 1 组 5 颗螺丝

操作步骤：按住【设置】3 秒 → 短按【设置】键 8 次进入界面“9-\*\*” → 按【向上/向下】调整为“9-01” → 短按【设置】进入“01\*\*”界面 → 按【向上/向下】调整为“0105” → 按下【确定OK】键保存并退出设置页面，设置完成。

### 例如：设置 3 组，分别 3、5、8 颗螺丝

操作步骤：按住【设置】3 秒 → 短按【设置】键8次进入界面“9-\*\*” → 按【向上/向下】调整为“9-03” → 短按【设置】进入“01\*\*”界面 → 按【向上/向下】调整为“0103” → 短按【设置】进入“02\*\*”界面 → 按【向上/向下】调整为“0205” → 短按【设置】进入“03\*\*”界面 → 按【向上/向下】调整为“0308” → 按下【确定OK】键保存并退出设置页面，设置完成。

在各对应界面上，按“向上/向下”可增加/下调相关对应参数值，按下“确定OK”键保存并退出设置页面。工作模式下，长按“向上”键螺丝暂停点数。

## 1. Display control panel function description and debugging



Press and hold the "Set" key for 3 seconds to enter the setting interface, and then press the "Set" key to enter the next parameter setting, the display is as follows:

("\*\*" represents relevant parameters)

1-\*\* for the size of the track vibration adjustment;

2-\*\* for the feeding speed adjustment;

3-\*\* Speed adjustment for indexing turntable;

4-\*\* for track vibration delay adjustment;

5-\*\* Delay adjustment for the feeding turntable;

6-\*\* Adjustment for abnormal alarm delay (6-00 indicates alarm off, 6-01 indicates alarm on)

7-\*\* Set for count function (7-01 for count on, 7-00 for count off)

8-\*\* Power supply output DC12v or 15v switching

9-\*\* Adjust for single or multiple groups of points (01-10 groups of points can be set).

01 \*... 10\*\* Set adjustment for the number of screws in each corresponding number group (screw number set range 01-99).

**For example, set a set of 5 screws. Procedure:**

Press and hold [Settings] for 3 seconds → Press the [Settings] key eight times to enter the "9-\* \*" screen → Press [Up/down] to change to "9-01" → Tap [Settings] to enter the "01\* \*" screen → Press [Up/down] to adjust to '0105' → press [OK] to save and exit the setting page.

**The setting is complete. For example, set 3 groups of 3, 5, and 8 screws respectively.**

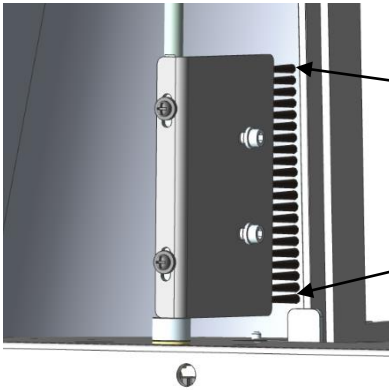
Press and hold [Settings] for 3 seconds → Press [Settings] eight times to enter the "9-\* \*" → Press [Up/down] to enter the "9-03" → Press [Settings] to enter the "01 \* \*" screen → Press [Up/down] to enter the "0103" → Tap [Settings] to enter "02 \* \*

"Interface → Press [Up/down] to adjust to" 0205 "→ Press [Settings] to enter the" 03 \* \*"interface → Press [Up/down] to adjust to" 0308 "→ Press [OK] to save and exit the setting page. The setting is complete.

On each screen, press Up or Down to add or lower parameter values. Press OK to save the Settings and exit the setting page. In working mode, long press the "Up" button to clear the screw count.

## 2. 刷子的检查/调整

检查刷子的高度，根据螺丝大小调整刷子高低位置，一般情况下调整为前低后高，如图：



如上图所示，将刷子安装在一个近似水平的位置，确保刷子的边缘可以刷到螺丝的头部。如果刷子的头部太高或者太低，都将会严重影响到螺丝的移动。如果需要调整，那就先松开开刷的螺丝来适当调整刷子的高度。

**要点：**为了避免损坏机器，调整机器前请将电源拔出

## 2. Check/adjust the brush

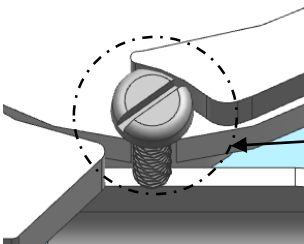
Check the height of the brush, adjust the height of the brush according to the size of the screw, generally adjusted to the front low and high, as shown in the figure:

As shown in the image above, mount the brush in an approximate horizontal position, making sure that the edge of the brush can be brushed to the head of the screw. If the head of the brush is too high or too low, it will seriously affect the movement of the screws. If you need to adjust, loosen the brush screws first to adjust the brush height properly.

