

I. Your Machine comes complete with the following items in the list below. Make sure that you have everything before trying to set up your unit.

RF-101-F

1. RF-101-F Main Body
2. Parts Bin
3. Tape Reel Holder
4. Wrench Set
5. Bowl Feeder
6. Chute

RF-101-FA

1. RF-101-FA Main Body
2. Part Bin
3. Wrench Set
4. Bowl Feeder
5. Chute

RF-101-FB

1. RF-101-FB Main Body
2. Part Bin
3. Tape Reel Holder
4. Wrench Set

II. Machine Setting Up and Adjustment

Effective Model: RF-101-F 、 RF-101-FA

Please setting up and adjusting your machine as the following steps:

- Make sure the out let of hopper (T) is aimed at the center of feeding arrangement sheet S and

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assemble the chute X in the position to the hopper T.

- Assemble the reel frame to the wall of left hand side and fixed in the 2 screw holes.
- Placing the bowl feeder in the stand and the outlet aim at the chute.
- Placing around 600 pieces of components to the bowl feeder. It can be increased gradually according to the situation of operation. Please avoid placing too much components at once to get rid of entangle each other.
- Adjusting the outlet adjustment sheet V in the feeder to screen the uneven (bended) parts and control the outlet quantities.
- Adjust the distance T1~T2 in the hopper. The distance = King length of components + 0.5~1.0mm. The body of the components must be in the center position of the feeding arrangement sheet. Please note that it is a place that tight-up most often.
- Turn on the power switch, red light will show the power is connected.
- Turn on the auxiliary vibrating switch. Please adjusting the screws in the hopper if it is too loudly. It can be turned off according to the feeding condition.
- Illustration — Mode Switch
 - Auto — The green lamp will light when turning to this position. In this mode the machine will be terminated automatically when if is no materials in the feeding carry wheel I. In this moment, it is same function as mode “Intermittent”.
 - Intermittent — Operating when the start button is pushed. It is frequently used in testing.
 - Manual — The green lamp will light when component is detected by the micro switch. The operation can follow-up the green lamp condition. This mode is keep the machine going on continuously. Must stop the machine by pause or stop button.
- Turn the speed regulator on bowl feeder to the lowest position, then turn on the power. Accelerate the speed by the regulator increasingly.
- The component will slide down from the chute, hopper to the feeding arrangement sheet turn on auto mode and push “Start” button when the components is over 2/3 of the feeding arrangement sheet.
- The automatic mode is started when the components are in the forming carry wheel and activated the micro switch.
- When the hopper us tight-up by the components. It may caused by the uneven raw material condition or the improper gap in feeding arrangement sheet (Further information will be introduced in next chapter)
- When the components are going to use up in the feeding arrangement sheet, pause the operation by pushing the pause switch. Restart the operation till 2/3 of the feeding arrangement sheet is occupied.

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III. Taped Packed Components – Machine Setting Up and Adjustment

Effective Model: RF-101-F 、 RF-101-FB

Please setting up and adjusting your machine as the following steps:

- Engaging the taped component to the teeth of wheel G and G1, The function of G1 is to cut the tape and the G transmit the components to the forming carry wheel.
- The G wheel is close to the forming carry wheel. Please keep the components not too close to the plastic trials. Make sure the body is in the center.
- Moving the G wheel toward right side according to the size of body. Check the distance of forming carry wheel by the length of component's body. Return the F wheel to original position and close to the forming carry wheel.
- **Caution:** The feeding arrangement sheet have to be adjusted when the distance of forming carry wheel is change.

IV. Adjustment and Operation Procedure – Forming Process Descriptions

Effective Model: RF-101-F 、 RF-101-FA 、 RF-101-FB

- The micro switch will be activated by the material in the forming carry wheel. Then the components will goes into the cutting and forming device one by one.
- The motor will be terminated as the feeding carry wheel is out of components that is controlled by the micro switch in automatic mode.
- The lead of components will be cut to the expected size by the cutting blade in cutting adjusting knob N,P. As the components are carried to the bending mold L0, the lead of it will be turn 270 degrees and parallel with the body of the components by the bending rod. The whole process is completed when the finished parts fall down the parts bin.

Forming construction — Descriptions

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- Bending mold L0 holding the top of the components to assist the forming operation of the bending rod.
- Various styles of forming such as kink or without, snap out , will be making by the forming mold L1 matching with the bending rod.
- The gear set of B4 is connected with the back & forward pinion by the connection rod. The forming degree will be adjusted by the length of the bending rod.
- 10 degree movement will be reached on the bending rod by shifting one teeth of the engagement between the pinion J4 & J5.

V. Forming Size Adjustment

※**Caution:** Please testing the machine by manual through the testing wheel.

Operation by electronic power as everything is settled.

- Aiming the bending point at the edge of the forming carry wheel. Then the forming point in line with the other side of the forming carry wheel.
- Turning around the testing wheel by the 8mm Allen key. Observing and making sure the bending rod can reached the bending point during the back & forth operation.
- The bending rod is working at the cycle of 270 degrees. When the forming rod is in original position. The closer to the forming carry wheel the radius is smaller and close to the body of the component. The pitch can be adjusted according to this principle.
- The adjustment of the position between the bending rod and forming point can control the type of kinking line, snap-in, snap-out or without the kinking. Please contact us for further assistance, if special specification is requested.

VI. Adjustment & Guideline for Special Mold

- The forming mold for special specification is design upon request. It is not equipped regularly for all machines. Typically, it divided into two categories ie. Single kink & double kinks.

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RF-101-F 、 FA Feeding Solution Adjustment for Hopper & Feeding Arrangement Sheet

1. The components sliding down in 45 through the feeding chute and crashing the intersection area of T5, T2, T6. Then entering into the hopper and goes into the feeding arrangement sheet swiftly.
2. The distance of T1 & T2 have to be adjusted according to the king length of the components. The distance = King length + 0.5mm~1.0mm.
3. When the body of the component is too big to enter the hopper, dismantle the screw T4 and move out the guide of the hopper T5 then making a cut-off on the guide, make sure the cutting-off size is bigger than the body 1mm. The guide can be using up-side-down when normal components are going to process.
4. The bend sheet under the hopper guide must be ensured to contact with the position of S1, S2.
5. Make sure the body of the components are processing on center of the 4 Feeding adjustment sheet.

