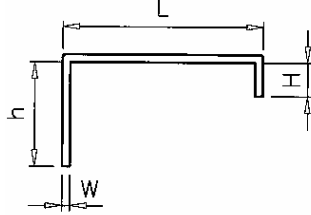


JF-760 跳線成型機 使用說明書

A. JF-760 跳線成型機之介紹

1. 本機器專門針對鍍錫銅線成型切斷無須人工作業，無材的成本，附有安全停車裝字幕顯示，操作簡單易學，
2. 成型規格



成型設計，採線材自動送料、廢料切斷方式可節省部份線置，定量停車裝置，電子計數可提高生產效率。

L=5~30m/m
h=0~12m/m
H= 3m/m
W=0.6~0.7 m/m

(H 腳長為固定型，若需不同規格需另訂購 A13 右成型切腳模)

B. 操作說明

- 1.核對正確與機台相同的電壓，再將電源線插上，開啓 E3 電源開關，按 E5 啓動按鈕，機台即可試運轉。
- 2.E2 為五位數計數器可隨意設定所要的數量，數量達到即自動停車。
- 3.B2 為腳寬固定旋鈕，可調整至所需要的規格，再將 B3 螺絲固定。
- 4.E151 為指示標，上有刻度指示可供調整時核對尺寸。
- 5.C11 腳長調整鈕為針對 h 腳長調整時使用，順時鐘方向轉動，h 腳長即減短逆時鐘即增長。

C. 線材入料方式

- 1.拆下 D91 梅花螺母，將軸裝線材裝於 D9 架料軸心上，再將 D91 梅花螺母鎖緊，線材順時鐘方向穿過 D16 導線輪再通過 D17 銅管，經由 B21 送料輪及 D18 夾線桿送入 C15 切腳模具內。
- 2.線材入料完成後，先用手轉動 E14 手轉輪，看線材送料是否順暢，腳寬及腳長是否符合。
- 3.經過以上調整，試車一切正常即可大量生產。

D. 保養與維護

- 1.A12、A13 成型模具與 C6 成型模導軌之間要加潤滑油加以維護。
- 2.A7 軸心及 A9、A10、A11 支架要機油潤滑。
- 3.線材成品若有毛邊情形出現，可能 A13 右成型模與 C15 切腳錫鋼模之間有空隙，產生毛邊，可鬆開 C151 螺絲調整 C15 切腳錫鋼模與 A13 成型模之間的密合度即可。
- 4.本機腳距 L 最小為 5m/m 如無法調到可能是線材或成品夾在 B7、B10 下模座之間，將它清除即可排除。

以上概略說明，如有疑問歡迎來電洽詢，本公司將以最大的熱忱為您服務，如需更換零件或購買備品，只要將圖上的代號傳真回本公司，即可將您所要的零件寄達貴公司。
服務專線 TEL：+886-2-8201-1187，2202-1205 FAX：+886-2-2202-1204

JF-760 跳線成型機零件表

代號	名稱	代號	名稱	代號	名號
A1	主軸心	B16	RCB101416單向軸承	D8	架料軸心座
A2	傳動凸輪	B17	6003軸承	D9	架料軸心
A3	蝸線斜齒輪-主動	B18	送料軸心	D10	白鐵感應棒
A3-1	蝸線斜齒輪-從動	B19	滑塊架板	D11	彈簧
A4	傳動軸心	B20	送料齒輪	D12	推桿
A5	軸心承座	B2B	送料輪	D13	POS-8軸承
A6	傳動輪	C1	左模具底板	D14	導線架板
A7	軸心	C2	左模具立板	D15	導線支板
A8	軸套鐵	C3	推料彈簧支柱	D16	導線輪
A9	右壓模支架	C4	彈簧	D17	導線輪蓋
A10	退料推桿	C5	左模具立位架板	D18	夾線桿
A11	左壓模支架	C6	成型模導軌	D19	壓線軸
A12	左成型模具	C7	送料直排齒	D20	拉簧固定支架
A13	右切腳、成型模具	C8	直排齒墊片	D21	壓座
A14	壓線板塊	C9	右模具立板	D22	底板
A15	滑片壓板	C10	腳長調整座	E1	控制面板
B1	腳長調整擋片	C11	腳長調整鈕	E2	計數器
B2	固定旋鈕	C12	送料滑塊	E3	電源開關
B3	梅花螺絲	C13	N12直線軸承	E4	保險絲
B4	調整架板	C14	12圓棒	E5	啓動按鈕
B5	滑座下	C15	切腳鋤鋼模具(鋤鋼下模)	E6	停止按鈕
B6	滑座上	C16	銅管座	E7	側封板
B7	左下模座	C17	銅管	E8	馬達
B8	推料片護蓋			E9	後封板
B9	左推料片	D1	左台身	E10	小皮帶輪
B10	右下模座	D2	中板	E11	皮帶A-18
B11	推料片護蓋	D3	上、下架板	E12	大皮帶輪
B12	右推料片	D4	壓桿連片	E13	皮帶輪蓋
B13	送料機構左、右板	D5	右台身	E14	手轉輪
B14	送料機構底板	D6	近接感應塊	E15	指示標
B15	送料軸心座	D7	架料板	E16	下料板