**Point:** In order to avoid damage to the machine, please unplug the power supply before adjusting the machine

## 3. 调节挡钩的检查/调整

因螺丝规格型号大小不同，调试时如有螺丝掉不下来的情况发生，需要调整调节挡钩位置使螺丝能完全掉入料仓内，调整时以调节挡钩前端圆弧与螺丝帽圆弧重叠0.5-0.8mm左右，调整完成试机检测无异常后再正常使用。



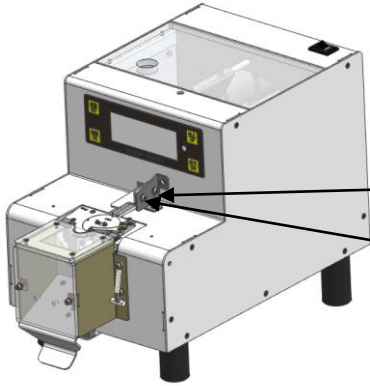
## 3. Check/adjust the adjusting hook

Due to different screw specifications, models and sizes, if the screw cannot fall off during debugging, it is necessary to adjust the position of the hook so that the screw can completely fall into the bunker. During adjustment, the overlap of the front arc of the hook and the arc of the screw cap is about 0.5-0.8mm. After adjustment, the machine can be used normally after no abnormality is detected.

挡钩圆弧与螺丝帽圆弧重叠  
The arc of the hook overlaps the arc of the screw cap

### 3. 压板的检查/调整

确保从压板出来的螺丝头部和压板之间的间隙 0.2-1mm 之间。如果没有间隙，螺丝不能正常出来；如果间隙过大，螺丝会重叠；如果需要调整，松开压板上的螺丝上下调整。如下图：



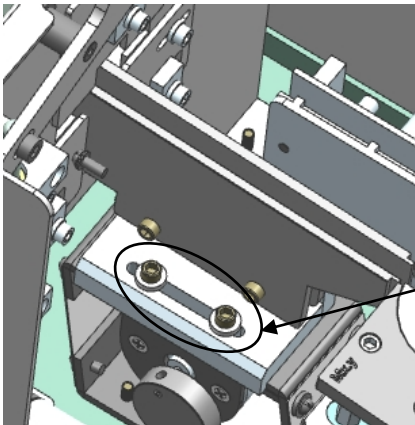
### 3. Inspection/adjustment of the pressure plate

Make sure that the clearance between the screw head and the pressure plate from the pressure plate is between 0.2 and 1 mm. If there is no clearance, the screws will not come out normally; if the clearance is too large, the screws will overlap; if adjustment is needed, loosen the screws on the pressure plate to adjust up and down, as shown below:

松/紧此处2颗螺丝  
Loosen/tighten 2 screws here

### 4. 轨道的检查/调整

确保轨道的间隙比螺丝的螺杆直径宽 0.2-0.4mm 之间。如螺丝排列不顺可用内六角扳手松开轨道挡板上两颗螺丝，拿出导轨，如图：

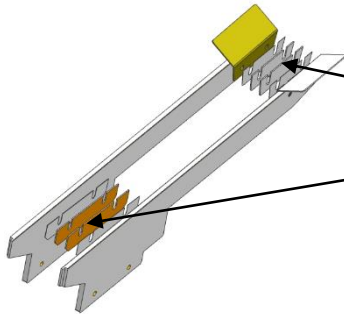


### 4. Inspection and adjustment of track

Make sure that the track clearance is 0.2-to-0.4 mm wider than the screw diameter. If the screws are not arranged properly, use the Allen wrench to loosen the two screws on the track baffle and pull out the guide rails, as shown in the figure:

松/紧此处2颗螺丝  
Loosen/tighten 2 screws here

一端通过调整两个螺丝的位置来调整轨道宽窄，另一端通过加减小片来调整间隙，以此来适应不同大小的螺钉，调好后把螺丝拧紧。



Adjust the position of the two screws at one end to adjust the width of the track, and adjust the clearance by increasing or decreasing small piece at the other end to adapt to the screws of different sizes. After adjusting, tighten the screws.

增减此处填充片可调节导轨宽度  
Add or subtract the filler plate here to adjust the width of the guide rail

## 5. 分度盘（转盘）的检查/调整

检查分度盘和导轨在工作中，分度盘开口处和导轨开口是否对应，然后锁紧固定螺丝，分度盘和轨道连接处间隙按螺丝规格大小调整（约为 0.3-1.0mm）。

## 5. Inspection and adjustment of the indexing turntable

Check that in the turntable and guide rail operation, the opening of the indexing turntable corresponds to the guide rail, and then lock the fixing screw. The clearance between the turntable and the track joint is about 0.3mm.

## 6. 轨道振动的检查/调整

螺丝的传送速度因螺丝型号的不同而不同。可改变马达速度来调整螺丝的传送速度。如果马达速度快使轨道振幅大，螺丝易重叠而造成卡料；如马达速度慢使轨道振幅小，螺丝在轨道内移动慢，易造成送料不足；所以应按照不同型号螺丝调整轨道速度以达到最适合的状态。

## 6. Inspection and adjustment of track vibration

The transfer speed of the screws varies depending on the type of screw. The motor speed can be changed to adjust the screw transfer speed. If the motor speed is fast and the track amplitude is large, the screws may overlap and cause jamming; if the motor speed is slow, the track amplitude is small, and the screw moves slowly in the track, which may cause insufficient feeding; therefore, the track speed should be adjusted according to different types of screws to achieve the most suitable state.

