

Introduction

A new generation of intelligent high-speed SMD parts counter developed independently by our company, in the collection of domestic and international numerous SMD parts counter manufacturer based on the advantage of, overcome the limitation of existing various, successfully solved the insurmountable technical problems, meet the market demand and reach the international advanced level, brought convenience to the user and improves efficiency. It is believed that with the continuous promotion and application of this new intelligent high-speed product, it will become the latest standard in the industry.

Chapter One Introduction

一、Product Principle

There are two models SMT counter in our company: Ordinary SMD counter and leaking hunting SMD counter

1. Ordinary SMD counter: Using photoelectric sensing principle and the corresponding relationship between the component carrying guide hole and the component, through the special processing chip and large scale integrated circuit processing, zero error can be achieved to accurately measure the number of SMD component which can realize convenient and fast counting. It is an efficient auxiliary equipment for SMT material management

2. leaking hunting SMD counter: Ordinary SMD counter ia equipped with high-speed optical fiber. According to the principle of light intensity contrast between empty material and solid material, accurate detection of empty material and indicates stop.

二、 The product features

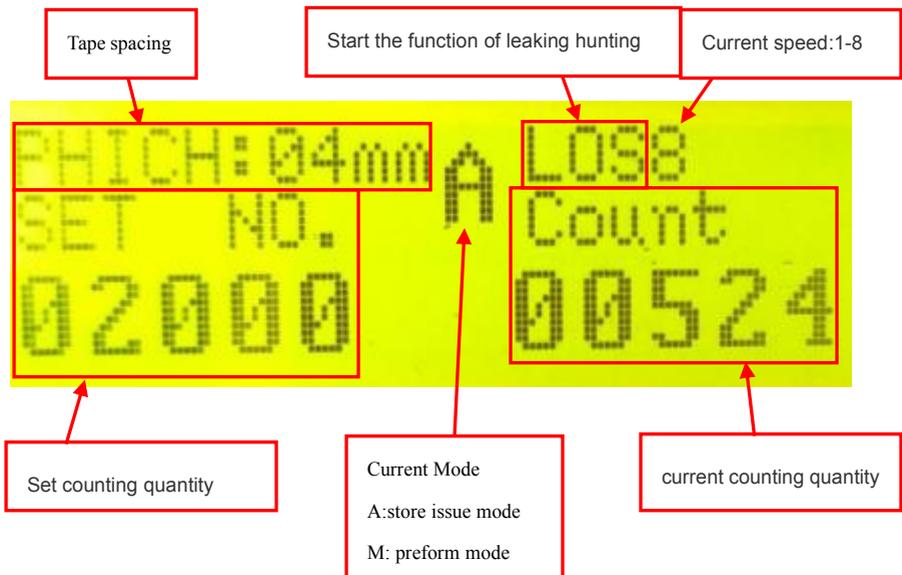
A new generation of intelligent high-speed SMD parts counter can automatic way to calculate parts number, convenient point materials, materials development operation, simple operation, unique design to prevent strip off material with less damage to the minimum, direction, all can count, can the preset number, precise calculation quantity, to achieve zero error, page can be mounted to the scanning gun and bar code printer, convenient operation management, compared with traditional counter, one of the biggest advantage is: a, have speech function, indicates the current working status; 2. The plate can stop automatically; 3. The motor power is increased and the operation is more stable when checking aniseed; 4. The running speed can be adjusted by 8 gears.

三. product specification

Scope	SMD belt component	Counting range	-99999--99999PCS
Material spacing	2, 4, 8, 10, 12, 16, 20, 24, 32, 44, 56mm	Feeding Plate	≤380mm
		Size	L730*W270*H230mm
Power	AC220/110, 50HZ, 80W	weight	11KG

Chapter Two Machine and Key Introduction

Screen display parameter description:



A Mode:

store issue mode:

After belt is installed, the machine can only operate by setting the count quantity. When the current count quantity reaches the set value, the machine will stop running

M mode:

After belt is installed, it can operate 801SJ、802SJ and stop automatically. and other models must manually press the [stop] button to stop the operation

Install the strip:

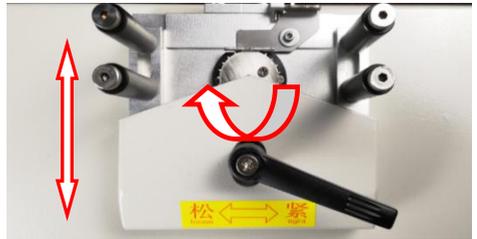


shrapnel

During installation, the material belt hole down, pressure shrapnel, then put into the material belt, and must be stuck hole teeth



881 upper part



882 upper part

Key introduction:



: The motor on the left side of the machine drives the feeding tray and reverses the feeding



: The motor on the right side of the machine drives the feeding pan, turning the feeding forward



: Long press 2s to turn on leak detection function (this function is only used for leak detection model)



: The speed at which the machine runs during the switching process



: Set the preset quantity in dot mode



: Enter the print interface and send the print signal



: The distance between two materials (see page 7, the specification for the confirmation method of spacing)



: Short pressing, the machine stops running, long press 2s to reset the current count value



: Long press 2s to switch the current feeding mode, A is the feeding mode, M is the perform feeding mode (long press 2s on the printing interface to enter the printing parameter setting interface)



: Verify the current input value

Figure 0~9: Inputting the corresponding values, letters, and punctuation marks in the corresponding interface (letters and punctuation marks are only used when Settings need to be printed)

Combined Keys Introduction:

The combination key refers to the hidden function composed of two keys, such as [print] + [leak detection], which means that the combination key can be formed by pressing the [print] key first and then the [leak detection] key.

