

供料器系列
Feeder Series



气吹式大料仓供料器

Air-Blow Bulk Hopper Feeder



扫码查看公众号



扫码查看视频号

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01

技术参数/Technical Specifications

KL

供料器系列
Feeder Series

S631

序列号
Model No.

1. 采用层级推料方式上料至直线轨道，上钉率高。

1. Uses a **hierarchical screw feeding method** with direct-line feeding, ensuring high feeding efficiency.

2. 推料运动机构与电控部分独立设计，分处机身两侧，安全合理。

2. Feeding and separation mechanisms are independently designed and arranged on both sides of the separator, ensuring operational safety.

3. 超大料仓容量，有效容积可达3L-4L，可放置螺丝（例M3*10）近5000-6700颗。

3. Extra-large hopper capacity with an effective capacity of 3–4 L, capable of holding approximately 5,000–6,700 screws (M3 × 10).

4. 直线轨道处于机身上层，无专业经验人员也可轻易排除异常。

4. Direct-line feeding structure simplifies operation; professional operators can quickly troubleshoot issues.

5. 通过自带环形传感器带有纠正补料功能，不漏送，多送螺丝。

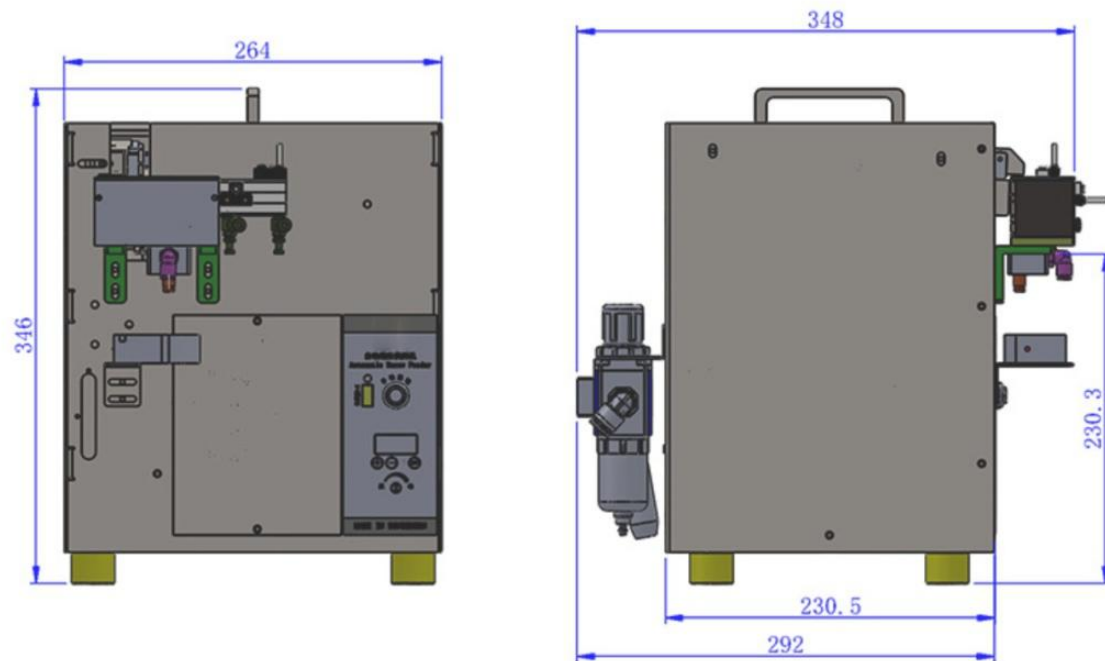
5. Ring-type separation sensor provides error-correction and anti-misfeed functions, preventing incorrect screw delivery.

6. 通过IO信号交互，螺丝准备好，吹料等动作。

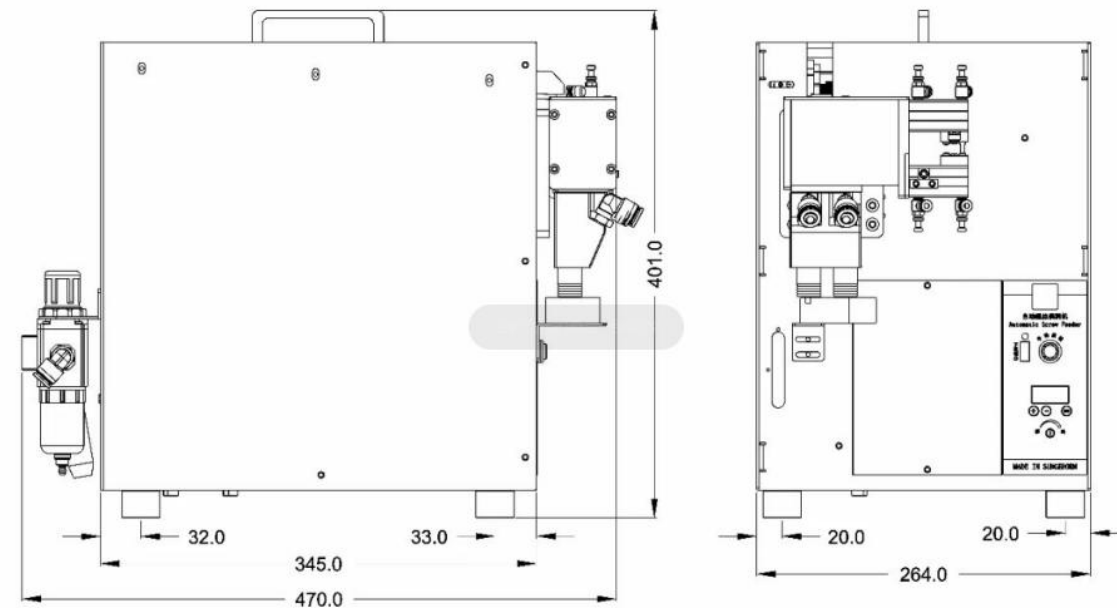
6. Supports IO signal interaction; screws are supplied on demand, enabling efficient and reliable operation.

产品型号: Feeder Model	KL-S631		KL-S634	
适用螺钉规格: Applicable Screw Size	M1.7-M6 牙长≤42mm M1.7-M6 screw length≤42mm		M1.7-M12 牙长≤48mm M1.7-M12 screw length≤48mm	
外形尺寸: Overall Dimensions	L348*W264*H346mm		L470*W264*H401mm	
整机重量: Machine Weight	24kg		27kg	
料仓有效容量: Hopper Effective Capacity	3L (例M3*10螺钉可放5000颗) 3 L (≈ 5,000 pcs for M3×10 screws)		4L (例M3*10螺钉可放6700颗) 4 L (≈ 6,700 pcs for M3×10 screws)	
适用轨道种类: Applicable Feeding Mode	单直线轨道 Single direct-line feeding			
供料速度: Feeding Speed	单输出分配体100pcs/min Single outlet: up to 100 pcs/min			
螺钉吹送距离: Screw Delivery Distance	2-15米 (螺钉和分配体不同, 距离不同) 标配吹钉管长度4米 2–15 m (varies by screw type and separation method) Standard configuration: hose length 4 m			
适配分配体种类: Applicable Screw Carrier	单输出分配体 Single outlet carrier			
通讯方式: Communication Interface	IO	整机功率: Power Consumption	50W	
工作电压: Power Supply	AC220W 50HZ	工作气压: Working Air Pressure	0.5-0.8Mpa	
定制供料器需提供螺钉200颗 Custom hose length available; extension up to 200 m supported.				

