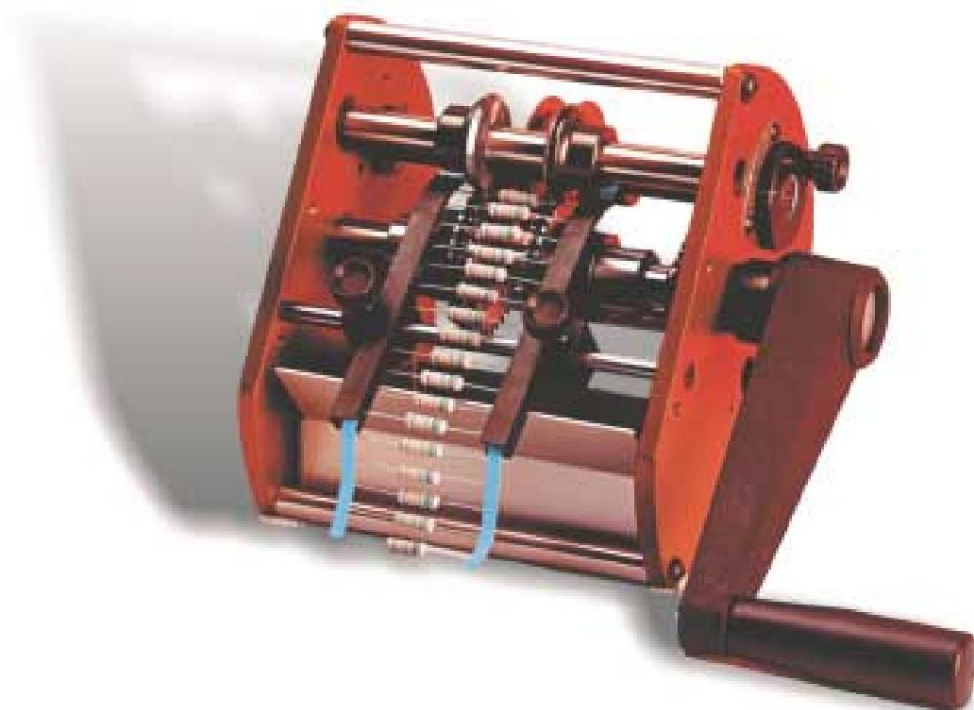


model

freshman

SUPERFORM/ A-LC

Italian



SUPERFORM/ A-LC

Preforming machine
axial components

SAFETY RULES

Attention! Always follow normal safety precautions when using the machine to reduce the risk of fire, electric shock or personal injury.

Read all the instructions contained in this manual carefully before operating the machine.

For correct and safe use:

- **Keep your work area clean.**
Clutter and debris cause accidents.
- **Use correct clothing.**
Do not wear loose clothing or jewelry as they could get caught in the moving parts of the machine. If you have long hair, tie it up with bands. • **Always unplug the power cord** for the motorized model when carrying out maintenance operations. • **Always be careful.**

Pay attention to what you are doing. Use your common sense. Do not use the machine if you feel tired.

- **Attention!**
The use of accessories or spare parts not indicated in this manual could cause accidents.
- **Repairs must be carried out by qualified personnel.**

Warnings for manual machine:

- **During any machine adjustment operation, make sure that the crank cannot be inadvertently hit or moved by strangers, which could cause cuts to the operator's hands.**
- **Always keep the security door secured when completing any recording.** • **Always install the cover over the bulk loader belt and over the TNS belt whenever these accessories are used.**

Warnings for motorized machine:

- **Place the pedal in a place accessible only to the operator.** • **The connection wires to the pedal must be protected as much as possible to avoid lacerations.** • **THE MOTORIZED MACHINE MUST BE CONNECTED TO A SYSTEM WITH CONNECTION EARTH.**

- **Disconnect all electrical connections at every stop, stop or end of processing.** •

The door equipped with a sensor guarantees that all preforming machine setting operations are carried out with the machine turned off. this deactivates every electrical connection between the motor unit and the machine, preventing any movement of the mechanical parts when the door is raised.

WARRANTY The

machine is guaranteed against all construction and material defects for a period of 12 months from the date of purchase. The manufacturer declines all responsibility if the machine is overloaded or used for uses other than those intended.
This situation also causes the warranty to expire.

