

When installed on any of GPD's CF-8, CF-12, or retrofitted CF-15 Axial Lead Formers the Jacobs Ladder Feeder (Part No. 8150004) enables you to continuously feed up to 6,000 axial leaded components per hour from either a vibratory bowl or by direct hand placement. It eliminates the need for three different zigzag feeders for different wire diameters.

This option feeds any axial components with a wire diameter from .015" to .060" (0.38 mm to 1.52 mm). The advance pitch is manufactured at .200" (5.08 mm). Any component with a larger body diameter will automatically space out to .400" or .600" (10.16 mm to 15.24 mm).

The Jacobs Ladder Feeder mounts on the lead former in place of the dual feeder chutes. As its inner rails move up and down on a specific pre-determined angle, they lift and advance each component to the next step on the stationary outer rails or "ladder". Components advance on the ladder in this manner until

they are automatically centered in the tooth spaces of the lead former's cutting wheel.

The Jacobs Ladder Feeder is driven from the lead former's existing shaft so no additional power is required, except the CF-15 which requires a factory retrofit.

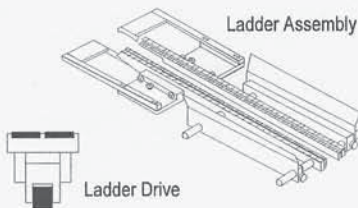
Standard Features:

- All materials hard chromed for wear, rust inhibition
- Extremely low maintenance design and construction

Specifications:

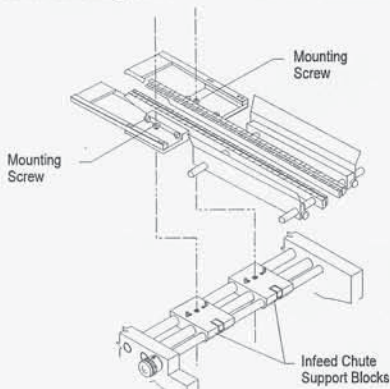
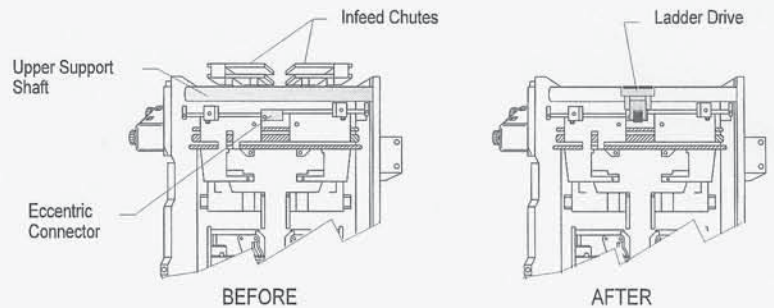
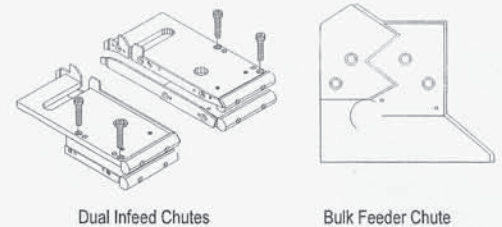
Height 3.0" (76.2 mm) Width 5.0" (127.0 mm)
Length 12.0" (304.8 mm) Weight 6.0 lbs. (2.7 kg)

Installation Instructions



The Jacobs Ladder Feeder is easy to mount and includes, as shown at left, a ladder assembly, ladder drive, and safety shield (not shown).

1. Remove infeed chutes from machine. Refer to the figure at right for examples of bulk and dual infeed chutes. Refer to the "BEFORE" figure below for infeed chute position on machine.
2. Install ladder drive - refer to the figures at right illustrating machine appearance BEFORE and AFTER infeed chute removal and ladder drive installation.
 - a. Position ladder drive on machine's upper support shaft.
 - b. Center drive's large roller on machine eccentric connector.
 - c. Lightly tighten 4 screws on ladder drive.
 - d. Carefully position ladder drive parallel to machine's infeed chute support blocks. See infeed chute support blocks in the figure below.
 - e. Finish hand tightening ladder drive screws.
3. Install ladder assembly on machine's infeed chute support blocks - refer to figure below. Hand tighten the 2 mounting screws on ladder assembly.



