

A I.C forming machine ICF-106 model

1 The model is suitable for trimming, cutting, bending and stretching lead.

2 ICF-106 is standard, only used for whole lead.

a) Machine plate attached 2 types tracks.

Forming track	Standard	0.3"; 0.6"
	Optional	0.4"; 0.75"

b) Proceeding capacity: 7 seconds forming one tube.

c) Special lead width I.C needs to order separately.

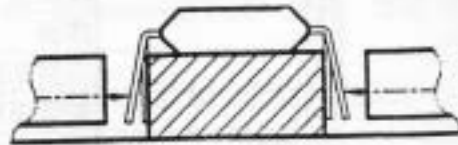


FIG.1
整型-Forming
ICF-106

3 ICF-106C is optional order.

a) Trimming: when order, needs you to provide sample & size specification drawings.

b) The minimum: length of trimming /1 mm.

c) Trimming size: fixed, not adjustable.

d) Each size specification: needs one set mode.



FIG.2
切腳-Cutter
ICF-106-C

4 ICF-106k is optional order.

a) Bending & trimming simultaneously.

b) Bending up high or plate usage.

c) When ordering you have to provide sample & size specification drawing.

d) Each specification needs one set mode.

5 This machine on forming could change for other function. For example, if ordering expanding lead width function, or according to your requirements to buy/choose mode change again.

B Feeding & Adjusting

1 Track check: Take out one processing I.C , check track (5) ,confirm size.

2 Turn on power: Check voltage,turn on power and try operating, stop again.

3 Try forming:

a) Take (59) pressing wheel cover, turning back.

b) Take one I.C and put on the track of (5), pushing middle to (38)(39) left & right forming model

c) Turn on power and let (38)(39) left/right forming mode, get two lead forming.

d) Take out I.C& check size.



FIG.3
成型-Forming
ICF-106-K



4 Forming adjusting

- a) Two line I.C lead open /close is adjusted separately.
- b) 38,39 approaching to track 5 , distance 0.3mm is suitable.
- c) Loose 106 screw, turning 49,33. 38,39 procedure goes toward, backward.
- e) After adjusted forming size, tight 106 nut again.

5 Adjust feeder

- a) Feeder plate 11 could turning 90 degree, prevent tube I.C from sliding.
- b) Take one empty I.C tube , insert on (12) (17) left/right adjusting plate.
Use (6) pressing plate to slightly press I.C. tube.
- c) Horizon inserts I.C tube, (11) feeder plate turning upward, at this time I.C. tube & (5) track has to be one line that make tube I.C smoothly get into (5) track.
- d) Take one empty I.C tube insert on (5) track end side, (52) pressing tube plate
Down pressing fixed I.C tube, get ready to collect forming sending I.C.

6 Track change:

- a) Loose (18)(19) turning nut, take out (20) pressing plate.
- b) Loose (28)(29) screw, replace by processing forming track.
- c) Forming mode (20) pressing plate just let I.C passed.

C Forming processing

- 1 Feeder plate (11) turn down with (5) track by 90-degree angel.
- 2 Place (59) , adjust(105) screw, I.C transferring smoothly.
- 3 Inserting I.C , sliding to (5) track.
- 4 Turn on power
- 5 Empty I.C tube always inserts on the end of (5) track, receiving forming I.C & packing.
- 6 Forming operation, no need to stop, continuing to operate one by one.
- 7 Forming explanation: As I.C approach track (5), touching (59) plate, will stop.
Waiting for (38)(39) forming to hit I.C lead, completely lead forming will open immediately (59).



D Caution

1 Right & left forming model (38)(39) knocking I.C lead simultaneously, if any mistake , has to adjust .

a) Adjust method: loose belt wheel(92) screw, turn (50) to wheel ,then tight (92) Screw.

b) Steel (59) only could operate one way.

c) Right & left forming (38)(39) couldn't knock the track (5), otherwise the machine will stop.

2 There are 3 pos-6 bearing (62)(63)(74) need lubricating.

3 There are 2 wall hole on (38)(39) for lubricating.

4 I.C two line lead due to different brand material hard/soft difference, need to adjust a little so as to reach the same forming size.