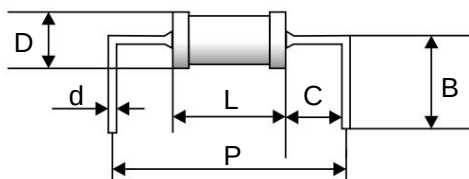
CE CONFORMITY

The 7915.063, 7915.091, 7915.200, 7915.101, 7915.102, 7915.108, 7915.104, 7915.113, , 7915.108
products: comply with the directive: 89/392/EEC,
with the harmonized standards: EN292, EN60204-1

The products: 7915.030, 7915.031, 7915.032, 7915.033, 7915.035
comply with the directives: 89/392/EEC, with the 89/336/EEC 72/23/EEC
harmonized standards: EN292, EN50081-1, EN50082-1, EN60204-1

Sound pressure <70dB (A)
Sound power <85dB (A)

1 - CHARACTERISTICS OF THE SUPERFORM/A



7915.200A STANDARD VERSION

	mm		inch.	
	min	max	min	max
P	6.5	60	0.255	2,362
B	4	13	0.196	0.511
C	1.2		0.047	
L		50		1,968
d	0.4	1.3	0.015	0.051
D		16		0.629

7915.200F REDUCED BEND, VARIABLE PITCH

Fold closer to the body / shorter cut length

On a standard model it is necessary to replace the original parts with:

- 2 REDUCED FOLDING KNIVES (400706)
- 1 REDUCED LEFT INTERNAL DRUM (400417)
- 1 REDUCED RIGHT INTERNAL DRUM (400418)

	mm		inch.	
	min	max	min	max
P	5.08	60	0.2	2,362
B	4	13	0.157	0.511
C	0.8		0.031	
L		50		1,968
d	0.4	0.8	0.015	0.031
D		10	0.07	0.039

7915.200G REDUCED BEND, FIXED PITCH FOR MICRO-COMPONENTS

Minimum bending distance to the component body.

The "P" (fixed) and "L" measurements must be specified when ordering.

On a standard model it is necessary to replace the original parts with:

- 1 FIXED PITCH BENDING KNIFE 5.08mm (400713)
- 1 FIXED PITCH BENDING KNIFE 7.62mm (400708)
- 1 FIXED PITCH BENDING KNIFE 10.16mm (400714)
- 1 EXTRA-REDUCED LEFT INTERNAL DRUM (400430)
- 1 EXTRA-REDUCED RIGHT INTERNAL DRUM (400431)

	mm		inch.	
	min	max	min	max
P	*5.08	*15	*0.2	*0.590
B	4	10	0.157	0.393
C	0.5		0.019	
L		*13.5		*0.531
d	0.4	0.6	0.015	0.023
D	0.4	4	0.015	0.157

7915.200D REINFORCED BEND

Processing of components with leads with a diameter of 1.3mm and beyond.

On a standard model it is necessary to replace the original parts with:

- 2 EXTRA-REINFORCED FOLDING KNIVES (400711)
- 1 EXTRA-REINFORCED RIGHT INTERNAL DRUM (400419)
- 1 EXTRA-REINFORCED LEFT INTERNAL DRUM (400420)

	mm		inch.	
	min	max	min	max
P	10.5	60	0.41	2,362
B	5	13	0.196	0.511
C	2.4		0.094	
L		50		1,968
d	0.6	1.4	0.023	0.055
D		16		0.629

PRODUCTION: from taped 20'000 pieces/hour
loose, with 5,000 pieces/hour loader

MOTORIZED VERSION with motor unit 7915.030/031

Power supply:

Speed... :

Control :

Power :

Absorbed current : Fuse:

220V (110V for 031) - 50/60Hz

adjustable from 3'000 to 20'000 pcs/hour max

from pushbutton panel - pedal (optional)

50W

1A max

5x25mm - rapid - 4A

2 - UNPACKING

- Remove the machine and accessories from the packaging.
- Check with the help of figure n.1 that all the accessories are present.
- Do not destroy the packaging but put the packaging materials back in the box and keep everything so that you can use it to transport the machine.



fig.1

Only on motorized cars

3 - FIXING THE MACHINE

Secure the machine on the work surface before starting work. The surface must be able to withstand a load of 40kg per machine.

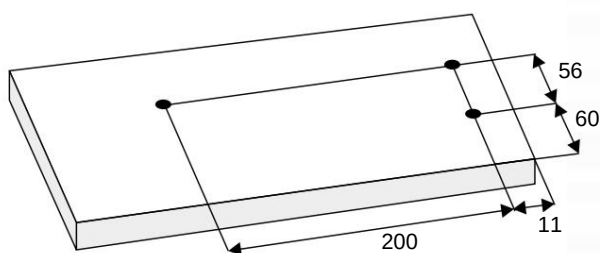
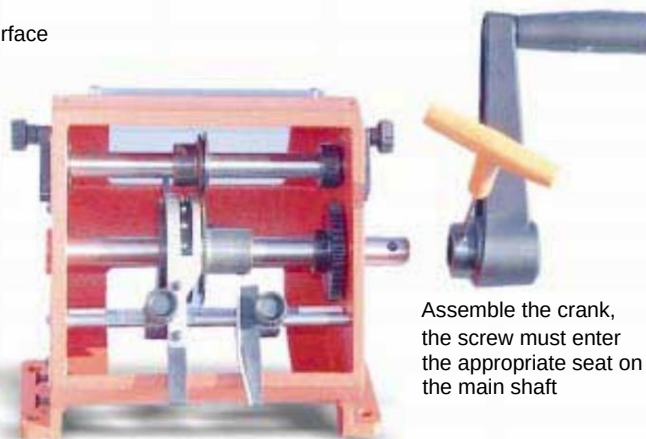


