



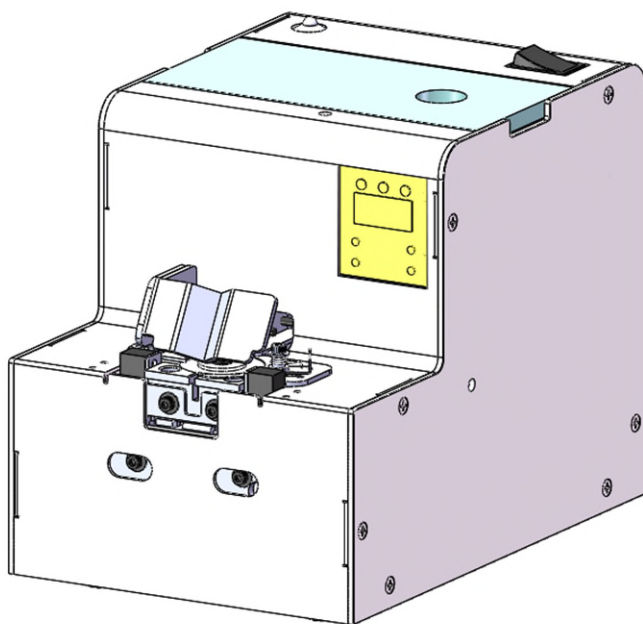
Automatic Screw Feeder

KFA-0850H

(PICK UP TYPE)

Instruction Manual

(ENGLISH)



Please read this manual thoroughly, before operating the unit and retain it for future reference.

Patented in China, Taiwan, Japan & Korea.

Imitation of product will be caused prosecution.

Y2F152-5-005

Safety Instructions

PLEASE NOTE FOLLOWING CONDITIONS BEFORE USING KILEWS KFA-0850

- ◎ For a normal performance, please install this machine on a flat and stable working table, do not slant or pad, otherwise machine function might be affected.
- ◎ Turn off the power switch and unplug the AC adaptor when this machine is not being used for a period of time.
- ◎ To avoid damage and malfunction, use the AC adaptor supplied with this machine only.
- ◎ Keep the surface of the rail groove clean and free from dust and oil. Failure to keep the rail groove clean could result in damage to the machine.
- ◎ The applied screws must be clean without grease or dust, and screw size is within specified range as machine rail.
- ◎ Handle screws on rails with care, do not use excess force to remove them or the rails may be damaged.
- ◎ When scooping chamber is turning, do not put fingers or objects other than screws into the chamber.
- ◎ Do not turn ON the power switch before the rails are set properly for operation.
- ◎ In case of malfunction during operation, please turn off the power and unplug the AC adaptor. Contact your supplier at once.

Whenever this machine requires service, please contact your supplier for assistance, or go to our website & e-mail us your contact detail and requirement, we will respond ASAP.

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Check Before Operation

Accessories Included

Please check if there are complete accessories included with your KFA-0820H:

HEX Wrench 2.0*107mmL Type*1



Orbit Back-End Chip Rule

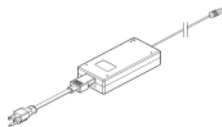
20*10*0.2mm*2pcs&0.5mm*6pcs



Instruction Manual*1



Power Controller AC 100~240V/DC12V*1



Orbit Front-End Chip Rule

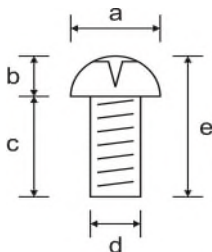
20*10*0.2mm*2pcs&0.5mm*6pcs



Check The Screw Sise

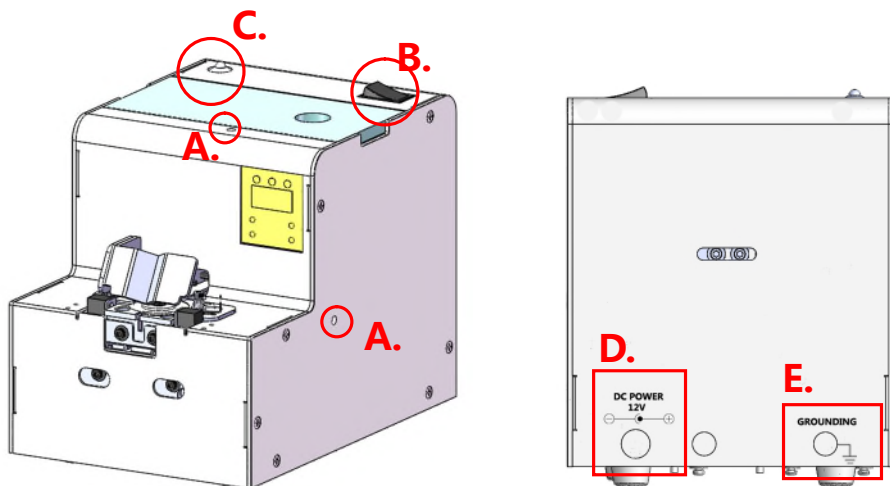
Measure the size precisely on each part of applied screw with a caliper.

