

# HAKKO 155

LEAD CUTTER

Lead Cutter

## Instruction Manual

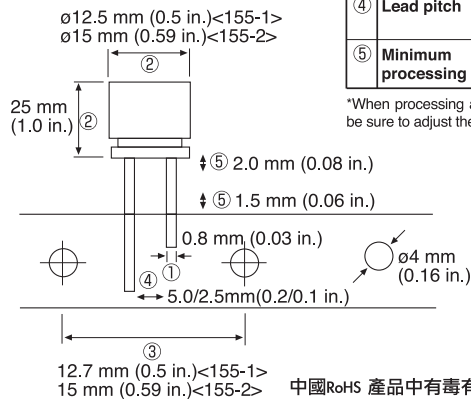
Thank you for purchasing the HAKKO 155 Lead Cutter. Please read this manual before operating the HAKKO 155. Keep this manual readily accessible for reference.

### PACKING LIST

Body	1	Hexagon wrench 2 mm (0.08 in.)	1
Parts tray	1	Hexagon wrench 2.5 mm (0.1 in.)	1
Clamp	1	Hexagon wrench 3 mm (0.12 in.)	1
Handle	1	Hexagon wrench 4 mm (0.16 in.)	1

### SPECIFICATIONS

No.	155-1	155-2	155-1	155-2
Name	HAKKO 155	HAKKO 155/15 mm (0.59 in.) Pitch		
External diameter	110 (W) x 140 (H) x 125 (D) mm 4.3 (W) x 5.5 (H) x 4.9 (D) in.			
Weight	Approx. 1.7 kg (3.7 lb) with Handle and Clamp			



\*When processing a part with lead pitch of 2.5 mm (0.1 in.), be sure to adjust the cutting wheel.

**CAUTION**  
For annealed copper lead wire only. Square lead wire is not adapted.

中國RoHS 產品中有毒有害物質或元素的名稱及含量

部件名稱	有毒有害物質或元素					
	鉛(Pb)	汞(Hg)	鎘(Cd)	六價鉻(Cr(VI))	多溴聯苯(PBB)	多溴二苯醚(PBDE)
驅動部	×	○	○	○	○	○
主機	×	○	○	○	○	○

○ : 表示該有毒有害物質在該部件所有均質材料中的含量均在 SJ/T 11363-2004 標準規定的限量要求以下。  
 × : 表示該有毒有害物質至少在該部件的某一均質材料中的含量超出 SJ/T 11363-2004 標準規定的限量要求。

### OPTIONAL UNITS

## HAKKO 152B

MOTOR DRIVE

This is a motor drive for lead formers and lead cutters. It features accurate, high-speed processing at stable torque.

Rotary	28 rpm (50 Hz), 34 rpm (60 Hz)
Size	430 (W) x 150 (H) x 140 (D) mm (16.9 x 5.9 x 5.5 in.)
Weight	Approx. 5.6 kg (12.34 lb.)
Max. processing capacity	18,000 pcs./hr (60Hz) 15,000 pcs./hr (50Hz)