【Print】 + 【leak detection】: Switch between Chinese and English broadcast

【Print】 + 【time】: Adjust the volume of voice broadcast, range is 0~15

【Print】 + 【set up】: Set the left disk diameter coefficient

【Print】 + 【space】: Set the right disk diameter coefficient

Note: the diameter coefficient of the left and right disk will affect the deceleration position during the operation of the machine, that is, the deceleration will start depends on the diameter. The parameter of the small disk with a radius of about 50 is set as 0060 (this parameter is the factory parameter), the disk with a radius of about 100 is set as 0120, and the disk with a radius of about 200 is set as 0160.

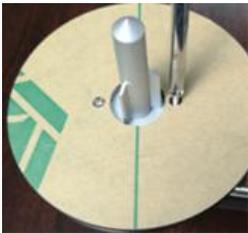
Chapter Three Machine Installation and

Instruction

一 Open carefully the box of this machine and check the following items:

One set machine a set of accessories (One instruction book, one optical frame, one power wire, two tow trays, two socket wrenches

二 mounting accessories:



Installation of tow material disc: remove the screw from the left and right rocket head, place the tow material disc on the rocket head, and lock the screw as

shown in the picture

三 Confirm whether the current power supply voltage is consistent with the machine voltage (if there is no special requirement, the machine's default voltage is 220V), turn on the machine switch in power on.

四. Loosen the hand screws on both sides of the machine counter clockwise, expand the material tray support on both sides into a shape, and then tighten the hand screws

五. install materials and operate machines:

1. Place the material tray and empty material tray on the tow tray on both sides of the machine, and align the hole position of the material belt with the gear in the middle of the machine face down (as shown in below).
2. Set the material spacing of the material belt, pull the material belt manually to the position of the first material, clear the current quantity, and then pull the material belt into the empty material plate manually (if leakage detection function is needed, press [leakage detection] button 2s to open the side leakage function, 802E, 802, 802SJ three models can use this function).
3. If the sending mode is needed, switch the mode to mode A and set the amount of sending material to run. The machine will stop running until the set amount stopped..If the plate mode is needed, switch the mode to M mode. When the machine runs until the end of material inventory, stop manually the machine and pull the material to the last material. The current quantity is the quantity of the whole plate

Remark: Note: 1. During manual pulling of the material belt, the machine also accounts, which is consistent with the automatic counting.

2.the inventory of aniseed plate speed must be reduced, otherwise the stop inertia is too large, material belt easy to fall off;

3.gear machine forward rotation in the first material on the right side, so that the last material on the left side is the correct value, similarly, reverse in the first material on the left side of the clear, to the last material on the right side is the correct value

Confirm Material Pitch Method:

1. Measurement

Select any two adjacent materials, take a point of the two materials as the reference point, and measure the distance between the two points, which is the distance between the materials, as shown in the figure below:

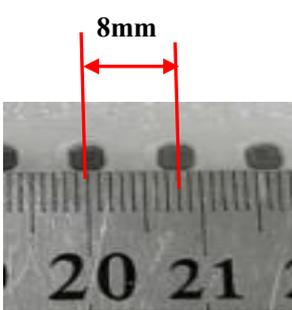


Image 1

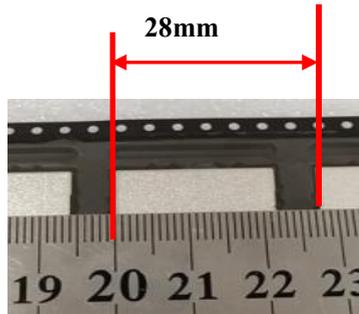
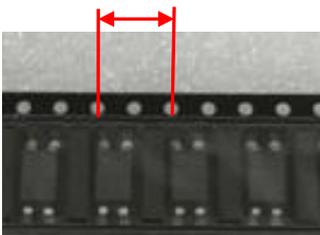


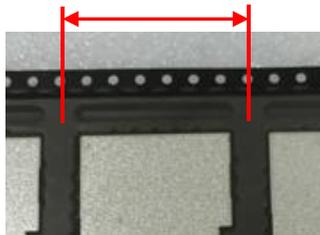
Image 2

2. Ocular estimate:

The hole spacing of material belt hole positions corresponding to standard machine gears is 4mm. Select a reference point and there are several hole spacing between the same reference point and the next one. Then multiply 4 to get the spacing of material belt, as shown in the figure below:



spacing: $2 \times 4\text{mm} = 8\text{mm}$



spacing: $7 \times 4\text{mm} = 28\text{mm}$

**Note: except 2mm spacing, the rest spacing is an integral multiple of 4.
During measurement, the same reference point on two materials should be selected, for example, the center of the selected material in figure 1 and the edge of the selected material in figure 2**