fig.2

NOTE: The motorized machine does not require fixing



Assemble the crank, the screw must enter the appropriate seat on the main shaft

4 - MOTORIZED MACHINE



fig.3a

Emergency fungus
Start/Stop
Speed regulation
Direction selection
Fan

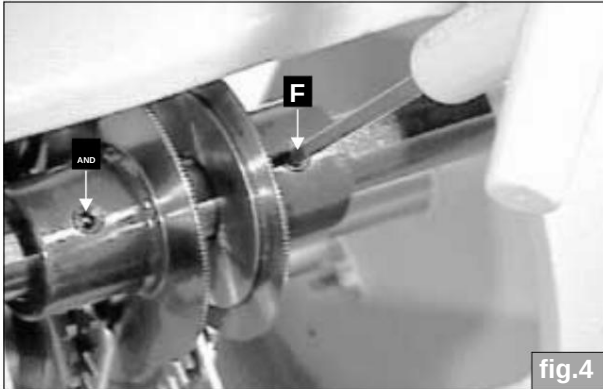


fig.3b

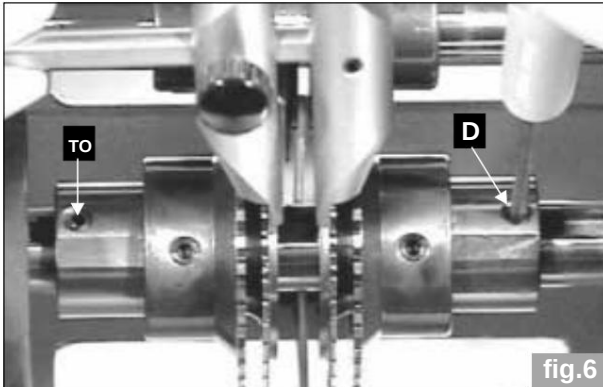
Pedal input
ON/OFF
Network input
4A fuse with spare

5 - MACHINE ADJUSTMENT

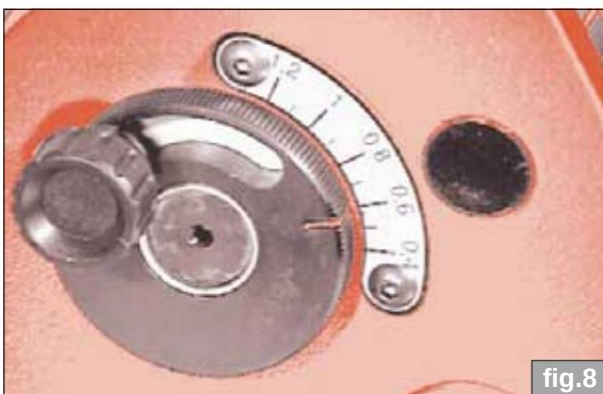
ATTENTION: IF DURING THE OPERATIONS OF ADJUSTMENT THE CRANK WAS MOVED ACCIDENTALLY THE RESULTING MOVEMENT OF DRUMS OR KNIVES COULD CAUSE CUTS TO THE OPERATOR'S HANDS



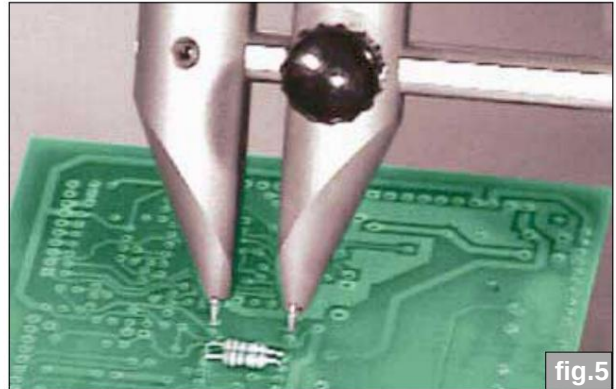
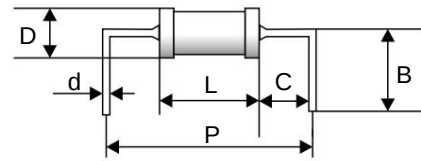
Loosen the folding knives, grains E, F



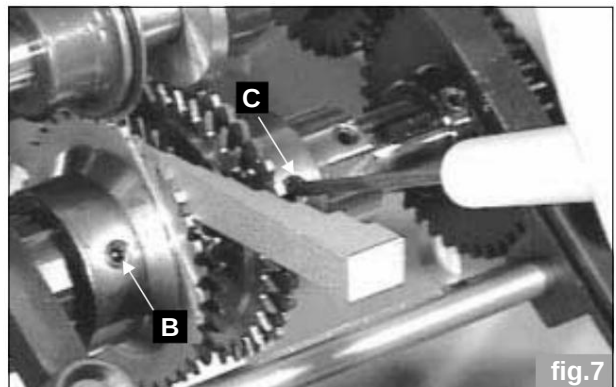
Adjust the two internal drums to the caliber size using the dowels A and D, when closing push the key downwards for correct alignment of the drums.



