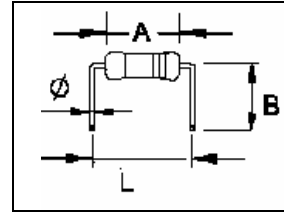


HRFT-301U 手搖帶式電阻成型機 使用說明書

A. 手搖帶式電阻成型機，HRFT-301U 及 HRFT-301S 型之介紹。

1. 本機機器本體輕巧，設計結構優良，操作非常容易，且堅固耐用，生產量每分鐘可達 1000 件，效率極高。



2. HRFT-301U 屬標準型，為最佳設計結構。

$B=3.6\sim 15(\text{mm})$, $\varnothing W=0.35\sim \varnothing 1.00$

$L=A+2.4\text{mm}+\varnothing W$ (為最小腳距)，例

$A=3.6\text{mm}$ $\varnothing W=0.5$

$3.5+2.4+0.5=6.5\text{mm}=L$ (即兩腳

距離 6.5mm~40mm 之間均任意調整)

3. HRFT-301S 屬特殊型,訂購時需指明,其折彎腳受力點較薄,不適於處理線徑 0.8Ø 以上的線腳使用，但對於線腳靠近本體成型，即可發揮強大的效果。除了彎腳齒輪較薄外，其他的結構與 U 型完全相同。

$B=3.6\sim 15(\text{mm})$ ， $\varnothing W= \varnothing 0.35\sim \varnothing 0.08$

$L=A+1.2+\varnothing W$ (為最小腳距)，例

$A=3.6\text{mm}$ $\varnothing W=0.5$

$3.5+2.4+0.5=5.3\text{mm}=L$ (即兩腳距離 5.3mm~40mm 之間均任意調整)

4. 本機型只成型臥式(軸向帶式零件，將線切斷及折腳成兩線腳平行，只要是帶式零件，卷裝，盒裝皆適用，如：電阻、二極體、電感等....)。
5. 本機附送有夾具，可將整台機器固定於桌上或工作台。
6. 本機台設計有量規(如圖 E63)，屬於選擇性配件，如有需要可另外訂購。

B. 操作說明

1. 調整順序

- a) 放鬆 C27 螺絲後，即可移動 C21 及 C22 成型齒輪。調到所需的尺寸(兩個成型齒輪距離加上零件線徑即為成型尺寸)。再固定 C27 螺絲。
- b) 放鬆 C28 螺絲，用手移動 C25 及 C26 切斷齒輪，此時 C29 及 C30 切斷刀會同時連動，C21 及 C22 成型齒輪與 C25 及 C26 切斷齒輪中間的空隙即等於成型後的腳長，而兩隻腳的長度必須個別調整。
- c) D34 及 D35 成型刀座，由 D49 旋扭轉動而調整，兩組左右成型刀座需要個別調整。
- d) D34 及 D35 調整成型定位，再固定 D44 螺絲，成型刀座與成型齒輪，要剛好等

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於一成型線徑能通過的間隙為最適當。

- e) 先取單支零件放在成型齒輪 C21 及 C22 中間，再轉動手搖柄 C10 即可確認尺寸是否正確。
- f) 試做的零件經認可後，再將 B1 及 B2 塑膠軌道調入再讓帶式零件能順利入料。
(要鬆,不可太緊,否則將阻礙入料)。

2. 使用方法

- a) 入料：帶式零件經由 B 1 及 B 2 塑膠軌道進入，延伸到 C21 及 C22 成型齒輪，本體平放於兩齒輪之間。
- b) 成型：轉動 C10 手搖柄，將帶式零件先切斷，再由 D44 及 D34 成型刀彎腳，成型隨之完成。
- c) 退料：零件成型後依然架於成型齒輪 C21 及 C22 上，藉 B15 退料器觸及本體而落入 A11 成品盒內，成型工作即完成。
- d) 紙帶：經 C29 及 C30 切斷刀，將帶式零件切斷，而兩端紙隨之退出，於開始轉動 C10 手搖柄時，就要將紙帶檢出防止紙帶進入 A11 成品盒內。