User's Manual –

Automatic Jumper Wire Forming Machine JF-760

A. JF-760 Jumper wire forming machine - introduction

1. This machine design for feeding, cutting and forming the tined copper wire automatically in less labor expense. A special feature of no waste during the operation that down the cost of raw material and increasing the production efficiency. An easy operation LED display counter is built in the machine that provides reset and counting function. Motor brake system installed to ensure safety in emergency.

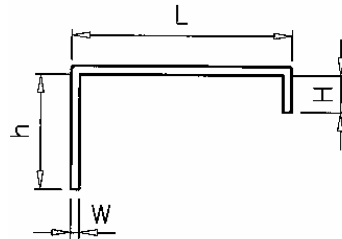
2. Forming specification

3. $L=5\sim30\text{m/m}$

4. $h=0\sim12\text{m/m}$

5. $H=3\text{m/m}$ or optional (fixed)

6. $W=0.6\sim0.7\text{ m/m}$



(H leg length is fixed , customized dimension in ordering or can be changed by exchanging die set A13)

B. Operation steps

1. Check carefully the power requirement of the machine and connecting to correct power source. Turn on the Power switch E3 and activate the machine by E5 push button.
2. E2- a five digits LED counter, pre-set the required quantities. The machine will stop while reaches the pre-set number.
3. B2 – Lead pitch adjust knob, for adjusting the required pitch distance. Don't forget to tight the screw B3 after adjustment.
4. E15, Pitch scale, the caliber therein indicating the pitch.
5. C11, Leg length adjust knob that is for "h" length adjustment., turning counter clockwise to decrease the distance vice versa.

C. Feeding of wire

1. Takedowns the nut D91, Push in the wire reel to the D9 reel shaft, re-assemble and tighten the nut D91 then. Leads the wire through the D16 wire guide roller,D17 brass tube,B21 feeding wheel,D18 wire clamping bar to the C15 die set.
2. Turning E14 hand wheel to test the running and ensure the required specification i.e. leg length and pitch.
3. Mass production can be started after testing and ensure.

D. Maintenance tips

1. Lubricating the die set A12 、 A13 and rail C6.
2. Oil lubricate the shaft A7 and bracket A9 、 A10 、 A11.
3. If burr appeared on the finished jumper wire, it may possible caused by the gap between die set A13 and cutting die set C 15. The simple remedy is to eliminate the gap by releasing the screw C15 and adjust the clearance between C15 and A13.
4. The minimum pitch of this machine is 5mm, if it can't be achieved, the wire or finished jumpers may jam in between B7 and B10 cause the trouble. Clean will solve it.

Contact with us for any unclear or question. Marked required parts on the attached sketch and fax back or tell us the part number if spare part required.