## 7. 对射感应器检查/调整

如果取料口处没有螺丝，感应器信号接通，螺丝机分度转盘将一直转动；如果有螺丝，感应器信号断开，螺丝机分度转盘将会停止，有无感应信号可按照上述提到的方法来判定，并可通过调节对射感应器的固定上下位置进行调整其信号。

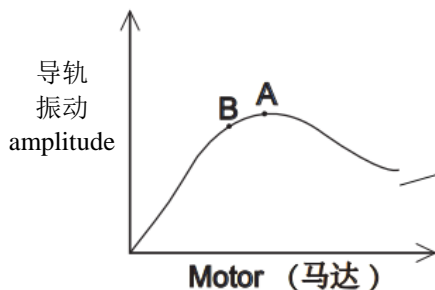
## 7. Inspection/adjustment of the thru-beam sensor

If there is no screw at the reclaiming port, the sensor signal is turned on, the screw feeder indexing turntable will keep turning; if there is a screw, the sensor signal will be disconnected, the screw feeder indexing turntable will stop, and the presence or absence of the sensing signal can be checked as mentioned above. The signal can be adjusted by adjusting the fixed upper and lower position of the radiation sensor.

## 维护与保养

### 1. 速度调整

#### A. 振动马达速度特性:



马达速度与轨道的  
振动关系  
Motor speed versus track  
amplitude

B. 上料转盘延时的调整: 当螺钉较大或螺钉外形不利进入导轨槽时, 将转盘延时调长, 反之螺钉较小时调短。

C. 轨道振动延时调整: 同样, 螺钉较大或外形不利进入导轨槽时, 将振动延时调长, 反之螺钉较小时调短。

### 2. 为了使取螺钉更轻松, 还需注意以下几点:

A. 转盘必须与导轨对中, 并且压板必须将螺钉帽护住。

B. 运动部件每隔三个月适当加注润滑油, 使设备运转顺畅。

## Maintenance

### 1. Speed adjustment

#### A. Vibration motor speed characteristics:

B. Feeding runner delay adjustment: When the screw is large or the screw shape is unfavorable to enter the rail slot, the delay of the runner is lengthened, and when the screw is small, it is shortened.

C. Orbital vibration delay adjustment: Similarly, when the screw is large or the shape is unfavorable to enter the guide rail slot, the vibration delay is lengthened, and when the screw is small, it is shortened.

### 2. In order to make the screw removing easier, please note the following points:

A. The turntable must be centered with the rail and the pressure plate must protect the screw cap.

B. The moving parts are properly filled with lubricating oil every three months to make the equipment run smoothly.

### 3. 螺丝点数机保养

序号	保养部件与组件	保养内容
1	导轨	1. 每隔 15 日用酒精清洗（擦拭）导轨内侧面 2. 建议每隔 2 个月对导轨用消磁器进行消磁处理
2	对射传感器	建议每隔半月对前端对射传感器用酒精擦拭清洗
3	传动齿轮	每隔三个月加注润滑脂
4	扫料传动导杆	每隔三个月加注润滑脂
5	直振机构件	每隔半年对所有螺钉检查有无松动并紧固

### 3. Screw feeder maintenance

No.	Maintenance parts and components	Maintenance content
1	Guide rail	1. Clean (wipe) the inner side of the rail with alcohol every 15 days 2. It is recommended to degauss the rail with a degaussing device every 2 months
2	Thru-beam sensor	It is recommended to wipe the front-end thru-beam sensor with alcohol every half month
3	Drive gears	Fill grease every three months
4	Sweeping drive guides	Fill grease every three months
5	Direct vibration mechanism	Check all screws for looseness and tighten every six months

## 故障处理

故障	原因	处理方法
螺丝机没电	1. 电源坏 2. 开关坏 3. DC 插座坏	更换配件
电源灯亮 机器不工作	1. 出口感应器没对好位置或物品挡住 2. 马达电源线断 3. 螺丝机活动部件卡住（偏心轮处，齿轮处）	1. 检测或调整 2. 重新焊接 3. 清除活动部件异物
轨道卡螺丝 料仓漏螺丝	刷子高低、轨道间隙、压板位置未调好，料仓挡板上下左右未调好	检测后做相应调整，调整挡板位置
信号灯长亮	1. 对射感应器损坏 2. 传感器支架下沉	1. 检查更新 2. 检查后做相应调整
出口一直 震动不停	1. 直振送料延时太长 2. 出口感应器位置不合适 3. 螺丝头位置没在感应器检测范围内	做相应调整
出螺丝太慢	1. 送料供料速度慢 2. 延时时间短 3. 轨道间隙调整不合适 4. 挡板顶住导轨 5. 轨道与前板处无间隙 6. 振动电机与底板之间有异物	1. 调整马达速度 2. 加大送料供料延时 3. 做相应调整 4. 调整间隙（0.5-1mm） 5. 调整间隙（0.5-1mm） 6. 清除异物