Adjustment for Feeding adjusting sheet & Forming Carry wheel

※**Caution:** The listed adjustment procedure is nothing to do with the forming dimension but increasing the efficiency of the machine.

1. Release the screws(S8) before adjusting the feeding adjustment sheet(S3). Adjusting the sheet by moving it out to properly position.
2. The S2 is fixed. The feeding arrangement sheet S1 can be adjusted according to the size of the body which must be a little bigger than the length of body.
3. Feeding adjustment sheet S4 is designed to control the wire lead dia.
Distance S4~S2 = Dia. of wire lead + 0.5mm.
Four of the hex screw rod S10 are fixed on the main frame, the nuts here are fixed, the S4/S2 are locked by spacer, please adjust the dimension for wire size by S4.
4. Release the 2 screws of S8 adjusting the feeding adjustment sheet. Please let the S3 sheet keep in line with the S1
5. Adjusting the gap S1~S3 = S2~S4. Please don't forget to release the nut S6,S7 before adjustment.

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Instruction for Forming Carry Wheel

1. The forming carry wheel is responsible for carry the component precisely to next operation. It is working synchronously with every portion of the machine. If it is out of position because of jamming by the components. Please return original point immediately. Otherwise, the machine would possible brake down.
2. If the wheel is out of position, readjusting by the screw I3 which fixed on the main shaft.
3. The distance of the forming carry can be adjusted by loosen the screw I2 according to the length of the body.
4. If the body of component is not applicable in the standard forming carry wheel. A customized wheel is necessary to solve this problem. Please tell us size and we would very please to serve you.
5. It is very important to prevent the forming carry wheel form deform or damaged. It will cause improper feeding situation.

Maintenance and Hints

1. Prevent not to damage the steel wire of the micro switch while exchange the forming carry wheel.
2. Removing the material chip in the position of cutting block. Otherwise, the cutting tool will be jammed components that will much help in this condition.
3. The testing wheel can only be turned clockwise or the smashing bearing would possible be damage.
4. Clean all chip in transmission gear.
5. If tight up condition is found in the hopper, plunking the jammed components that will much help in this condition.
6. Lubricate and clean the machine daily.

Welcome your inquiry for the item unclear. It is our pleasure to serve you at all time. Thanks!!

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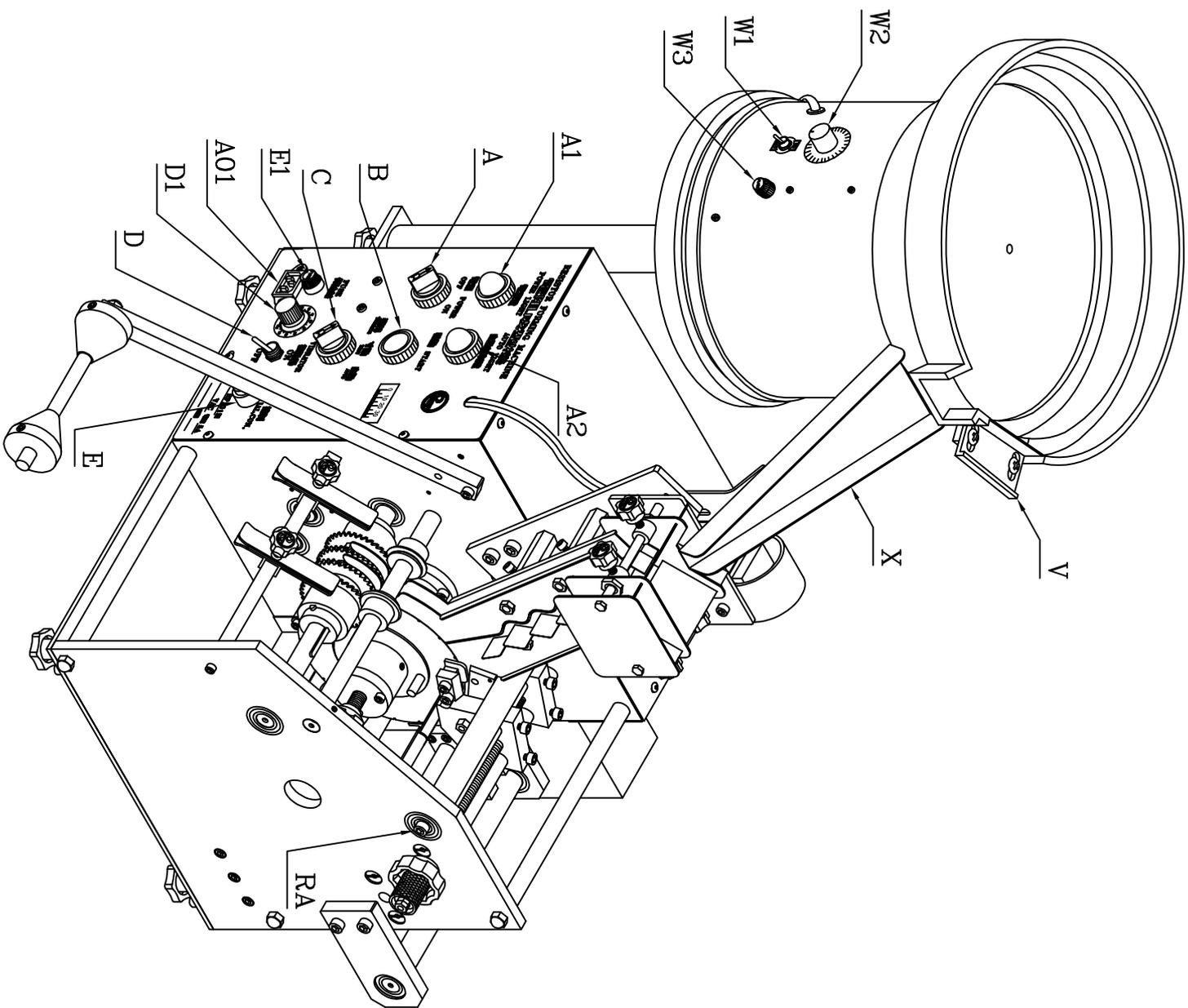