I.C. former machine/ ICF106 spare parts list

code	name	code	name
(1)	Face Plate	(61)	Transmission Belt
(2)	Base	(62).(63).(74)	Elliptic pull and push rod
(3)	Working Base Plate	(64).(65).(66).(78)	Support Bracket
(4)	Fixed Working Base Plate Screw	(67)	Driving Belt
(5)	Sharp Forming Track	(68)	Motor
(6)	Inlet Pressing Plate	(69)	Motor Face Plate
(7).(53)	Pressing Plate Fixed Screw on I.C. material inlet	(70)	Driving Gear
(8).(54)	Pressing plate adjusting bar	(71)	Driving Gear
(9).(56)	Adjusting rod fixed	(76)	Belt Adjustment Wheel
(10).(55)	Adjustment rod base-unit	(77)	Adjustable Interval Rod
(11)	Adjustable track base-unit	(79).(80).(81)	Belt Gear
(12)	Right-side Adjustable track	(82)	Back Plate
(13).(14)	Right-side Adjustable track Fixed Screw	(83).(84)	Motor Screw
(15).(16)	Left-side Track fixed screw	(85).(86)	Motor Screw
(17)	Left side track	(87)	Handle
(18).(19)	Long sharp pressing plate turning nut	(88)	Pad
(20)	Long sharp pressing Plate	(89)	Belt 106
(21).(22)	Pressing Plate adjustment spring	(90).(91).(92)	Screw
(23)	Long sharp pressing Plate base -unit	(93)	6003 Bearing
(24).(25)	Oblong pressing plate Fixed screw	(94)	6002 Bearing
(26).(27)	Pressing plate base-unit fixed screw	(95)	C Washer
(28).(29)	Track fixed screw	(96).(97)	Screw Hat
(30).(42)	Shape forming knife base	(98)	Motor Screw
(31).(41)	Sharp Forming Leading seat	(99)	Belt Wheel
(32).(40)	Knife Bearing Cover Plate	(100)	Reciprocating Transmission Shaft
(33).(49).(75)	Universal Transmission	(101)	Reciprocating Transmission



code	name	code	name
(38)	Percussion Blade	(102)	Bearing
(39)	ditto	(103)	Pressing wheel
(34).(35).(36).(37)	Knife Bearing Cover Plate	(104)	Washer
(43).(44).(45).(46)	ditto	(105)	Screw
(47).(51).(73)	Fixed Screw	(106).(107)	Screw Hat
(48).(50).(72)	Eccentric Shaft	(108).(109)	Screw
(52)	Material Outlet Pressing Material Plate Fixed Screw	(110).(111)	Screw
(57)	Pressing Material Plastic Wheel Fixed Plate	(112)	Handle Screw
(58)	Reciprocating Transmission Shaft	(113)	Screw
(59)	Pressing Material Plastic Wheel	(114)	Back Plate
(60)	Driving Shaft	(115)	Screw



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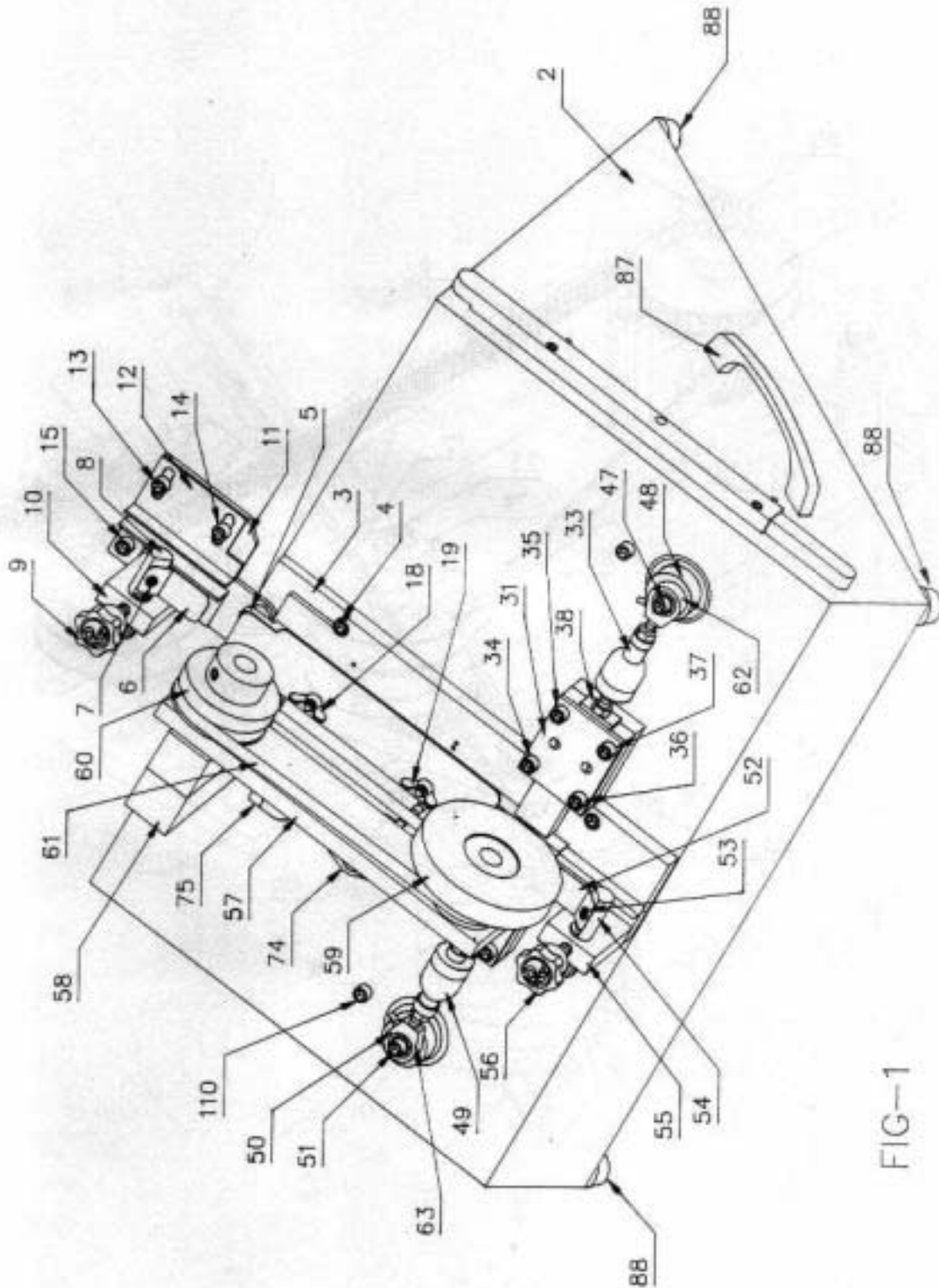