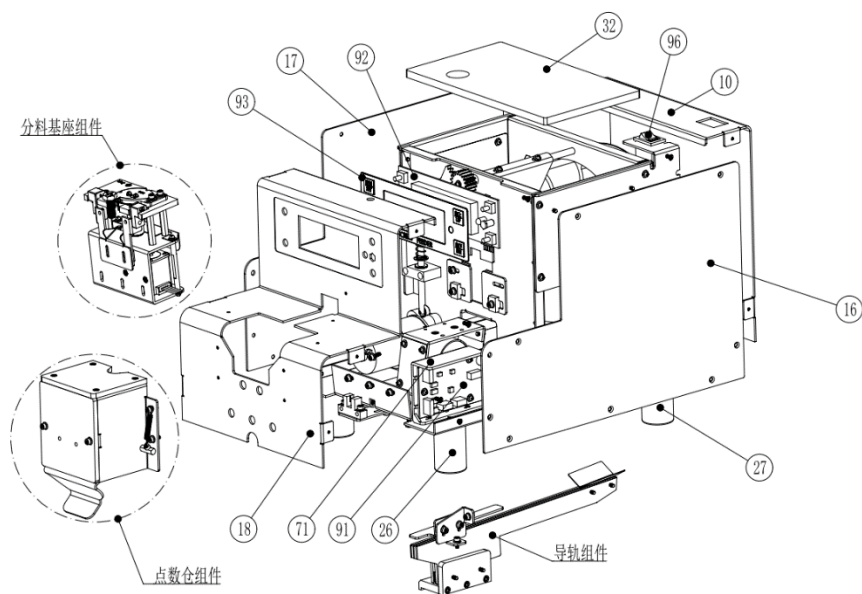
# Troubleshooting

Fault	Reason	Treatment method
The screw feeder is dead	1.The power supply is broken. 2. The switch is broken. 3. The DC socket is broken	Replace parts
The power light is off and the machine is not working	1.The exit sensor is not placed in right position or blocked by items 2.Motor power line is broken 3.The moving parts of the screw feeder are stuck (at the eccentric wheel, at the gear)	1. Detect or adjust 2. Re-weld machine 3.Remove moving parts foreign objects
Screw stuck in track Screw missed in silo	Brush height, track clearance, pressure plate position is not adjusted, the silo baffle is not adjusted in all directions	Make corresponding adjustment after detection and adjust the position of baffle
The signal light is long on	1.The sensor is damaged 2.Sensor bracket is sinking	1. Check for updates 2.Make adjustments after inspection
Export keeps vibrating	1.Direct vibration feed delay is too long 2.The exit sensor position is not suitable 3.The screw head position is not within the sensor detection range	Make adjustments accordingly
The unscrewing is too slow	1.The feeding rate is slow 2.Short delay time 3.Track clearance adjustment is not suitable 4.The baffle is against the guide rail 5.There is no clearance between the track and the front plate 6.There is a foreign object between the vibration motor and the bottom plate	1.Adjust the motor speed 2.Increase the feeding delay 3.Makethe appropriate adjustments 4. Adjust clearance (0.5-1mm) 5. Adjust clearance (0.5-1mm) 6.Remove foreign objects