02 产品尺寸/Product Dimensions



KL-S631



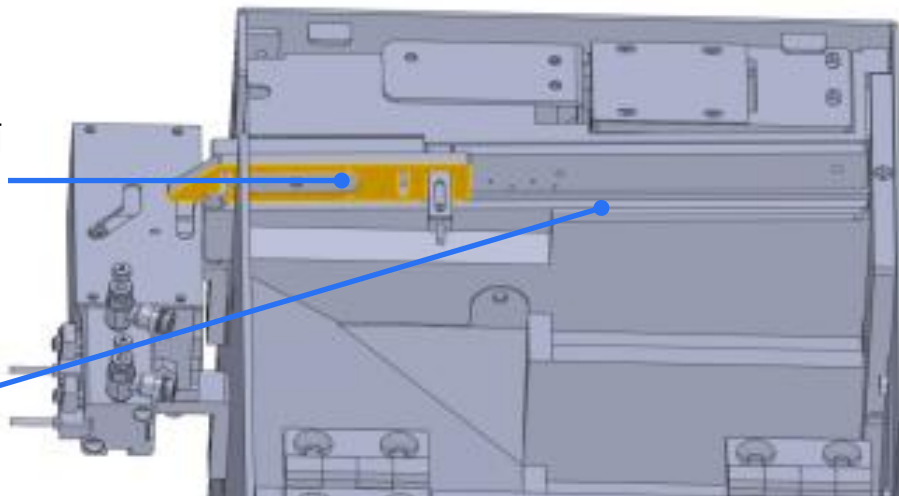
KL-S634

03 清洁模块-选配/Cleaning module - Optional

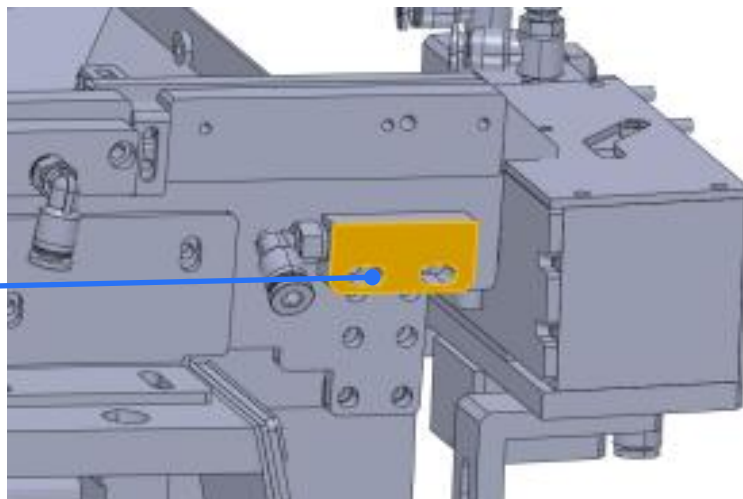
压条上接气源，吹螺钉表面
(除尘)

The air source is connected to the pressure strip to blow the surface of the screw (for dust removal)

螺丝在导轨上排列
Screws are arranged on the track.



导轨下方接负压气源，将吹下的
粉尘进行吸附 (集尘) A
negative pressure air source is
connected below the guide rail
to adsorb (collect dust) the
blown dust.



供料器清洁模块：此功能为选配项

Feeder cleaning module: This function is optional

1、螺丝在导轨上进行排列，到达压条位置后开始清除除尘，用气吹的方式，将螺丝上的粉尘吹掉，也包含导轨上的粉尘一起清洁；

1、 The screws are arranged on the guide rail. Once they reach the position of the pressure strip, dust removal begins. The dust on the screws is blown off by air, and the dust on the guide rail is also cleaned together.

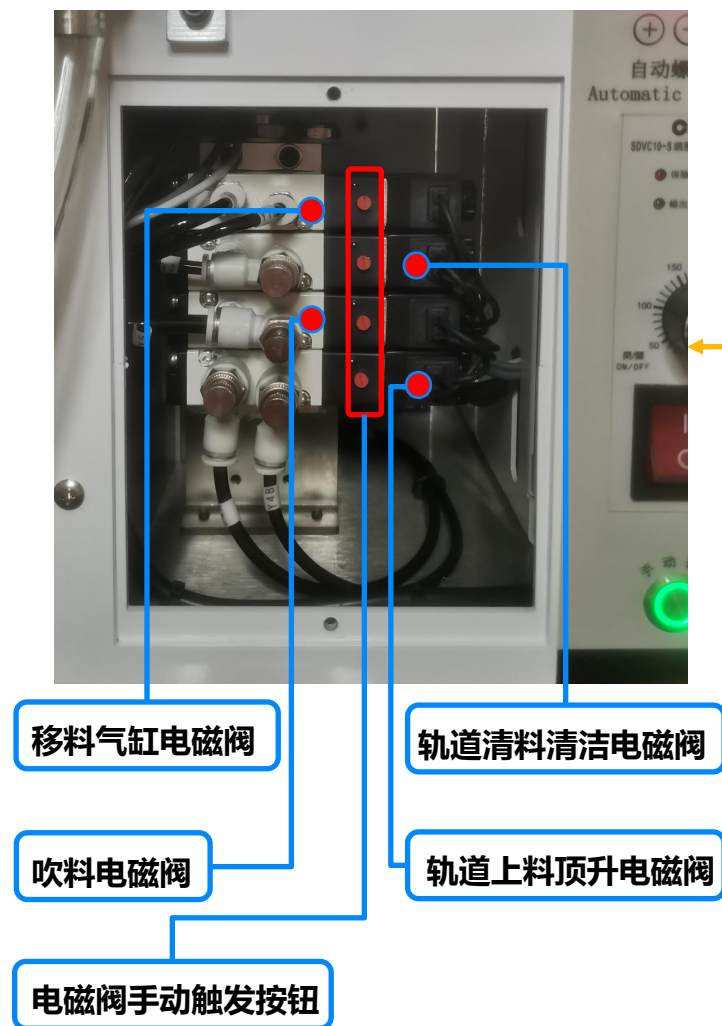
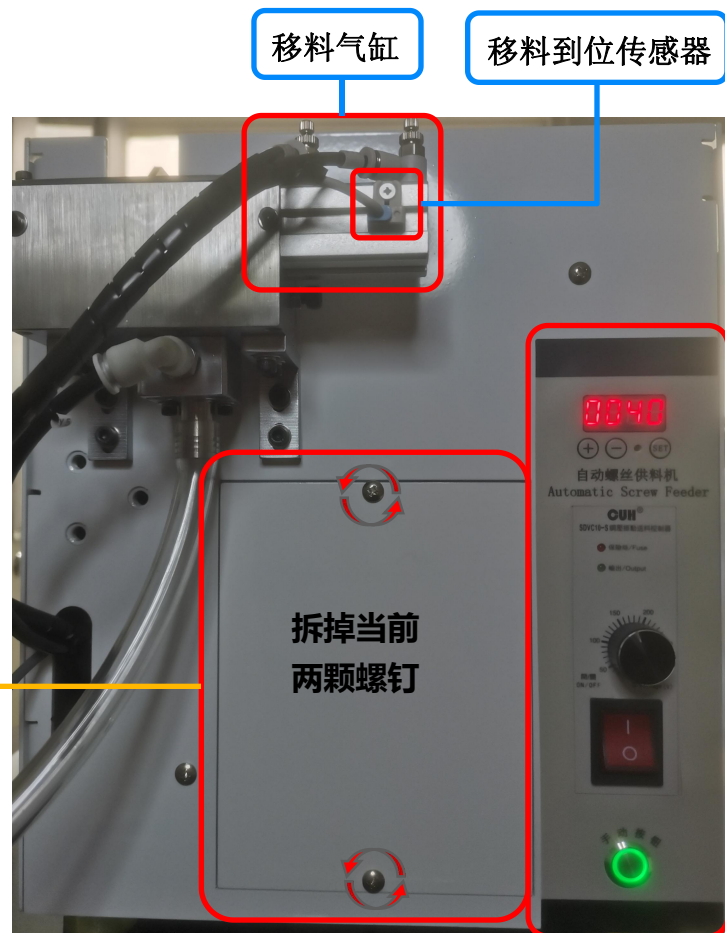
2、上方压条在吹气清洁的过程中，下方有一个集尘装置，带真空负压，将吹下来的粉尘进行回收；

2、 During the air-blowing cleaning process of the upper pressure strip, there is a dust collection device at the bottom with vacuum negative pressure to recover the blown dust.

