

RT-500 功率晶體成型機 操作使用說明書

關於 RT-500

RT-500 是台散裝零件成型及彎腳的多功能機器,尤其適用於功率晶體的成型及切腳。
爲了因應不同的需求，我們提供了各種供料器及許多尺寸的模具。

用途:

RT-500 用於管裝功率晶體零件的成型與切腳。若需進一步擴充機器的功能，也可訂製模具及加裝自動送料盤處理散裝零件。

功能:

一小時約達 6,000 顆(視零件及模具的情況而定)
成型速度可無段式調整
以微動開關偵測軌道中零件的有無並啓動自動模式.
可選購光電計數器
功率:150 瓦特
尺寸:約 300X450X300

安全事項:

惟有專業技術人員才能對機器進行服務及保養的工作。機器的處理和應用只能依操作說明書上的方式使用。任何不根據指示的用途，若因不當使用造成傷害，製造商將不負任何責任。

交貨狀況:

已完成測試的機器。
安全穩固的包裝。
基本配備:電源線。
機器操作手冊。
選購的配件:模具及進料導軌。

安裝:

安裝地點
機器需放置和平穩的地面及穩固的桌面。請注意工作區是否有良好照明設備。
安裝程序
小心地將機器取出，並放至在預定好的工作地點。插上電源線(注意是否在適當電壓的插座上)準備啓動機器。



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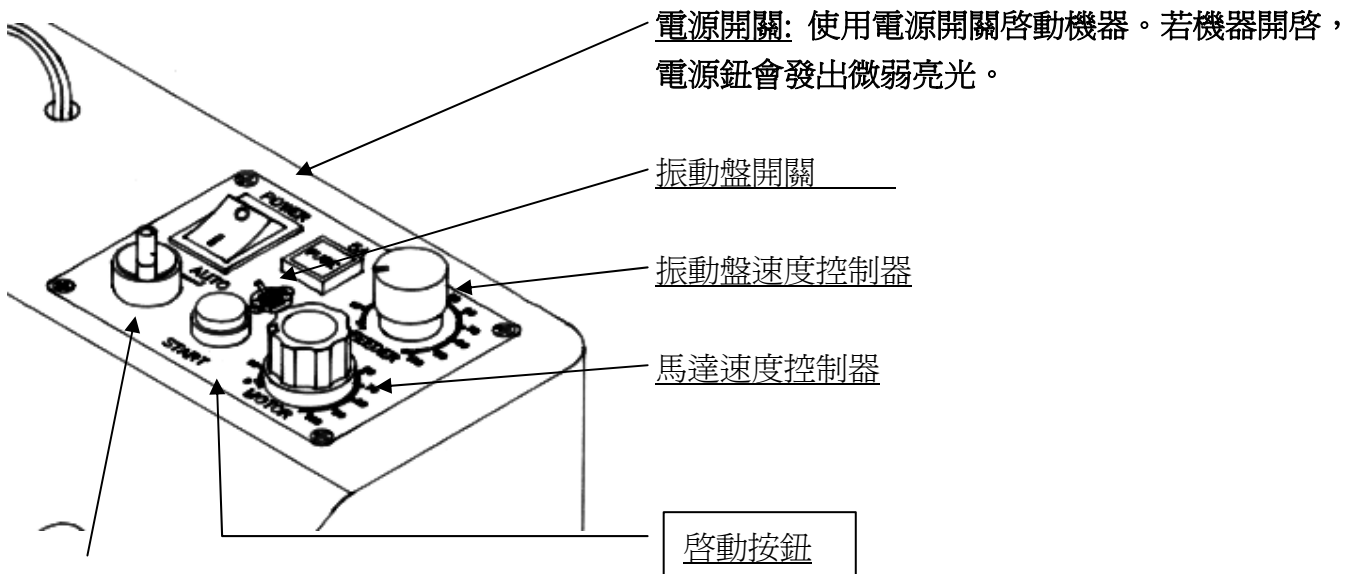
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操作:

RT-500 功率晶體成型機非常容易使用操作。一個清楚、容易判別的面板，加上少量且明白的定義與描述各開關，可簡化機器的操作程序。這可使機器有效率地運作及減少操作失誤。



模式選擇:

階段位置:惟有按著啟動鈕，機器才會運作。

自動位置:惟有此鈕被設定在此模式時，機器才會自動運轉。

注意:

- 當組裝完成，只能用極低的速度運作。
- 當機器運轉時，不要去碰觸模具。
- 若保護蓋被移開，機器會自動地停止運轉。
- 在自動模式下重新開啓機器，請按重新設定鈕。

模具:

將依據顧客提供的成型規格及樣品製作模具及提供進料導軌。

散裝零件可以依據零件的外型,種類來選擇管狀進料或再加裝振動送料盤進料。然後，零件會隨著它的重量向下滑動進入模具中成型。

注意:

❖ 不可將速度調得太高。因零件須有足夠的時間落在適當位置。

管裝零件的進料導軌:

不同的管裝零件需要不同進料導軌，使零件能排列整齊地進入機器軌道中。若是一般的管狀零件，

例如:TO-220、TO-126 或 TOP-3，我們提供標準型進料導軌。至於特殊零件的進料導軌則依據客戶的要求製作。

管裝零件的進料操作:

移開管裝零件包裝上的蓋子及栓子(注意對準模具方向)然後把管裝零件以出口向上的方向裝入進料軌道中，然後提起管子的上部，直到磁性吸簧將管子定位。

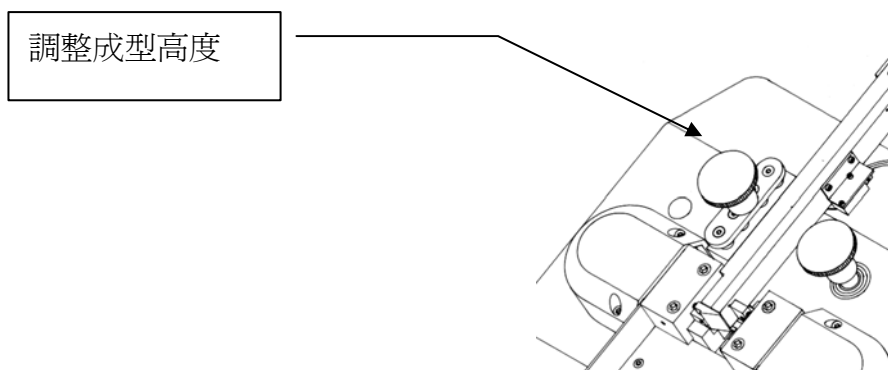
調整速度並選定操作模式後，機器即可開始啓動並成型零件。

注意:

- ✧ 爲了避免零件發生不能控制之情形；當在換新管時，請注意進料軌道需留有零件不能是空的，如有需要，換管時請降低機器速度。如果進料軌道中已經完全沒有零件，在換新管前，請先停止機器讓進料導軌中有零件後再啓動。
- ✧ 新機型以微動開關偵測零件的存在，在自動模式下自動會停止機器，如需成型進料軌道內的零件需使用階段模式，按住啓動鈕成型零件。

安裝供料器:

從 L 型架子角落的上方安裝供料器。然後，旋轉螺絲以調整高度。



注意:

- ✧ 小心！不可使供料器碰到模具。用標準尺測量出適當的距離。

保養與維護:

潤滑

因機器有持續的潤滑作用，所以不需上潤滑油。

清潔

請使用溫和、易溶解的清潔劑。

維修

若沒有任何異議，只能經由製造商修理機器。若是由未經授權的廠商修繕機器，製造商將不負任何責任。

User's manual –

RT-500 Automatic Power Transistor Forming Machine

Description

The RT-500 is a multi-purpose component performing machine for cutting and bending of loose radial Components especially for the power transistors. Due to the different requirements, different feeders and many standards are available.