## 结构零件图 Structural part drawing

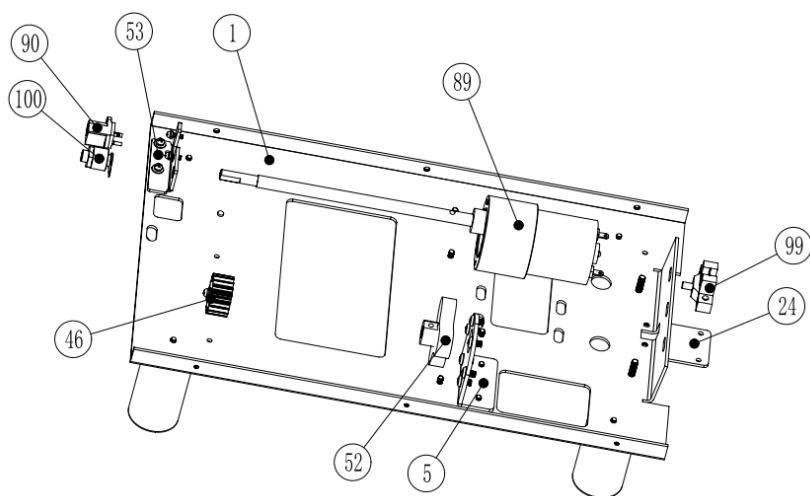
总外观装置分解图

General appearance unit breakdown drawing



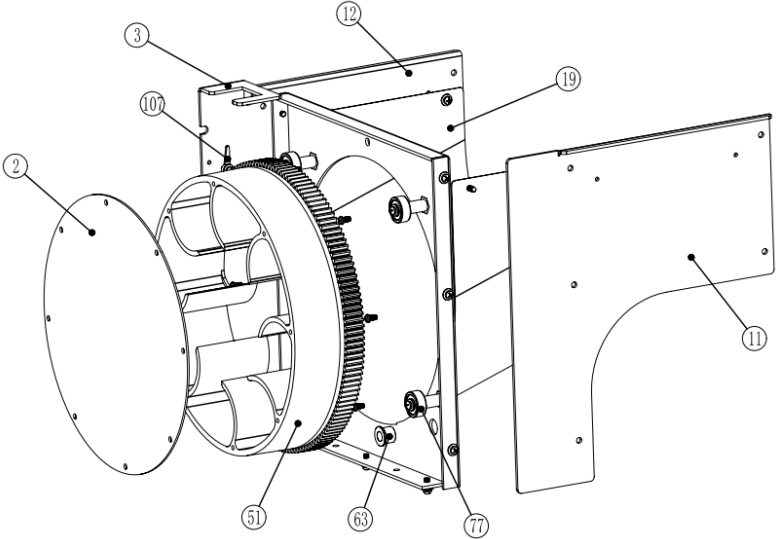
底板装置分解图

Base plate unit breakdown drawing



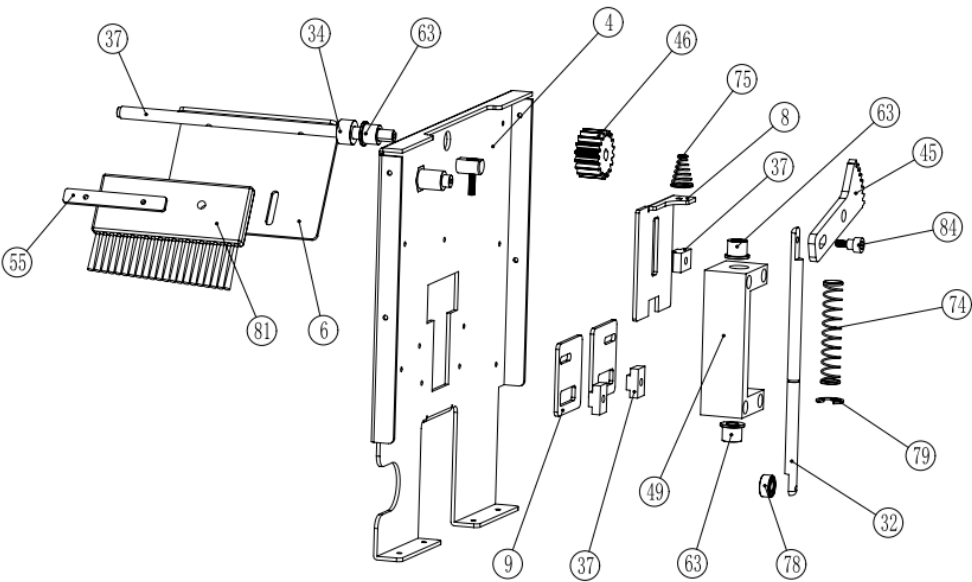
兜料装置分解图

Material loading device breakdown drawing



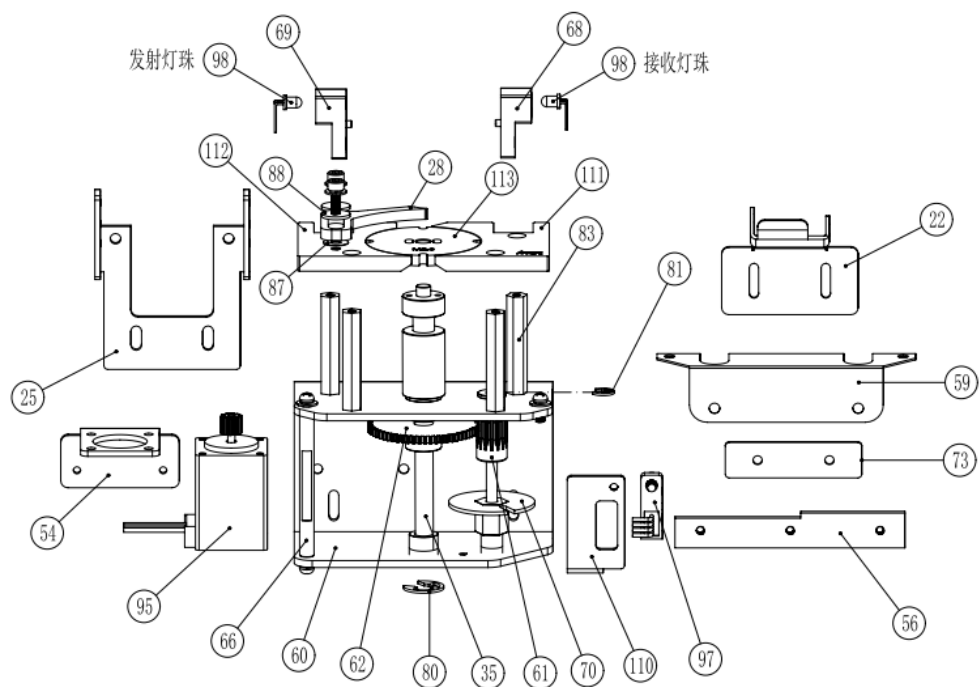
扫料装置分料图

Sweeping unit dispensing drawing