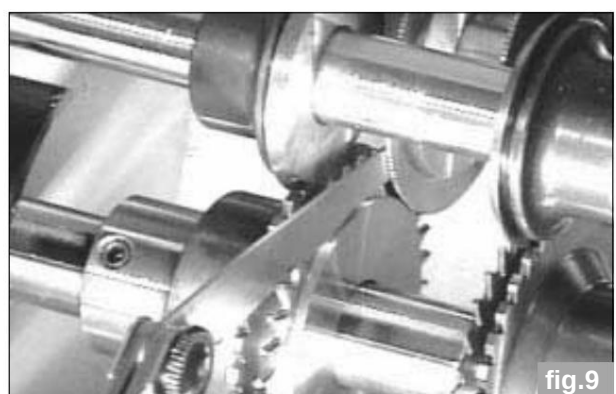
Adjust the eccentric devices on the right and left of the machine to the LEAD DIAMETER "d".



Set the caliper to the pitch measurement of the "P" component



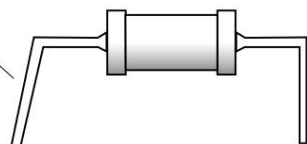
The length "B" is set by adjusting the external drums (screws B and C) to the correct distance from the internal drums. Use the graduated ladder.



Space the bending knives from the internal toothed drums by the size of the diameter of the lead "d", using the feeler gauge supplied. Fix the dowels E and F.

BEND > 90°

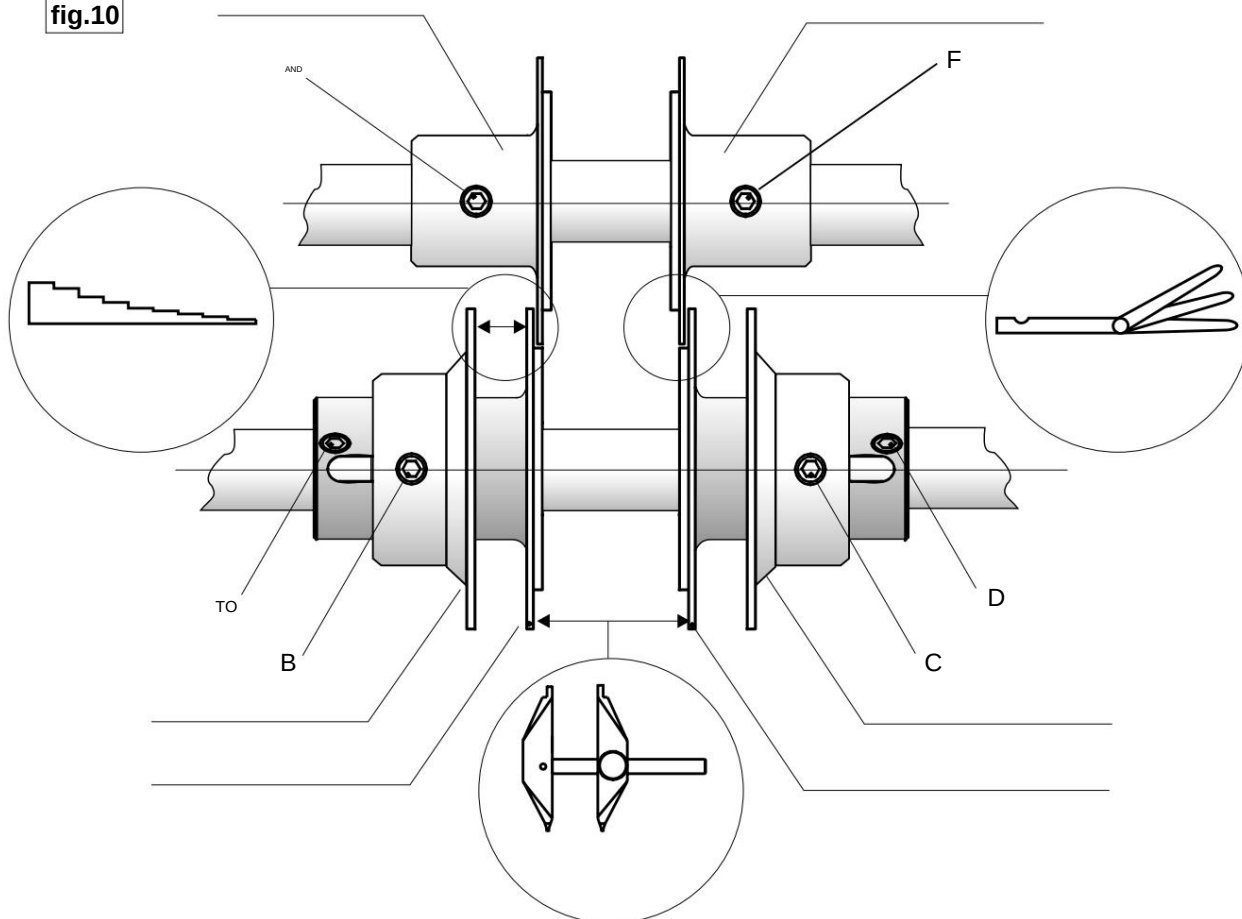
Too much space between folding knives and internal toothed drum