FIG-1

-9-



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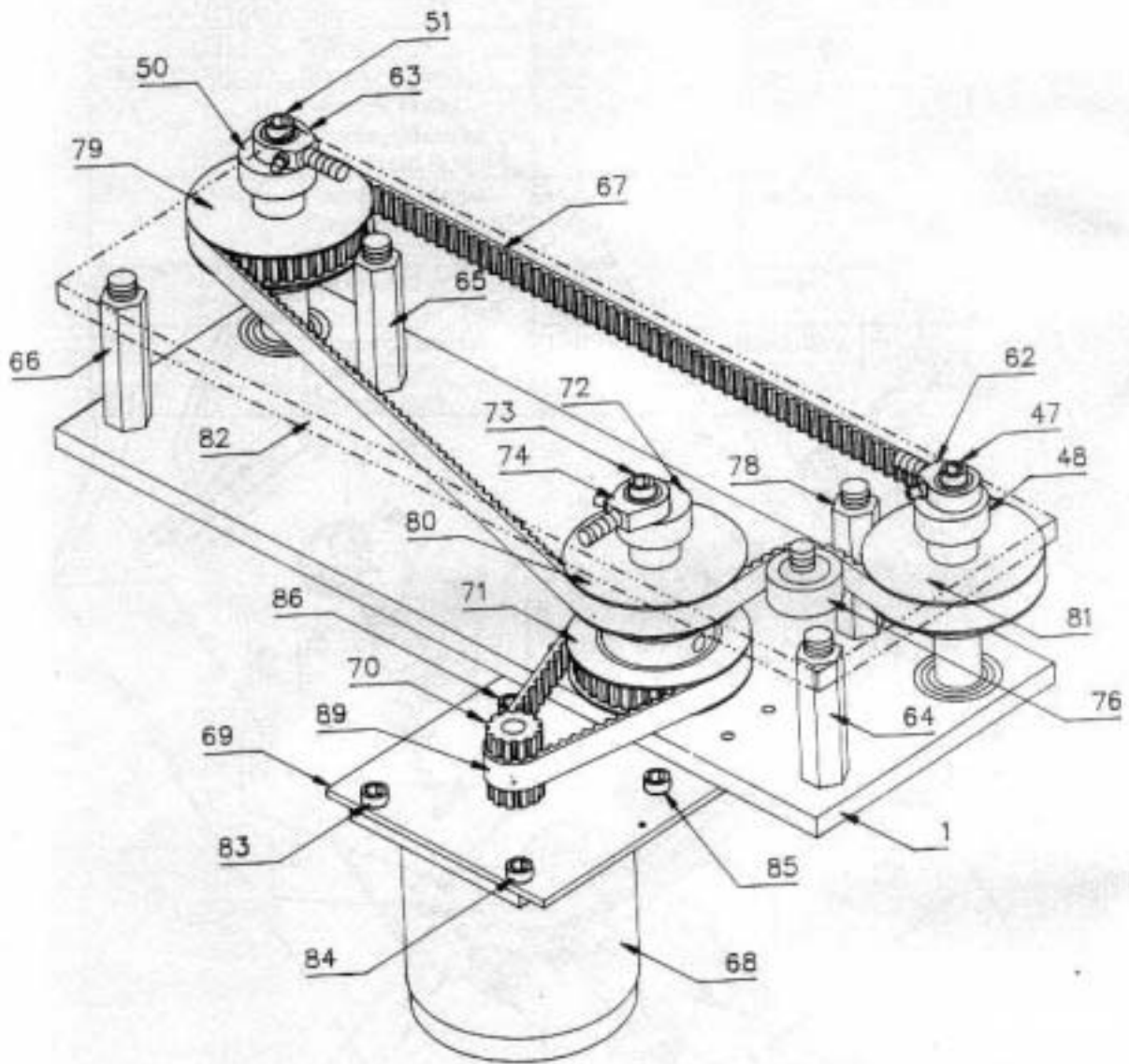