## HAKKO CORPORATION

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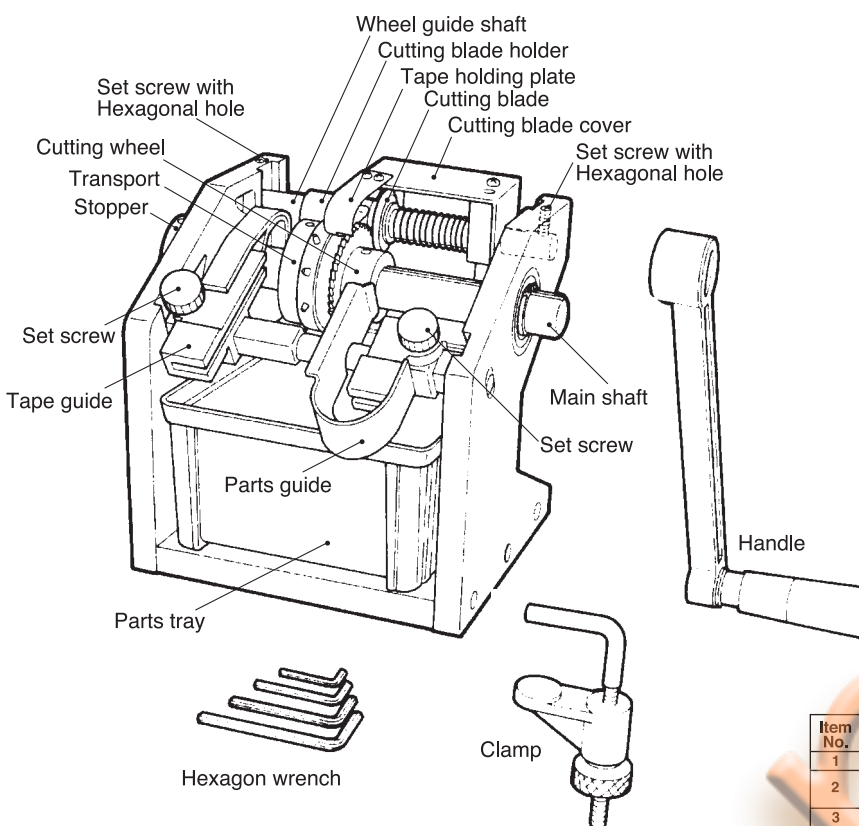
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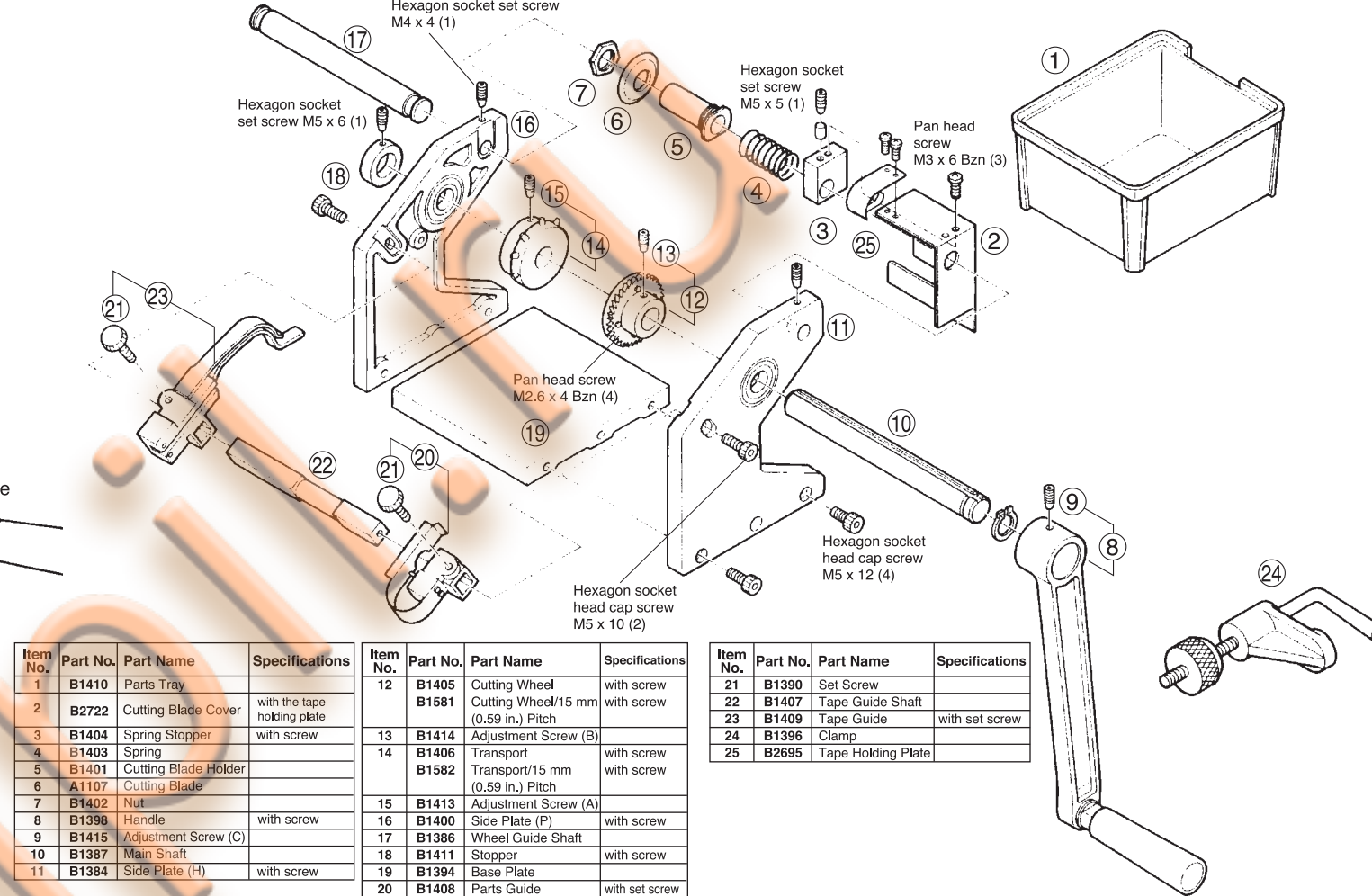
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### PART NAMES