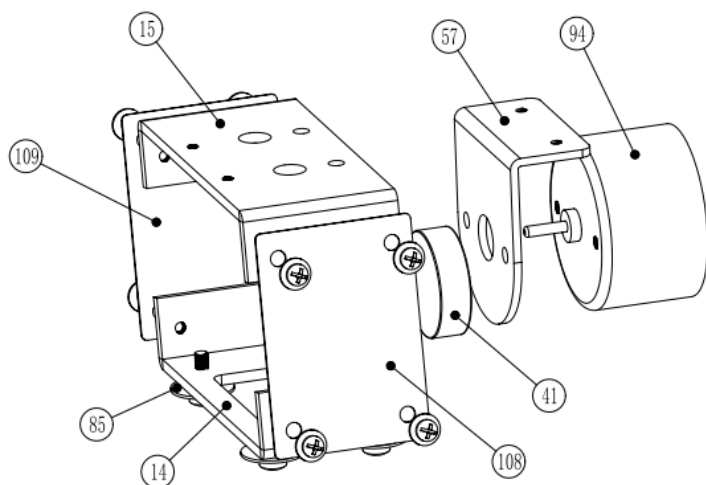


# 分料组件分解图

## Dispensing component breakdown drawing

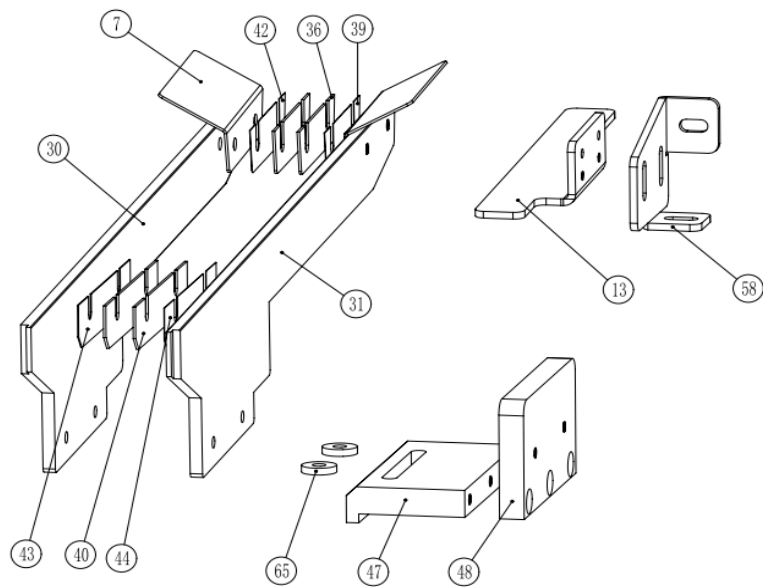


## Direct vibration unit breakdown drawing



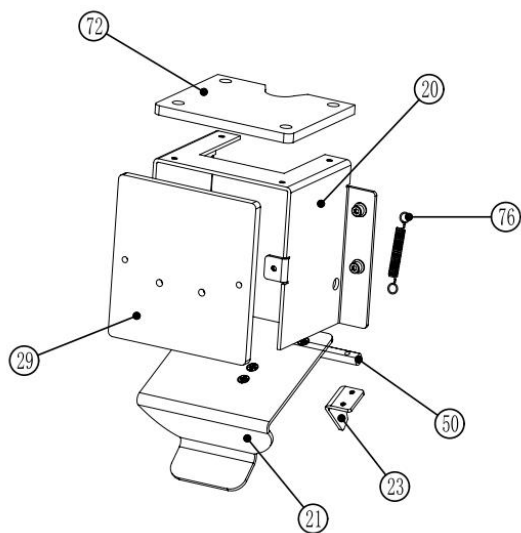
导轨组件分解图

Rail component breakdown drawing



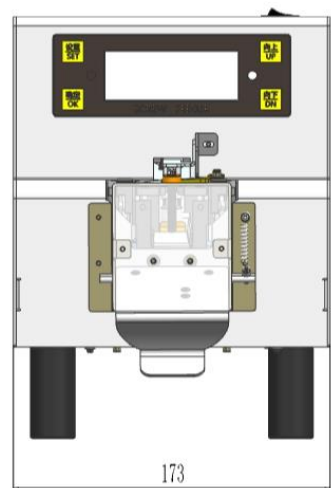
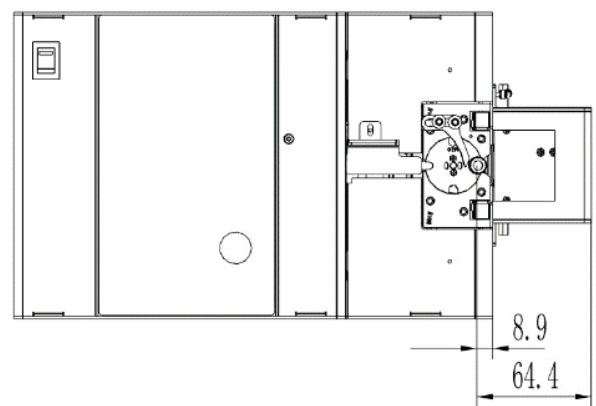
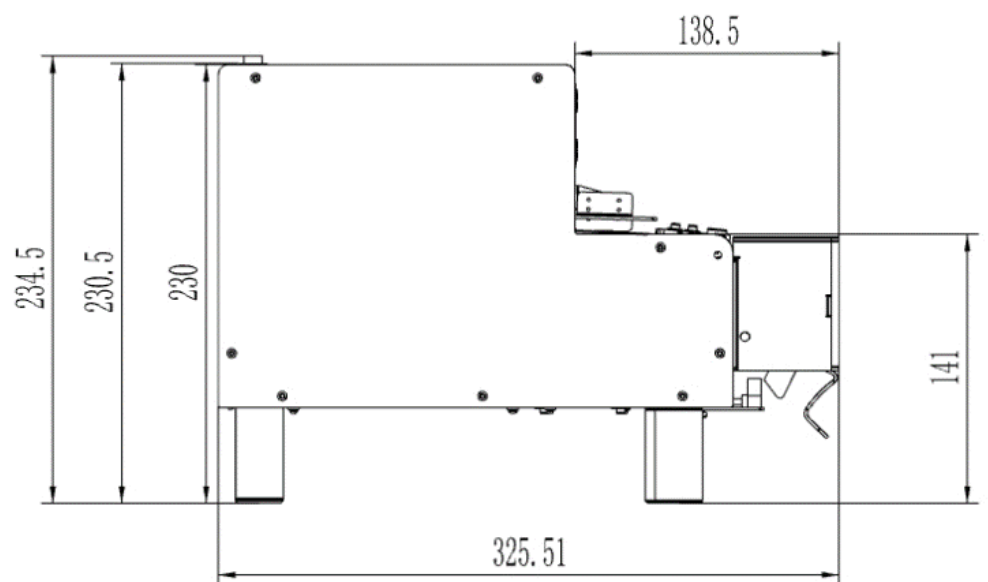
点数仓装置分解图