FIG-2
-10-



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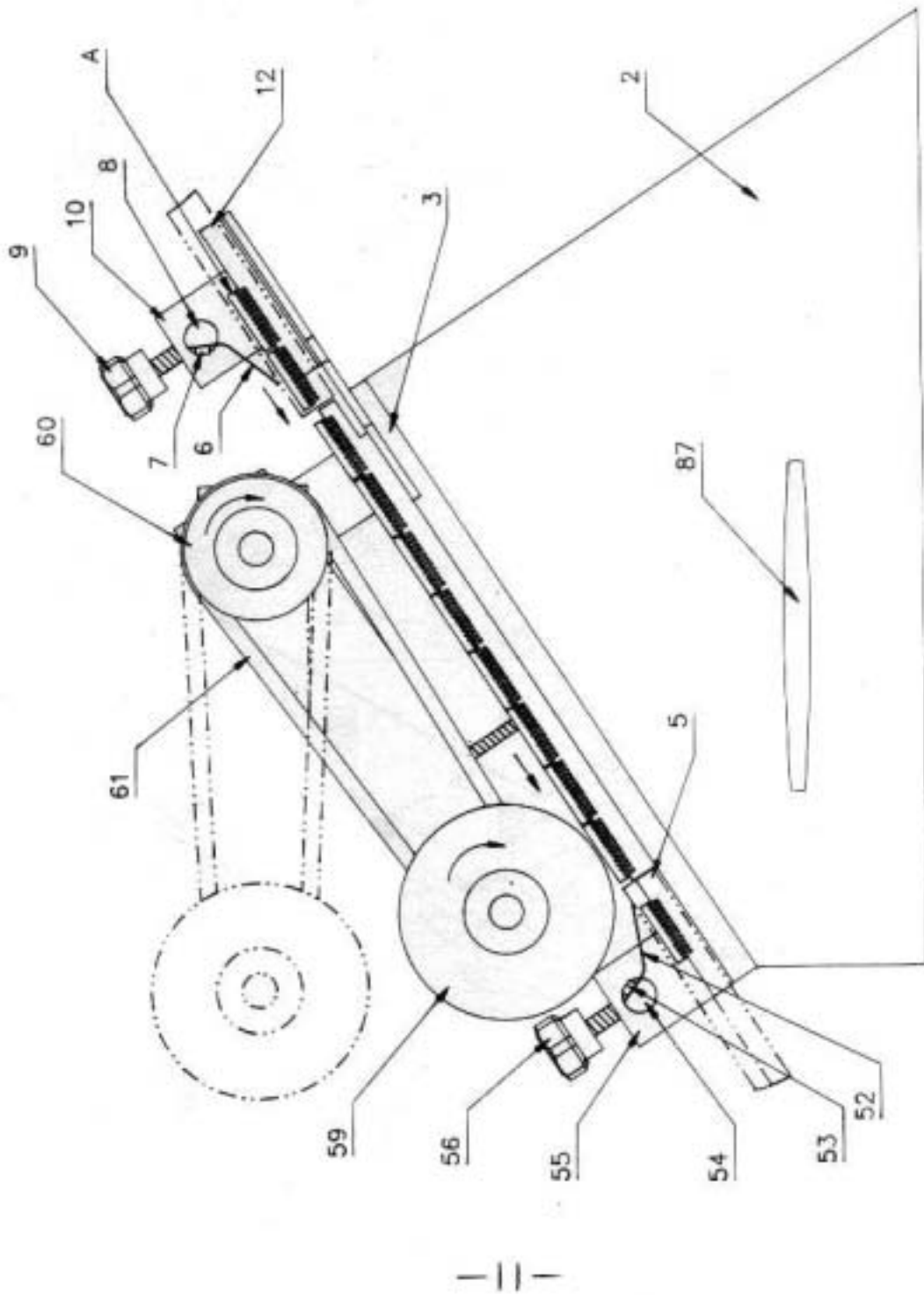