### PARTS LIST



Item No.	Part No.	Part Name	Specifications
1	B1410	Parts Tray	
2	B2722	Cutting Blade Cover	with the tape holding plate
3	B1404	Spring Stopper	with screw
4	B1403	Spring	
5	B1401	Cutting Blade Holder	
6	A1107	Cutting Blade	
7	B1402	Nut	
8	B1398	Handle	with screw
9	B1415	Adjustment Screw (C)	
10	B1387	Main Shaft	
11	B1384	Side Plate (H)	with screw
12	B1405	Cutting Wheel	with screw
13	B1414	Adjustment Screw (B)	
14	B1406	Transport	with screw
15	B1413	Adjustment Screw (A)	
16	B1400	Side Plate (P)	with screw
17	B1386	Wheel Guide Shaft	
18	B1411	Stopper	with screw
19	B1394	Base Plate	
20	B1408	Parts Guide	with set screw
21	B1390	Set Screw	
22	B1407	Tape Guide Shaft	
23	B1409	Tape Guide	with set screw
24	B1396	Clamp	
25	B2695	Tape Holding Plate	

### OPERATION

#### 1. Fasten the unit to the work bench.

- Use the Clamp to attach the Unit to the work bench.

#### 2. Attach the handle.

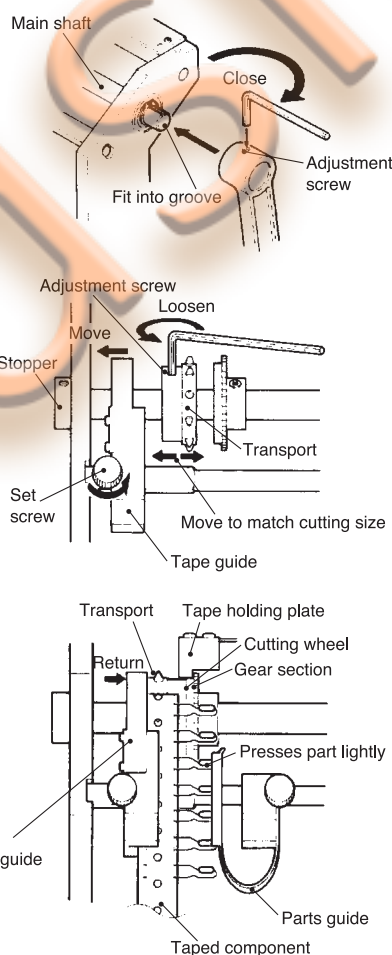
- Fit the Handle in so the end of the Adjustment Screw goes into the groove on the Main Shaft, then tighten the Adjustment Screw with a Hexagon Wrench 3 mm (0.12 in.).

#### 3. Set the cutting size.

- Loosen the Set Screw on the Tape Guide and move it in the direction of the Stopper.
  - Use a Hexagon Wrench 3 mm (0.12 in.) to loosen the Adjustment Screw on the Transport.
  - Match the feed holes on the taped component with the protruding portion on the Transport and adjust the position of the Transport to the desired cutting size. Then tighten the Adjustment Screw.
- \*The tape on the taped component should be facing up.