Marketing service TEL: +886-2-8201-1187, 2202-1205 FAX: +886-2-2202-1204

JF-760 Part list

Code	Part Name	Code	Part Name	Code	Part Name
A1	Main shaft	B16	BearingRCB101416	D8	Reel shaft base
A2	Transmission cam	B17	Bearing6003	D9	Reel shaft
A3	Bevel tooth wheel	B18	Feeding shaft	D10	SS sensing bar
A3-1	Bevel tooth wheel-Slave	B19	Block	D11	Spring
A4	Main shaft	B20	Feeding tooth wheel	D12	Push rod
A5	Shaft bracket	B2B	Feeding wheel	D13	Bearing POS-8
A6	Transmission hub	C1	Tooling base -left	D14	Wire guide plate
A7	Shaft	C2	Tooling wall -left	D15	Wire guide frame
A8	Hub	C3	Post –push spring	D16	Guide wheel
A9	Cutting bar- right	C4	Spring	D17	Cover
A10	Push rod -inject	C5	Tooling bracket - left	D18	Wire clamping rod
A11	Cutting bar- left	C6	Track - forming	D19	Shaft - pressure
A12	Cutting forming die set -left	C7	Straight tooth bar	D20	Post fro spring
A13	Cutting forming die set -right	C8	Straight tooth plate	D21	Base
A14	Block	C9	Tooling bracket - right	D22	Base plate
A15	Slide board	C10	Leg length adjust base	E1	Control panel
B1	Stopper- length adjust	C11	Leg length adjust knob	E2	Counter
B2	Fixed knob	C12	Feeding slide block	E3	Power switch
B3	Tighten knob	C13	Linear bearing N12	E4	Fuse
B4	Bracket -adjust	C14	Slide bar	E5	Start push button
B5	Slide base -down	C15	Cutting die set	E6	Stop push button
B6	Slide base -up	C16	Brass tube base	E7	Side enclosure
B7	Die base – left down	C17	Brass tube	E8	Motor
B8	Cover			E9	Back enclosure
B9	Feeding plate-left	D1	Left frame	E10	Pulley -small
B10	Right die set base	D2	Mid frame	E11	Belt A-18
B11	Cover	D3	Up/down plate	E12	Pulley -big
B12	Feeding plate-right	D4	Connection plate	E13	Cover
B13	Feeding plate – R, L	D5	Right frame	E14	Hand wheel
B14	Base - feeding	D6	Sensing block	E15	Pitch scale
B15	Base – feeding shaft	D7	Bracket	E16	Bracket