CRUSHED LEAD

Insufficient space between folding knife and internal toothed drum

fig.10



6 - POSITIONING OF THE BELT

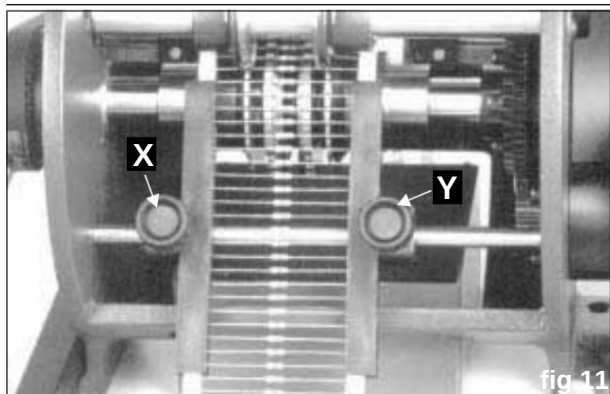


fig 11

Loosen the guide knobs (X,Z), move the guides outwards, insert the first components on the teeth of the drive unit, the body must be between the two internal drums.

Do not screw the knobs with excessive force to avoid breaking the guides.

Bring the guides together, insert the tape into the grooves, lock the knobs.

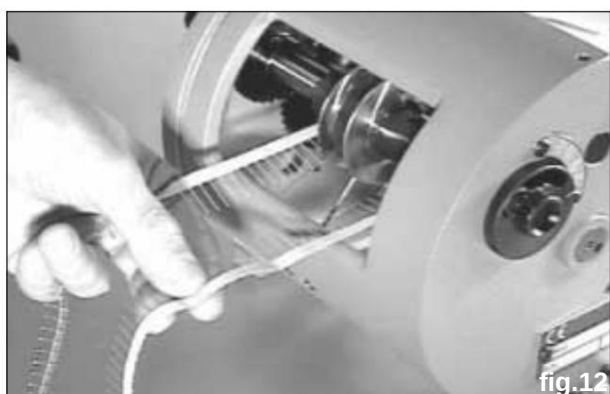


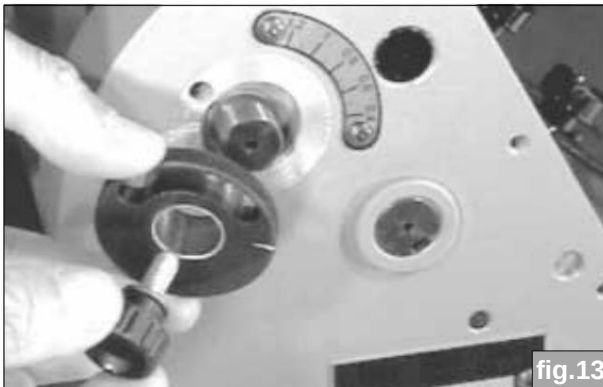
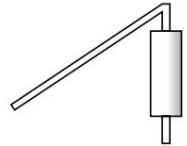
fig.12

Manually take the tape without components and insert it into the rear opening, helping it to come out when necessary. It is possible to make tape ejection

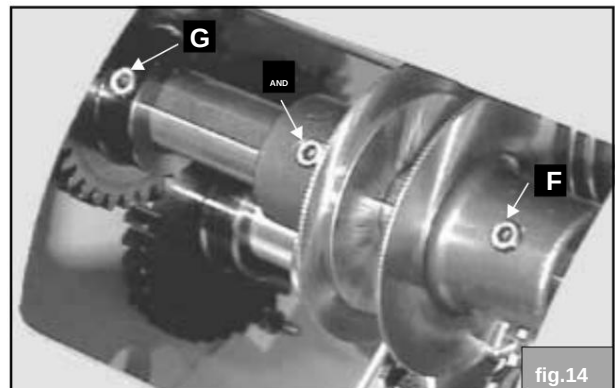
automatic by installing the TNS accessory on the machine.

