

JF-600 跳線成型機 操作使用說明

I. 入料機構：

1. 線材 7 由 11→12→13→14→15，將 25 打開，線材通過後，再將 25 回復並固定。
2. 線材經由 11 可視需要由 111 將固定 11 之螺絲放鬆，即可左右移動，線材座 111 也可用扳手，不用螺絲直接轉動。
3. 線材經 12 後，只要引線輪 12 能自然轉動即可。
4. 線材經 13→14、15 須保持由 12→13→14 成一直線。
5. 線材經 14、15 後，在開機運轉時，線材必須貼近 25 與 26 之夾角處最為適宜。線材往上翹時，較容易卡料，此種情況為彈簧 153 太緊，應調整彈簧 153 之鬆緊度。彈簧不宜過緊，否則影響成品長度的穩定性。如線料太細，可能造成卡料，用扳手將 13 線材引座往 14 方向旋轉即可。
6. 線材輸送輪 14，有四條軌道可隨磨損度轉換。

II. 線材成型機構：

1. 轉輪 21(圖 FIG-1)，當 a 轉至 b 點時，線材輸送 14 停止送料。當 a 轉至 c 點時，14 又開始送料，14 與 21 有同步運轉關係，如 a 點位置不對時，須調動 21 本身與 14 軸之兩個結合螺絲。
2. 帶動臂 22 是由 POS-6 與 PHS-6 兩個培林組合，是調整沖模 23 之深淺，即是成品腳的開合度。
3. 沖模 23 與 21 帶動 22 時，期可上下滑動，上方有一油孔，必須時常加油保持 23 之潤滑度。
4. 護片 28 為一輔 23 之密合度，如太鬆將會影響成品的準確度與外型，隨時保持 23 之順暢，須調整上方之螺絲。
5. 沖刀 231 共有三支，左右兩支為成型彎刀，中間為切斷刀，左右兩支圓形刀須與 26 在成型時，線材與碳化鎢模具間距約為線材之直徑。當線材直徑(線徑)不同時，左右兩支彎刀亦必須旋轉調整方向。中間切斷刀如有磨損時，請拆下研磨。
 - 研磨方法：只要將圓型底部磨平即可。
 - 在回歸定位時，請注意中間切斷刀必須比左右彎刀長出線徑距離。
6. 計數器 233 在歸零時，需注意轉輪 21 之 a 點確於底部，方可歸零。否則計數器無法準確計數。
7. 彈片及碳化鎢鋼模具 26 需長保清潔，且勿任意拆動。如遇有成品腳有毛邊，只需將沖刀 231 與中間切斷刀拆下研磨即可。



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III. 線距調整機構：

1. 調整腳距之長短，將 311 放鬆，由 34 轉動，當 311 越往上腳距越短，反之愈下愈短。
2. 314 為一預留螺絲孔，所要成型的直線太長時，請將 33 右邊的固定 POS-6 螺絲放鬆，鎖入 314 即可。
3. 33 支兩端有兩個固定培林 POS-6 與 POS-8，注意保持油漬以減少磨損，如有磨損影響成品腳之精密度。
4. 315 之螺絲為固定單向培林，請勿任意放鬆。

IV. 馬達機構：

1. 41 為主傳動軸，411 齒輪與 41 軸，4 馬達與 42 齒輪上各有兩個螺絲乃固定無法鬆動。如果螺絲鬆脫，成品之腳距必會長短不一，請注意！
2. 411 與 42 之齒輪，也必須保持密合度，如兩齒輪距離過大，也會使腳距產生長短不一之現象。

※以上所提供為 JF-600 一般性之保養與說明，如有問題敬請惠予指教，本公司當提供最佳之服務，謝謝！

※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。



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OPERATION METHOD FOR MODEL JF-600

(I) MATERIAL ENTRY MECHANISM:

- a. The wire material 7 passes through 11 - 12 - 13 - 14 and 15, then open 25, restore the 25 to the original condition and fix it after the wire material has passed.
- b. When wire material passes through 11, loose the screw which fixes the 11 at 111 according to your necessity, then it can be movable left and right, you also can turn the wire material base with a spanner and need not loose the screw.
- c. It wants only lead wire wheel 12 can turn naturally when the wire material passes through 12.
- d. When the wire material passes through 13 - 14 - 15, should keep a straight line from 12 to 13, 14 and 15.
- e. After the wire material passes through 14 and 15 and when the machine is running, the wire material had better close to the angle space between 25 and 26. If the wire material turns upward, the material may be easily blocked, this is because the spring 153 is too tight, so you should adjust the spring 153, but it can not be too loose, otherwise, it will affect the precision of the finished product's length. A extremely thin wire material may cause the material block too, you may turn the lead wire base 13 toward the 14 direction with a spanner.