Table A



a	Dia. of screw head
b	Height of screw head
c	Length of screw body
d	Dia. of screw bolt
e	Total length of screw

Function With Adjusting Holes On Housing And PCB



- A. Lock Gate Plate
- B. Power S.W.
- C. Indication Light
- D. DC Power Hole
- E. Grounding Hole

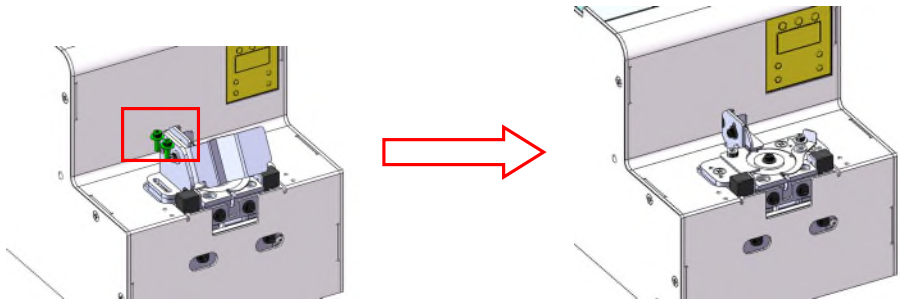
Adjustment

After checking the screw size, it needs to adjust all related parts according to the screw size for the first use.

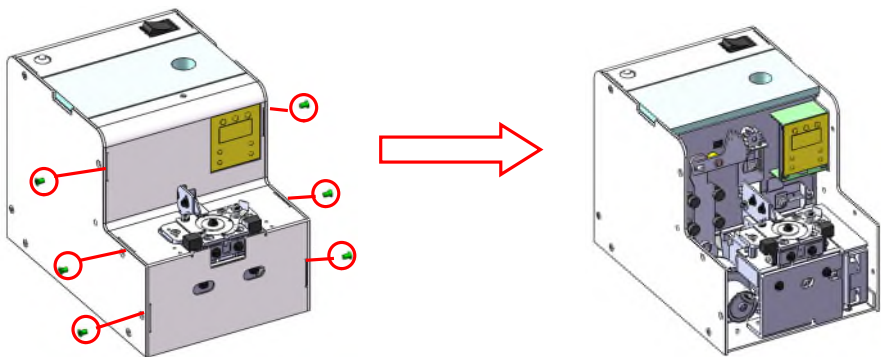
Adjust The Rail Assembly

Dismantle The Rail Assembly

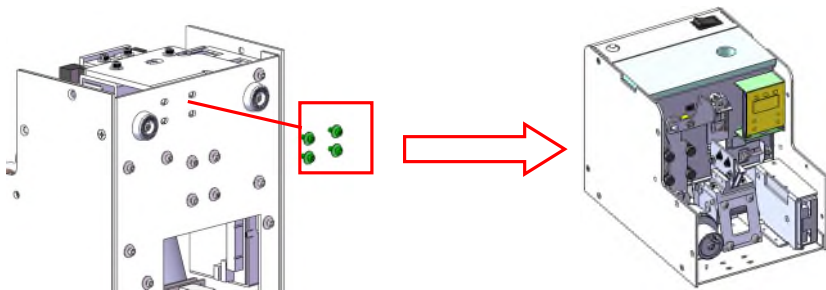
1. Remove the fixing screws of guide assembly, dismantle the guide assembly.



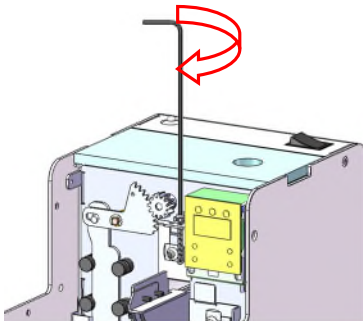
2. Remove the fixing screws (6pcs) of front housing and take off the front housing.



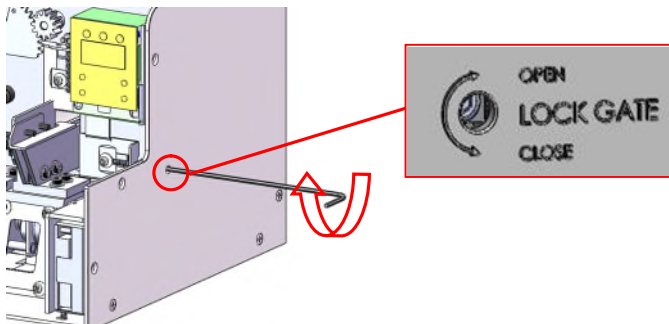
3. Dismantle the fixing screws (4pcs) of feeding structure and take it off.