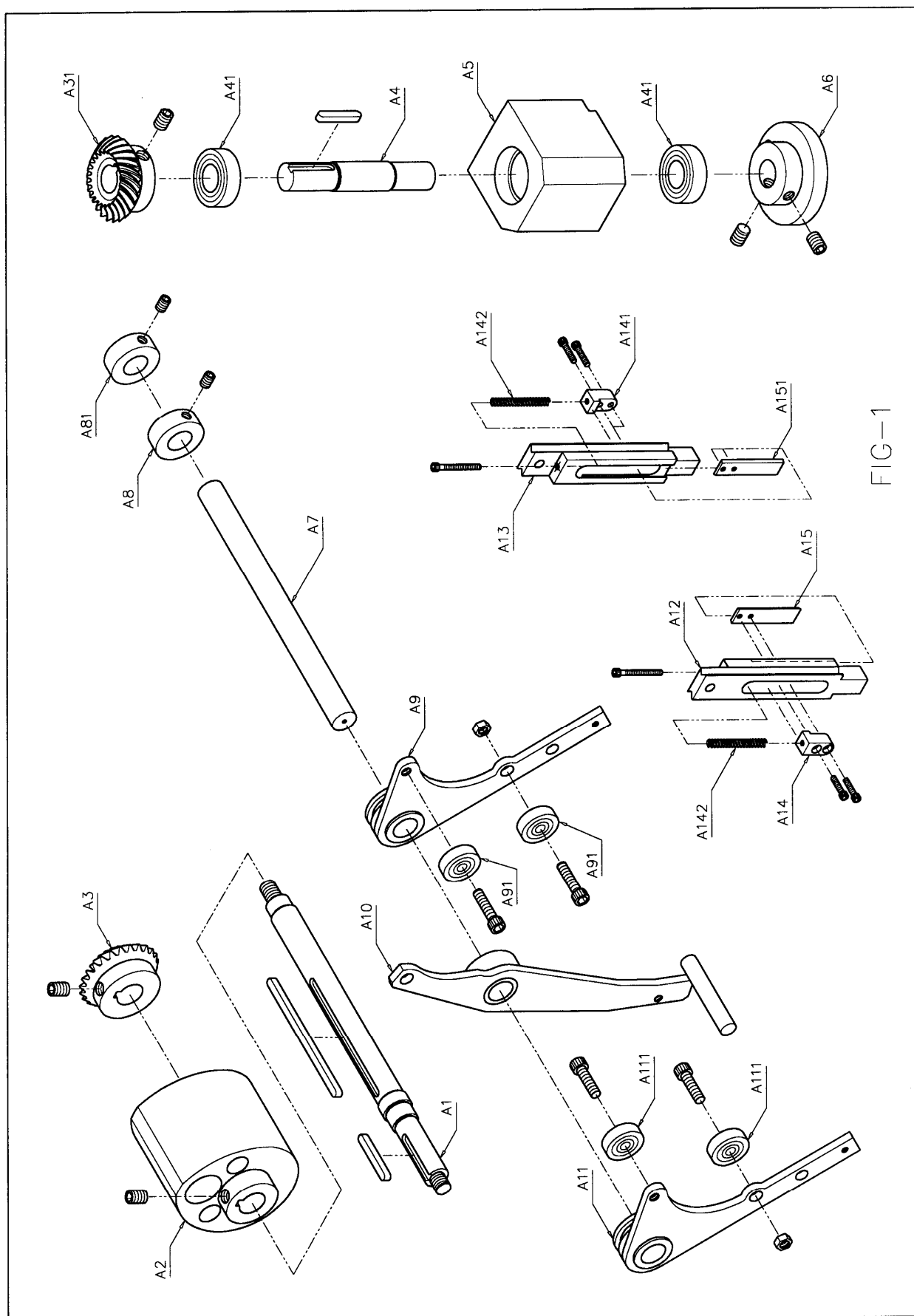


FIG-1