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- f. The wire material delivery wheel 14 has four tracks, can be replaced according to its degree of wear and tear.

II. WIRE MATERIAL FORMING MECHANISM:

- a. When the rotary wheel 21 (Fig. 1) turns from "a" to "b" point the wire material delivery wheel 14 will stop delivering material, and when it turns from "a" to "c" point, it will begin to deliver material again, 14 and 21 have synchronous turning relationship, so if "a"'s position is incorrect, you have to adjust the two joint screws between the 21 itself and the axis 14.
- b. The driving arm 22 consists of bearing PQS-6 and bearing PHS-6, which can adjust the deepness and shallowness of striking mold 23, that is the open and close degree of finished product's leg.
- c. When the 21 drives 22, the striking mold 23 will slide up and down, there is an oil hole on the upper position, it needs oiling often to keep 23's lubrication.
- d. Protection sheet 28 can assist to adjust the 23's close degree, if too loose will affect the finished product's precision and appearance, should keep 23 going smoothly all the time, and need to adjust the screw on the upper place.



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- e. The striking blades 231 totaled 3 pieces, the right one and left one are forming round blades, the middle one is a cutting blade. The distance from the left/right round blades and the 26 to the tungsten carbide steel tool is same as the diameter of the wire material during forming, so if the wire material's diameter is different, you have to turn the left and right round blades and change their direction. In case of any wear and tear in the middle cutting blade, please take the blade apart and grind it, the grinding method is that grind only the underside of the round blade till it becomes flat. When reset back onto its position, please note that the middle cutting blade must be longer than the left/right blades, the exceeded length is same as the diameter of the wire material.
- f. If you want to return the counter 233's digit to zero position, the "a" point on the rotary wheel 21 must be at the downward position, otherwise, the counter will trip-out.
- g. Keep the spring leaf and tungsten carbide steel tool clean and can not take them apart. If you find the finished product's leg has bur, only need to take apart the middle cutting blade of the striking blades and grind it.



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III. WIRE DISTANCE ADJUSTMENT MECHANISM:

- a. Adjust the leg distance, loosen 311, start turning from 34, the leg distance will be shorter when 311 moves upward, and the leg distance will be longer when 311 moves downward.
- b. 314 is a reserved screw hole, if the forming straight line is longer, please loosen the screw which fixes POS-6 on the right side of 33 and lock it into the 314.
- c. There are two fixing bearings, POS-6 and POS-8 on the two ends of 33, please keep them oily to reduce wear and tear. Any wear and tear will affect the finished product's leg's precision.
- d. The screw on 315 is used for fixing one-way bearing, don't loosen it without necessity.

IIII. MOTOR MECHANISM:

- a. The 41 is a main driving axis. There are two screws which are used to fix the gear 411 and the driving axis 41, the motor axis 4 and the gear 41 respectively, can not be loosened forever, if they have loosened, the leg distances won't be same, please note this.



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b. Must keep 44 and gear 42 closely,
if the distance between these two gears is too long
will cause different leg distances too.

** The above are general maintenance instruction for
JF-600. Please don't hesitate to contact us if
you have any question, we will try our best to
satisfy you. Thank you !

※Maintenance and technical support.

Please copy the sketch on the manual for further questions. For spare parts
requirement, please ordering by fax in which specified part number or indicate
by sketch. Welcome your inquiry for any question if unclear!



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一. 入料機構：

(為 1 字頭，如圖 FIG-1)

零件編號	品名	零件編號	品名
11	線材引導座	111	線材引導固定座
13	引線管座	14	線材輸送輪
15	線材夾持滑輪	151	活動臂
152	螺絲	153	伸縮彈簧
12	引線輪		

二. 線材成型機構：

(為 2 字頭，如圖 FIG-1)

零件編號	品名	零件編號	品名
21	轉輪	22	帶動臂
23	沖模	231	沖刀
232	帶動臂	233	計數器
24	沖座	25	線材固定座
26	彈片及碳化鎢鋼刀模具	27	壓縮彈簧
28	沖模護片		

