

HRFT-301F & RFT-201F Manual

• 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.

1. Main Body
2. Handle
3. Parts Bin
4. Tape Reel Holder Bar

• Setting Up Your Machine

Please setting up your machine as the below steps

1. Assemble the handle to the main body.
2. Put the unit along the side of the bench and fix it onto the bench.
3. Assemble the tape reel holder on the machine. There are two sets of holes on both sides of the base that you can choose to mount it.
4. Put the parts bin under the machine .Now it is ready for adjustment.

• Operation Procedure

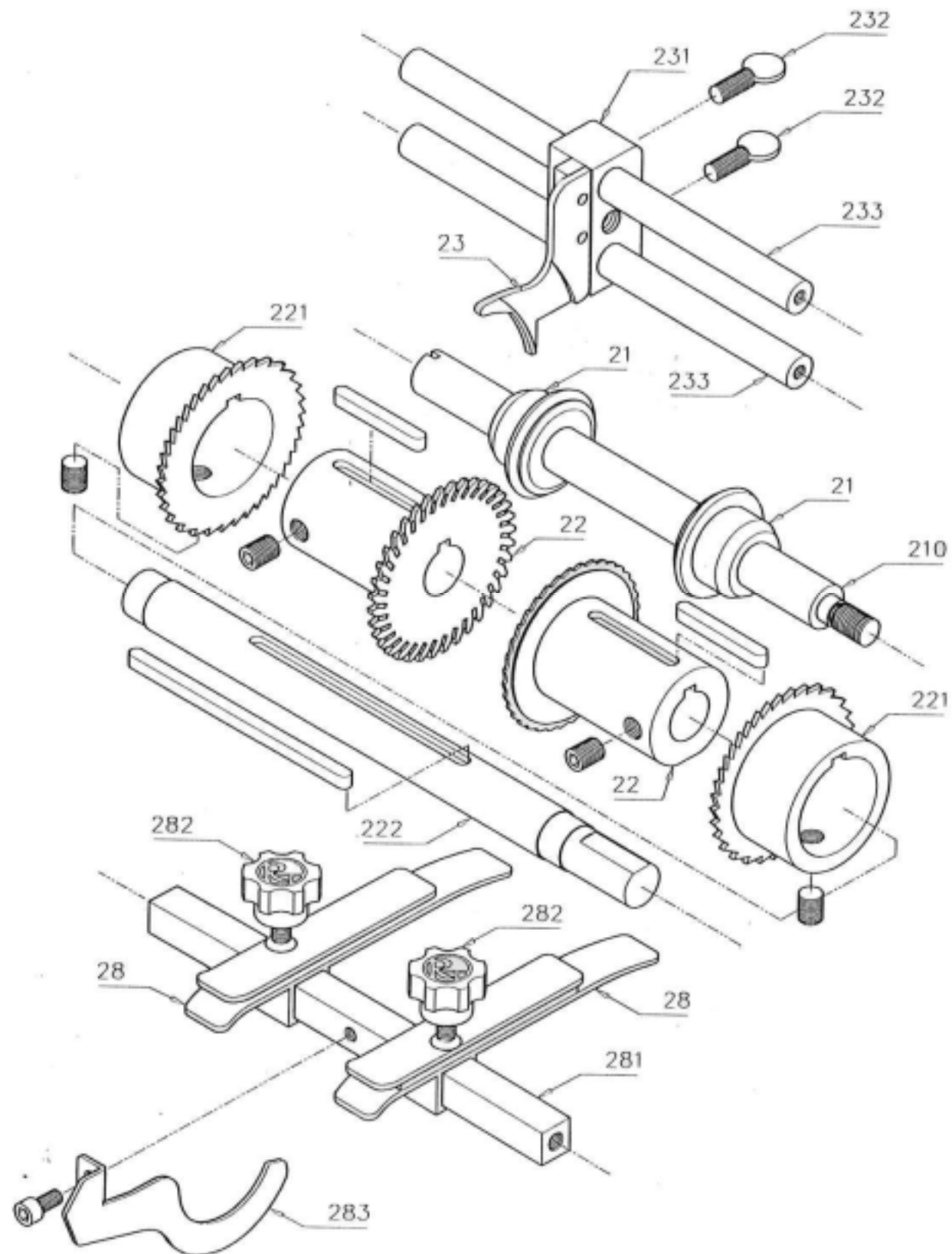
1. Sliding the taped components into the plastic Feeding guide (28). Please note to make it freely not too tight. Then engaging the lead of components to the forming wheel (22) and put the body to the right side of the forming wheel as illustrated in FIG-5.Cranking the handle to test the forming condition.
2. Adjusting the Pitch of the components. Release the fixed screws in the forming wheel (22), Adjusting the distance between the forming wheel (22) and Bending Plate (23) to the desired specification (Please don't forget to tight the screw released.)
3. Adjusting the length of the components. Release the fixing screws of the cutting Disc and adjusting the distance to meet the requirement (tighten the screw released)
4. Setting the Shoulder Height of the Components One (!) mm is a normal distance between the body of components to the forming wheel (22) More distance will get more height in the shoulder of the components. (Basing on the principle of no damage of the body.)

• Your Machine Is Ready For Running Now

- 301F Cranking the handle of the machine clockwise slowly. You will see some components that are cut and drop into the parts bin. Take some and check. Please re-adjust the machine according the procedure if failed to meet specification. Otherwise the machine is ready for mass production.
 - 201F Turning the speed regulator (162) to Zero(O) position before turn on the ON/OFF Power Switch (161).Then increasing the speed gradually when the power is ON until proper speed is reached. Take some of the parts formed and check the specification. Re-adjusting the data according to procedure listed or the machine is ready for mass production.
- If the cutting edge of the lead is not good as before after a long time operation or burr is found, please dismantle the cutting blade and re-sharpen it. Don't forget, your regular lubrication and maintenance. If any further service is needed. Please call our agent or contact us directly.

Spare Parts List 零件表

Parts No.	Description	品名
14	Parts Bin	成品盒
16	Side Wall(R)	右主機板
161	Power Switch	電源開關
162	Speed Regulator	調速器
163	Main Body	圓形本體
17	Side Wall (L)	左主機板
171	Bearing Ring, Main Shaft	主軸培林座
172	Base	腳座
21	Cutting Disc Assembly	切刀
210	Shaft, Cutting Disc	切刀軸
22	Forming Wheel	成型齒輪
221	Cutting Wheel Assembly	切斷齒輪
222	Main Shaft	主軸
23	Bending Plate	成型彎刀
231	Bending Plate Block	成型刀座
232	Screw, Bending Plate	彎刀固定螺絲
233	Shaft, Bending Plate	彎刀導桿
25	Frame	支架
26	Motor	馬達
26A	Handle	把手
260	Motor Gear	馬達齒輪
261	Main Shaft. Motor	馬達主軸
262	Frame, Motor	馬達支架
28	Feeding Guide	帶裝進料軌道
281	Square Bar	方型軸
282	Fix Screw, Feeding Guide	軌道固定螺絲
283	Component's Remove	退料器
29	Bar, Tape Reel Holder	料架桿
290	Roller, Tape Reel Holder	料架輪
291	Shaft, Tape Reel Holder	料架軸
292	Spring, Tape Reel Holder	彈簧
293	Knob, Tape Reel	料架固定螺帽



 **Ren Thang Co., Ltd.**

TEL: +886-2-82011187、22021205

FAX: +886-2-22039391、22021204

www.renthag.com

E-mail: renthag@renthag.com