4. Manually rotate machine with T-wrench to verify proper installation and check for faulty setup.

NOTE: The inner ladder of the ladder assembly must rise above its outer ladder. If it does not, rotate the ladder drive slightly, altering its "parallel to infeed chute support blocks" position.

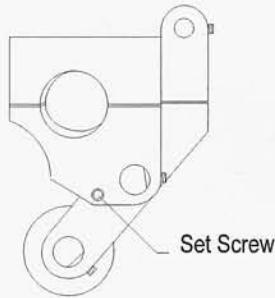
5. Install Jacobs Ladder Feeder safety shield: remove machine's standard safety shield from its hinges and install the modified shield.

To Use a Different Feeder...

When you want to use a bulk or dual tape feeder, remove only the Jacobs ladder assembly.

**** You can leave the ladder drive and modified safety shield in place ****

1. Remove ladder assembly.
 - a. Loosen 2 mounting screws.
 - b. Pull ladder up off machine's infeed chute support blocks.

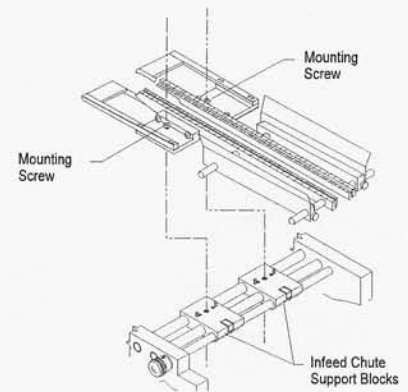


2. To disengage ladder drive from CF-8 operations and secure it in place:
 - a. Hold A (see at left) so it's flush with B.
 - b. To secure A in place, snug set screw.

NOTE: DO NOT over tighten set screw.