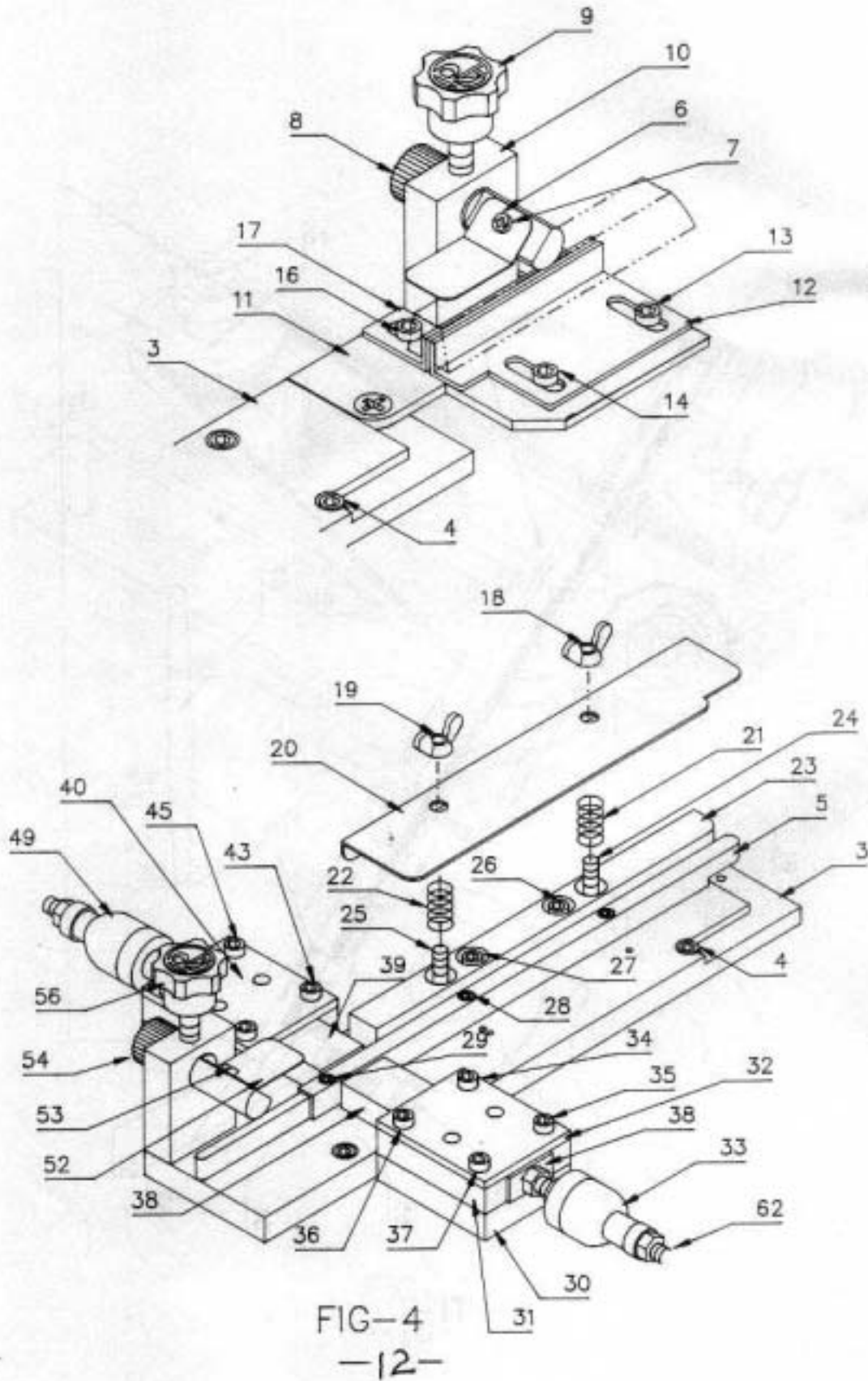
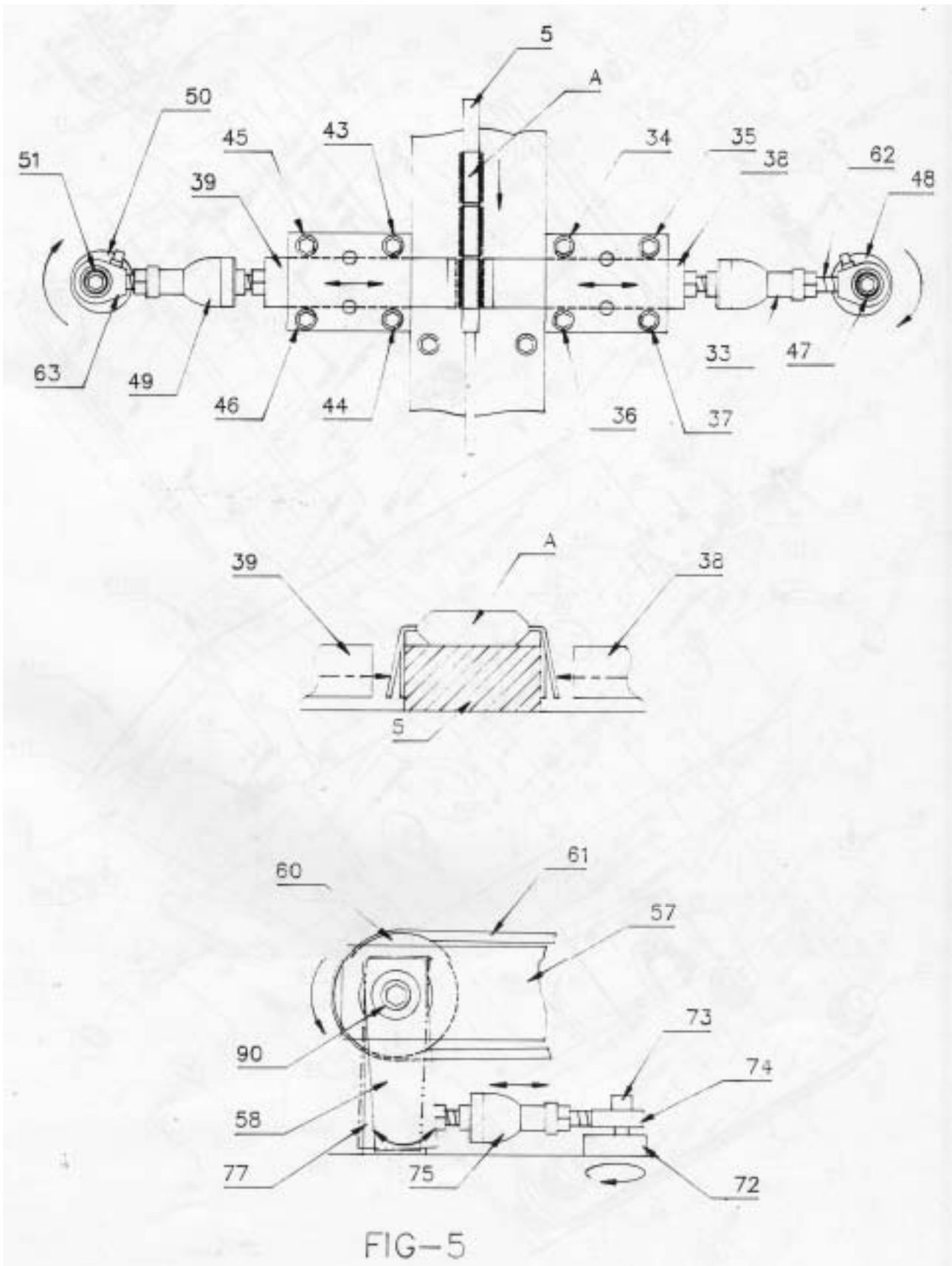