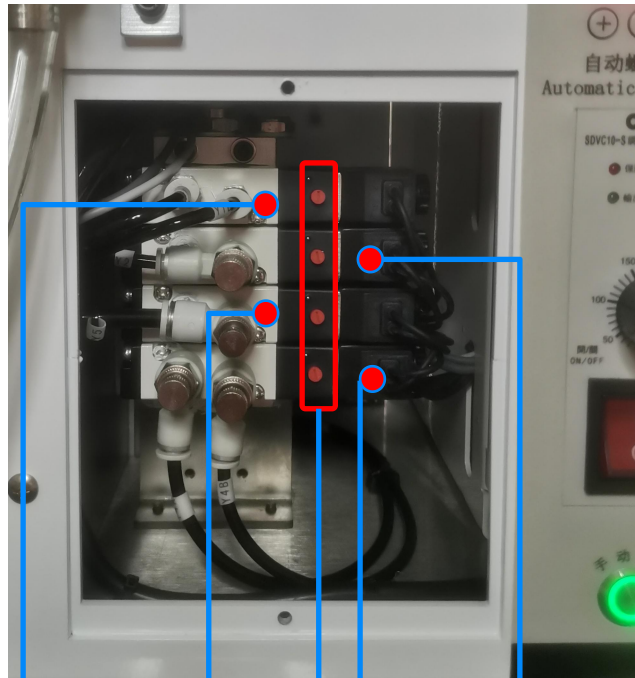
备注：以上清洁动作，由送钉机自主工作，内部控制，无需外接PLC进行控制。

Note: The above cleaning actions are independently operated by the nail feeder with internal control, and there is no need to connect an external PLC for control.

04 功能说明/Function Description



04 功能说明/Function Description



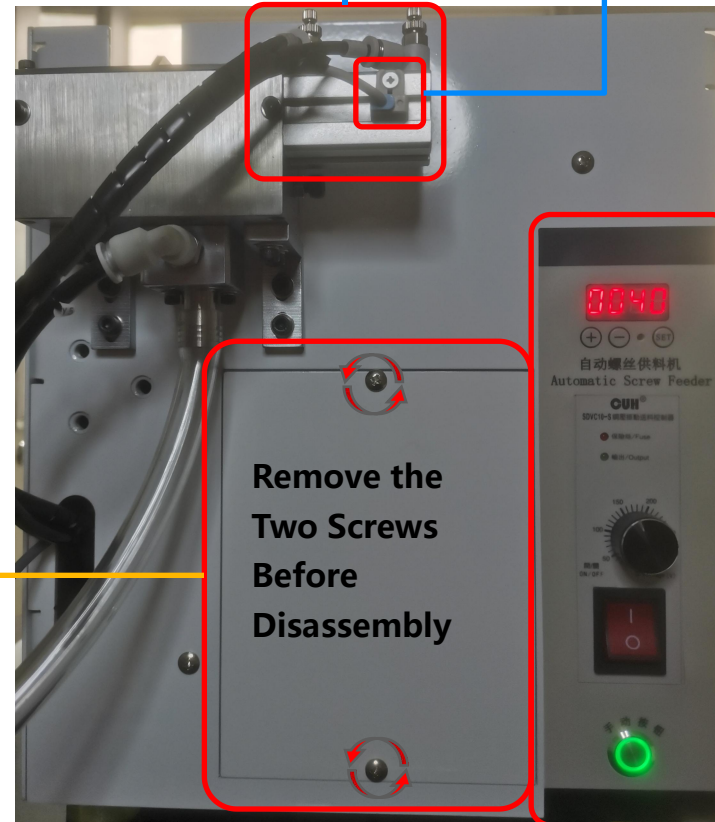
Transfer Cylinder Solenoid Valve

Blow-off Solenoid Valve

Solenoid Valve Manual Trigger Button

Track Cleaning Solenoid Valve

Track Lifting Solenoid Valve



Remove the Two Screws Before Disassembly

Transfer Cylinder

Transfer Position Sensor

Screw Counter & Function Display

Function Setting Button

Linear Vibration Intensity Adjustment (Turn Right to Increase)