4. Facing the machine, use Hex wrench to loose the screw clockwise to open the lock gate upward.

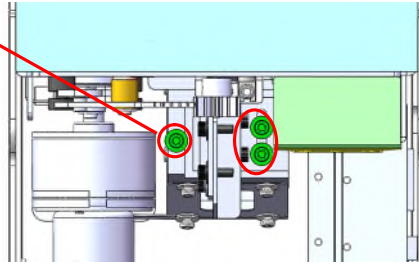


5. Facing the machine, use Hex wrench to loose the screw clockwise to open the lock gate rightward.

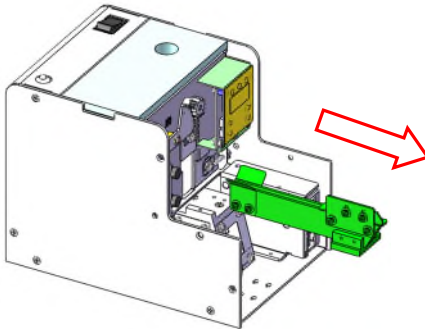


6. Remove the fixing screws of rail assembly.

The fixing screws
of rail assembly



7. Draw out the rail assembly from the machine.

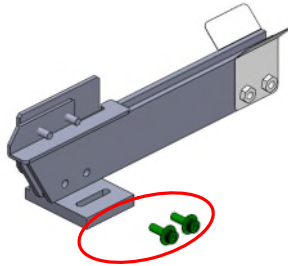


※Note The Following When Making Above Adjustment※

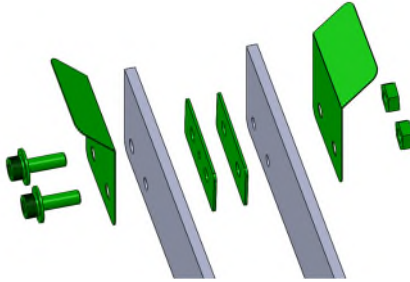
- a. Before dismantling the rail assembly, please confirm the lock gate status is open.

Adjust The Width of Rail Assembly

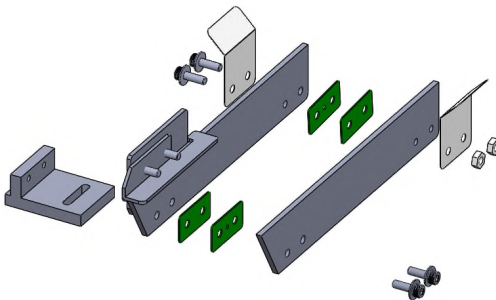
1. Remove the fixing screws on the front end of rail assembly.



2. Remove the fixing screw on the rear end of side of rail assembly, take off the tooling plate.



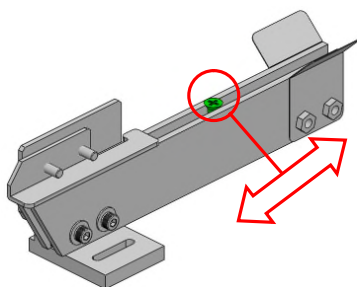
3. According to Table b, insert the suitable tooling plate into the rail groove for the width required and tighten the screw of step 1.2.



※ Combination Of The Thickness For Reference ※Table B

Dia. of Screw Bolt (d) mm	Accessory-Tooling Plate (Rear) mm	Dia. of Screw Bolt (d) mm	Accessory-Tooling Plate (Rear) mm
1.2	$0.5 \times 2 + 0.2 \times 2 = 1.4$	2.5	$0.2 + 0.5 \times 5 = 2.7$
1.4	$0.2 \times 3 + 0.5 \times 2 = 1.6$	3.0	$0.2 + 0.5 \times 6 = 3.2$
1.7	$0.2 \times 2 + 0.5 \times 3 = 1.9$	3.5	$0.2 + 0.5 \times 7 = 3.7$
2.0	$0.2 + 0.5 \times 4 = 2.2$	4.0	$0.2 + 0.5 \times 8 = 4.2$
2.3	$0.5 \times 5 = 2.5$	5.0	$0.2 + 0.5 \times 10 = 5.2$

4. After width adjustment of the rail assembly, take one screw into the groove and slide it up and down to both sides. Then check whether the movement is smoothly.