三. 線距調整機構：

(為 3 字頭，如圖 FIG-2)

零件編號	品名	零件編號	品名
31	傳動臂	311	固定旋鈕
312	螺絲	32	方塊傳動臂
33	傳動臂	34	固定旋鈕
314	預留螺絲孔	315	固定螺絲

四. 馬達機構：

(為 4 字頭，如圖 FIG-3)

零件編號	品名	零件編號	品名	零件編號	品名
4	馬達	41	傳動軸	411	齒輪

五. 其他附件：

零件編號	品名	零件編號	品名
6	成品收集箱	6	廢料收集箱
8	感應體	9	面板



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A. Material Feeding Mechanism (Initial digit: 1)

ITEM NO.	NAME
11	Wire leading base
13	Wire leading base
15	Wire chucking pulley
152	Screw
12	Wire leading wheel
111	Wire leading fixed base
14	Wire delivery wheel
151	Movable arm
153	Expanding spring

(See FIG-1)

B. Wire Shape Forming Mechanism (initial digit: 2)

ITEM NO.	NAME
21	Rotary wheel
23	Punching die
232	Driving arm
24	Punching base
26	Spring & tungsten carbide steel knife mold tool
28	Punching die porteciton plate
22	Driving arm
231	Cutting & forming knife or (punching knife)
233	Digital counter
25	Wire fixed base
27	Compression spring



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C. Wire Distance Adjustment Mechanism (initial digit: 3)

ITEM NO.	NAME
31	Transmission arm
312	Screw
33	Rotary arm
314	Reserve screw hole
311	Nut
32	Rotary body
34	Adjustable screw
315	Fixed screw
	(See FIG-2)

D. Motor Mechanism (initial digit: 4)

ITEM NO.	NAME
4	Motor
411	Gear
41	Axis
	(See FIG-3)

E. Other accessories:

ITEM NO.	NAME
6	Finished products collection box
8	Inductive body
6	Waste material collection box
9	Face plate



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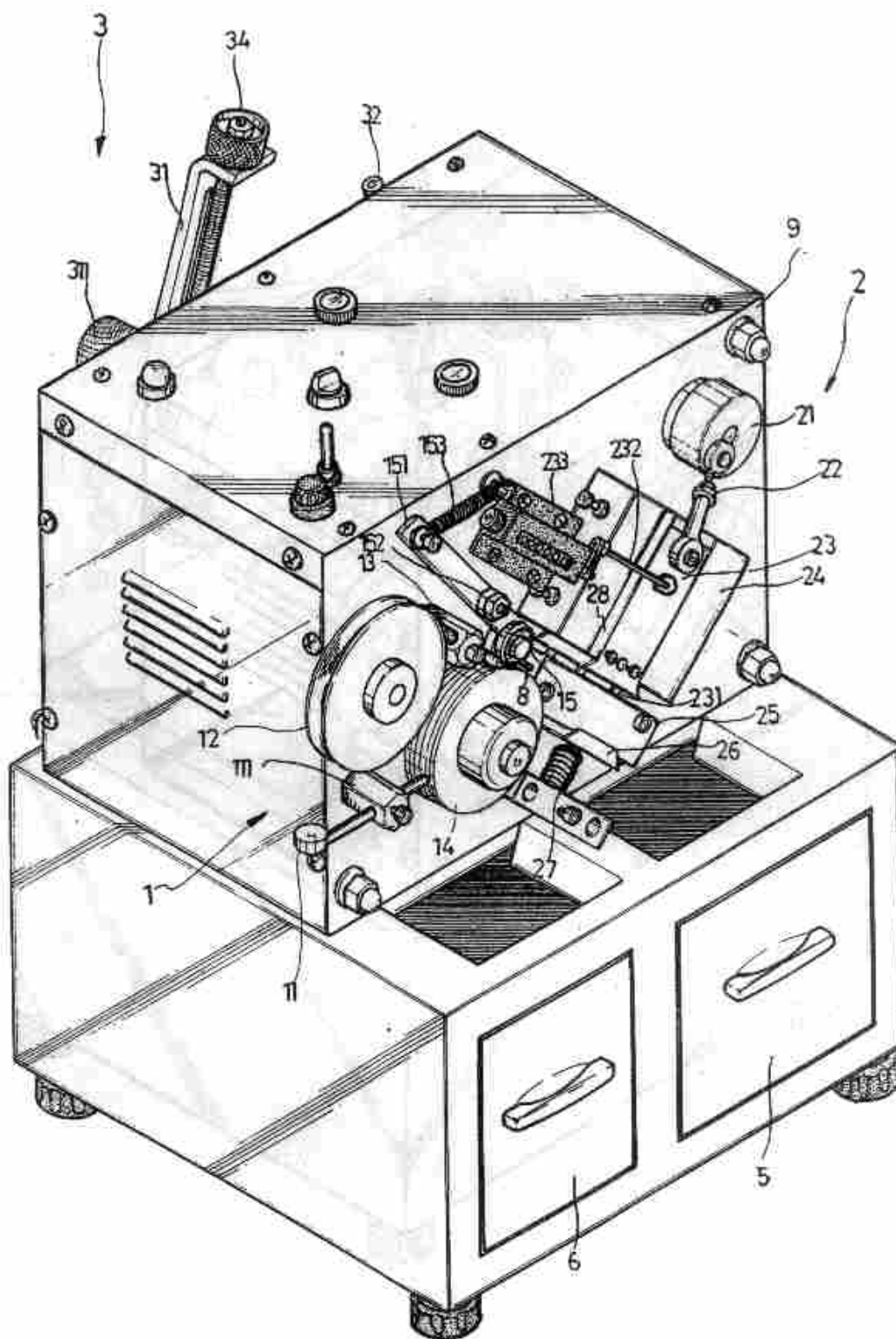