FIG-1

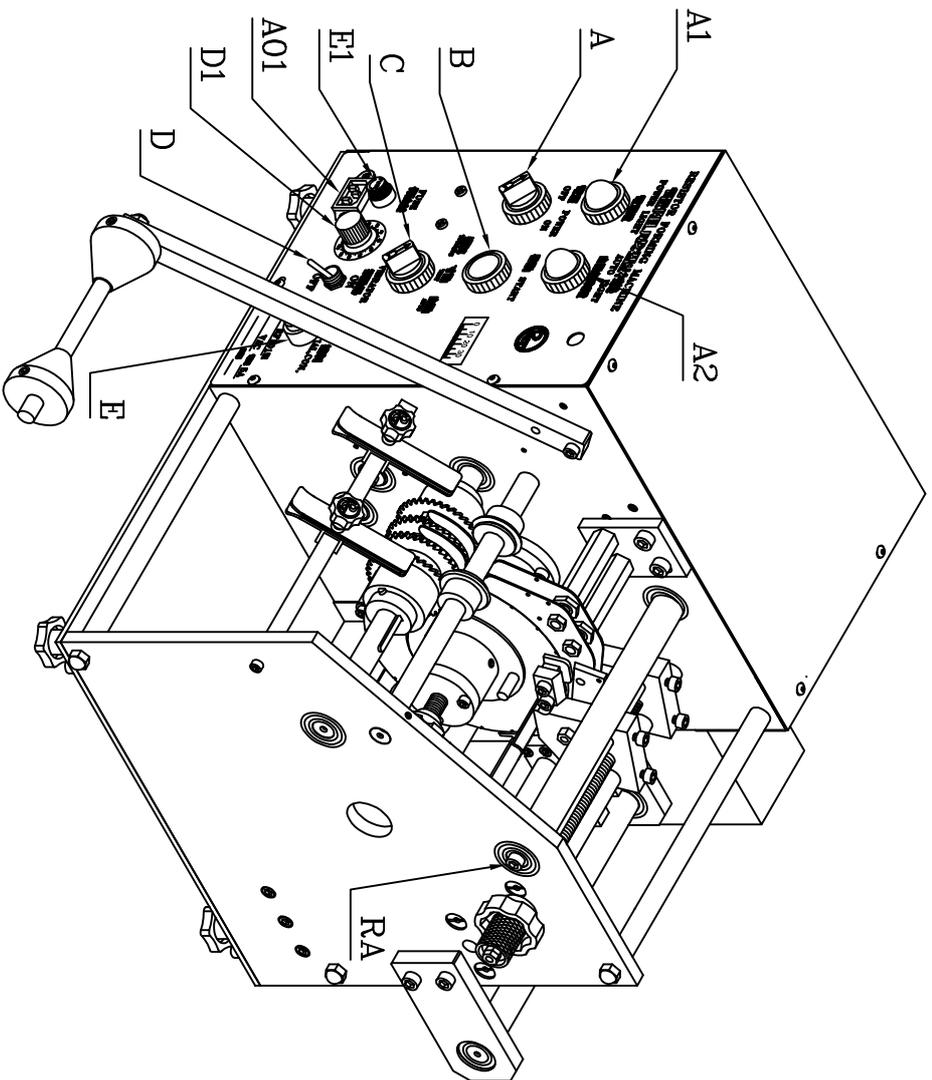
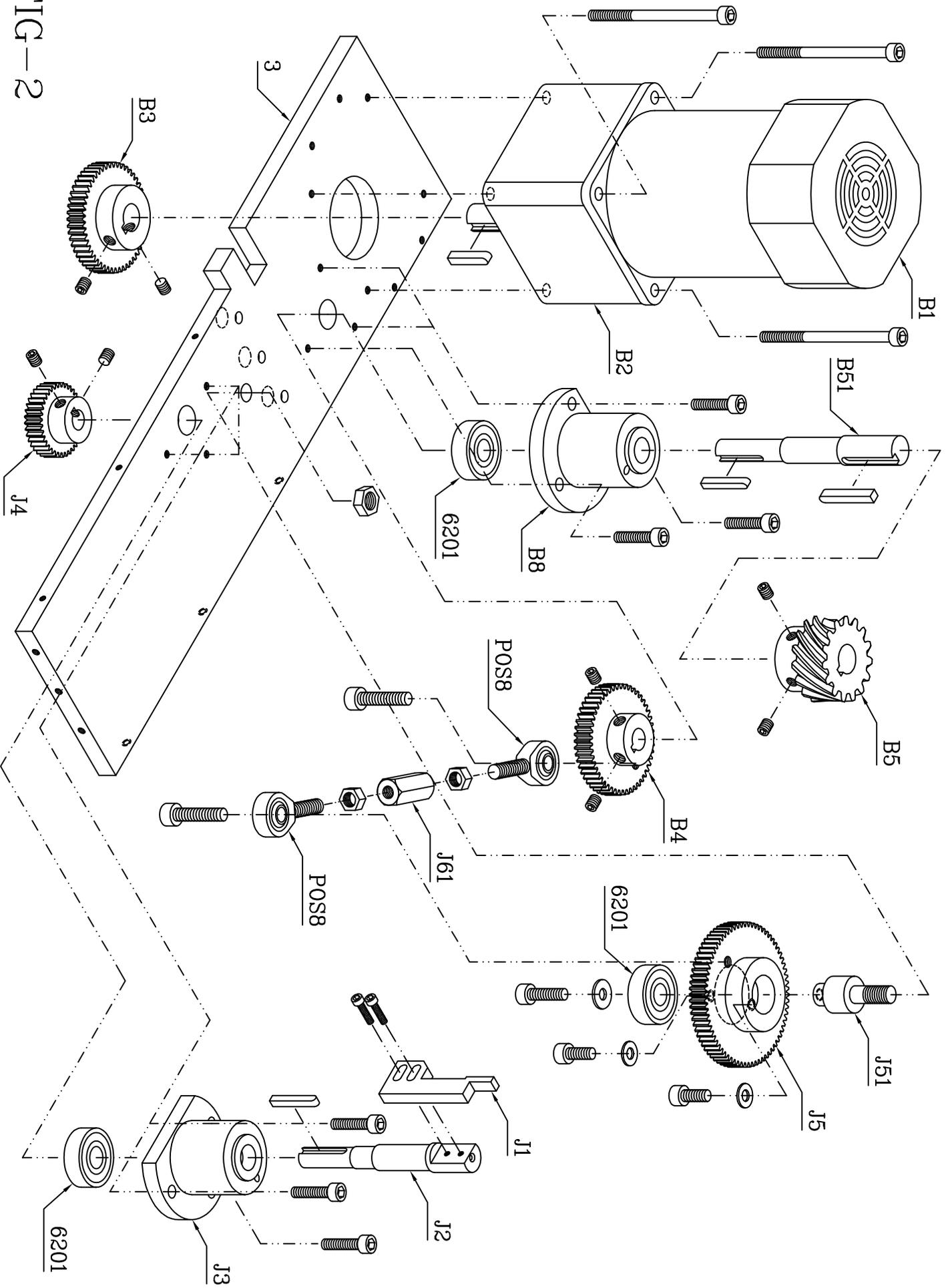