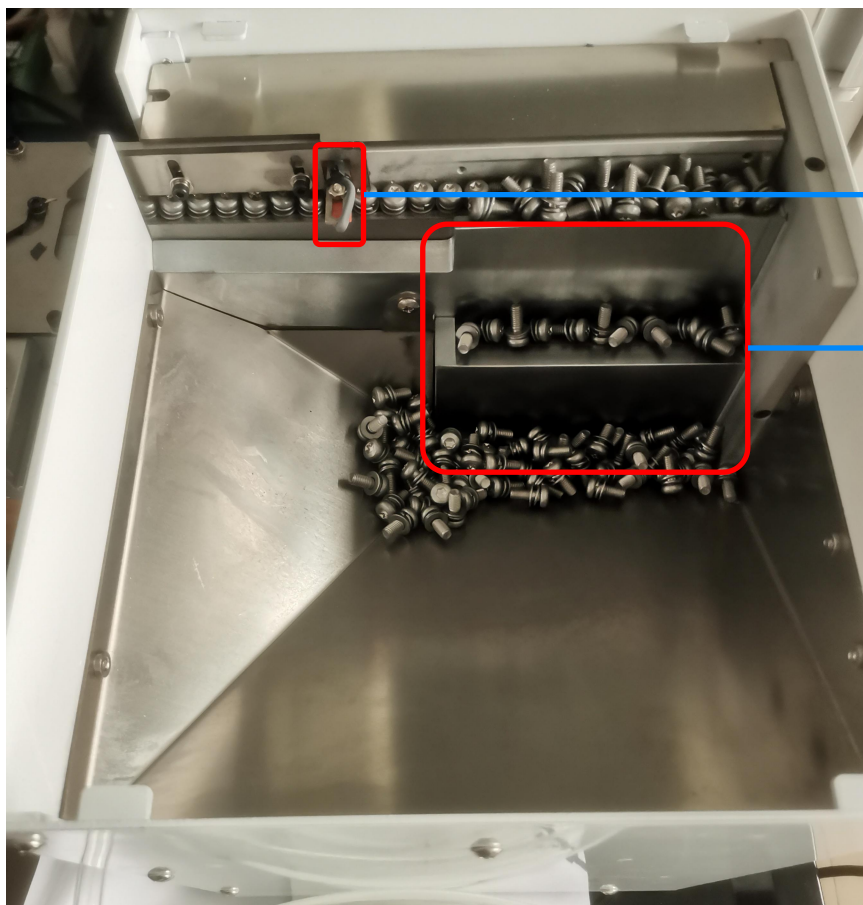
Vibration ON / OFF Switch

Manual Trigger Button



05

功能说明/Function Description



轨道有料检测传感器

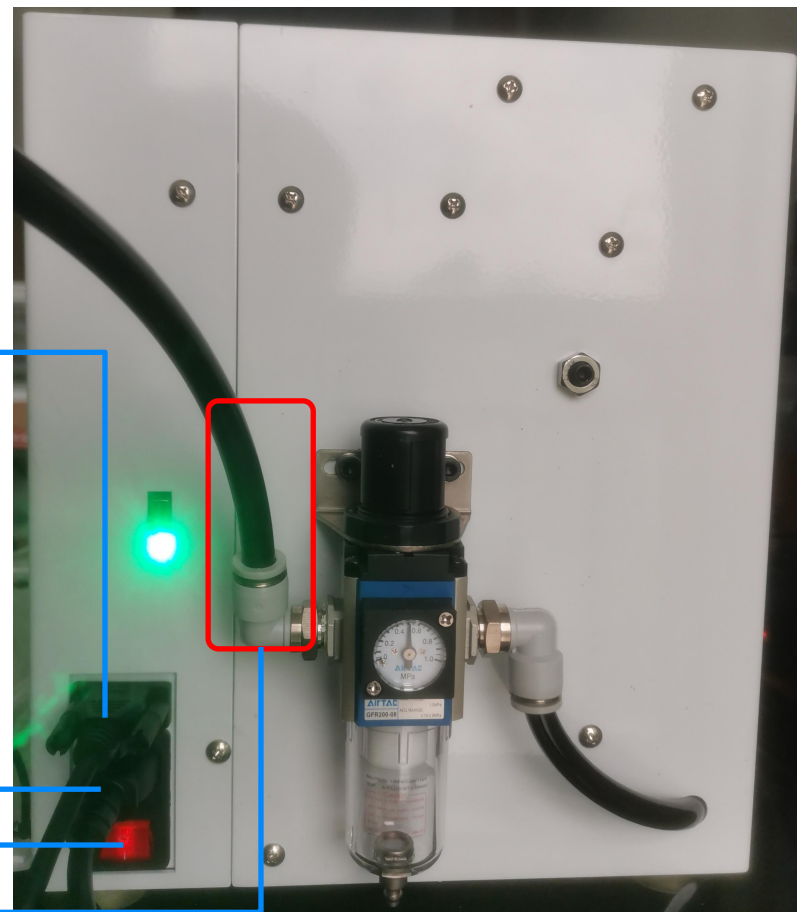
顶升上料机构

IO信号线接口

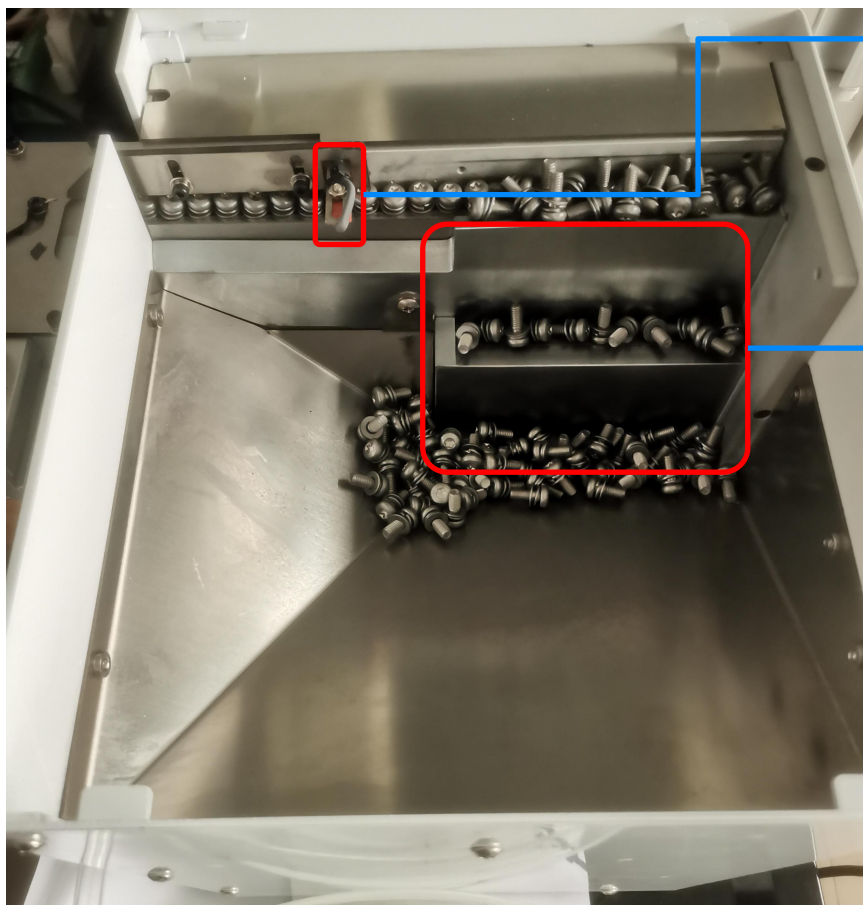
电源线接口

电源开关

ø 10进气管
【0.4Mpa-0.6Mpa】



05 功能说明/Function Description



Track Material
Detection Sensor

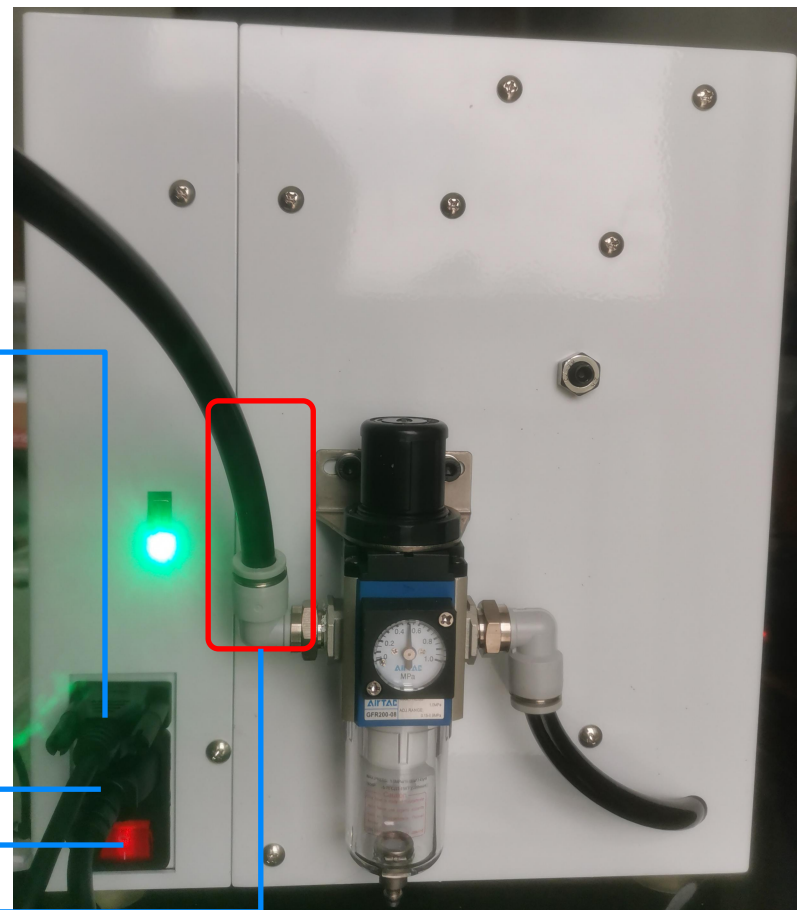
Lifting Feeding
Mechanism

I/O Signal Cable
Interface

Power Cable
Interface

Power Switch

Ø10 Air Inlet (0.4–0.6
MPa)