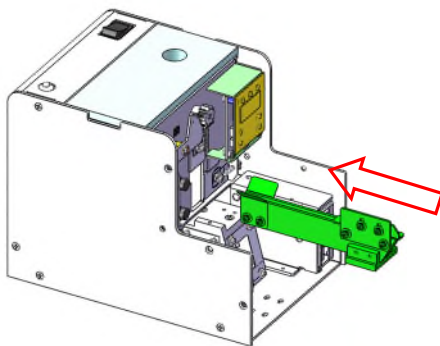


※ Note The Following When Making Above Adjustment※

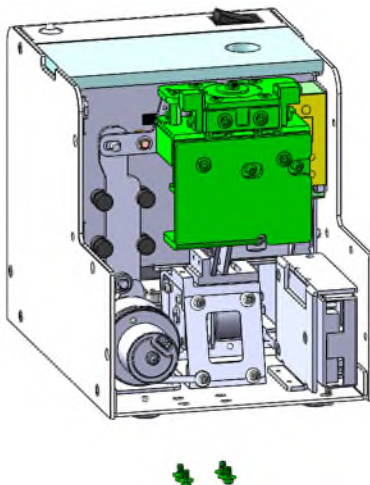
- Please be sure to keep the width of rail from the beginning to the end uniformly.
- When adjusting the width of front rail assembly, the screw of step 1 must be fastened tightly.

Install The Rail Assembly

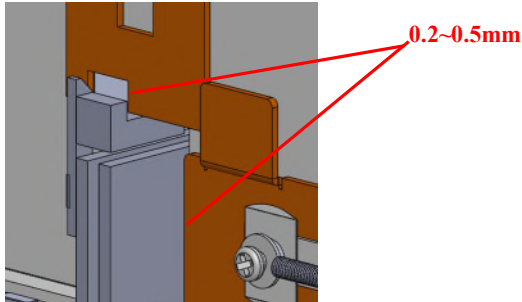
1. Insert the adjusted rail assembly into the machine. Then fasten the fixing screws.



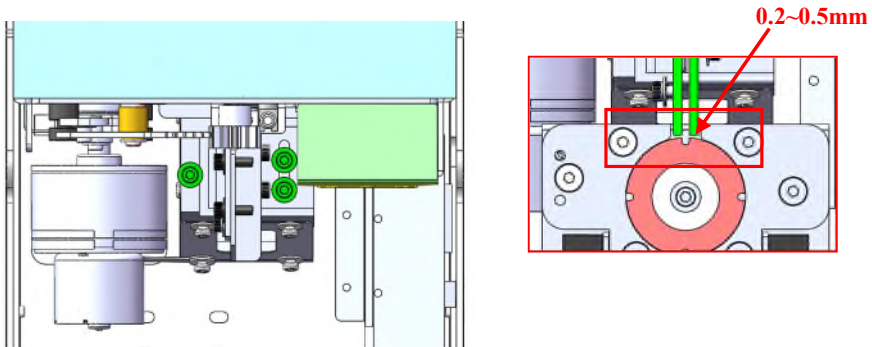
2. Install the feeding structure, and then fasten screws.



3. Adjust up and right gate to make distance between rail and gate around 0.2~0.5mm.



4. Loosen rail fixing screw, adjust distance between the front of rail and disc around 0.2~0.5mm, fasten the screw.

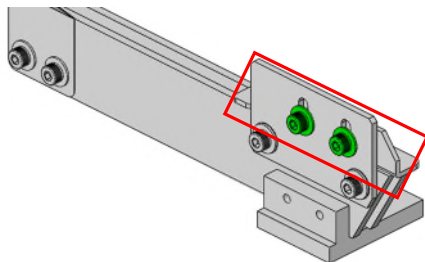


※ NOTE

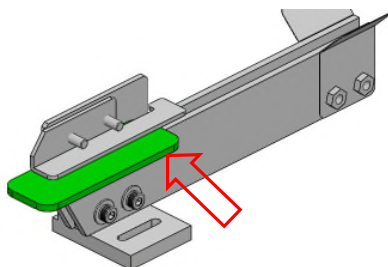
- Rail installation must keep 0.2~0.5mm gap with disc, must not be touched.
- When rail cannot install successfully, please check.
- Must keep 0.2~0.5mm gap between up 、 right gate and rail.

Force-down plate adjustment

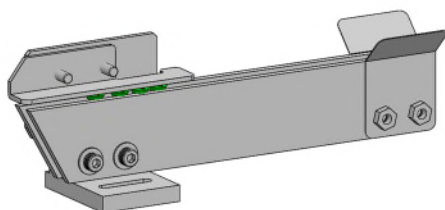
1. Loosen fixing screw on force-down plate.