FIG-1

FIG-2



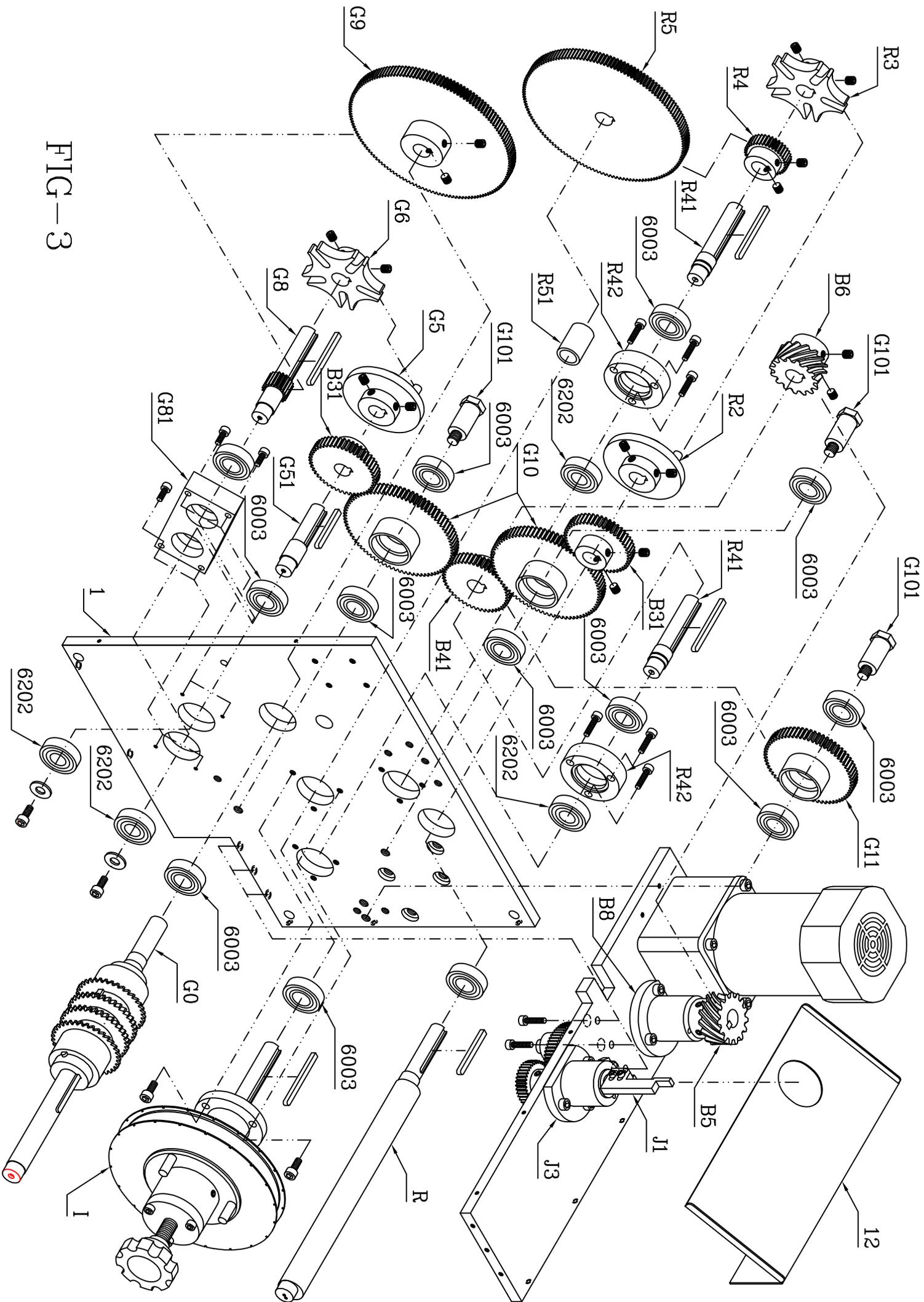


FIG-3