NPN接线方式介绍

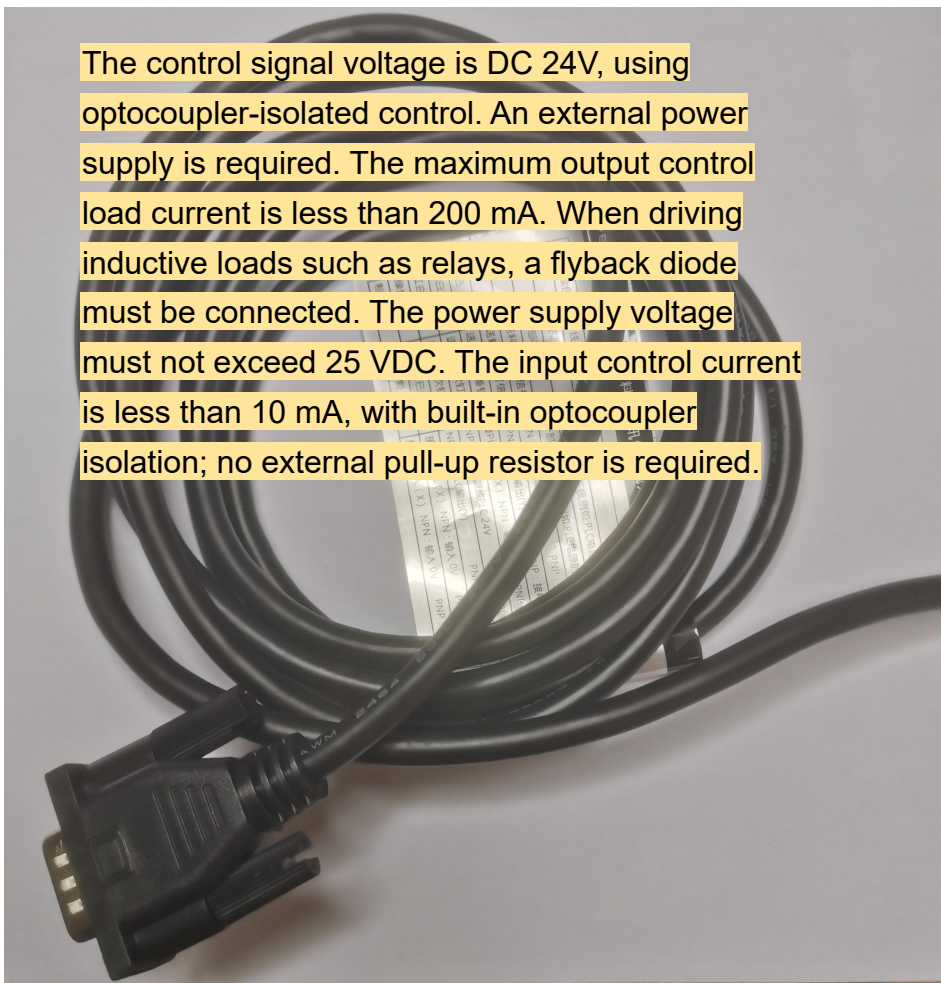


紫	引脚01 电源	接外部24V电源+24V	必接
蓝	引脚02 电源	接外部24V电源0V	必接
橙	引脚03	接外部24V电源+24V 【与引脚7搭配】	必接
黑白	引脚04	接外部24V电源+24V 【与引脚8搭配】	一拖二用
黑	引脚05	接外部24V电源+24V 【与引脚9搭配】	选接
棕白	引脚06	接外部24V电源+24V 【与引脚10搭配】	备用
棕	引脚07 输入	送料管 1请求吹钉信号 接PLC或控制器输出	必接
红白	引脚08 输入	送料管 2请求吹钉信号 接PLC或控制器输出	一拖二用
红	引脚09 输入	清除报警 接PLC或控制器输出	选接
白	引脚10 输入	输入备用 接PLC或控制器输出	备用
黄	引脚11 输出	送料管1有料信号 接PLC或控制器输入	选接
绿	引脚12 输出	送料管2有料信号 接PLC或控制器输入	一拖二用
灰	引脚13 输出	送料管3有料信号 接PLC或控制器输入	备用
粉	引脚14 输出	缺料报警 接PLC或控制器输入	选接
浅绿	引脚15 输出	故障报警 接PLC或控制器输入	选接

06

接线说明/Wiring Description

The control signal voltage is DC 24V, using optocoupler-isolated control. An external power supply is required. The maximum output control load current is less than 200 mA. When driving inductive loads such as relays, a flyback diode must be connected. The power supply voltage must not exceed 25 VDC. The input control current is less than 10 mA, with built-in optocoupler isolation; no external pull-up resistor is required.



NPN Wiring Method Overview

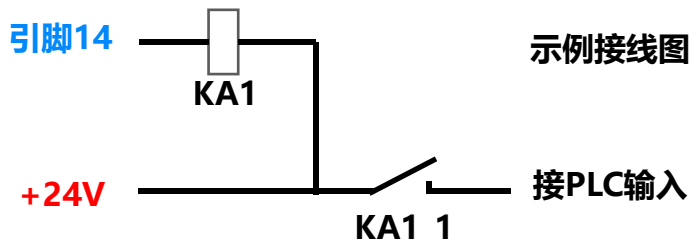
Pin 01 – Power: External 24V power supply +24V	Required
Pin 02 – Power: External 24V power supply 0V	Required
Pin 03 – Power: External 24V power supply +24V Paired with Pin 07	Required
Pin 04 – Power: External 24V power supply +24V Paired with Pin 08	Dual-head only
Pin 05 – Power: External 24V power supply +24V Paired with Pin 09	Optional
Pin 06 – Power: External 24V power supply +24V Paired with Pin 10	Optional
Pin 07 – Input: Feeding Tube 1 Screw Request Signal Connect to PLC or controller output	Required
Pin 08 – Input: Feeding Tube 2 Screw Request Signal Connect to PLC or controller output	Dual-head only
Pin 09 – Input: Clear Alarm Signal Connect to PLC or controller output	Optional
Pin 10 – Input: Input Reserved Connect to PLC or controller output	Optional
Pin 11 – Output: Feeding Tube 1 Available Signal Connect to PLC or controller input	Optional
Pin 12 – Output: Feeding Tube 2 Available Signal Connect to PLC or controller input	Dual-head only
Pin 13 – Output: Feeding Tube 3 Available Signal Connect to PLC or controller input	Reserved
Pin 14 – Output: Screw Shortage Alarm Connect to PLC or controller input	Optional
Pin 15 – Output: Fault Alarm Connect to PLC or controller input	Optional

07 接线说明/Wiring Description

PNP接线方式介绍



控制信号电压为 DC24V，光耦隔离控制方式，
需接外部电源，输出控制带负载能力总电流
<200mA（输出口可驱动一般的继电器），接口
电压不超过 25VDC，输入口控制电流
<10mA(内部已加限流电阻，外部不要再加)。



引脚11到引脚15默认输出NPN，改为PNP输入到PLC可参照此图继电器中转接法。

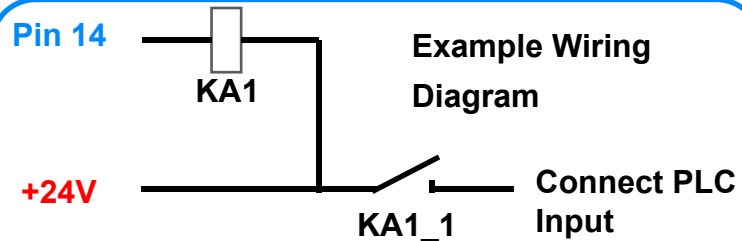
紫	引脚01 电源	接外部24V电源+24V	必接
蓝	引脚02 电源	接外部24V电源0V	必接
橙	引脚03 输入	送料管 1请求吹钉信号 接PLC或控制器输出	必接
黑白	引脚04 输入	送料管 2请求吹钉信号 接PLC或控制器输出	一拖二用
黑	引脚05 输入	清除报警 接PLC或控制器输出	选接
棕白	引脚06 输入	输入备用 接PLC或控制器输出	备用
棕	引脚07	接外部24V电源0V 【与引脚3搭配】	必接
红白	引脚08	接外部24V电源0V 【与引脚4搭配】	一拖二用
红	引脚09	接外部24V电源0V 【与引脚5搭配】	选接
白	引脚10	接外部24V电源0V 【与引脚6搭配】	备用
黄	引脚11 输出	管道1有料信号 通过继电器或光偶隔离中转	选接
绿	引脚12 输出	管道2有料信号 通过继电器或光偶隔离中转	一拖二用
灰	引脚13 输出	管道3有料信号 通过继电器或光偶隔离中转	备用
粉	引脚14 输出	缺料报警 通过继电器或光偶隔离中转	选接
浅绿	引脚15 输出	故障报警 通过继电器或光偶隔离中转	选接

The control signal voltage is **DC 24V**, using **optocoupler-isolated control**. An **external power supply is required**.