2. Use accessory tooling plate adjust height of force-down plate and then fasten screw in step1.



3. Put some screws into the groove and slide it up, to check whether the movement is smooth.

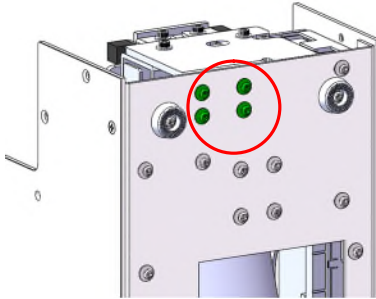


※ NOTE

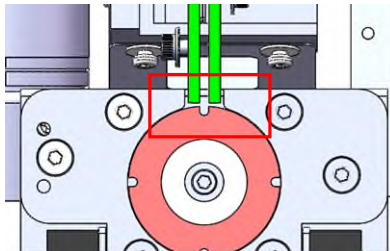
- a. When adjust force-down plate, the screw in step 1 must fasten tightly to avoid losing.

Distribution Mechanism adjustment

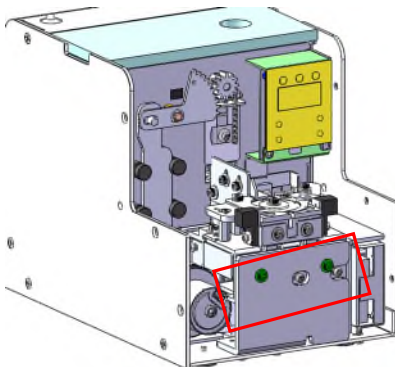
1. Loosen fixing screw from front of distribution mechanism.



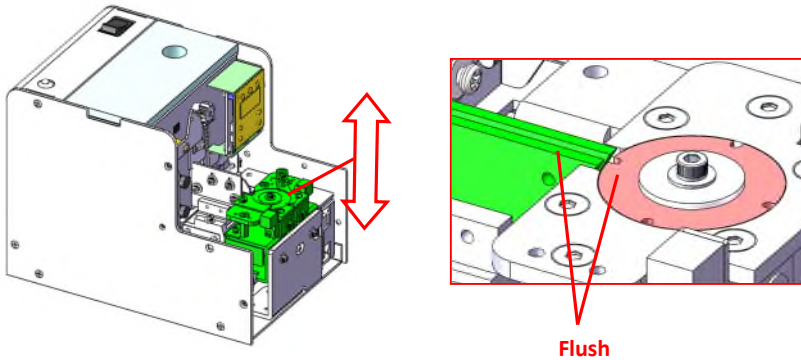
2. Align disc gap with central of rail by adjust front of distribution mechanism by left and right, fasten the loosen screw in step 1.



3. Loosen two hexagon screws.



4. Adjust from part by up and down to make disc and rail flush, and then fasten loosen screw in step 3.

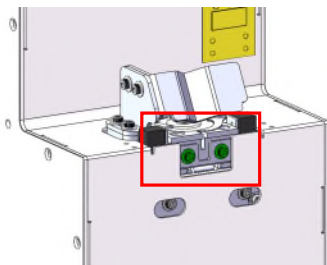


※ NOTE ※

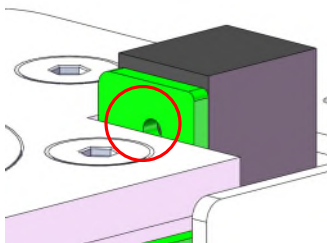
- Align disc gap with central of rail, and upper plane cannot higher than upper plane of front rail.
- Disc plane cannot higher than rail plane.

Adjust Sensor Function

1. Loosen the fixing screw of sensor fixing plate.



2. Make sure to cover half of the hole, and then fasten the screw of step 1.



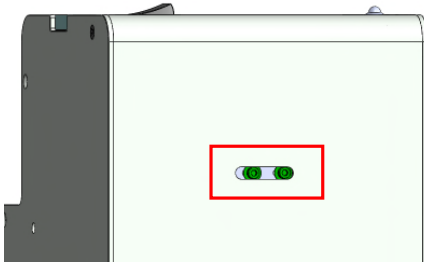
※ NOTICE ※

- a. Make sure to cover half of the hole and do adjustment to ensure the sensor function no problem.