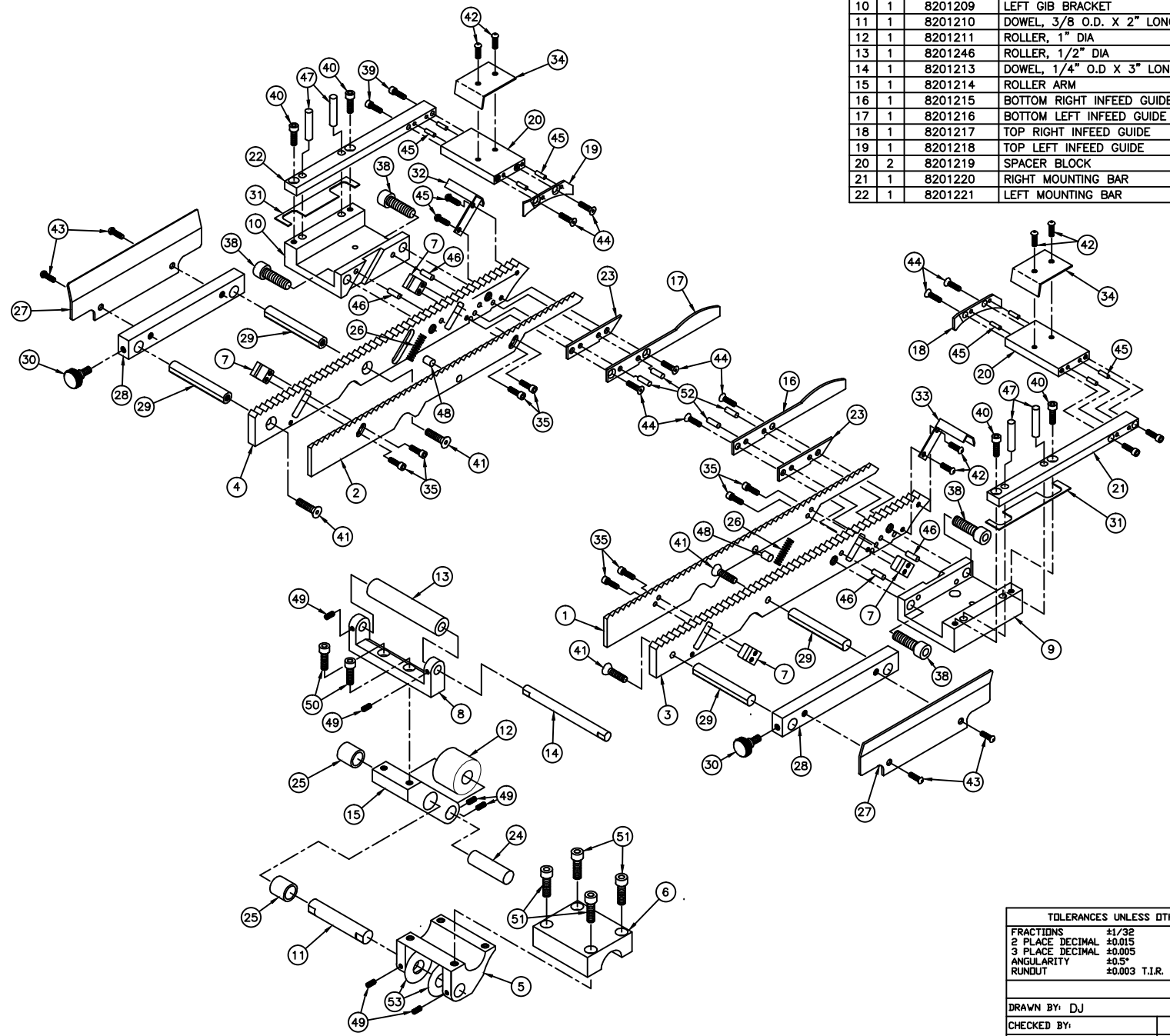
To set up Jacobs Ladder again:

1. Loosen ladder drive set screw.
2. Reinstall ladder assembly.



REVISION HISTORY			
REV	DATE	BY	DESCRIPTION
A	5/22/08	SO	ORIGINAL ISSUE
B	6/29/11	ARM	ADDED WASHERS, UPDATED PARTS 41,43,45,48,50