#### 4. Set the taped component in place.

- Temporarily remove the taped component.
- Return the Tape Guide to its former position and fasten it in place with the Set Screw.
- Pass the taped component along the Tape Guide and match the feed holes with the protruding portion of the Transport.
- Adjust the Parts Guide so it lightly presses the top of the part, then fasten the Set Screw.

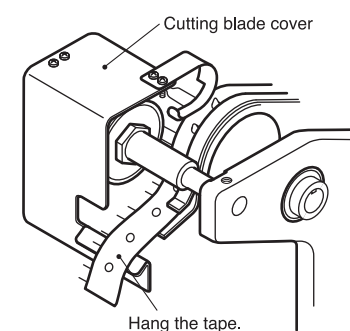


#### 5. Set the parts tray in place.

- Place the parts tray so it comes in contact with the Cutting Blade Cover.

#### 6. Turn the handle.

- Before turning the Handle, check to make sure that the lead of the component meshes perfectly with the gear section of the Cutting Wheel. Hang the tape on the cutting blade cover to avoid the tape getting in the parts tray.



#### When Cutting a Component with a Lead Pitch of 2.5 mm (0.1 in.)

When shipped, the Unit is set for components with a lead pitch of 5.0 mm (0.2 in.). Therefore, when cutting component with a lead pitch of 2.5 mm (0.1 in.), it must first be set as follows:

#### 1. Remove the cutting wheel.

- Use a Hexagon Wrench 2.5 mm (0.1 in.) to loosen the Set Screw (with the hexagonal hole) on the Cutting Blade Cover.
- Use a Hexagon Wrench 2.5 mm (0.1 in.) to loosen the Set Screw (with the hexagonal hole) on the Stopper, then remove the Stopper.
- Use a Hexagon Wrench 3 mm (0.12 in.) to loosen the Adjustment Screws on the Transport and Cutting Wheel.
- Remove the Main Shaft in the direction of the Handle, then take off the Cutting Wheel.

#### 2. Adjust the cutting wheel.

- Remove the screws (4) on the Cutting Wheel, then turn the gear section 90° (either clockwise or counter-clockwise) and refasten the screws.

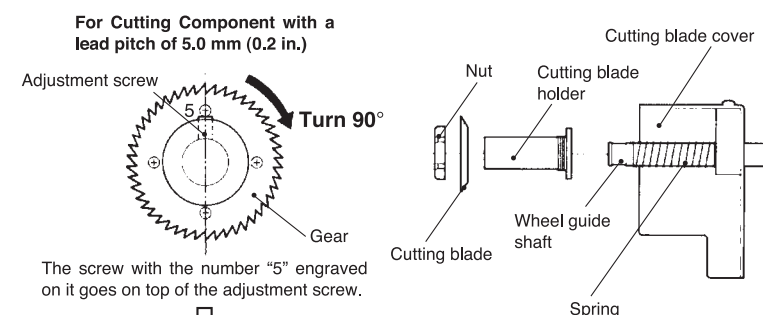
#### 3. Assemble as before.

- Use the same procedure in reverse to assemble.

**CAUTION**  
Fasten the Cutting Blade Cover so it encloses the Cutting Blade. It is dangerous to use the Unit with the Cutting Blade exposed.

#### Replacing the Cutting Blade

- Remove the cutting blade holder.**
  - Use a Hexagon Wrench 2.5 mm (0.1 in.) to loosen the Set Screw (with the hexagonal hole) on the Cutting Blade Cover.
  - Use a Hexagon Wrench 2 mm (0.08 in.) to remove the two Screws holding on the Wheel Guide Shaft.
  - Move the Wheel Guide Shaft in the Handle direction, being careful not to move it enough to dislodge the screw, then remove the Cutting Blade Holder.



- Replace the cutting blade.**
  - Remove the Nut.
  - Remove the Cutting Blade from the Cutting Blade Holder and insert the new blade.
- Assemble as before.**
  - Use the same procedure in reverse to assemble.