FIG. 1 (1)



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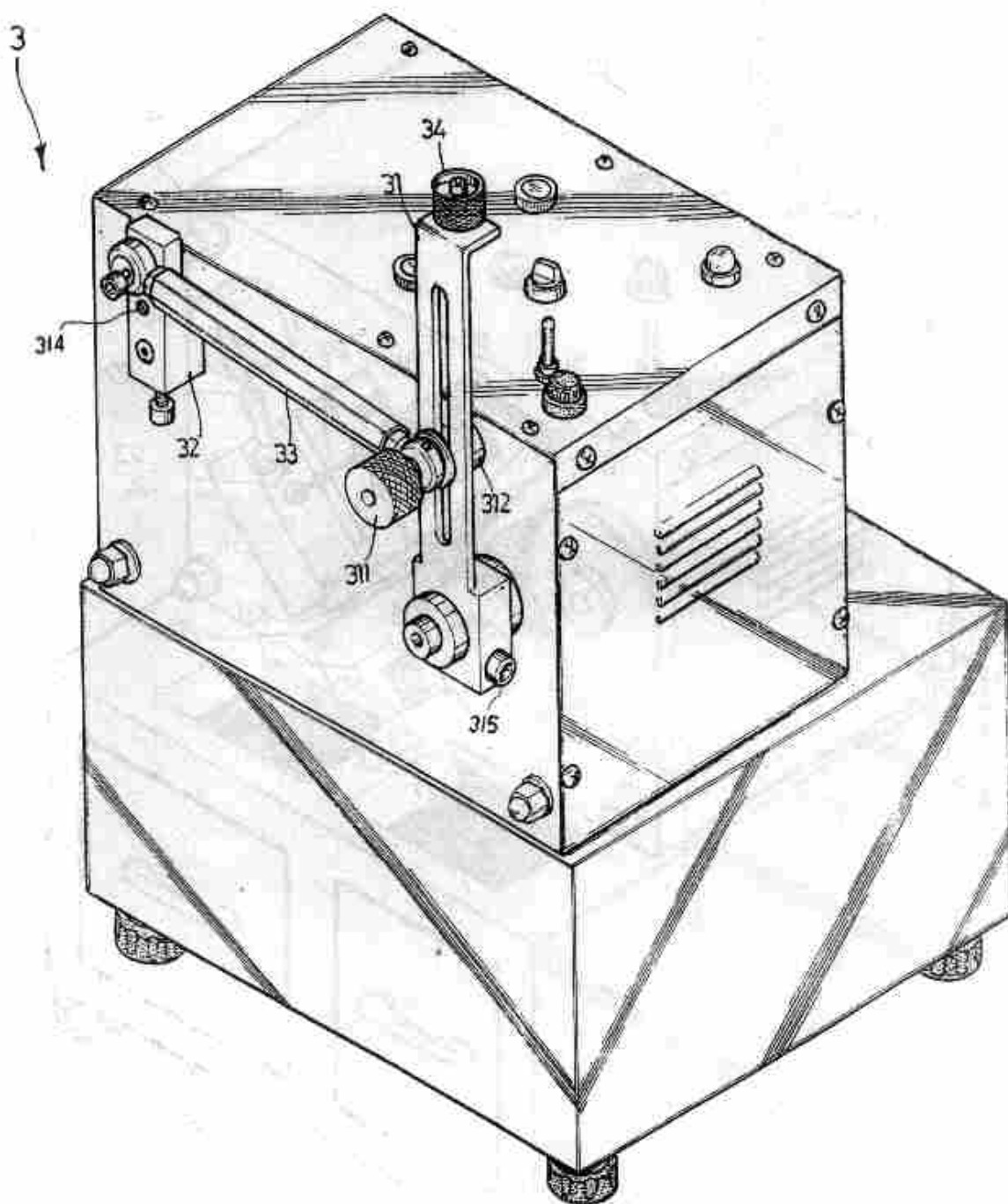