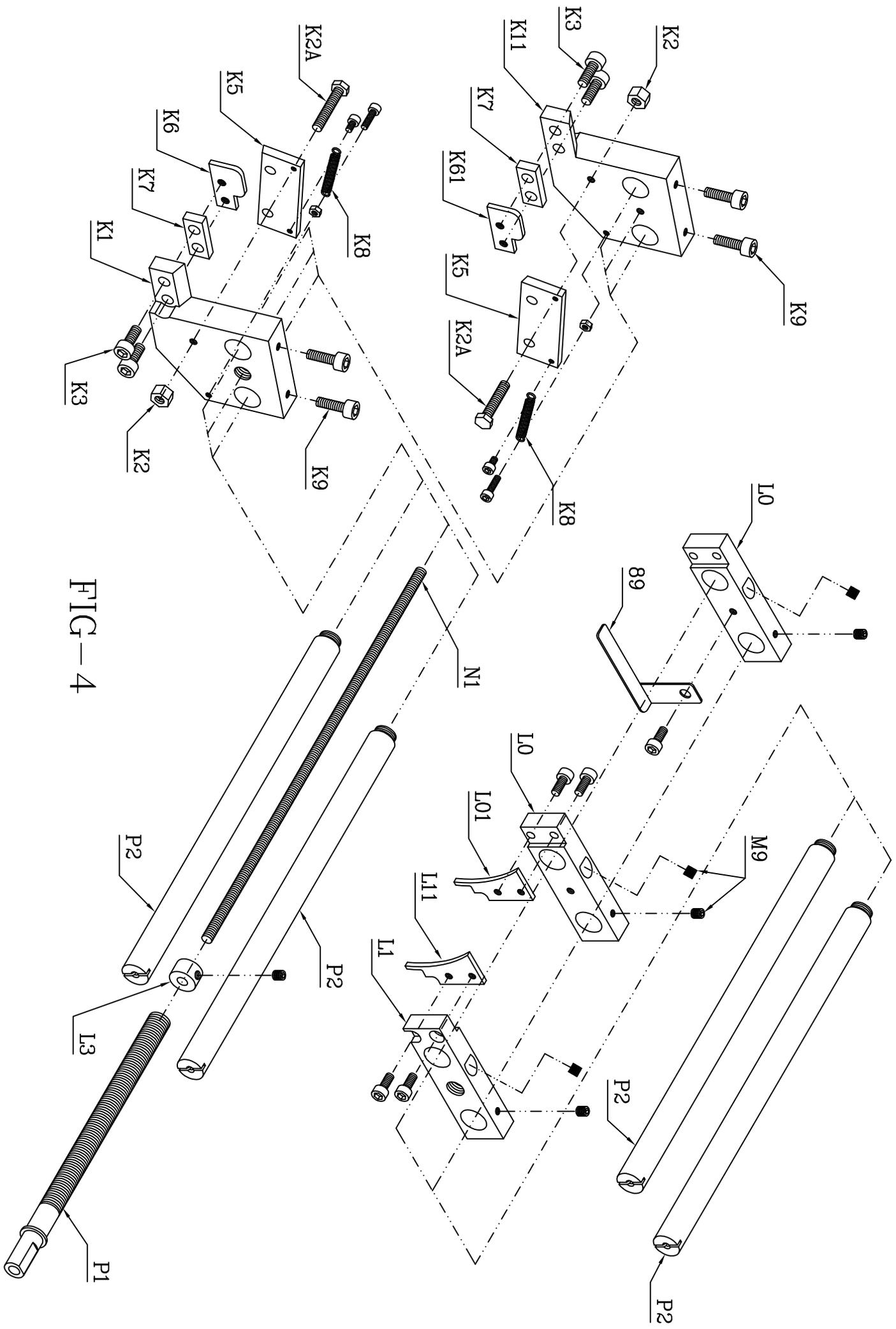


FIG-4

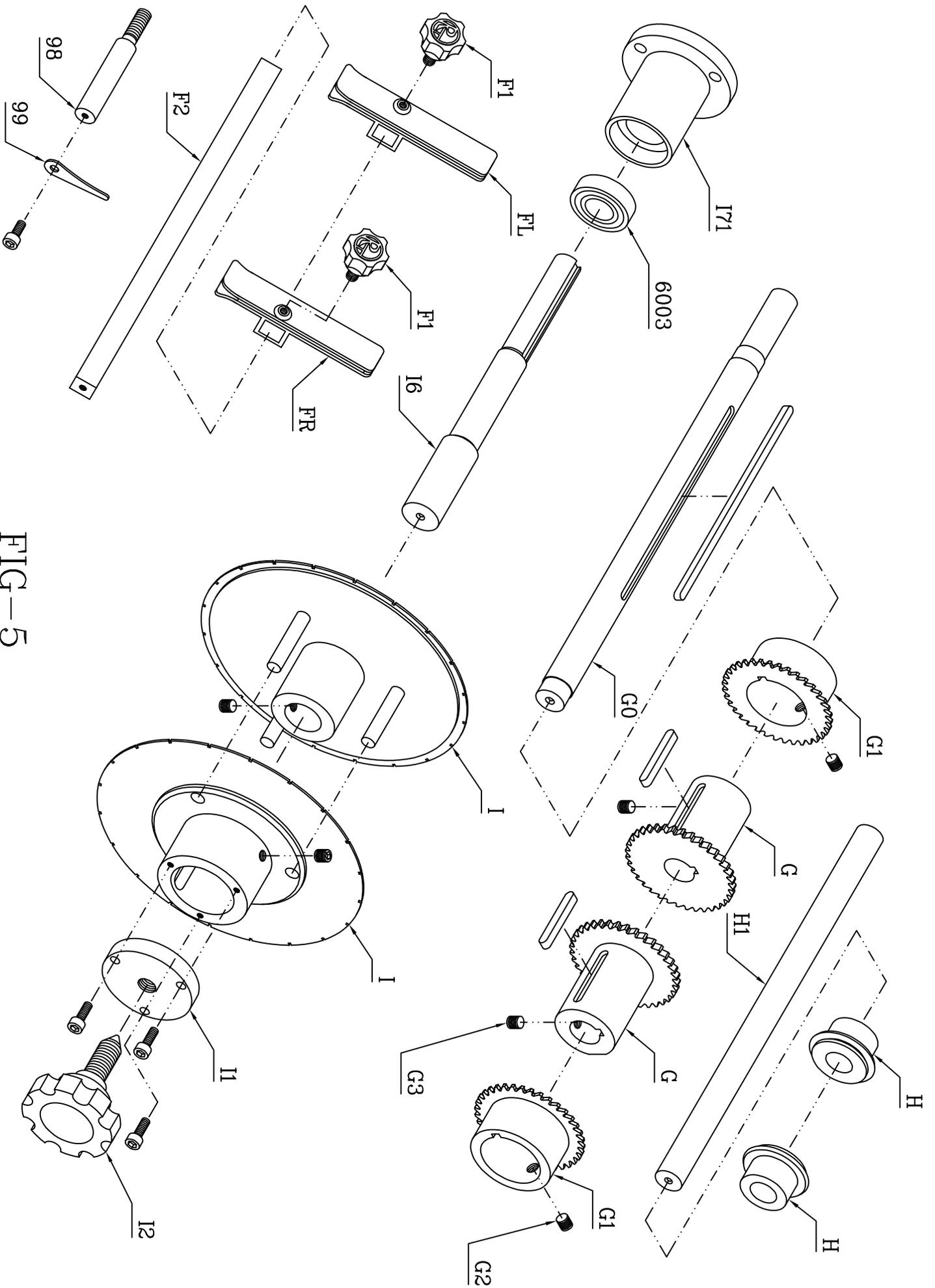