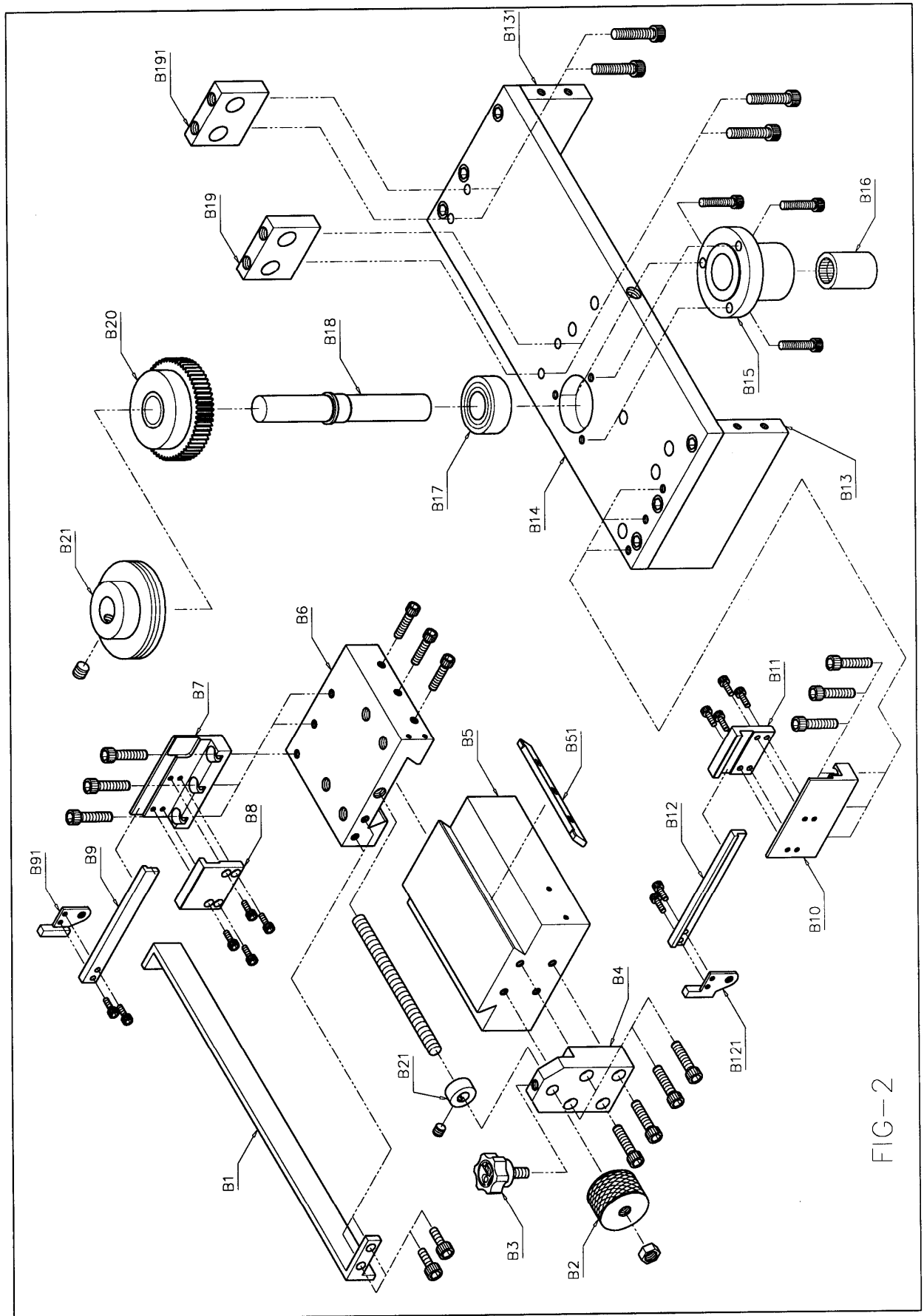


FIG-2

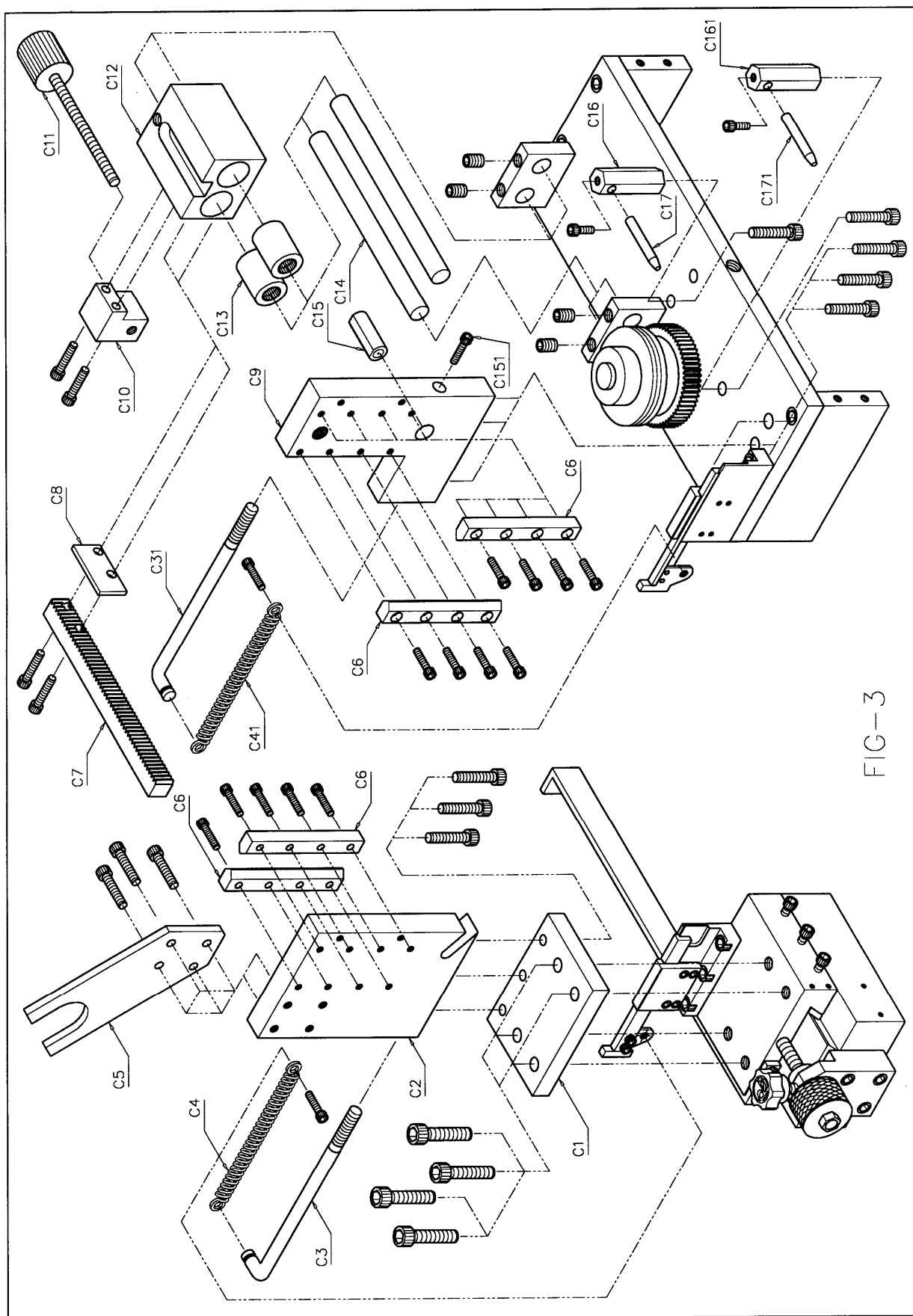