FIG. 2
(2)



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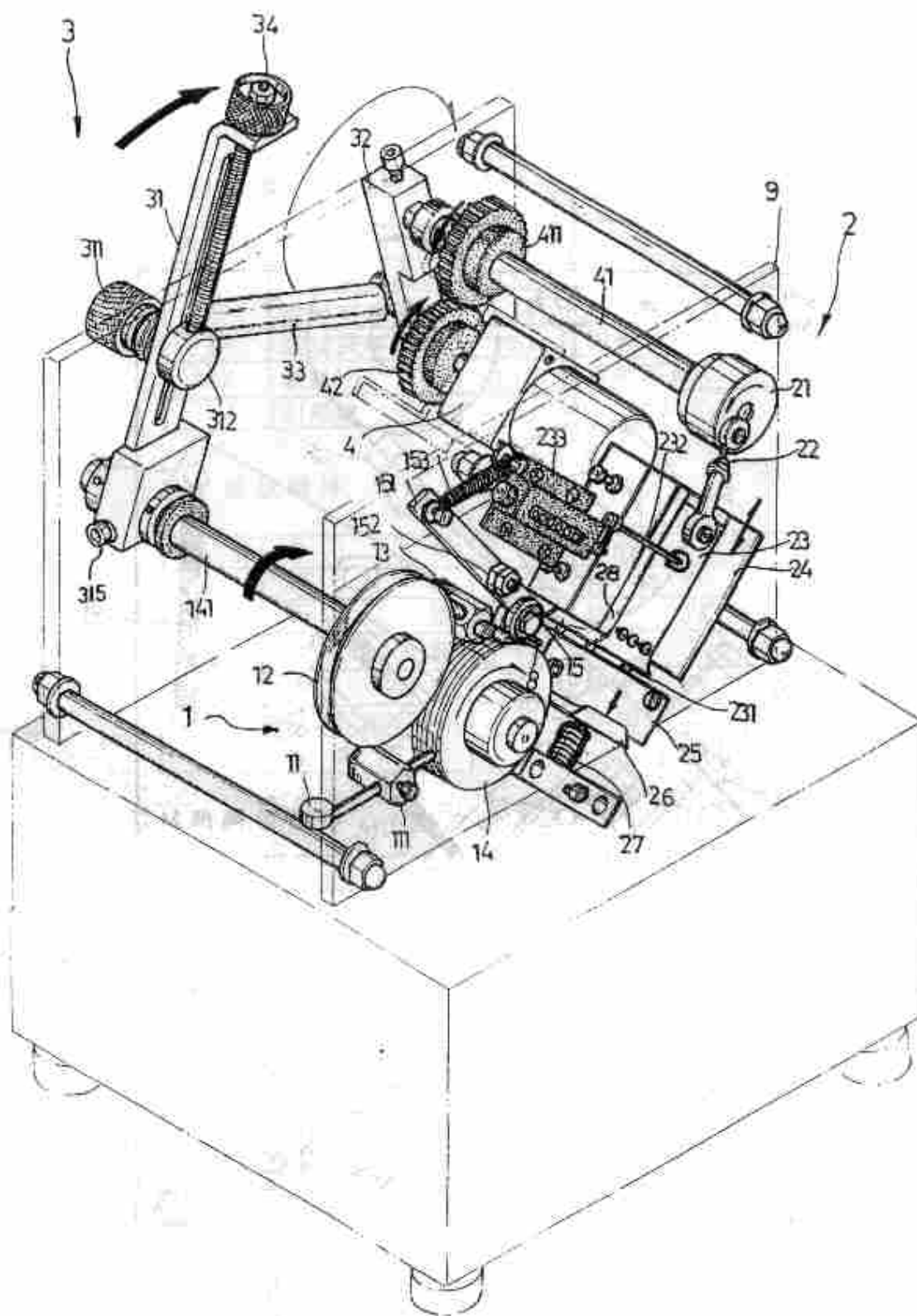