NO.	QTY	PART NUMBER	DESCRIPTION	NO.	QTY	PART NUMBER	DESCRIPTION
1	1	8201201	MOVING LADDER, RIGHT	23	2	8201223	LOWER GUIDE SPACER
2	1	8201202	MOVING LADDER, LEFT	24	1	8201224	DOWEL, 3/8" DIA. X 1.3" LONG
3	1	8201203	STATIONARY LADDER, RIGHT	25	2	L0506	BUSHING_AA521-1
4	1	8201225	STATIONARY LADDER, LEFT	26	2	S0017	SPRING_3/16 OD, 7/8 LONG
5	1	8201204	SHAFT CLAMP, LOWER	27	2	LS-425	GUIDE RAIL
6	1	8201205	SHAFT CLAMP, UPPER	28	2	LS-424	GUIDE MOUNT
7	4	8201206	SPRING T-GIB	29	4	LS-423	GUIDE SHAFT
8	1	8201207	DUAL ROLLER BRACKET	30	2	801-1-20	SCR, WASH FACE TH'B
9	1	8201208	RIGHT GIB BRACKET	31	2	816-1-9	SHIM SPACER
10	1	8201209	LEFT GIB BRACKET	32	1	8201228	LEFT LEAD SUPPORT
11	1	8201210	DOWEL, 3/8 O.D. X 2" LONG	33	1	8201229	RIGHT LEAD SUPPORT
12	1	8201211	ROLLER, 1" DIA	34	2	8201231	LEAD GUIDE
13	1	8201246	ROLLER, 1/2" DIA	35	8	SACAN0440018LOW	4-40 X 3/16 LOW HEAD CAP SCR
14	1	8201213	DOWEL, 1/4" O.D X 3" LONG	36	1	8201213	DOWEL, 1/4" O.D X 3" LONG
15	1	8201214	ROLLER ARM	37	1	8201214	ROLLER ARM
16	1	8201215	BOTTOM RIGHT INFEED GUIDE	38	4	LINE STOCK	1/4-20 UNC X 1/2 LG CAP SCREW
17	1	8201216	BOTTOM LEFT INFEED GUIDE	39	4	LINE STOCK	4-40 UNC X 1/2 LG CAP SCREW
18	1	8201217	TOP RIGHT INFEED GUIDE	40	4	LINE STOCK	6-32 UNC X 3/8 LG CAP SCREW
19	1	8201218	TOP LEFT INFEED GUIDE	41	4	LINE STOCK	8-32 UNC X 1/2 LG FLAT HD CAP SCR
20	2	8201219	SPACER BLOCK	42	8	LINE STOCK	4-40 UNC X 1/8 LG BUT. HD CAP SCR
21	1	8201220	RIGHT MOUNTING BAR	43	4	LINE STOCK	8-32 UNC X 1/4 LG BUT. HD CAP SCR
22	1	8201221	LEFT MOUNTING BAR	44	8	LINE STOCK	4-40 UNC X 1/4 LG CSK HD CAP SCR
45	8	LINE STOCK	Ø3/32 X 5/16 LG DOWEL PIN	45	8	LINE STOCK	Ø3/32 X 5/16 LG DOWEL PIN
46	4	LINE STOCK	Ø1/8 X 3/8 LG DOWEL PIN	46	4	LINE STOCK	Ø1/8 X 3/8 LG DOWEL PIN
47	4	LINE STOCK	Ø3/16 X 7/8 LG DOWEL PIN	47	4	LINE STOCK	Ø3/16 X 7/8 LG DOWEL PIN
48	2	LINE STOCK	Ø3/16 X 1/2 DWL PIN GRD BOTH ENDS TO .300	48	2	LINE STOCK	Ø3/16 X 1/2 DWL PIN GRD BOTH ENDS TO .300
49	6	LINE STOCK	4-40 UNC X 1/8 LG SET SCREW	49	6	LINE STOCK	4-40 UNC X 1/8 LG SET SCREW
50	2	LINE STOCK	8-32 UNC X 7/16 LG CAP SCREW	50	2	LINE STOCK	8-32 UNC X 7/16 LG CAP SCREW
51	4	LINE STOCK	10-24 UNC X 1/2 LG CAP SCREW	51	4	LINE STOCK	10-24 UNC X 1/2 LG CAP SCREW
52	4	LINE STOCK	Ø1/8 X 5/16 LG DOWEL PIN	52	4	LINE STOCK	Ø1/8 X 5/16 LG DOWEL PIN
53	2	817-1-10	NYLATRON SPACER	53	2	817-1-10	NYLATRON SPACER



TOLERANCES UNLESS OTHERWISE SPECIFIED			
FRACTIONS	±1/32	METRIC	±0.4MM
2 PLACE DECIMAL	±0.015	0.0 MM	±0.1MM
3 PLACE DECIMAL	±0.005	0.00MM	
ANGULARITY	±0.5°		
RUNDUT	±0.003 T.I.R.		

GPD Global

NAME: JACOBS LADDER - EXT. STROKE
 USED ON: CF-8
 MATERIAL: -
 HEAT TREAT: -
 FINISH: -
 PART NUMBER
8201200M

DRAWN BY: DJ	DWG SIZE: C
CHECKED BY:	DO NOT SCALE DRAWING
DATE: 8-9-95	SCALE: N/A