FIG-3

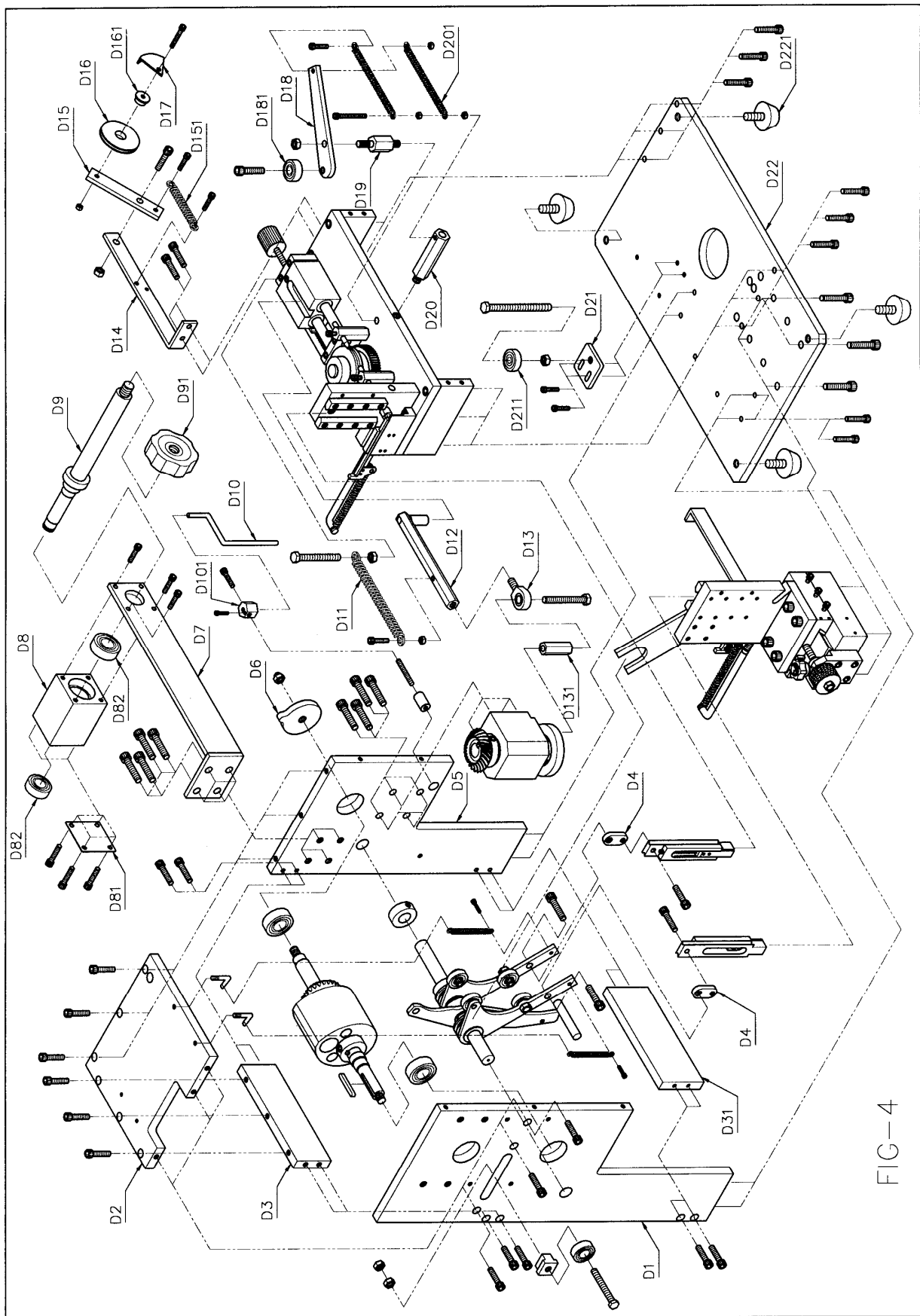