FIG-3





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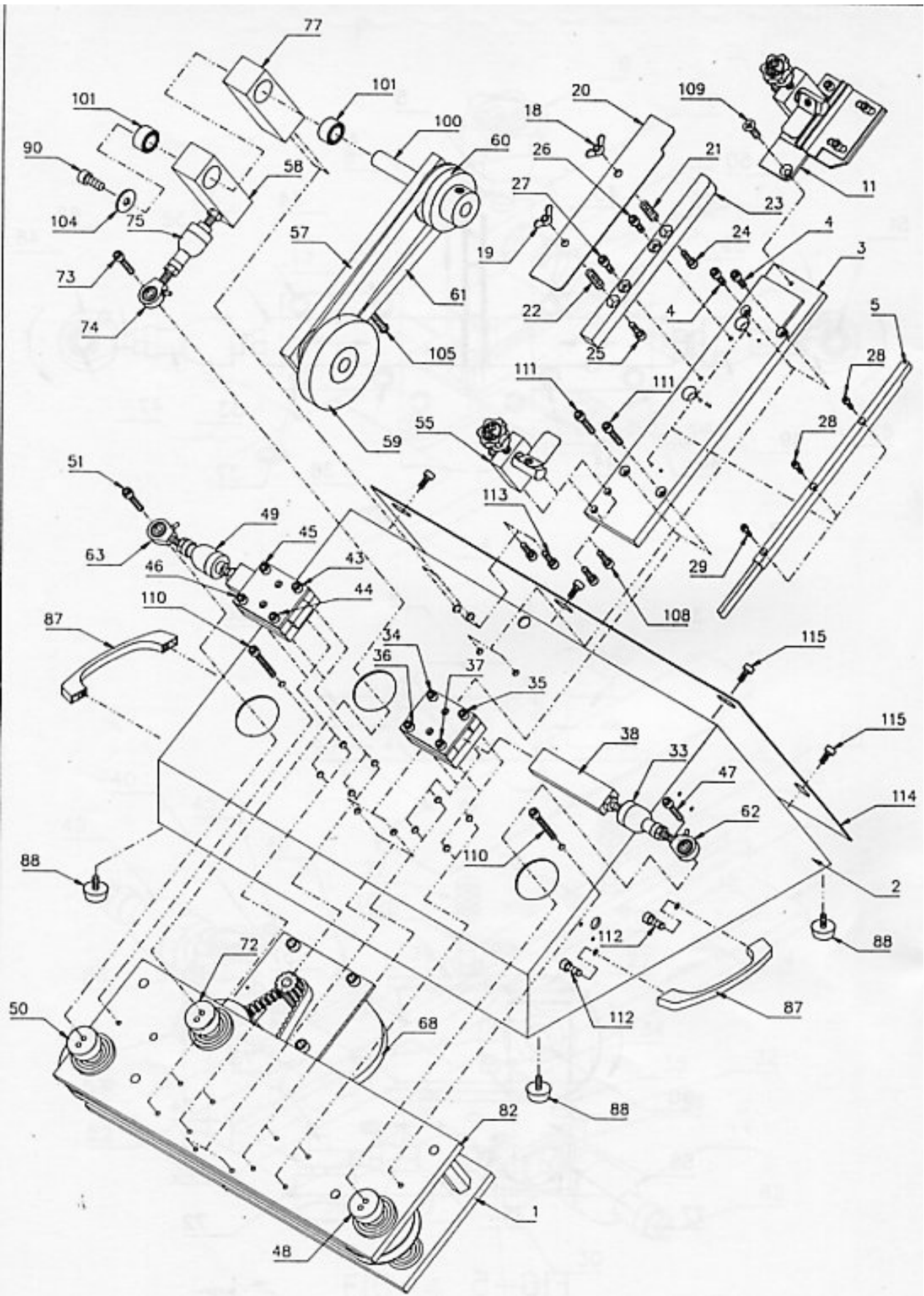