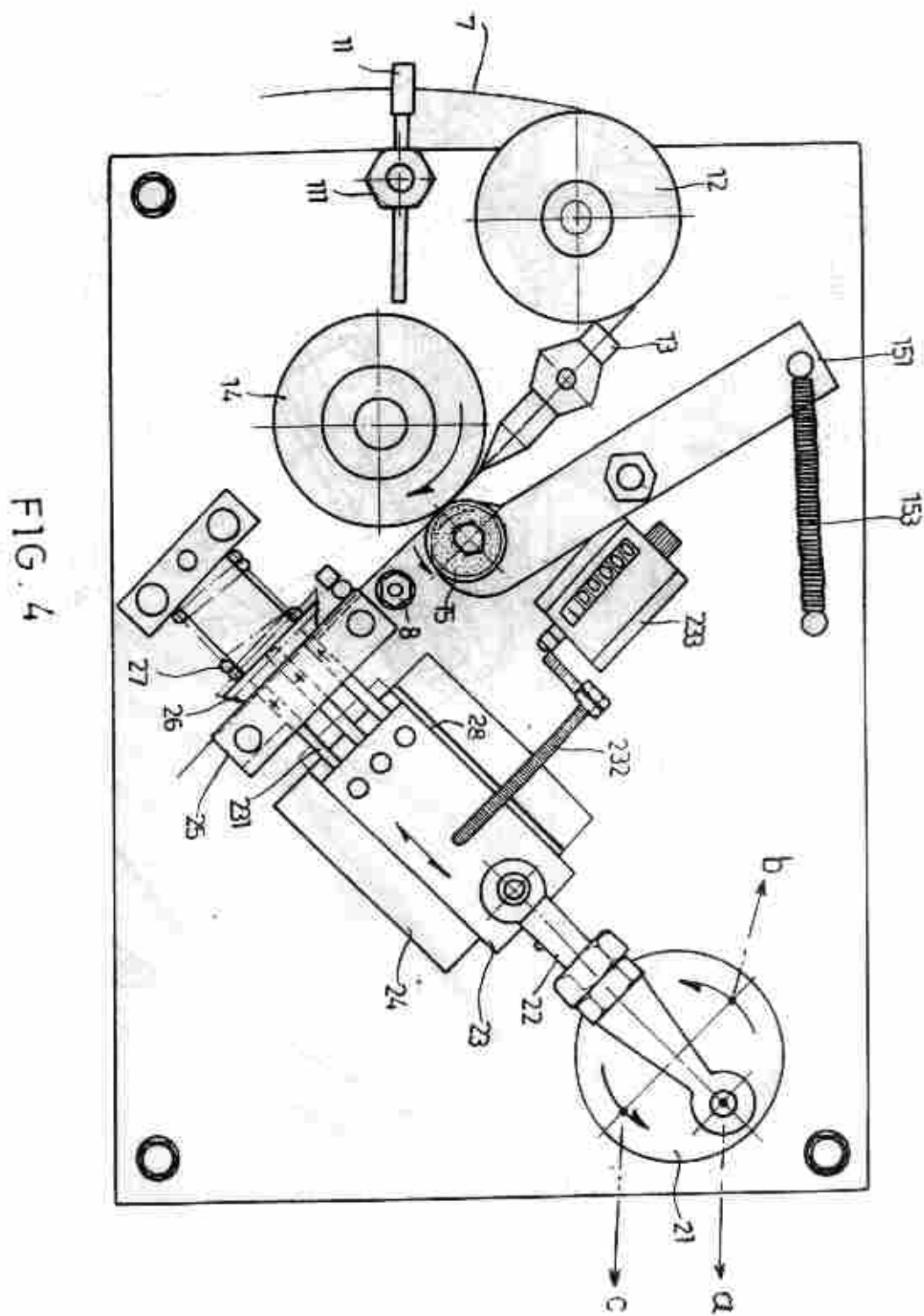


FIG. 3

(3)



(4)



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