Scanner and Of Printer:



Connection diagram between counter and printer, scanner

Note: there will be a two-part RS232 connection line in the accessories of the printer and scanning gun, the female head will be connected to the rear interface of the machine, the two male heads will be connected, the long line will be connected to the printer, and the short line will be connected to the scanning gun

operating steps:

Press the [print] button to enter the print interface, as shown in the figure



1. Move the cursor left and right by pressing the key [forward] [reverse], move the cursor to the first character in the first line, press the number "1" for two consecutive times to clear the current character, then move to the second character and double-click the number "1" to clear the character, until all characters in the first line are cleared and press the "Enter" key to save
2. The first line of the interface: Enter the company name abbreviation, press Enter to save after the input is completed;

The second line of the interface: Enter the current date and time. After the

input, press Enter to save.

The third line of the interface: enter the material number information of the product. If you purchase a scanning gun, you can directly scan the material information. After the scanning, the content of the scanned barcode will be displayed in this line

3. Press [↑] on the print interface to enter the print parameter setting interface, as shown below:



X: Move left and right to print

Y: move up and down to print

W: print the space between bar code

H: print the high between bar code

Move the cursor and set the corresponding parameter as XYWH: 150, 050, 02, 040

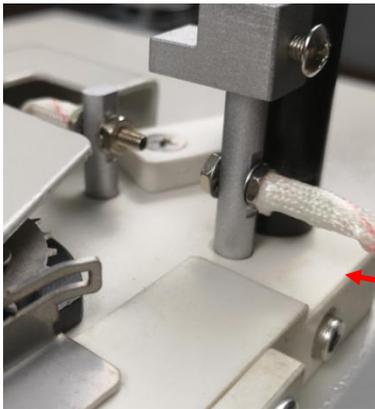
Note: this parameter is used for standard printing paper (the size is 70*40mm). If the size of printing paper used by users is inconsistent with that of standard paper, please adjust the parameter according to the actual printing situation. Generally, only the X and Y values need to be changed

Adjustment Description Of Fiber Leakage

Detecting:

Leakage detection machine need to meet the following two conditions:

1. Correct fiber optic detection height



Loosen the screw indicated by the arrow, adjust the height of the optical fiber

mounting seat on the whole up and down, so that the transmitted light is aimed at the center of the material belt, then it is the correct detection height (if the material belt is too wide, adjust the distance of the optical fiber, loosen the nut of the optical fiber head and move back).

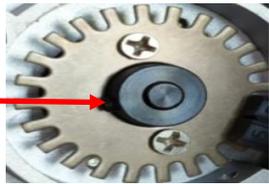
2. Appropriate detection sensitivity



After the Height adjustment you need to check whether leak function is open (open the screen will show LOS, see the description page 2), open the function and test the machine whether will place a drops of alarm after running to the material, and stop running, if not then adjust the sensitivity of the machine rear optical fiber amplifier, the arrow of the knob in the direction of MAX adjustment, until a prompt alarm when they can be detected, if in the process of testing in a location with material will also send out alarm, shows high detection sensitivity, the knob must be adjusted to MIN.

Chapter Four Common Trouble And Solution

fault phenomenon	fault cause	solution
When the machine is running, the material belt falls off from the gear or jumps out of	1. The tape is not installed correctly	Install material belt position correctly, hole facing down
	2.The left and right material tray supports sag, resulting in the material belt and gear running in an inclined	Take back the material tray bracket and adjust the position of the left and right material tray bracket so that it is basically in the same

the belt	state, at which time the material belt is easy to fall off	horizontal plane with the machine shell
	3. The gap between shrapnel and gear is too large, and the material belt falls off from the gap during operation	Loosen the two screws of the part shown in the figure, adjust the gap between the shrapnel and the gear, and the lowest point of the shrapnel is roughly in the middle of the gear tooth 
Check quantity is not accurate and calibrate it back and forth The same material belt, each time the quantity is not consistent	1.Strip off	See previous troubleshooting
	2.The lower gear screw is loose	 Open the back cover of the machine and check whether the screws are loose
	3.Damage of induction switch	If the above problems are excluded, open the back cover of the machine and

		 <p>replace the induction switch shown in the figure</p>
The screen does not display or the screen is white or black	1,Poor screen contact or damage	Disconnect the power, open the bottom cover of the machine, shake the display screen line, and test on the power
	2.The machine is not powered on	When the power-on screen is not displayed after power-on, check whether the red switch is on. If not, check whether the connected power supply has electricity or the switch is damaged. If the switch is on, please contact the supplier
Note: if the machine fails, please contact the supplier		