Application

With the RT-500 it is possible to form and cut loose radial power transistor in sticks. The customized tooling will be available upon request to extend the function of the machine.

Performance

Up to 6,000 comp / hour (depends on component and tooling)

Continuously adjustable speed control

Step-switch

Auto-sensing the components in the rails

Optional: programmable counter

Power consumption: 150 watt

Dimensions: approx 300x450x300mm

Security hints

Service and maintenance of the machine only by skilled personnel

Handling and application of the machine only corresponding this operation manual

No liability of the manufacturer for damages or injuries caused by inexperienced handling or using the machine against its purpose.

Observe security precautions during handling.

Delivery Conditions

Machine function-tested

Content of delivery

Basic machine with power cord

Instruction manual

Optional: tooling and feeder

Put up

Place of put up

The machine shall be put up on a sufficient stable and rank-solid table.

Pay attention to good illumination of the working area.

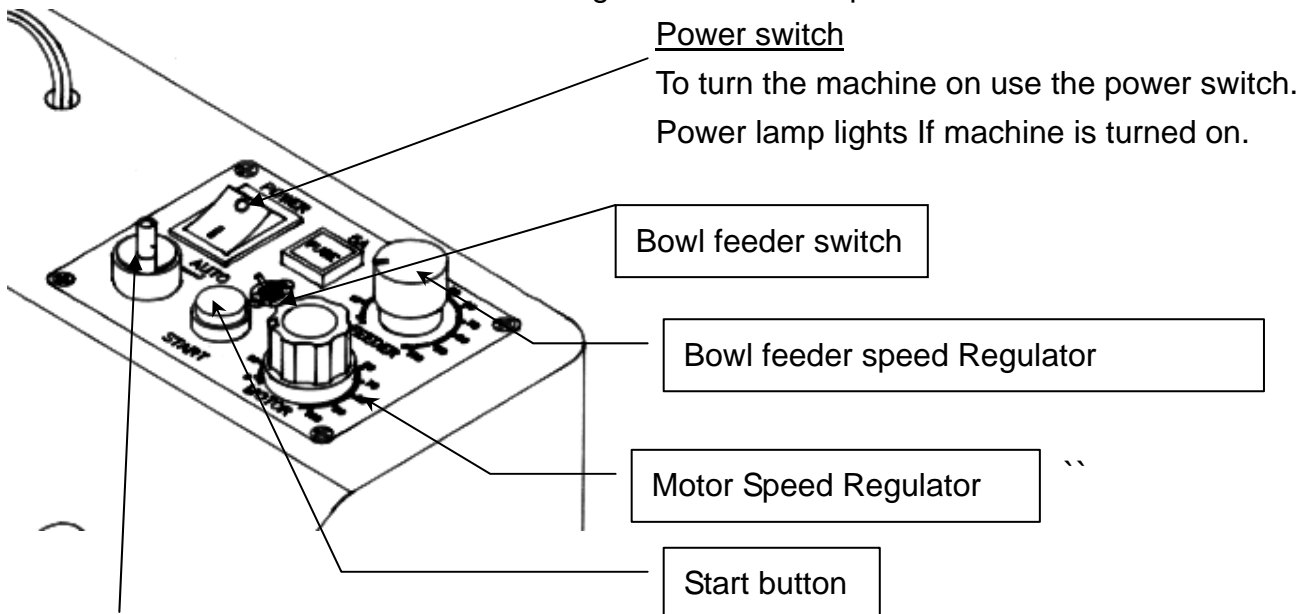
Procedure

Unpack the machine carefully and put it up at the planned working place. Insert power cord (pay attention to correct power supply). Machine is ready to operation now.