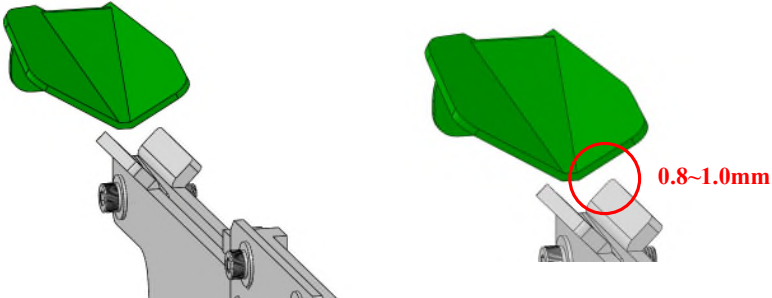
Adjust V Chase on Scooping Chamber Back

The V Chase is located on top of the rail and fastened to the back of Roller Assembly. The purpose is to catch fallen screws from the Rollers, and guide screws back to the rail.

1. Using the Allen wrench to loosen the Hex Socket Head Cap Screws behind the main body.



2. Adjust V Chase to face to the center of the rail. Distance between Chase and rail should be 0.8~1.0mm



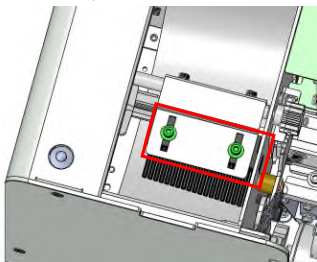
constantly bright

※ NOTICE ※

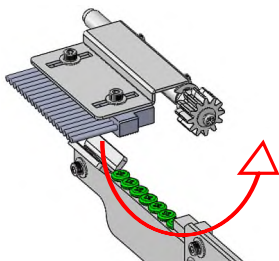
- a. Keep 0.8~1.0mm open space between V Chase and the end of the rail, and V Chase aligned to the center of the rail.

Adjust the Brush

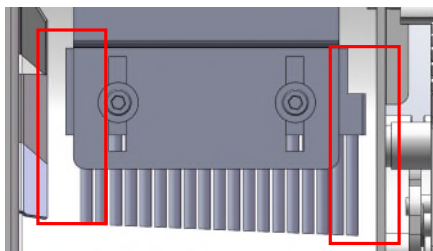
1. Swing the brush to stay almost horizontal, loosen screw on the side of brush bracket.



2. Place 5~8 screws into the rail groove close to the holding plate rear end and loosen 2 screws on the side of the brush bracket. Swing the brush and adjust the height until the brush just touch the screw heads slightly and tighten the screws after adjustment.



3. When fix the brush position, keep suitable space form the Front Plate and Fixing Plate.



4. Brush bracket and driving rod must be parallel and fix to the center.



※ NOTICE ※

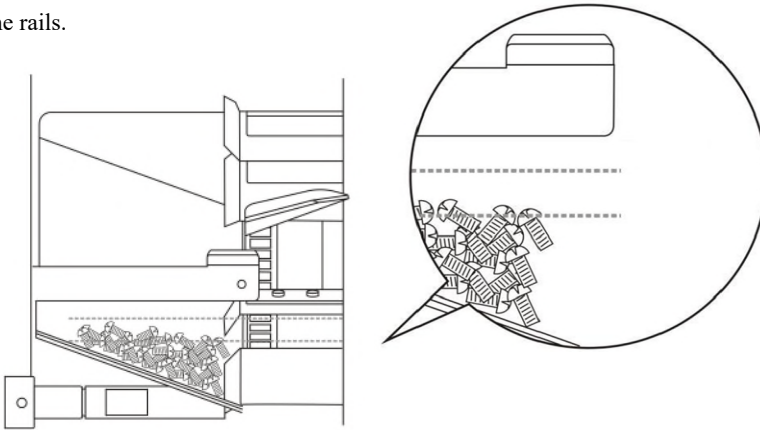
a. After adjustment of the height of the brush, swing the brush by hand to make sure the movement runs smoothly.

b. The brush length is inconsistently, please ensure the brush match rail when replace it.

Method of Operation

Load Screws Into the Chamber

Turn off the power first and open the Top Cover Box. Ensure the screws are loaded without foreign materials, pour in screws until they come up to 1~2mm below the top on both sides of the rails.

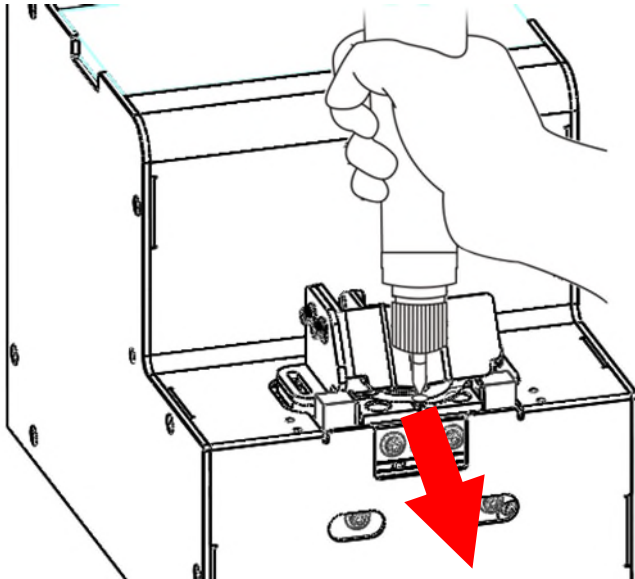


Can contain screws between 200~220cc. All objects other than applied screw are deemed as foreign material which should be removed first; or it will affect the performance of this machi