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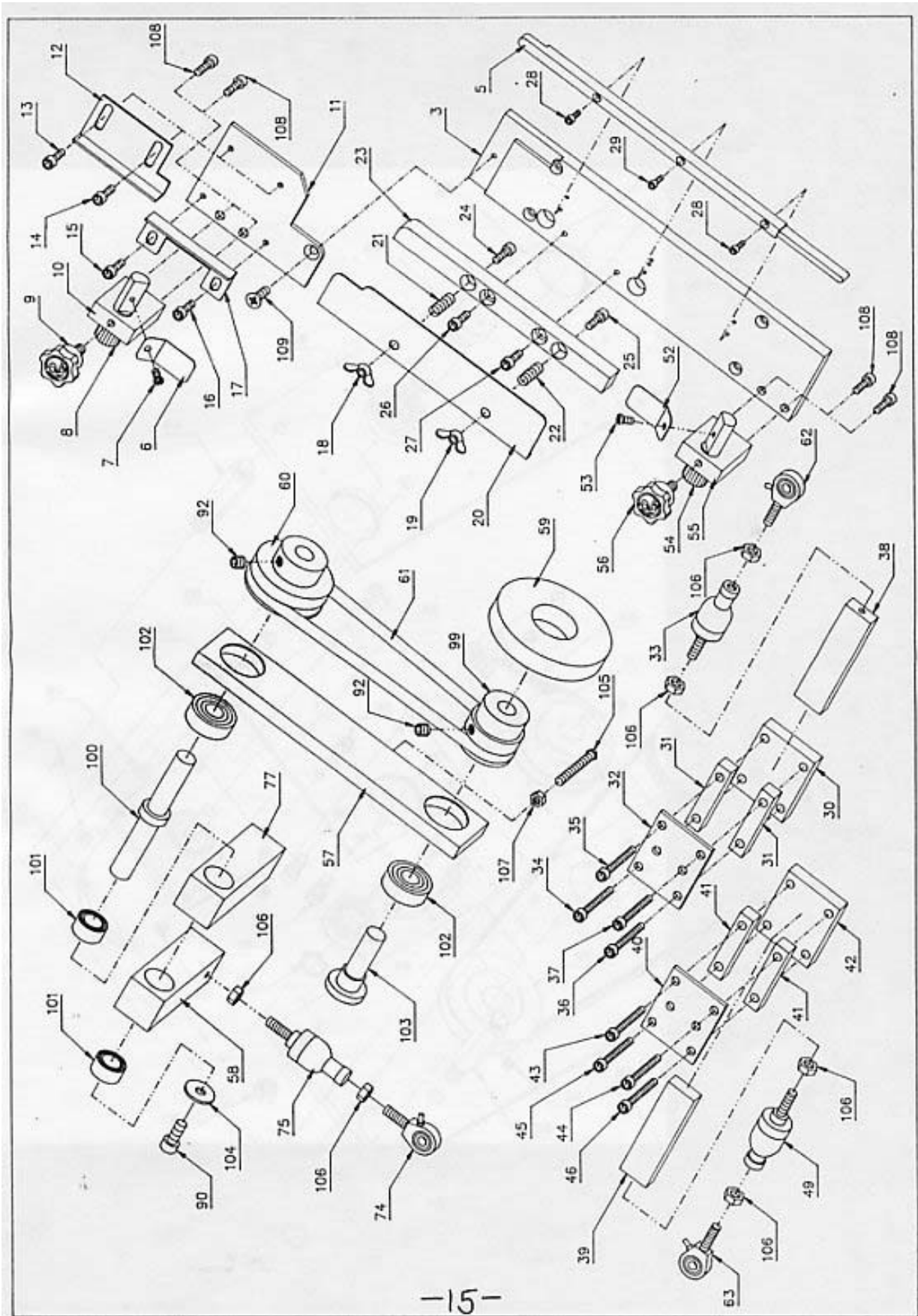
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