7 - FOLD FOR VERTICAL ASSEMBLY

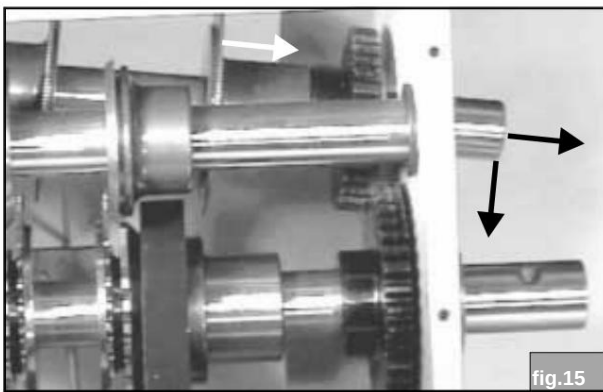
To obtain this type of fold it is necessary to exclude one of the two folding knives by proceeding as follows:



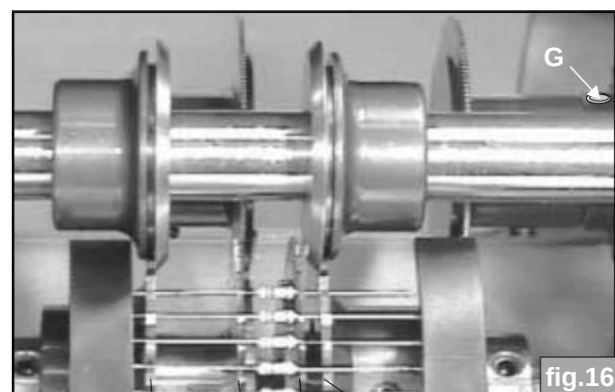
Unscrew the knobs and remove the two eccentrics.



Loosen the bending knives (dowels E, F) and the gear (dowel G)



Remove the shaft to the right, tilting it, move the right knife all the way to the right.



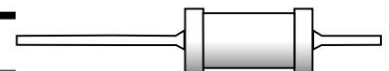
1 2 3 4 Put the shaft back in its place and refit the eccentrics. Lock the gear (screw G) by pushing it forcefully towards the wall in order to reduce the axial play.

ADJUSTMENTS - Right

internal toothed drum (3) flush with the body - Left internal toothed drum (2) approximately 2-3mm from the body - Right external toothed drum (4) close to the internal drum (3) to obtain a length of approximately 4mm from the body - Left external toothed drum (1) at a distance to be established with tests and depending on the length of the component - Eccentrics set to the diameter of the lead - Left bending knife positioned with the feeler gauge to the diameter of the lead (see adjustment in fig.9)
- To obtain a 90° fold it is necessary to increase the distance between the folding knife and the toothed drum

8 - EXCLUSION OF BENDING

To cut only the hair holes, you need to remove both folding knives (Fig.13-14-15)



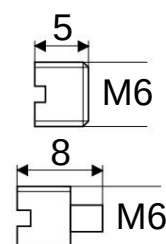
9 - . ORDINARY MAINTENANCE

The SUPERFORM/A does not require particular maintenance. The internal and external toothed drums must be kept clean from waste residues to avoid damaging the mechanical parts. For this purpose, a stiff brush or a breath of air is sufficient.

If the machine is used constantly, occasionally replacing the adjustment screws will avoid damage to the shafts. The screws most subject to use during adjustments are:

400413 M6X5 SCREW FOR THE EXTERNAL TOOTHED DRUMS

**400304 M6X8 SCREW FOR THE INTERNAL TOOTHED DRUMS
FOR BENDING KNIVES AND Z30/Z39 GEARS**



10 - EXTRAORDINARY MAINTENANCE

REPLACING THE BELT GUIDES (200201 and 200202)

Loosen the two X,Y knobs (fig.11). Remove the screw on the right side of the machine and remove the shaft (400207) to the left. Place the new guides on the shaft and secure it again using the screw.

REPLACEMENT OF DISCHARGED RESISTORS (400113)

Loosen the screws on the back of the machine and remove the damaged part. Replace it by carrying out the reverse operation.

REPLACEMENT OF BENDING BLADES (400702)

Remove the two eccentrics (fig.13). After loosening the screws of the folding knives and the gear (fig.14), remove the folding shaft (400712) to the right (fig.15). Remove the knife that needs to be replaced and put the new one.

Then reassemble the shaft. Place the eccentrics both on the right and left of the machine at the same height. Tighten the eccentric knobs. Forcefully push the Z30 gear against the right eccentric in order to eliminate the axial play.

CUTTING KNIFE REPLACEMENT (200502)

Remove the two seegers fixed on the shaft inside the machine (be careful during this operation as the seegers can come off with force). Remove the shaft (200501) and remove the damaged knives, place the knife on the corresponding toothed drum and slide the shaft inside the knife, carry out the same operation for both knives, until the shaft is in seat, replace the two seegers.