The maximum output control load current is **less than 200 mA**. When driving inductive loads such as relays, a **flyback diode** must be connected.

The power supply voltage must **not exceed 25 VDC**. The input control current is **less than 10 mA**. With **built-in optocoupler isolation**, no external pull-up resistor is required.

PNP Wiring Method Overview



Pins **11 to 15** originally use **NPN outputs**. When configured for **PNP input to PLC**, a **relay or optocoupler isolation conversion** must be used, as illustrated in the wiring diagram.

Pin 01 – Power: External 24V power supply **+24V** **Required**

Pin 02 – Power: External 24V power supply **+24V** **Required**

Pin 03 – Input: Feeding Tube 1 Screw Request Signal *Connect to PLC or controller output* **Required**

Pin 04 – Input: Feeding Tube 2 Screw Request Signal *Connect to PLC or controller output* **Dual-head only**

Pin 05 – Input: Clear Alarm Signal *Connect to PLC or controller output* **Optional**

Pin 06 – Input: Input Reserved *Connect to PLC or controller output* **Reserved**

Pin 07 – Power: External 24V power supply **0V (Paired with Pin 03)** **Required**

Pin 08 – Power: External 24V power supply **0V (Paired with Pin 04)** **Dual-head only**

Pin 09 – Power: External 24V power supply **0V (Paired with Pin 05)** **Optional**

Pin 10 – Power: External 24V power supply **0V (Paired with Pin 06)** **Reserved**

Pin 10 – Power: External 24V power supply **0V (Paired with Pin 06)** **Optional**

Pin 12 – Output: Feeding Tube 2 Available Signal Relay or *optocoupler-isolated output* **Dual-head only**

Pin 13 – Output: Feeding Tube 3 Available Signal Relay or *optocoupler-isolated output* **Reserved**

Pin 14 – Output: Screw Shortage Alarm Relay or *optocoupler-isolated output* **Optional**

Pin 15 – Output: Fault Alarm Relay or *optocoupler-isolated output* **Optional**

08 信号说明/Signal Description

引脚1 电源 必须接外部控制电路正极, 例如 PLC电源的 【24V】

Pin 1 Power External control circuit power supply required, e.g. PLC power supply [24V]

引脚2 电源 必须接外部控制电路负极, 例如 PLC电源的 【0V】

Pin 2 Power External control circuit power supply required, e.g. PLC power supply [0V]

引脚3 输入 【送料管 1请求吹钉信号+】

Pin 3 Input 【Feeding Tube 1 Screw Request Signal +】

在 DB头 3脚与7脚间施加 24V电压, MCU得到低电平, 低电平须持续 10ms以上, MCU检测到信号下降沿, 则触发送料管 1吹螺丝。如果电批有扭力返回信号, 可用此信号控制吹螺丝。

When 24V is applied between DB connector pin 3 and pin 7, the MCU detects a low-level signal. If the low-level signal is maintained for more than 10 ms, the MCU recognizes a screw request and activates the screw feeding mechanism.

引脚4 输入 【送料管 2请求吹钉信号+】

Pin 4 Input 【Feeding Tube 2 Screw Request Signal +】

在 DB头 4与 8脚间施加 24V电压, 触发送料管 2吹螺丝

When 24V is applied between DB connector pin 4 and pin 8, the feeder sends a screw request signal.

[一拖二专用]
[Dedicated for Dual-Head Models]

引脚5 输入 【清除报警+】

Pin 5 Input 【Clear Alarm +】

在 DB头 5与 9脚间施加 24V电压, MCU得到低电平。

When 24V is applied between **DB connector pin 5 and pin 9**, the MCU detects a low-level signal.

引脚6 输入 【输入备用+】

Pin 6 Input 【Input Reserved +】

在 DB头 6与 10脚间施加 24V电压, MCU得到低电平

When 24V is applied between **DB connector pin 6 and pin 10**, the MCU detects a low-level signal.

引脚7 输入 【送料管 1请求吹钉信号-】

Pin 7 Input 【Feeding Tube 1 Screw Request Signal -】

与 3组合成一组

Paired with Pin 3.

引脚8 输入 【送料管 2请求吹钉信号-】

Pin 8 Input 【Feeding Tube 2 Screw Request Signal -】

与 4组合成一组

Paired with Pin 4.

引脚9 输入 【清除报警-】

Pin 9 Input 【Clear Alarm -】

与 5组合成一组

Paired with Pin 5.

引脚10 输入 【输入备用-】

Pin 10 Input 【Input Reserved -】

与 6组合成一组

Paired with Pin 6.

引脚11 输出 【管道 1有料信号】

Pin 11 Output 【Channel 1 Available Signal】

输出 0V

Output 0V

引脚12 输出 【管道 2有料信号】

Pin 12 Output 【Channel 2 Available Signal】

输出 0V

Output 0V

引脚13 输出 【管道 3有料信号】

Pin 13 Output 【Channel 3 Available Signal】

输出 0V

Output 0V

引脚14 输出 【缺料报警】

Pin 14 Output 【Screw Shortage Alarm】

输出 0V

Output 0V

引脚15 输出 【故障报警】

Pin 15 Output 【Fault Alarm】

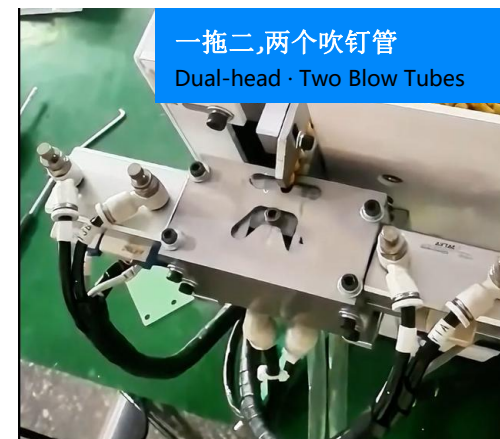
输出 0V

Output 0V

[一拖二专用] **[Dedicated for Dual-Head Models]**

[备用] **[Reserved]**

[一拖二专用] **[Dedicated for Dual-Head Models]**



1. 长按 SET 键 3 秒，显示[SE]设备参数界面，按下SET出现 [A-0.3] 的界面；再按SET 键切换至下一参数，长按 SET 键 3 秒后松开则返回主界面。

1. Press and hold the SET key for 3 seconds to enter the [SE] Parameter Setting Interface.

参数 Parameters	参数名称 Parameter Name	设定范围 Setting Range	范围 Range	参数定义 Description
A-0.3	螺丝接驳时间 Screw Detection Time	1-60	100-6000ms	在导轨处等待螺丝的时间，时间结束后分料气缸拉螺丝到下料口，最小单位 100ms Time allowed for detecting screws while waiting for screw feeding. If no screw is detected within the set time, the feeder pulls back to the screw outlet. Minimum unit: 100 ms.
B-0.8	气缸动作时间 Pneumatic Action Time	1-60	100-6000ms	气缸来回动作的最大检测时间，若气缸上感应器在设定时间内没有感应，则判断为气缸动作异常，最小单位 100ms Maximum detection time for pneumatic cylinder action. If no sensor signal is detected within the set time, it is considered a pneumatic action fault. Minimum unit: 100 ms.
C-0.3	吹气时间 Blowing Time	1-60	100-6000ms	往气管中吹螺钉的时间，最小单位 100ms Duration of air blowing. Minimum unit: 100 ms.
D-0.6	螺丝检测时间 Screw Detection Time	1-60	100-6000ms	分料气缸到下料口后开始计时，如果环形感应器在设定时间内没有感应到螺丝，则判定为无螺丝，最小单位 100ms Detection time after screws reach the screw outlet. If no screw is detected by the ring sensor within the set time, it is considered a missing screw. Minimum unit: 100 ms.
E-2.0	上料一次的时间 Single Feeding Time	1-99	100-9900ms	推料块动作一次时间，最小单位 100ms Time for one screw feeding action. Minimum unit: 100 ms.
F-20	循环模式设定数量 Cycle Mode Setting Quantity	01-45		设定送料节拍 Sets the screw feeding cycle count.
H-0.5	接近开关检测延时 Proximity Switch Detection Delay	1-99	100-9900ms	轨道上的接近开关(或光线传感器)检测到螺丝后延时一段时间后停止上料 After the proximity switch (or photoelectric sensor) detects screw feeding completion, feeding stops after a delay.
L-1.0	推料启动延时 Feeding Delay Time	1-99	100-9900ms	当检测到导轨缺料，延时一段时间后启动推料 When guide rail screw shortage is detected, feeding starts after a delay.
U-2.0	振动延时 Vibrator Delay Time	1-99	100-9900ms	当检测到导轨料满后，振动和导轨吹气延时一段时间后停止 When guide rail is full, the vibrator stops after a delay.
Y-15	缺料报警时间 Missing Screw Alarm Time	1-99	1-99秒	在设定时间内导轨上一直没检测到螺丝则报警，默认 15秒 Alarm is triggered if screws are not detected within the set time. Default: 15 seconds.