C. 注意事項

- 1. C21 及 C22 成型齒輪，C25 及 C26 切斷齒輪，調整時只能用推移不可用敲擊，齒輪堅硬易碎。
- 2. C29 及 C30 切斷刀經長時間使用會鈍，可研磨或換新。
- 3. D34 及 D35 屬於一體成型如有磨耗整組更換。
- 4. C21 及 C22、C25 及 C26 四個為一組，只要其中一損壞就必須組更換無法單獨更換。
- 5. B1 及 B2 塑膠軌道零件入料時，需保持順暢，不可太緊會阻礙入料。
- 6. 卷裝之整捆零件於成型時，必須架於 B51 架料輪內，當啟動 C10 手搖柄時，要用手輔助整卷的材料轉動。
- 7. C20 成型輪軸，C31 切刀軸等機構要上油，以保持潤滑。

以上概略說明，如有疑問歡迎來電洽詢，本公司將以最大誠意為您服務。如需更換零件或購買備品，只要將圖上之代號傳真回本公司，即可將您要的零件寄達貴司。

手搖帶式電阻成型機 HRFT-301U/S 零件表

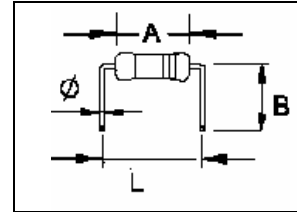
代號	名稱	代號	名稱
A8	右台身	C21	成型齒輪
A9	左台身	C22	成型齒輪
A11	成品盒	C23	平鍵
A13	底座	C25	切斷齒輪
A82	螺絲	C26	切斷齒輪
A81	銘版	C27	螺絲
		C28	螺絲
B1	左塑膠軌道	C29	切斷刀
B2	右塑膠軌道	C30	切斷刀
B3	軌道螺絲	C31	切斷刀軸
B5	軌道滑桿	D34	左成型刀座
B57	螺絲	D35	右成型刀座
B15	退料器	D37	螺絲
B16	螺絲	D40	止滑輪
B50	料架	D42	成型座滑軸
B51	架料輪	D44	螺絲
B53	架料軸	D49	成型座旋鈕
B56	螺絲	E60	機台固定桿
C10	手搖桿	E61	固定夾具
C101	搖柄	E62	緊迫螺母
C17	培林座	E63	量具
C171	螺絲		
C19	平鍵		
C20	成型輪軸		
6003	培林		

User's Guide –

Manual Taped Axial Lead Former HRFT-301U/S

A. Brief introduction for HRFT-301U and HRFT-301S, Manual taped axial lead former,

1. A hand crank unit with compact and solid design to form and cut the taped axial lead components. 1,000 pieces per minute working capacity are possible in this high production efficient model; With advantage of easy maintenance, adjustment and simple operation procedure.



2. HRFT-301, Standard model, The best structure.

$B=3.6\sim15(\text{mm})$, $\text{Ø}W=0.35\sim1.00\text{mm}$

$L=A+2.4+\text{Ø}W(\text{Minimum Pitch})$,

for example

$A=3.6\text{mm}$ $\text{Ø}W=0.5$

$5+2.4+0.5=6.5\text{mm}=L(\text{Adjustable Pitch between } 6.5\text{mm}\sim40\text{mm})$

3. HRFT-301, Slim model, for small pitch requirement. It's not suitable for lead wire over $\text{Ø}0.8$. The structure is same as standard model except more thinner forming wheel .

$B=3.6\sim15(\text{mm})$, $\text{Ø}W=0.35\sim\text{Ø}0.8$

$L=A+1.2+\text{Ø}W(\text{Minimum Pitch})$,

for example

$A=3.6\text{mm}$ $\text{Ø}W=0.5$

$5+2.4+0.5=5.3\text{mm}=L(\text{Adjustable Pitch between } 5.3\text{mm}\sim40\text{mm})$

4. This model is for cutting and bending the taped(boxed or reeled) axial lead components only. Such as resistors. Diodes, conductors etc.
5. The bench clamp is included in the package which will help to fix the machine to the side of the bench or working table.
6. The Pitch gauge is available which is optional in ordering (Ref. Sketch E63)

B. Operation instructions

1. Adjusting procedure

- a) Releasing the C27 screw then adjusting the forming wheels of C21&C22 until reaching the required pitch.(The pitch is equal to two distance of forming wheel with the wire diameter) , Don't forget to tight the screws released.
- b) Adjusting the cutting distance by moving both the C25&C26 Cutting wheel after releasing the screw C28. The Cutting discs C29 & C30 will be moved synchronously by the action. The distance between forming wheels(C21&C22) and cutting wheels(C25 &C26) is the lead length after forming. Both side of lead length are to be adjusted independently.
- c) The distance of Bending tool (D34 & D35)are to be adjusted independently by

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- both side of the adjusting knobs(D49).
- d) Adjusting the pitch of the leads by the bending tool D34 & D35. Don't forget to fix the screws D44 after adjusting . A space of one working wire lead diameter must be maintain in between the forming wheel and bending tool.
 - e) Placing one components in between the forming wheels C21 & C22, Moving the hand crank slowly to form and cut the components. Re-adjusting is required if unsatisfactory
 - f) Setting up the Plastic guide B1 & B2 when the adjusting procedure is finished. Adjusting the distance between the plastic guide. Make sure the taped component will be running smoothly in it.