FIG-5

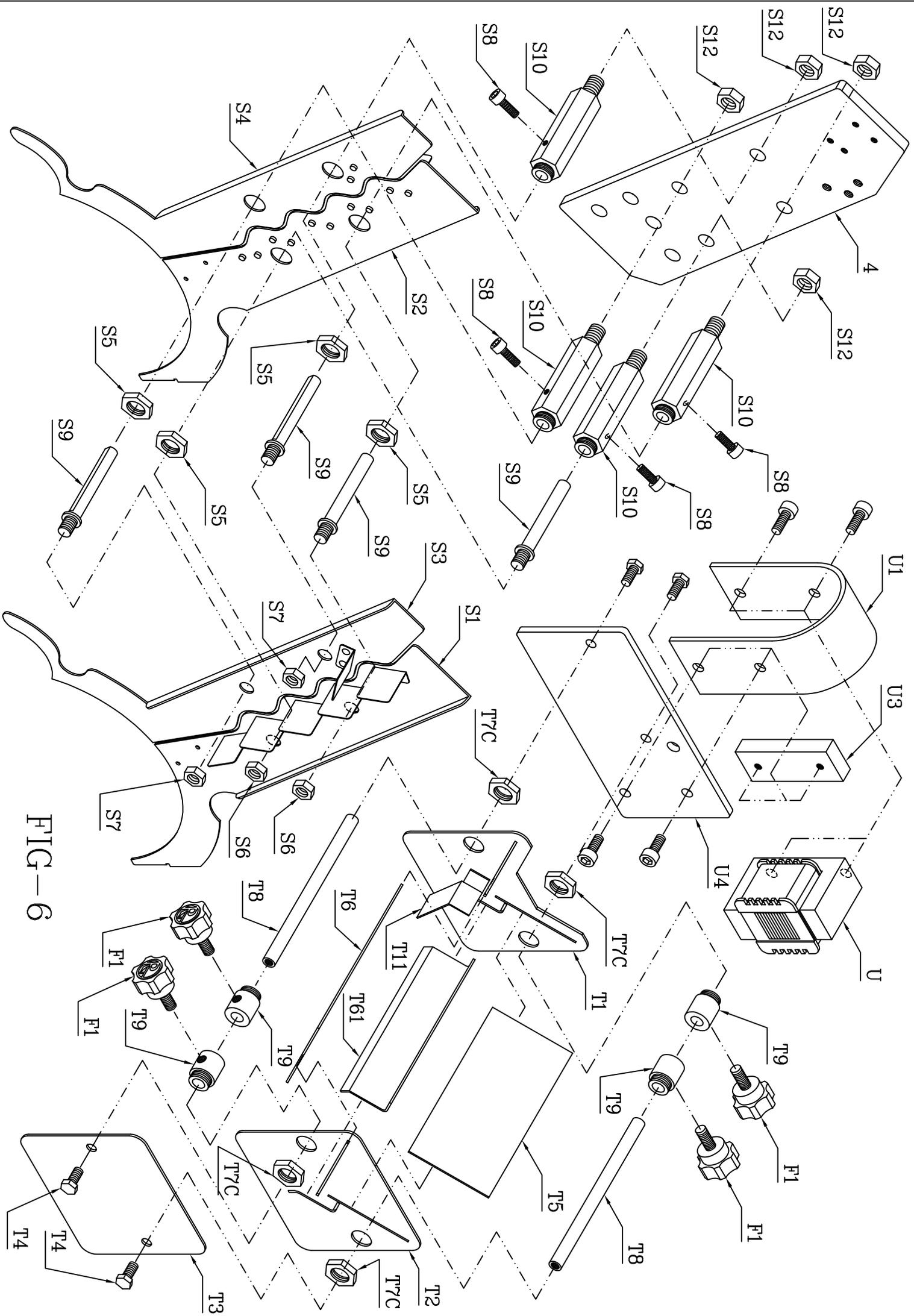


FIG-6