10 故障说明/Fault Description

2.主界面长按 + 键同时按一下 SET 键, 当出现 [n-__] 时, 松开+键, 进入手动测试程序。

2. Interface Operation: On the main interface, press and hold the “+” key, then press the SET key once. When [n--] appears, release the “+” key to enter Manual Test Mode.

① 按两下 + 键立马回到主界面并自动吹料测试。

① Press the “+” key twice to immediately return to the main interface and automatically perform a material blowing test.

②按 SET 则出现 [CL--] ,长按 - 键显示 [----] 表示螺丝计数清除成功, 并自动退出手动界面。

② Press the SET key until [CL--] appears, then press and hold the “-” key.

When [----] is displayed, it indicates that the screw count has been successfully cleared, and the system will automatically exit the manual mode.

③ 其余未列出功能不可修改。

③ All other unlisted functions are locked and cannot be modified.

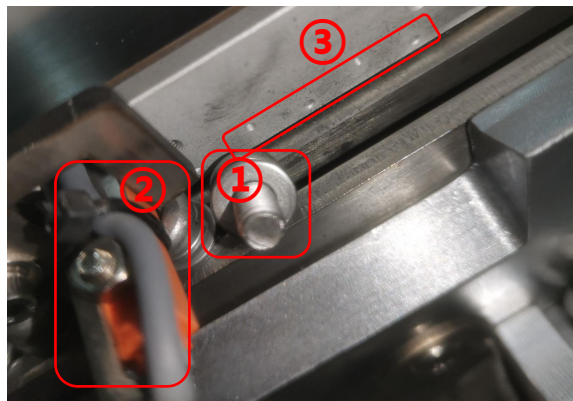
3.报错码及对应说明

报错码 Error Codes	故障信息 Fault Type	故障说明及排除方法 Fault Description & Troubleshooting Method
E-01	自检异常 Self-check error	开机报警, 请检查X1感应器是不是有感应 (单通道, 双通道) Alarm at startup. Check whether X1 sensor is sensing properly (single-channel / dual-channel).
E-02	自检异常 Self-check error	开机报警, 请检查X2感应器是不是没感应 (单通道, 双通道) Alarm at startup. Check whether X2 sensor is sensing properly (single-channel / dual-channel).
E-03	自检异常 Self-check error	开机报警, 请检查X3感应器是不是没感应 (双通道) Alarm at startup. Check whether X3 sensor is sensing properly (dual-channel).
E-04	自检异常 Self-check error	开机报警, 请检查X4感应器是不是有感应 (双通道) Alarm at startup. Check whether X4 sensor is sensing properly (dual-channel).
E-05	运行故障 Operation fault	接料口对着导轨位置检查X3感应器是不是没亮 Check whether the left positioning sensor is sensing properly.
E-06	运行故障 Operation fault	接料口对着导轨位置检查X2感应器是不是没亮 Check whether the right positioning sensor is sensing properly.
E-07	运行故障 Operation fault	检查左通道是否卡料, X3感应器是不是没亮, 检查环形感应器是不是没感应 Check whether the left channel is jammed; check whether the X3 sensor is illuminated; check whether the ring sensor is sensing properly.
E-08	运行故障 Operation fault	检查右通道是否卡料, X1感应器是不是没亮, 检查环形感应器是不是没感应 Check whether the left channel is jammed; check whether the X1 sensor is illuminated; check whether the ring sensor is sensing properly.
E-09	缺料报警 Missing screw alarm	导轨缺料, 检查导轨是否缺料, 导轨感应器是否坏了 Guide rail missing screws. Check whether screws are missing or whether the guide rail sensor is damaged.
E-10	感应器故障 Sensor fault	左通道环形感应器异常, 感应器处于感应状态 Abnormal ring sensor in the left channel. The sensor remains in a sensing state.
E-11	感应器故障 Sensor fault	右通道环形感应器异常, 感应器处于感应状态 Abnormal ring sensor in the right channel. The sensor remains in a sensing state.



① 移料气缸反复动作，且动作到最右侧时停顿时间较长：

需观察气缸运动到最右边时到位传感器不亮还是只是闪亮一下，如存在任一现象，基本可以确定是传感器位置不对，手动按电磁阀【电磁阀位置参照第4页功能说明】触发气缸，气缸至最右侧时再缓慢左右移动传感器查找检测位置，到达检测位传感器亮红灯，取检测位的居中位置，将传感器螺丝拧紧即可。【传感器不亮还有可能是传感器本身损坏，需购买同款进行更换】

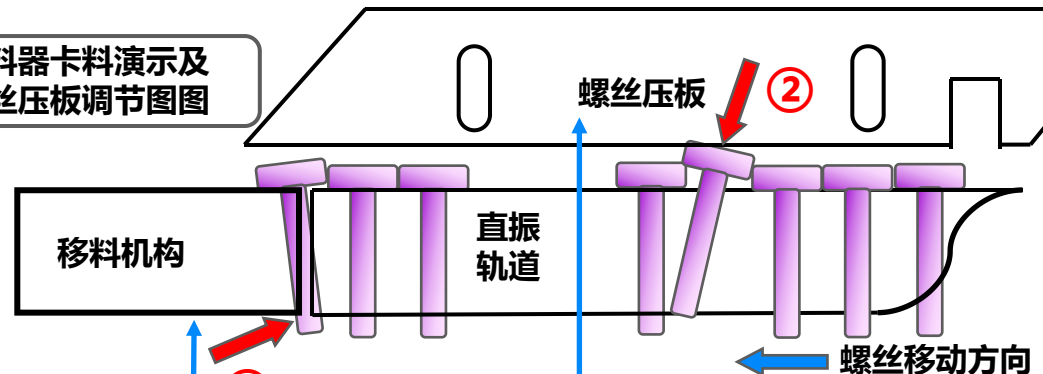
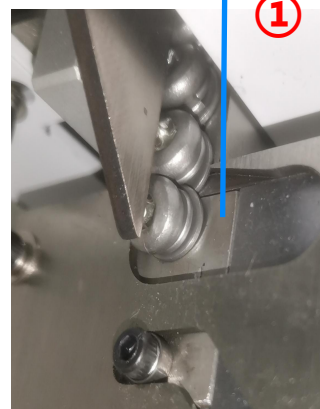