Pick Up Screws

Make sure the bit type on your electric screwdriver matches the head of the screw, and the bit is magnetized before use. (Bit that not magnetized will not stick with the screw and screw will fall off after picking up).

Hold the screwdriver and put the driver bit above the Bit Guide and push it straight down to "+" on top of the screw figure below.

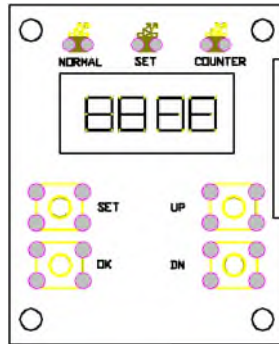


※CAUTION FOR THE ABOVE OPERATING ※

- Do not push the driver bit with too much force when picking up the screw, or it will damage the Rail Assembly.
- Do not deliberately apply force on the Rail Assembly or it will damage the machine.

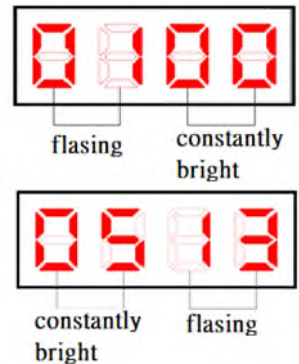
Counter interface operation

1. Display interface diagram



Setting :

1. Press the SET button for 3 seconds to enter system setting. Select setting options when the SET light is on. Now the first two digits led are flashing for changing and press the UP or DN button to select item number that you wish to change its value.
2. Now press the OK button briefly to enter last two digits led for changing values and now these two led lights are flashing. Press the UP or DN button to make changes.
3. Press the OK button to get back to the first two digits for other items setting. For now, just repeat setting procedure like above.
4. We will exit system setting 3 seconds after finish settings without pressing any key.



Zeroing:

1. Press both SET and OK buttons at the same time to clear numbers of screws count to zero.

Target counting function switching.

1. Normally the number of counting displayed that are accumulated as the NORMAL light on. Press the OK button briefly to switch screws counting between accumulate and target counts under system setting at the item 01. The COUNTER light on means target count is enabled.

Feature Comparison Table

Item	Feature	Definition (UP/ DN)
01	Count Quantity Setting	Target Quantity (Value: 00~99 screws (00 means Off this function))
02	Count Quantity Increment or Decrement Setting	Item 01 Count Method (Value: 00 Increment; 01 Decrement)
03	Buzzer Setting	Buzzer is on or off. (Value: 00 ON; 01 OFF)
04	Vibration Motor Delayed Shutdown Setting	Set Vibration Motor Delayed time to stop. (Value: 01 ~ 12 (each number is one second))
05	Vibration Motor Intensity Setting	Set Vibration Motor intensity. (Value: 01 ~ 20)
06	Roller Motor Delayed Shutdown setting	Set Roller Motor Delayed time to stop. (Value: 01 ~ 12 (each number is one second))
07	Roller Motor Intensity Setting	Set Roller Motor intensity. (Value: 01 ~ 20)
08	Rotary Motor Speed Setting	Set Rotary Motor turning Speed. (Value: 01 ~ 10)
09	Vibration Moto Directuin Setting	Set Vibration motor Direction. (Value: 00 Forward; 01: Reverse Rotation)
10	Enable Pick up Screw Quantity Setting in Drum Mode	Set Enable Pick up Screw Quantity in Drum mode. (Value: 00 ~ 20 (00: Shutoff Function))
11	Enable Rotary Motor Delayed Setting	Set Enable Rotary Motor Delayed Time (Value: 01 ~ 10 (each number is 0.5 second))
12	Infrared Sensor Numerical Display Setting	Set Infrared Optocoupler Adjustment Value (Value: 00 Off; 01 On)
13	Screw Dimension Selection	Set gape by thickness of the head of screw (Value: 00 Large; 01 Small)

※Note:

1. When enable Infrared Optocoupler Adjustment Value, there is rotary with the lowest speed turning only. Others like vibration and roller motors do not work. In the meantime, the infrared value will be showed over on the display panel. However, it is time to adjust the height base on

the display. Normally, set value to 2500 without screw. Reboot the screw feeder after adjustment.