Operation

General

The RT-500 Power transistor forming machine is very simple to operate. A clear easy to survey display, few , plainly defined and described switches simplify the operation of the machine. This enables an efficient working and minimizes operation mistakes.



Mode selector:

Step position: The machine will be moved only when the start button is activated

Auto. Position: the machine will run automatically when the parts are sensed in the rail.

Attention: When set up the machine use only very low speed, do not touch the tooling when machine is running! If safety cover is put away, the machine automatically stops.

To reactivate the machine in automatic mode please operates the reset switch.

Tooling

The customized dies will be made corresponding to customer-drawings and preformed sample.

Feeder for loose components

The Loose components can be fed either by stick (tube) or by special bowl feeder that designed according to the component's shape and type. The components, by their own weight will slide downwards.

ATTENTION! Do not adjust the speed too high! The components should have enough time to fall in the right position.

Feeder for components in sticks

To process components directly out of the stick (tube) different feeders for different stick shapes are available. To feed components in TO 220, TO 126 or TOP 3 packaging which is delivered in common sticks, standard feeders are available. Customized feeders upon request.

Process components out of sticks

Remove the locking pin of the stick on the right side (take care for right position of the component to the tooling) and putting on the stick on the feeder in mouse up direction. Then move upward the stick (tube). A magnetic will attached the stick. Adjust the speed. Start automatic made.

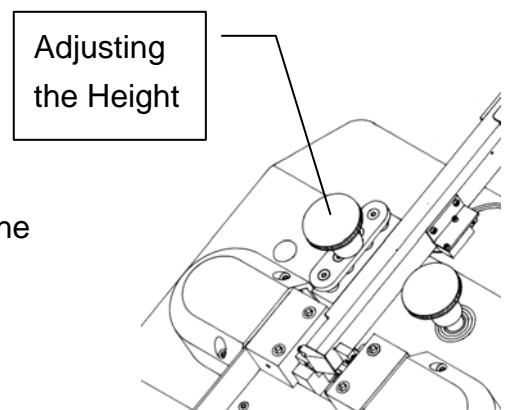
Components will be preformed.

ATTENTION! To avoid an uncontrolled situation of the components, take care for a filled feeder when changing the stick. The feeder must not be empty when placing a new stick on the feeder. Reduce the speed if necessary. If the feeder becomes empty stop the machine before placing a new stick.

Set up

Feeder

Place the feeder from above in the angle bracket. Adjust the height and fix the screws.



ATTENTION! Take care that the feeder does not touch the tooling, Test by using the int. mode to check for correct installation.

Maintenance

Lubrication

No lubrication necessary, because duration-lubrication.

Cleanings

Use only mild and solvent free cleansers.

Repairs

If there are no other agreements, repairs might be executed only by the manufacturer.

No liability of the manufacturer if repairs are done by unauthorized persons.