Breakdown diagram of bin device



外观尺寸图

Appearance dimension drawing



## D 系列螺丝点数机配件清单

D series screw counting machine accessories list

序号 No	料号	中文名称	English name	数量 quantity
1	Z.00.6020	底板	Bottom plate	1
2	Z.00.3002	料兜端盖	Material pocket end cover	1
3	Z.00.3003	转盘立板组合件	Turntable vertical plate assembly	1
4	Z.00.3004	扫料立板焊接组件	Sweep vertical plate welded assembly	1
5	Z.00.3005	减速电机固定板	Gear motor fixing plate	1
6	Z.00.3006	扫把固定板	Broom holding plate	1
7	Z.00.6021	接料挡片	Receiving stop plate	2
8	Z.00.3008	上风门板	Windward panel	1
9	Z.00.3009	两侧封门板	Two side door sealing panels	2
10	Z.00.3010	后罩	Rear cowl	1
11	Z.00.3011	兜料挡板 左	Pocket baffle left	1
12	Z.00.3012	兜料挡板 右	Pocket baffle right	1
13	Z.00.6022	压料板	Pinch plate	1
14	Z.00.3014	直振基座 下	Direct vibration under the base	1
15	Z.00.3015	直振基座 上	Direct vibration on the base	1
16	Z.00.3016	外罩右封板	Outer cover right sealing plate	1
17	Z.00.3017	外罩左封板	Outer cover left seal plate	1
18	Z.00.6023	前罩组合件	Front cover assembly	1
19	Z.00.3019	不锈钢斜料兜板	Stainless steel slant plate	1
20	Z.00.6043	点数仓前罩板	Counting bin front cover plate	1
21	Z.00.6044	点数仓活动板	Counting bin activity board	1
22	Z.00.6045	螺丝掉料斜板	Screw drop inclined plate	1

序号 No	料号	中文名称	English name	数量 quantity
23	Z.00.6046	感应片	Sensor chip	1
24	Z.00.6047	感应器固定板	Inductor mounting plate	1
25	Z.00.6048	对射开关固定架	Shooting switch mounting frame	1
26	Z.00.9012	前脚垫	Forefoot pad	2
27	Z.00.6051	后脚垫	Back foot pad	2
28	Z.00.6049	调节挡钩 (M6.0)	Adjust the block hook (M6.0)	1
	Z.00.6051	调节挡钩 (M2.0)	Adjust the block hook (M2.0)	1
29	Z.00.6050	点数仓亚克力挡板	Count bin acrylic baffle	1
30	Z.00.6025	导轨片左	Guide rail left	1
31	Z.00.6026	导轨片右	Guide piece right	1
32	Z.00.3022	扫料传动导杆	Sweep drive guide rod	1
33	Z.00.3023	斜料兜盖板	Slant cover plate	1
34	Z.00.3024	隔离套	Spacer sleeve	1
35	Z.00.3025	分度盘导杆	Indexing plate guide rod	1
36	Z.00.3026	1.0 导轨后填片	1.0 Guide rail rear filler	2
37	Z.00.3027	扫把固定杆	Broom holding rod	1
38	Z.00.3028	方型导向块	Square guide block	3
39	Z.00.3029	0.2 导轨后填片	0.2 Backfill of guide rail	1
40	Z.00.3030	1.0 导轨前填片	1.0 Front filling plate of guide rail	1
41	Z.00.3031	直振偏心轮	Direct vibration eccentric	1
42	Z.00.3032	0.5 导轨后填片	0.5 Guide rail rear filler	1
43	Z.00.3033	0.5 导轨前填片	0.5 Guide rail front filling plate	1
44	Z.00.3034	0.2 导轨前填片	0.2 Front filling plate of guide rail	1
45	Z.00.3035	48 齿手齿轮	48 tooth hand gear	1