REPLACEMENT OF INTERNAL TOOTHED DRUMS (400406 - 400407) AND EXTERNAL (200401 - 200402)

Unscrew the three grub screws of the right and left internal drums and of the gear. Slide out the main shaft to the right (400401). When the two groups are freed from the tree, replace the damaged drums. Reassemble the main shaft.

11 - MOTORIZED MACHINE

INSTRUCTIONS FOR USE

- Connect the power cable and activate the ON/OFF switch located on the back of the drive.
The "POWER" and "SECURITY" LEDs must light up.
- If the "SECURITY" LED remains off, check that the Plexiglas door is closed and the door is unlocked.
Emergency fungus.

- Press the button  , the motor starts moving and the "MOTOR" LED lights up.

Adjust the speed using the potentiometer. • To

reverse the direction of travel (only in case of jamming) it is necessary to: 1)

Stop the engine 2)

Bring the speed to minimum

3) Insert a small screwdriver into the center hole of the reverse



LED control.

4) Unlock the components, always proceeding at minimum speed.

5) Stop the engine again.

6) Engage forward gear again by pressing the button



WARNING: DO NOT ENGAGE REVERSE GEAR IF THE CHARGER IS PRESENT OF LOOSE COMPONENTS CS10

- The engine stops by pressing the button



- After stopping, whatever the cause, to restart you must always press the button



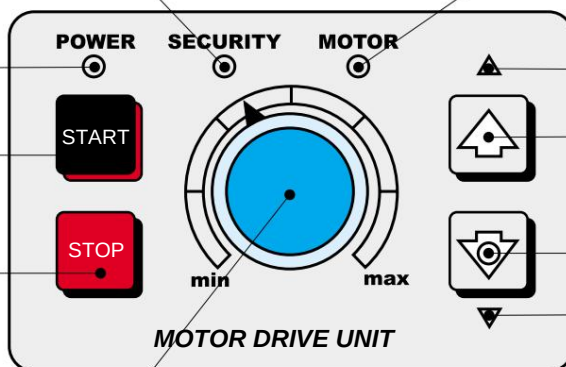
LED on =
"safeties enabled"

LED on = "mains
presence"

"Engine
start" command

"Engine
stop" command

Speed adjustment
potentiometer



LED on = "motor
running"

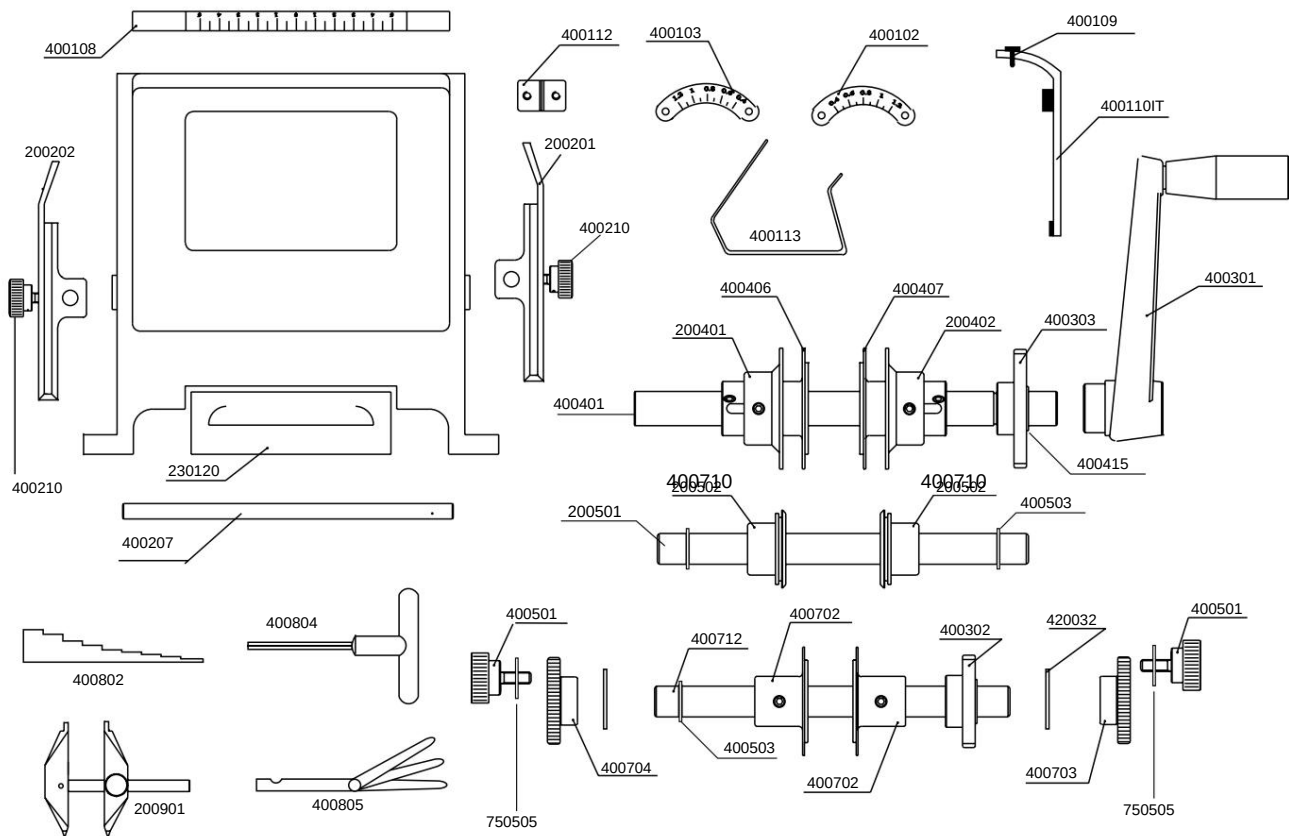
LED on =
"forward"