② 螺钉横料导致的卡料，轨道上有料传感器检测不到螺丝导致报警，如右图：

- ① 是横着导致卡料的螺钉
- ② 是直振轨道上有料检测传感器
- ③ 是清料清洁吹气孔【电磁阀位置参照第4页功能说明】

这种情况只需要调节清料清洁电磁阀的节流阀即可，左旋稍稍增大气流，注意适中即可，切勿过度调大，否则会影响上料效率。

供料器卡料演示及
螺丝压板调节图



松开螺丝可调节螺丝压板高度

③ 如上演示图所示，螺丝移动方向为从左到右，如果螺丝压板高度未调节合适，则会出现上面①②两种卡料情况【出厂已调节好】

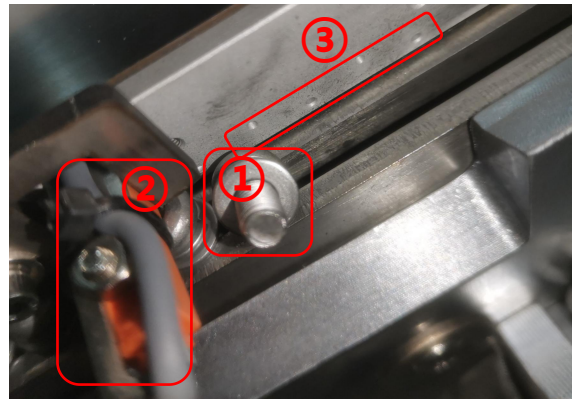
- ① 由于螺丝压板高度不合理，轨道振动时后面螺丝会一直往前挤运动，导致第一个螺丝虽然从上面看虽然在移料机构中，但螺杆部分却因倾斜在轨道中，最直接的故障现象就是移料气缸无法移动导致报警，与故障现象①同样报错码。
- ② 由于螺丝压板高度不合理，轨道振动时后面螺丝会一直往前挤运动，导致螺丝倾斜顶住螺丝压板而无法向前运动。

解决方法：将压板高度调节到距离帽头平面1mm至2mm处，根据螺丝大小及帽头厚度不同适当调节，平弹垫螺丝需额外加大距离，必要时将震动强度降低。【震动调节按钮位置参照第4页功能说明】



① The material transfer cylinder repeatedly actuates, and the pause time is longer when it moves to the far right side:

You need to observe whether the positioning sensor (limit sensor) is not lit or just flashes briefly when the cylinder moves to the far right side. If either of these phenomena occurs, it can basically be confirmed that the sensor position is incorrect. Manually press the solenoid valve [Refer to the Function Description on Page 4 for the solenoid valve position] to trigger the cylinder. When the cylinder reaches the far right side, slowly move the sensor left and right to find the detection position. The sensor will light up a red light upon reaching the detection position. Find the center point of the detection range and tighten the sensor screw. **[If the sensor does not light up, it could also be that the sensor itself is damaged, and you will need to purchase the same model for replacement.]**



② Material jam caused by horizontally oriented screws, which leads to the track material detection sensor failing to detect the screw and triggering an alarm (refer to the image on the right):

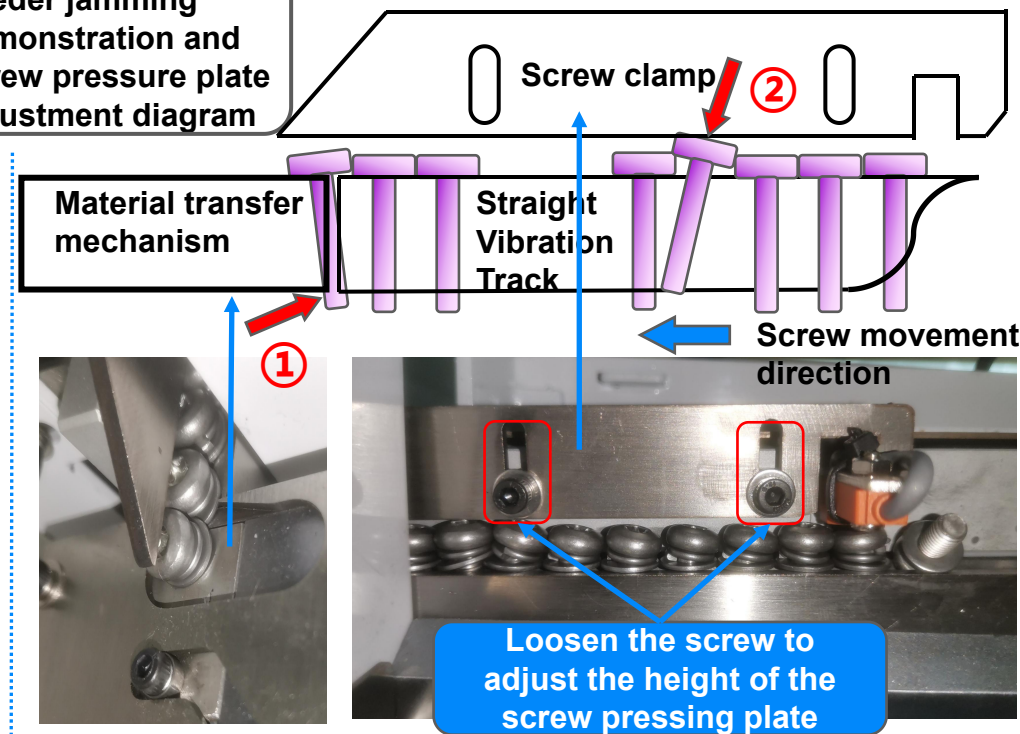
① This is the horizontally oriented screw causing the material jam.

② This is the material detection sensor on the vibratory feeder track.

③ This is the clearing/cleaning air-blowing hole [Refer to the Function Description on Page 4 for the solenoid valve position].

In this situation, you only need to adjust the throttle valve on the clearing/cleaning solenoid valve. Turn it slightly counter-clockwise to increase the airflow. Be careful to adjust moderately; do not over-adjust, as this will otherwise affect the feeding efficiency.

Feeder jamming demonstration and screw pressure plate adjustment diagram



③ As shown in the diagram (Screw Feeder Demonstration Diagram & Screw Pressing Plate Diagram), the screw movement direction is from left to right. If the height of the screw pressing plate is not adjusted correctly, the two types of jams described in ① and ② above will occur [Pre-adjusted at the factory]:

① Due to the unreasonable height of the screw pressing plate, the screws behind will continuously push forward during track vibration, causing the screws to tilt and push against the transfer mechanism, preventing them from moving forward. The most direct fault symptom is the alarm that the transfer cylinder cannot move, which results in the same alarm code as Fault Symptom ①.

② Due to the unreasonable height of the screw pressing plate, the screws behind will continuously push forward during track vibration, causing the screws to tilt and push against the screw pressing plate itself, preventing them from moving forward.

Solution: Adjust the pressing plate height to be 1mm to 2mm away from the plane of the screw head. Adjust appropriately according to the screw size and head thickness. For screws with a plain washer/spring washer, an additional distance adjustment may be needed. If necessary, reduce the vibration intensity. [Refer to the Function Description on Page 4 for the position of the vibration adjustment button.]

随机配件清单 Standard Accessories List			
序号 No.	品名 Item Name	数量 Qty	图片 Image
1	IO信号线 [1.8m] IO Signal Cable [1.8m]	1	
2	说明书 Manual	1	/
3	电源线 [1.5m] Power Cord [1.5m]	1	
4	进气管 [黑色∅ 10×1.5m] Intake Pipe [Black ∅ 10×1.5m]	1	
5	吹料管 [4m] Blowing Tube [4m]	1	
6	底脚固定座 Base Fixing Mount	4	

供料器保养 Maintenance List		
序号 No.	保养部位或组件 Maintenance parts or components	保养内容 Maintenance Contents
1	导轨 Guide rail	1.每隔15日用酒精擦拭导轨内侧面。 2.建议每隔两个月对导轨用退磁器进行退磁。 1. Wipe the inner side of the guide rail with alcohol every 15 days. 2. It is recommended to demagnetize the guide rail using a demagnetizer every two months.
2	对射传感器	1.建议每隔半月对料满停机传感器用酒精擦拭清晰。 It is recommended to wipe the full material stop sensor clean with alcohol every half month.
3	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。 Check every six months whether all the screws of the linear conveyor are loose and tighten them if necessary.

感谢支持

Thanks for the support



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