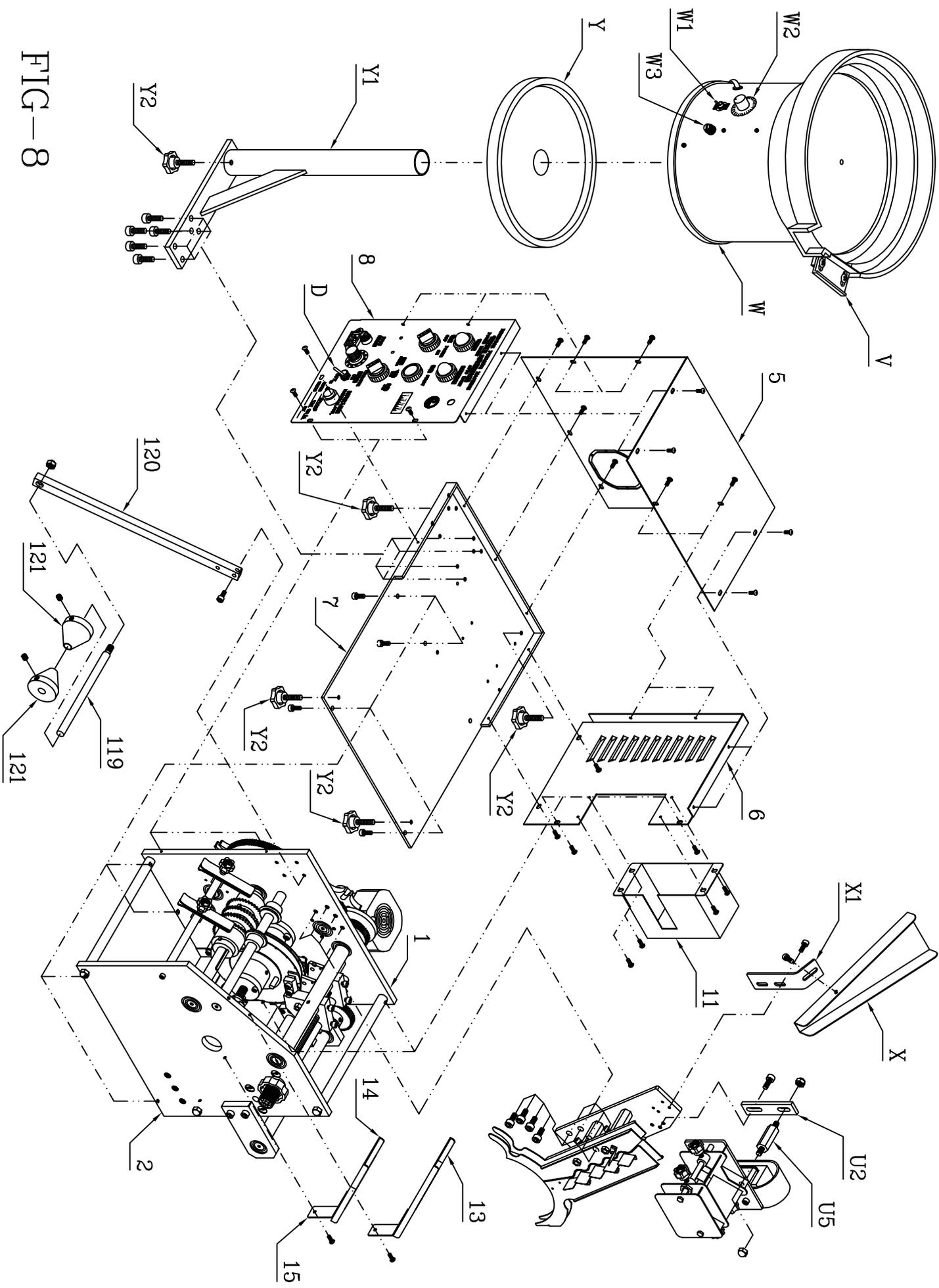
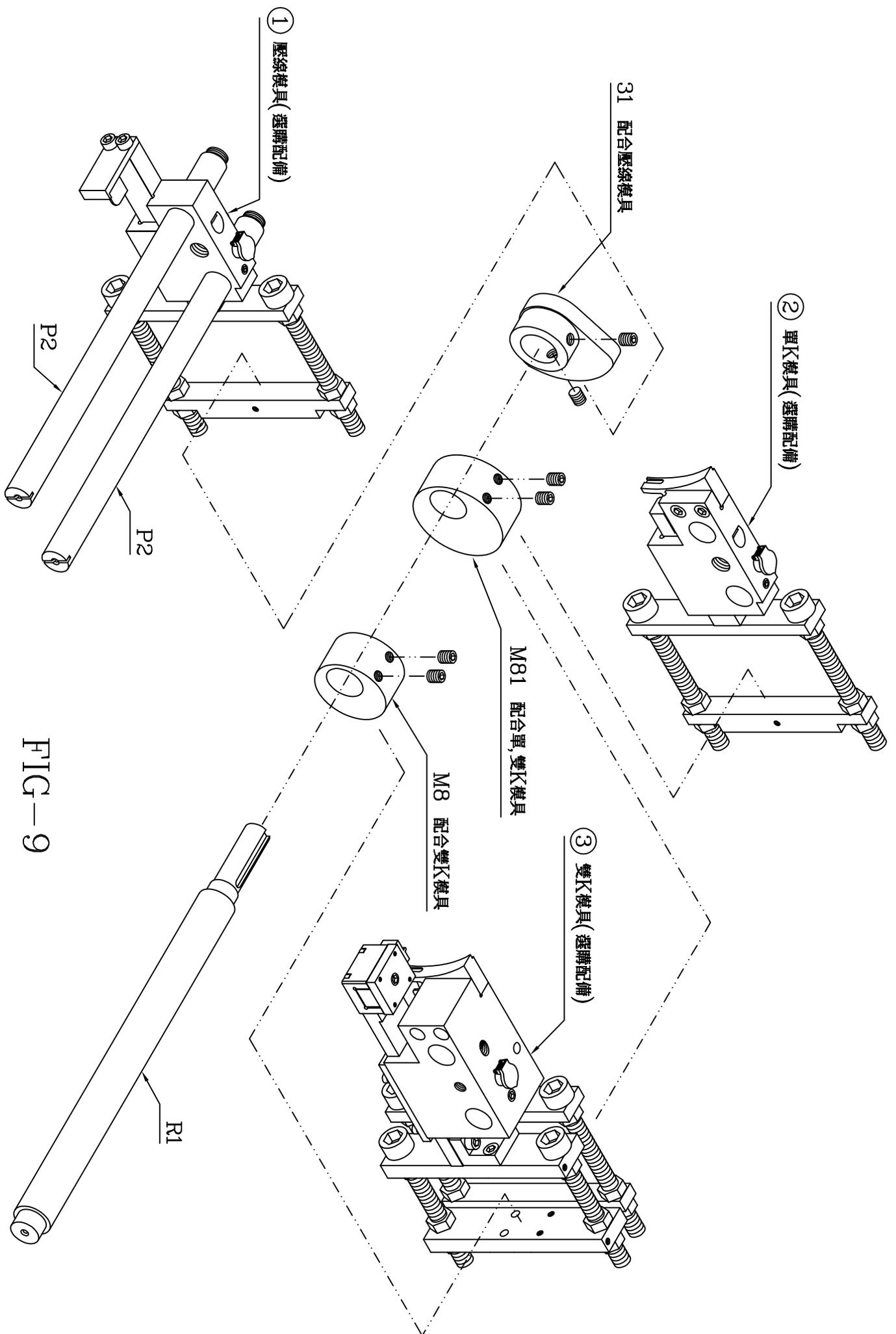