"Forward"
command

Protected
"reverse"
command

LED on =
"reverse"

12 - EXPLODED VIEW OF THE MACHINE



REPLACEMENT PARTS

200201 RIGHT BELT GUIDE

200202 LEFT BELT GUIDE

200401 LEFT OUTER DRUM

200402 RIGHT EXTERNAL DRUM

200501 CUTTING TREE

200901 PITCH SETTING CALIPER

OF BENDING (leads 0.5-1mm) 400102
RIGHT LEAD DIAMETER INDEX

400103 LEFT LEAD LEAD DIAMETER INDEX

400108 MILLIMETER CENTERING RULER

400109 DOOR FIXING PIN

310104 PROTECTIVE DOOR

400112 RESISTANCE DISCHARGE BLOCK

400113 DOWNLOAD RESISTORS

400117 TC SCREW M4X10 FOR EXHAUST BLOCK
RESISTANCES 2

400207 GUIDE SHAFT 1

400210 KNOB M5X16 FOR TAPE GUIDE 2

400214 SCREW TS M5X16 FOR GUIDE SHAFT 3

400301 CRANK 1

400302 Z30 GEAR FOR FOLDING SHAFT 1

400303 Z39 GEAR FOR MAIN SHAFT 1

400305 PP GRAIN M6X10 FOR CRANK 1

400401 MAIN SHAFT 1

400406 LEFT INTERNAL DRUM 1

400407 RIGHT INTERNAL DRUM 1

400429 CYL PLUG. D. 5X9 INTERNAL DRUM
RIGHT-

SX 400413 PP GRADE M6X5 FOR EXTERNAL DRUMS

400304 PTS GRADE M6X8 FOR INTERNAL DRUMS

BENDING KNIFE, Z30/Z39 GEAR 6

400415 SEEGER RS15 FOR MAIN SHAFT

400501 KNOB M6X16 FOR ECCENTRIC MACHINES 2	1
400503 SEEGER RS12 FOR CUTTING/BENDING SHAFT 3	1
400702 BENDING KNIFE 2	1
400703 RIGHT ECCENTRIC ADJUSTMENT BENDING	1
400704 LEFT ECCENTRIC ADJUSTMENT BENDING	1
400710 SUPERFORM/A CUTTING KNIFE 400712	2
FOLDING SHAFT 230120	1
DRAWER 400802	1
GRADUATED LADDER FOR LENGTH CUTTING	1
400804 HEX SCREWDRIVER mm. 3 400805	1
KNIFE ADJUSTMENT FEELER GAUGE OF BEND	1
420032 THRUST RACE 750505	2
WASHER D6 FOR ECCENTRIC	2

FOR VERSIONS DIFFERENT THAN STANDARD

400417 REDUCED LEFT INTERNAL DRUM 1	1
400418 REDUCED RIGHT INTERNAL DRUM 1	1
400419 EXTRA REINFORCED RIGHT INTERNAL DRUM 1	1
400420 EXTRA REINFORCED LEFT INTERNAL DRUM 1	1
400430 EXTRA REDUCED LEFT INTERNAL DRUM 1	1
400431 EXTRA REDUCED RIGHT INTERNAL DRUM 1	1
400706 REDUCED BENDING KNIFE 2	2
400707 REINFORCED BENDING KNIFE 2	2
400708 SINGLE BENDING KNIFE PITCH 7.62mm 1	1
400713 SINGLE BENDING KNIFE PITCH 5.08mm 1	1
400714 SINGLE BENDING KNIFE PITCH 10.16mm 1	1
400710 REDUCED CUTTING KNIFE 2	2
400711 EXTRA REINFORCED BENDING KNIFE 2	2