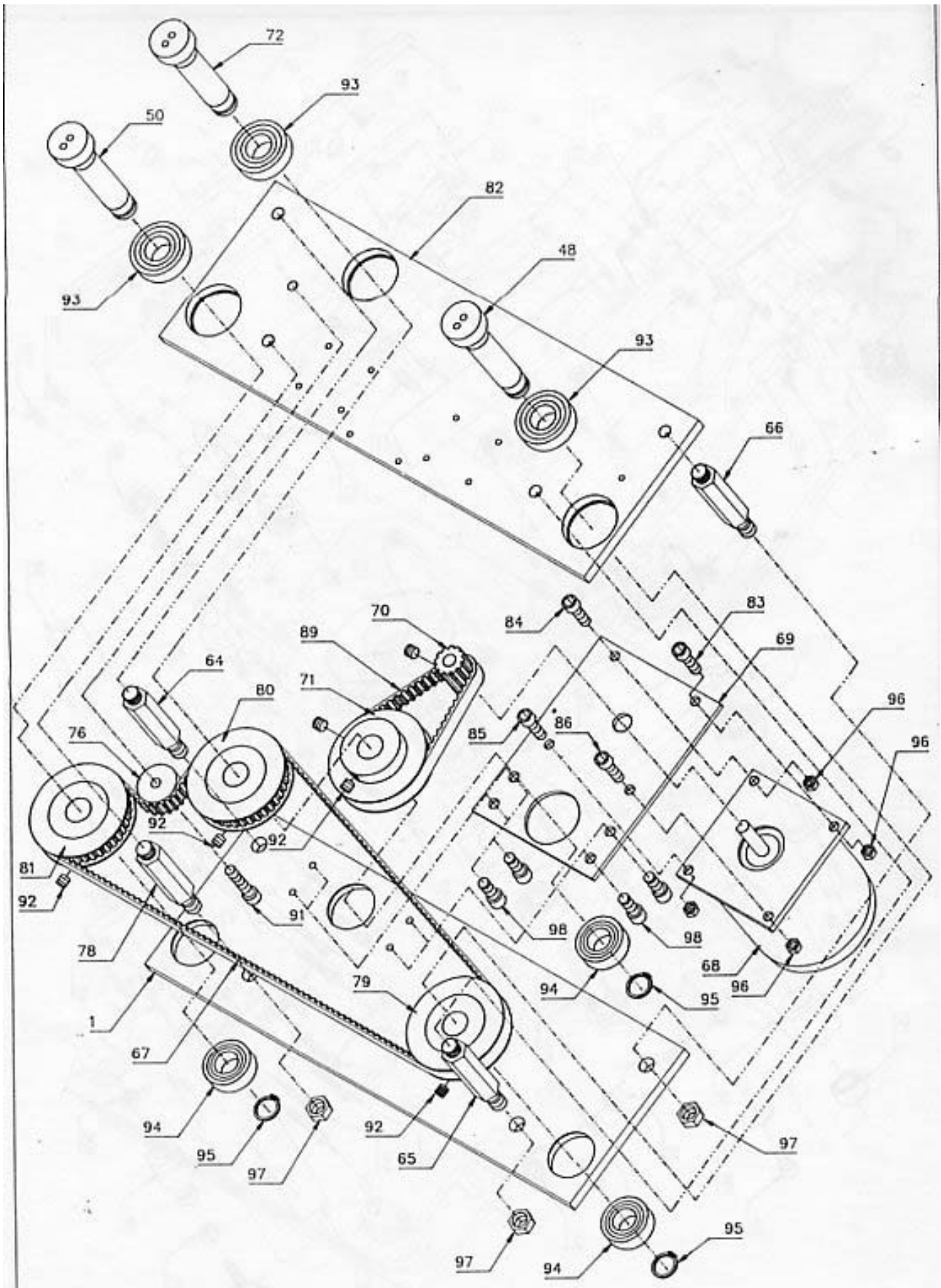
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