FIG-8



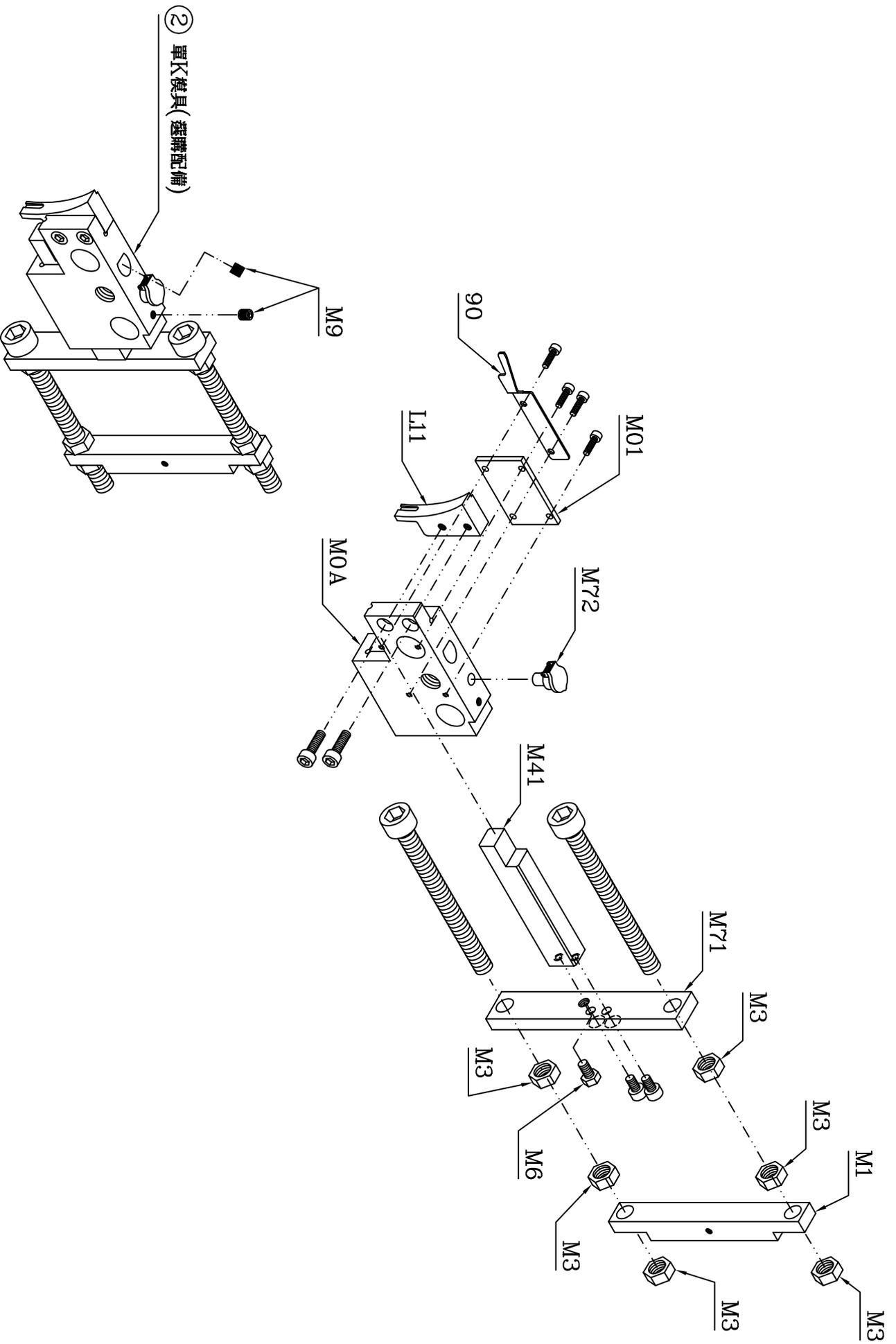


FIG-11

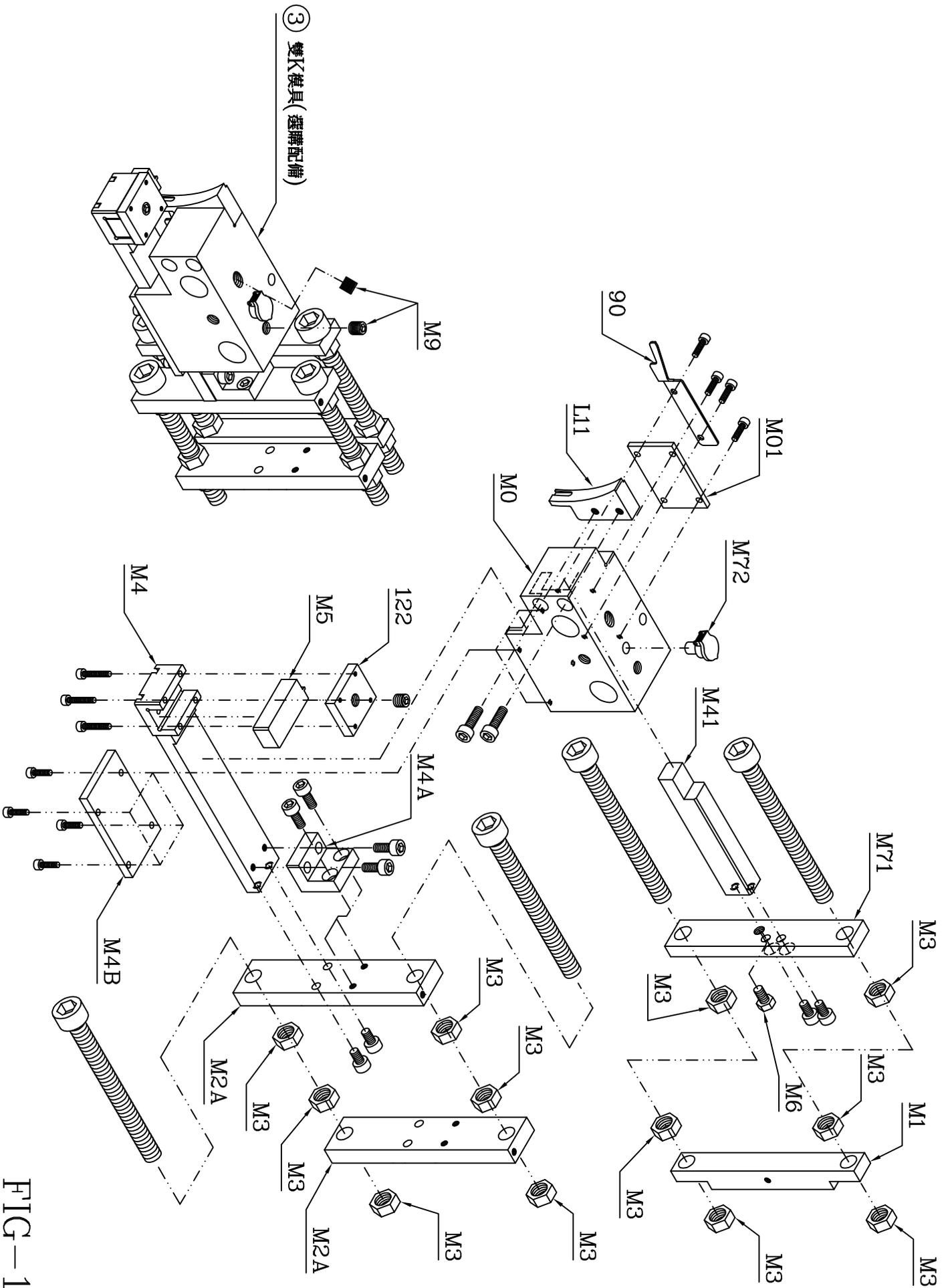


FIG-12