FIG-4

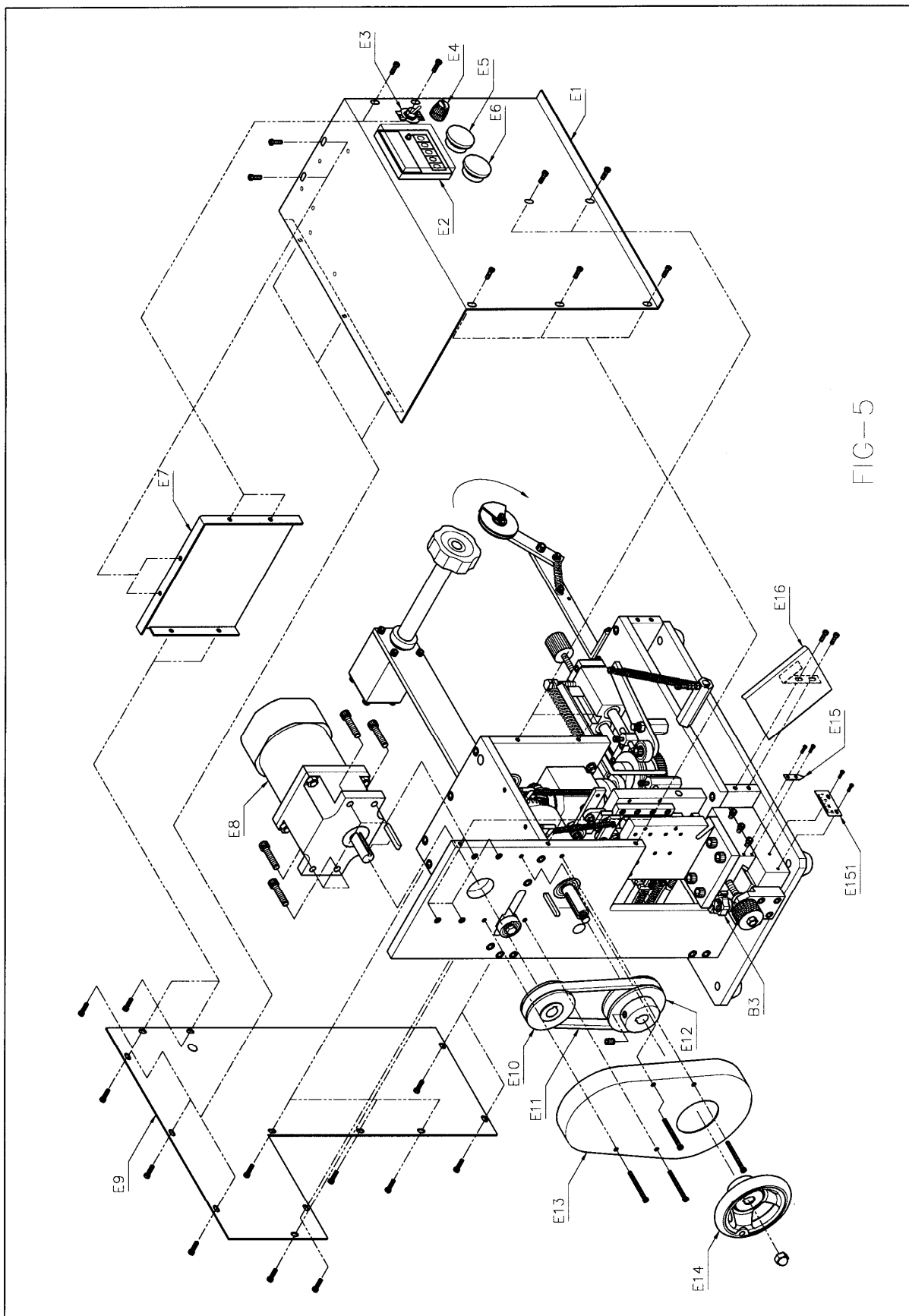


FIG-5