序号 No	料号	中文名称	English name	数量 quantity
46	Z.00.3036	18 直齿轮	18 spur gear	2
47	Z.00.3038	导轨垫板	Guide plate	1
48	Z.00.3039	导轨固定块	Guide retaining block	1
49	Z.00.3040	N 型支座	N-type support	1
50	Z.00.6006	活动板转接轴	Movable plate adapter shaft	1
51	Z.00.3044	145 直齿轮转盘	145 Spur gear turntable	1
52	Z.00.3045	大凸轮	Big cam	1
53	Z.00.1082	电源插座固定板	Power socket fastening plate	1
54	Z.00.1093	分料电机固定板	Separator motor fixing plate	1
55	Z.00.1099	扫把牙块	Broomstick teeth	1
56	Z.00.1102	分料固定牙块	Split the material to fix the tooth block	1
57	Z.00.2009	直振电机固定板	Fixed plate of direct vibration motor	1
58	Z.00.2012	压料支架	Press bracket	1
59	Z.00.2017	齿轮护板	Gear guard	1
60	Z.00.2016	分料基座	Parting base	1
61	Z.00.1121	15 齿直齿轮	15 tooth spur gear	1
62	Z.00.1122	60 齿直齿轮	Spur gear with 60 teeth	1
63	Z.00.1126	内 5 铜导套	Inner 5 copper guide sleeve	6
64	Z.00.1127	内 3 铜导套	Inner 3 copper guide sleeve	2
65	Z.00.1142	导轨前后调节垫片	Guide rail front and rear adjusting gasket	2
66	Z.00.2051	分料基座支杆	Dividing base support rod	1
67	Z.00.2054	分料感应器导杆	Separator inductor guide rod	1
68	Z.00.1159	对射开关外壳左	Ejector switch housing left	1
69	Z.00.1168	对射开关外壳右	Firing switch housing right	1

序号 No	料号	中文名称	English name	数量 quantity
70	Z.00.1162	分料感应片	Split induction tablet	1
71	Z.00.2113	电路板护罩	Circuit board guard	1
72	Z.00.9014	点数仓盖板	Counting bin cover	1
73	Z.00.9013	落料间隙片	Blanking gap sheet	1
74	Z.00.8009	大型扫把复位弹簧	Large broom return spring	1
75	Z.00.2024	喇吧型弹簧	Roll bar spring	1
76	Z.0.3103	不锈钢拉簧	Stainless steel spring	1
77	Z.00.1003	轴承	bearing	4
78	Z.00.1004	轴承	bearing	1
79	Z.00.1005	磁铁	magnet	4
80	Z.00.1034	E 型卡环	Type E clasp	3
81	Z.00.1033	E 型卡环	Type E clasp	2
82	Z.00.3047	大款毛刷	Big hair brush	1
83	Z.00.3076	铜螺柱	Copper stud	4
84	Z.00.3052	台阶螺丝	Step screw	1
85	Z.00.2129	垫片	gasket	4
86	Z.00.6013	不锈钢超薄垫片	Stainless steel ultra-thin gasket	1
87	Z.00.3100	不锈钢超薄垫片	Stainless steel ultra-thin gasket	1
88	Z.00.3101	304 平垫圈	304 flat washer	1
89	Z.00.3053	大型减速电机	Large gear motor	1
90	Z.00.1060	总电源插头	Main power plug	1
91	Z.00.2028	中型控制电路板	Medium control board	1
92	Z.00.3054	大型数显电路板	Large digital display circuit board	1
93	Z.00.3055	大型数显按钮贴	Large digital display button sticker	1

序号 No	料号	中文名称	English name	数量 quantity
94	Z.00.2202	中型直振电机	Medium size direct vibration motor	1
95	Z.00.1038	分料步进电机	Dividing stepper motor	1
96	Z.00.1065	船型开关	Hull switch	1
97	Z.00.1066	分料盘感应器光电开关	Dispenser sensor	1
98	Z.00.1067	取料对射光电开关	Retracting photoelectric switch	1
99	Z.00.6014	紧凑型槽型光电传感器	Compact trough type photoelectric sensor	1
100	Z.00.1068	地线接头	Ground connector	1
101	Z.00.1078	电源器	Power supply unit	1
102	Z.00.3072	直振电机线	Direct vibration motor line	1
		兜料减速电机线	Retarder motor line	1
103	Z.00.3073	对射开关感应线	Cross-fire switch induction wire	1
104	Z.00.3074	U 型感应器线	U-shaped sensor line	1
105	Z.00.3075	操作面板线	Operating panel line	1
106	Z.00.3057	大型内置电源线	Large built-in power cord	1
107	Z.00.2157	电线固定夹片	Wire fastening clip	2
108	Z.00.1117	0.4 直振片	0.4 Direct vibration plate	1
109	Z.00.1096	0.3 直振片	0.3 Direct vibration plate	1
110	Z.00.2019	U 型感应器固定架	U-type sensor holder	1
111	对应型号	左面板	Left panel	1
112	对应型号	右面板	Right panel	1
113	对应型号	分度盘	Index plate	1