2. Application

- a) Feeding : Sliding the taped components into the plastic guide B1 & B2 until the first components is placed in the slot in between the cutting and forming wheels.
- b) Cutting / Forming : Moving the hand crank clockwise. The taped components will be cut and formed efficiently.
- c) Ejecting : The components will be ejected and fallen into the part's bin by the ejectors B15 in the forming wheels C21 & C22 after formed and cut.
- d) Tape Waste : Guiding the tape out the part's bin when moving hand crank to cut and form the parts.

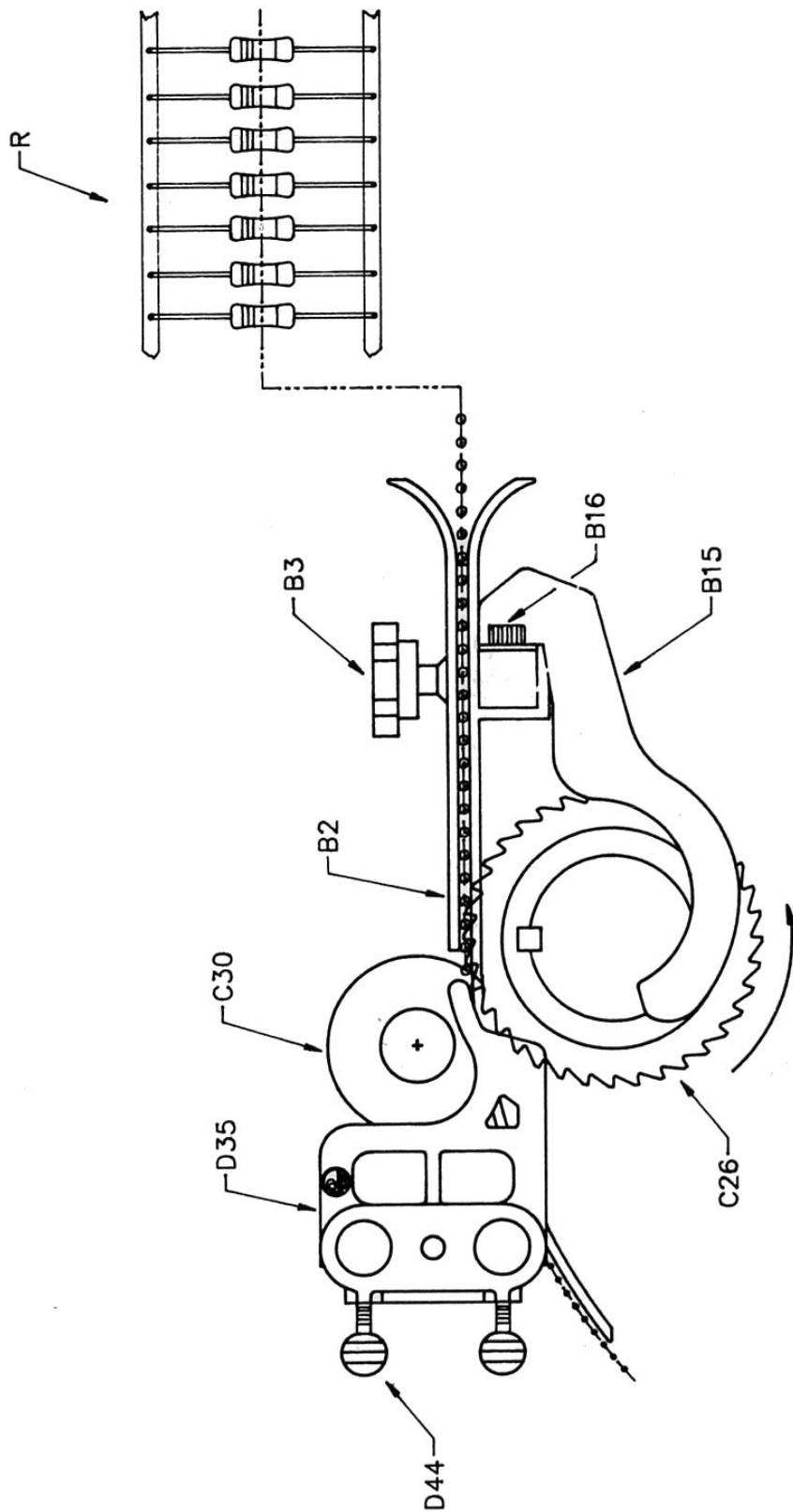
C. Caution:

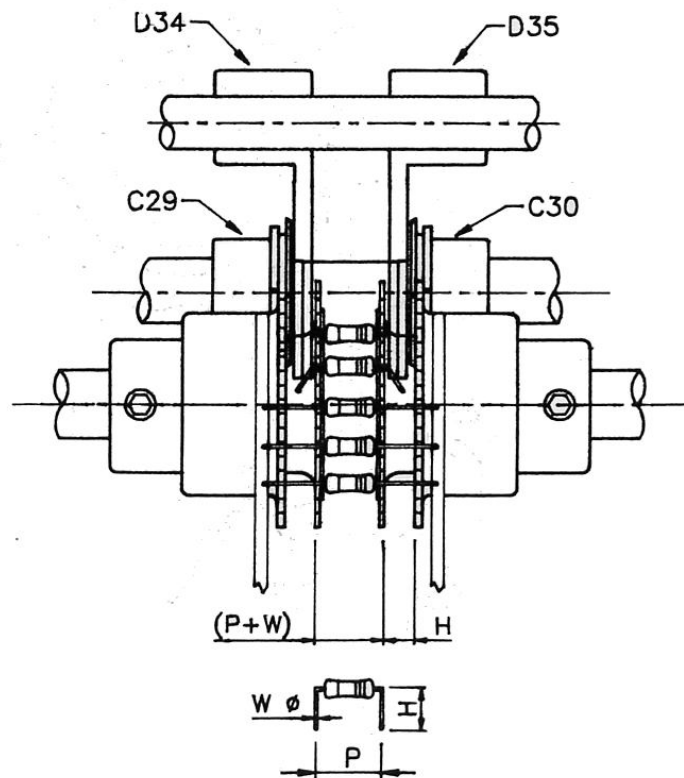
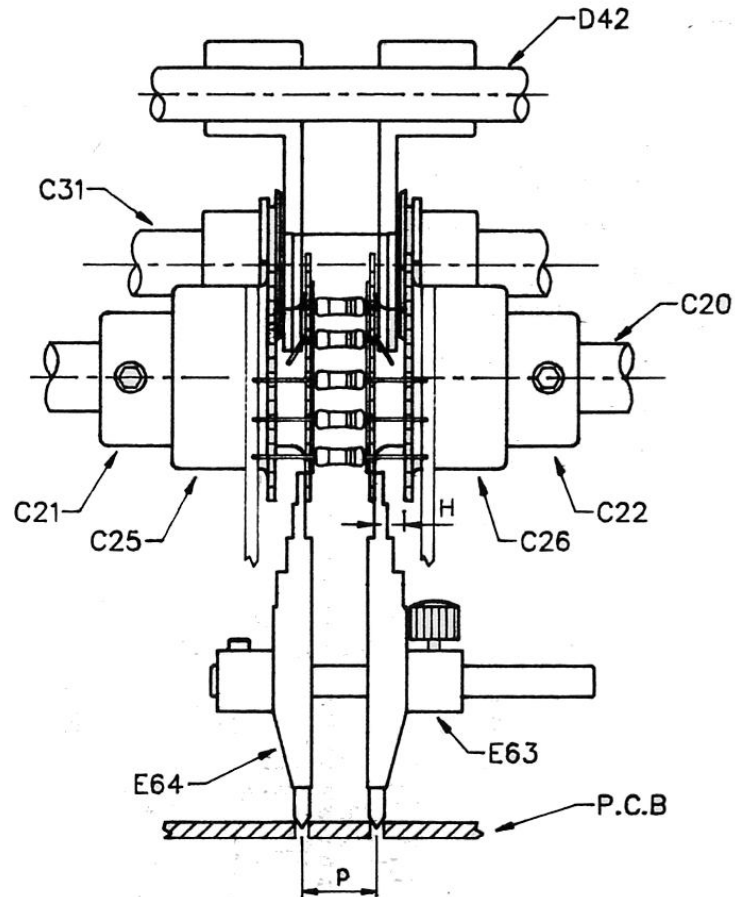
- 1. Never knocking the forming wheel C21,C22 or cutting wheels C25 & C26 by steel especially during adjustment. It's easy to damage the sharp edges of the wheel. Adjusting the distance by pulling/pushing the wheels gently .
- 2. The cutting discs need to be re-grinned or replaced when burr is created or cutting incompletely.
- 3. The bending tool D 3 4 & D 3 5 is calibrated in set. Replacing it contemporaneously when it is wear off.
- 4. Replacing the whole set of cutting wheel(C 2 1 & C 2 2)and forming wheel(C 2 5 & C 2 6)when one of them is wear off. Since they are calibrated as one set.
- 5. Keep the taped components sliding smoothly in the plastic guide B 1 & B 2 that never too tight to interfere the feeding.
- 6. The Reel B51 must be installed when processing reel packed components. Assisting the moving of the reel by hand when it is cut and formed .
- 7. Lubricating the forming shaft C 2 0 and cutting shaft C 3 to ensure running freely.

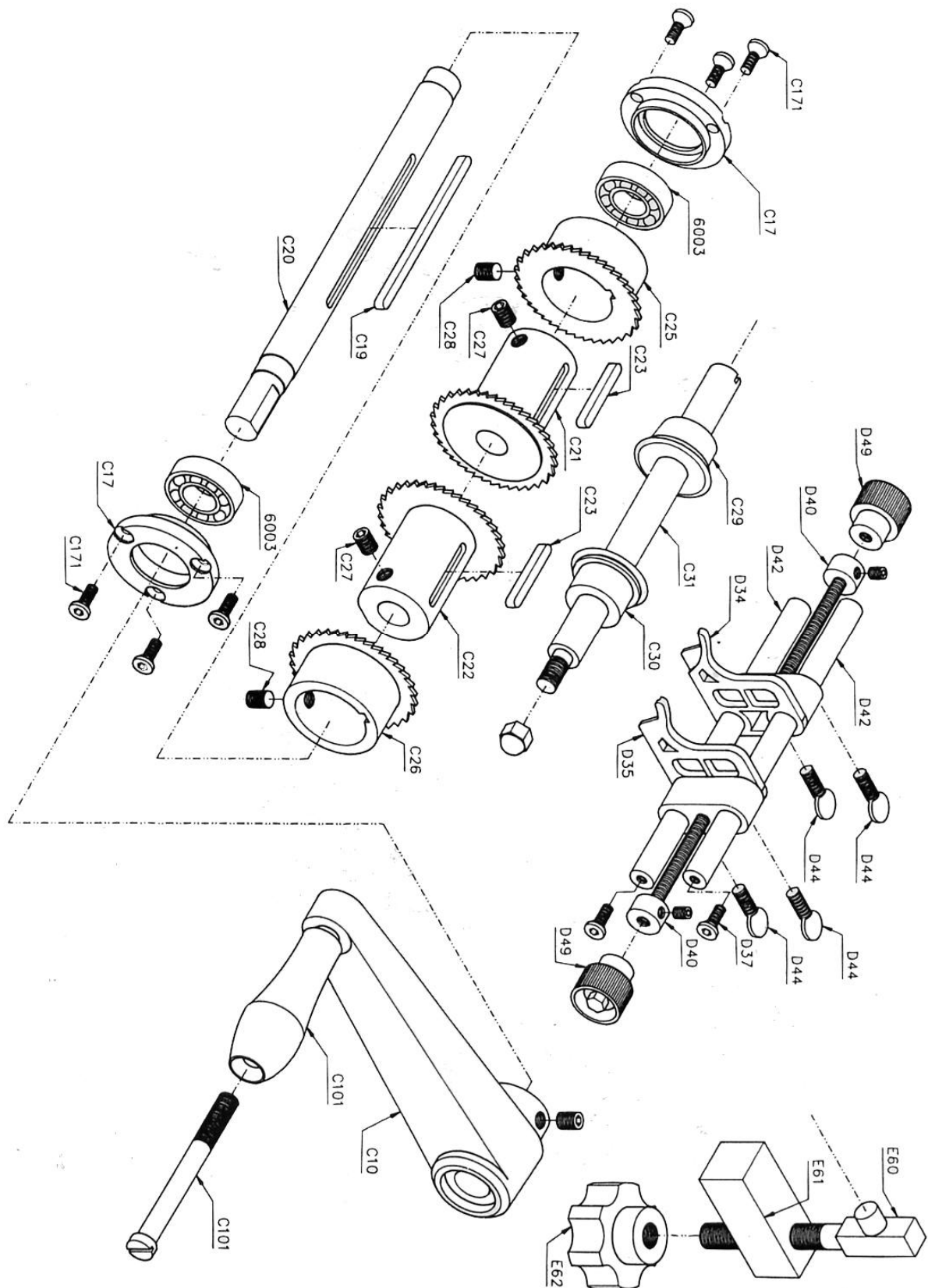
Please tell us part number that shown in the drawings if ordering spare parts is necessary. Contact us for any unclear or assistant needed. It's our pleasure to serve you at all time.

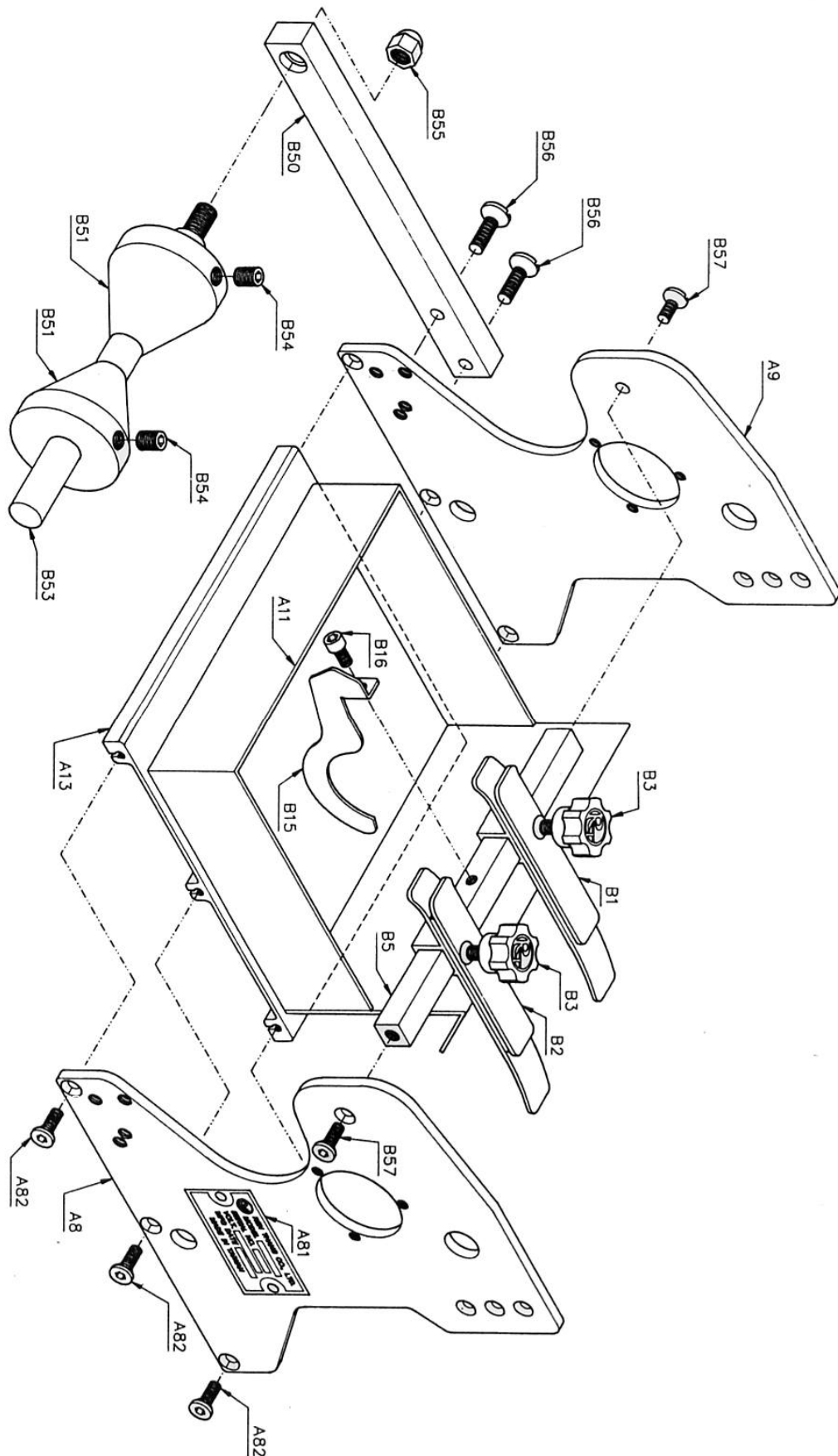
**Spare Part list HRFT-301U/S Manual Taped
Axial Lead former**

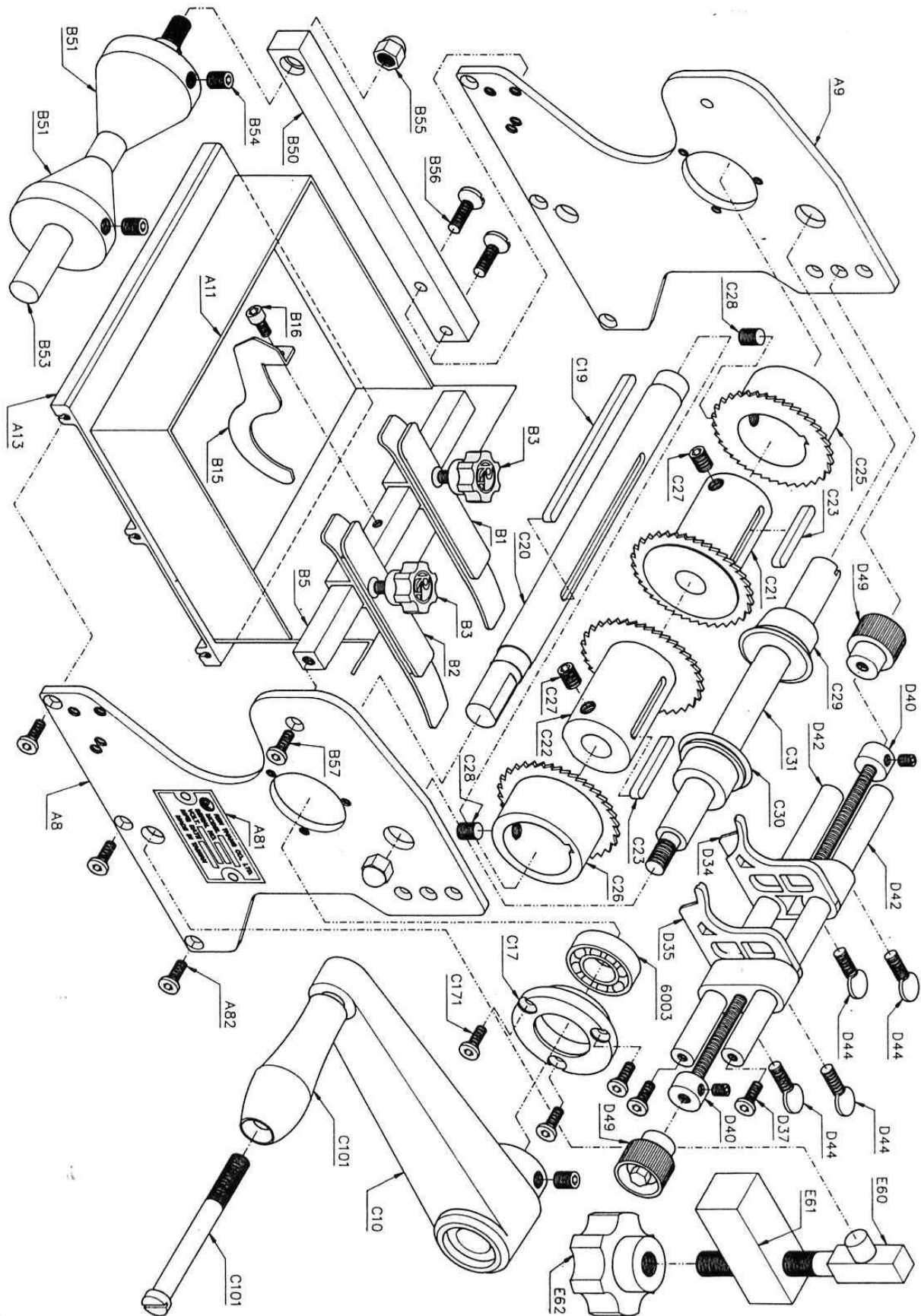
Part No.	Part Name	Part No.	Part name
A8	Side wall, Right	C21	Forming wheel
A9	Side wall, Left	C22	Forming wheel
A11	Parts bin	C23	Key
A13	Base	C25	Cutting Wheel
A82	screw	C26	Cutting Wheel
A81	Logo	C27	screw
		C28	screw
B1	Left Plastic guide	C29	Cutting disc
B2	Right Plastic guide	C30	Cutting disc
B3	Screw, rail	C31	shaft, Cutting disc
B5	Square bar, plastic guide	D34	bending tool, left
B57	screw	D35	bending tool, Right
B15	ejector	D37	screw
B16	screw	D40	Stop washer
B50	Components	D42	Shaft, bending tool
B51	reel	D44	Screw
B53	shaft, reel	D49	Knob, bending tool
B56	screw	E60	Fixing rod.
C10	crank arm	E61	Clamp
C101	Handle	E62	Nut
C17	base, bearing	E63	pitch gauge
C171	Screw		
C19	Key		
C20	Shaft, forming		
6003	bearing		