2. Since gape selection is depending on the thickness of screw's head, please choose value 01 for the thickness less or equal to 0.5mm and value 00 for other that greater than 0.5mm.

2. Fault codes and meanings

Code	Error Summary
E-01	Alert: Roller Motor Jam Notification
E-02	Alert: Rotary Motor Jam Notification
E-03	Roller Motor works abnormal
E-04	Vibration Motor works abnormal
E-05	Both Roller and Vibration Motors work failure

Troubleshooting

Please power off for examination once needed.

Status	Caused	Solution
No action after power on or come with abnormal sounds	No AC power or loose cable	Check the power controller
	Screws quantity too much	Take some screws out
	Switch, motor, PCB malfunction	Replace Switch, motor or PCB
	Screws fall in to the inside of machine	Clean it up
	Infrared sensor not in the correct position	Adjust the infrared sensor
	The infrared device is blocked	Clean it up
Roller chamber does not rotate	Roller motor malfunction	Replace the roller motor
	Foreign stuck between the gears or gear crack	Remove foreign objects, replace components
Screw can't slide out from screw feeder's rail	The track clearance does not match the screw	Adjust the width of the gap between the left and right of the track
	Screws block the gate way that brush can't remove it	Adjust the height of brush
	Gate door too small	Adjust the upper, right gate door
	Push down plate not high enough	Adjust the position of push down plate
	The vibration motor does not vibrate	Replace the motor of vibration
No signal output	Relays PCB burned or connection issue as cables fall	meter detects if there is a signal. ° 1.Signal indicates that the cable is disconnected and just need reconnect. 2. No signal Description Relay burned, replace the relay board
	PCB got damaged or connection issue as cables fall	Use meter to check if there has 5V output ° 1.Signal indicates that the cable is disconnected and just need reconnect. 2. No signal Description PCB burned, need replace the PCB
Beep alarm with signal lights always on	PCB burned out	Replace the main PCB

Maintenance & Cleaning

Turn off the POWER before performing maintenance and cleaning.

CLEANING AND MAINTENANCE THE BRUSH

Using the dry cotton to wipe the brush to remove the dust, Swing the brush by hand and adjust the height of the brush to make the brush in touch with screw heads.

Replace the brush when brush hair is too worn and cannot wipe down screws in an improper position.

CLEANING AND MAINTENANCE THE RAIL

Withdraw the rail assembly, clean the rail groove and top of the rail (area for screws flow) with a clean, thin cotton cloth soaked with alcohol or benzene. Use the Allen Key to check if the screws for the parts of rail assembly are fastened.

INTERIOR CLEANING

After cleaning the rail assembly, take out any screw or foreign material inside of machine, and clean whole interior parts, walls particularly the motor, PCB and gear to prevent effecting against machine functions.

OPTIONAL PARTS:

Please use genuine parts to ensure products quality and avoid influences caused against performance of this machine.

REMARK:

When using screw of special types or other than specified, please consult our distributors.

International Warranty Conditions

The warranty is valid for 12 months from purchase date (based on 8 working hours a day). Please contact your supplier during the warranty period for repair or maintenance.

❖ NOTE:

1. The service cost shall be considered as chargeable if the failure/cost was induced by any of the following conditions:

- Failure due to improper handling or un-authorized modification.
- Failure has nothing to do with the original design of the machine.
- Labor and parts cost to replace the consumable parts (brush, rail assembly, etc.).

2. The WARRANTY will be void under any of the following conditions:

- Failure arising from a case or an accident beyond one's control or Act of God.
- It has been modified, altered and/ or repaired by an unauthorized dealer, purchaser or third party.
- The serial number, warranty card has been altered, de-faced and /or removed.
- Failing to use genuine parts sold or recommended by the Company.

3. Under this warranty, the company only provides service at any time during normal business hours. Should emergency service is required outside normal business hours, and such service if available will be provided with a charge on a per call rate basis.

4. The warranty is not transferable without the consent of the Company.

WARRANTY CARD

CUSTOMER :	
TELEPHONE :	
ADDRESS :	
PURCHASE DATE :	
DISTRIBUTOR :	
MODEL NAME	AUTOMATIC SCREW FEEDER (PICK UP TYPE)
MODEL NO.	
SERIAL NO.	
SCREW SIZE	1.2~5.0mm
SWITCHING ADAPTOR	DC IN 12V
MEASUREMENT	MACHINE : 182 (L) *124 (W) *147 (H) mm
	EACH CARTON :282 (L) *142 (W) *201 (H) mm
WEIGHT	N.W 3.1kg
	G.W 3.67kg

Remark: