

NTG-20

NTG-20NS with Conveyer

Pre-scored (V-CUT) PCB Depaneling Machine - Moving Blade

Operation Manual

A. Operation Instruction

1. Power Plug 8. Make sure 110V or 220V. (Plug in).
2. Power Switch 10 turn ON and the light will be on.
3. Emergency Stop 5 turn to open (Push in will be emergency stop)
4. There are 4 set-up strokes to set up PCB mounting component distance. 12 choose the length of PC board.
5. Choose Jog or Auto Switch 11. (Usually use Auto Switch).
6. Speed adjustment 9 Put on 60~80 location.
7. Make sure Blade Guard 3 is fixed on the top of Horizontal Blade and set up PCB in V groove. .
8. Every time when you change each kind of PCB, need to put PCB on the blade. Push Circle Blade 1 by hand. Check if Circle Blade 1 and Blade Guard 3 are moved or squeezed during cutting PCB. If so, SMT parts can be cracked. (Visual test: if V-CUT depaneling distance is more than 1.2MM, don't need this action).
9. Check if Safety Sensor 20 on the right height level can sense height correctly. (It needs to sense bypassed PCB parts' height level and hands; the machine will automatically shut down.)
10. Try Foot Switch 7, doing practical action.
11. PCB is needed to be stuck in V groove when cutting the PCB. Using hand to hold down and see if it moves.
12. After procedure is confirmed OK, can start to operate the machine.

PS: Attached the machine picture(Analysis 1) 、 (Analysis 2) 、 (Analysis 3)and(Circuit diagram)



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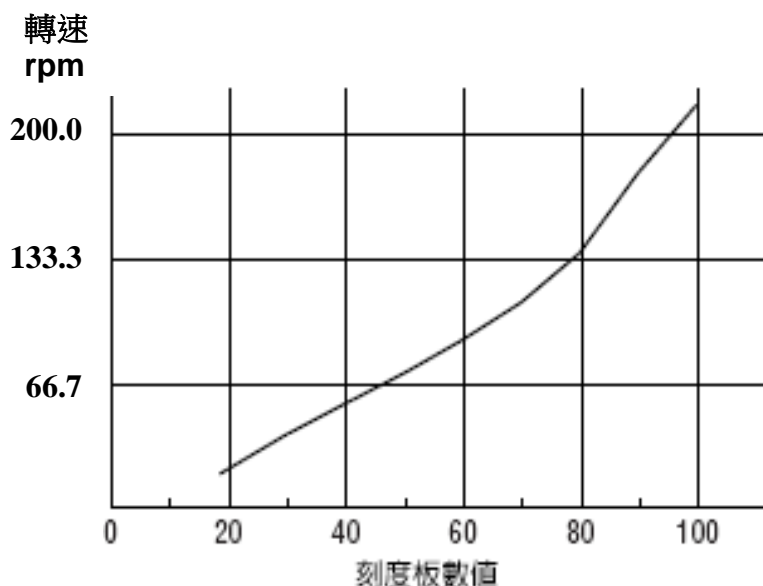
B. Machine Maintenance

1. Adjust blade, Circle Blade 1 and Horizontal Blade 2 contact 0.1 mm (PIC 1)
2. Blade side view (PIC 2) Circle Blade is in the back and Horizontal Blade is in the front.
3. Adjustment the front blade side of machine as below:

Release the screw 18 and adjust Bed Height Adjustment 17. During the adjustment, need to turn on the Emergency Stop 5 and then move Circle Blade 1. Moving left and right until can reach 0.1MM (PIC 3).

4. Adjust the side of blade as below: (PIC4)

There are 4 Blade Adjustment Screws (21) at the each side of Horizontal Blade (2). Release it in half circle and move Blade block. Use a hammer to tighten it, and use a piece of paper to check gap. Then, screw back tightly, use paper to test again.



Scale on board

外部速度設定器刻度 — 轉速特性（搭配 15 比減速機代表值）

Outer speed set-up scale – RPM (match with 15 induction motor's signature value)



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