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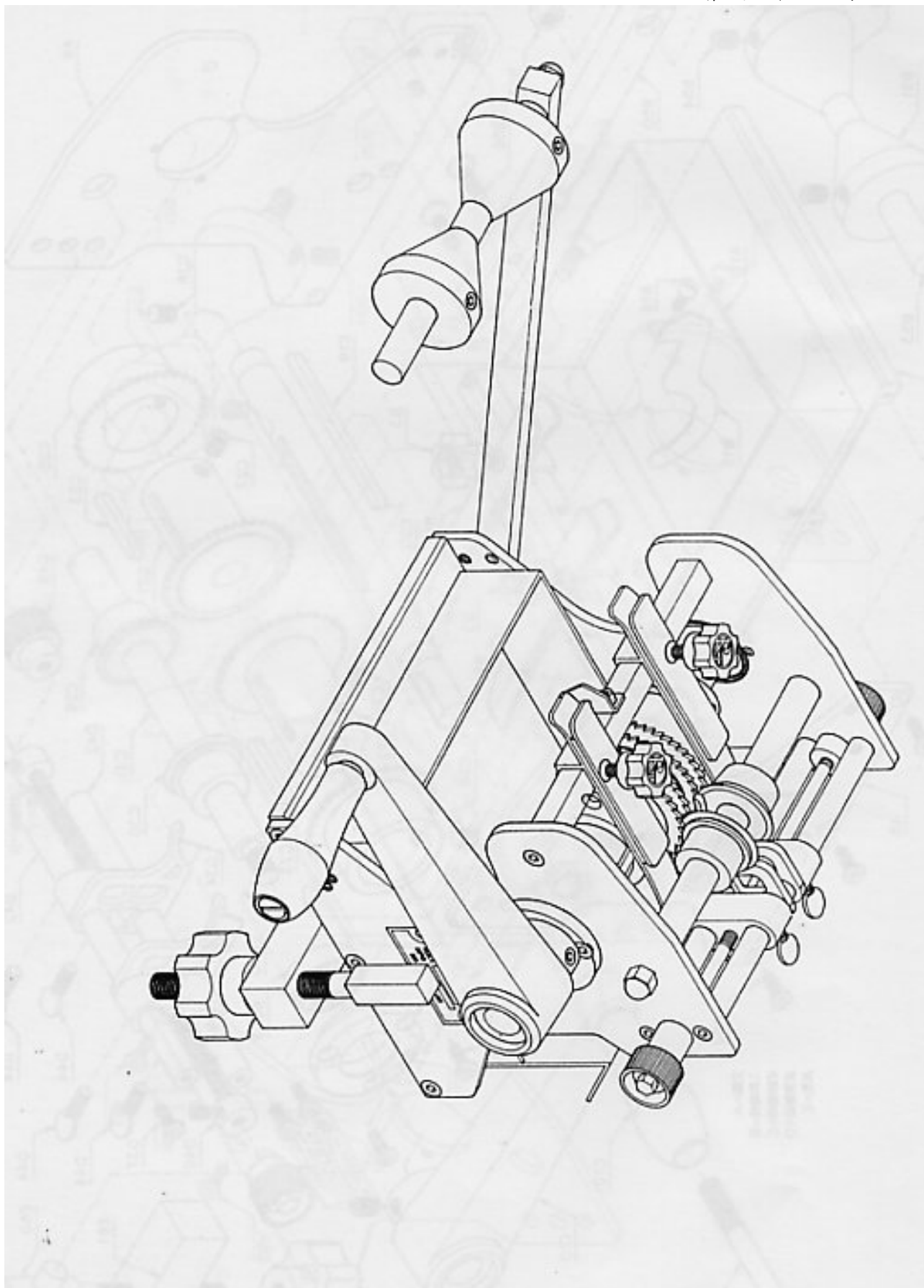
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