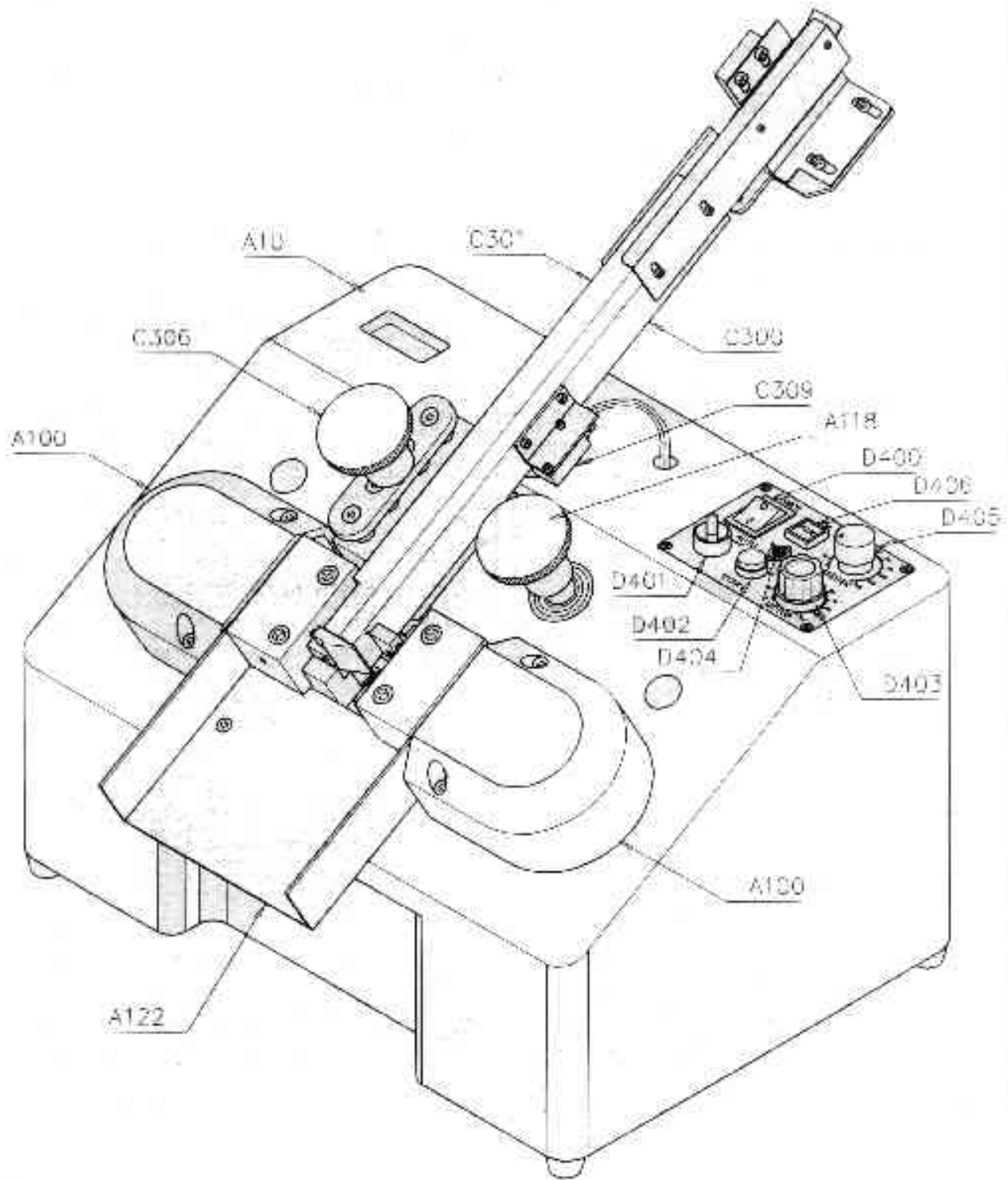


RT-500 零件表

零件編號	零件名稱	零件編號	零件名稱
A10	台身	B214	培林 634ZZ
A100	凸輪蓋	B215	模具彈簧
A101	台柱	B216	壓線彈簧
A102	凸輪軸	B217	擋料推軸
A103	手轉軸	B218	擋料拉片
A104	內板	B219	右擋片
A105	皮帶齒輪	B220	左擋片
A106	馬達齒輪	B221	擋料彈簧
A107	惰輪	B222	優力膠
A108	傳動皮帶		
A109	馬達皮帶	C300	右軌道
A110	培林座	C301	左軌道
A111	培林 6202ZZ	C302	滑軌軸
A112	培林 608ZZ	C303	滑軌座
A113	C 型扣環	C304	下滑軌座
A114	雙圓平鍵	C305	滑軌固定片
A115	單圓平鍵	C306	調整鈕
A116	馬達	C307	昇降螺絲
A117	培林 6003ZZ	C308	微動開關固定片
A118	手轉輪	C309	微動開關
A119	凸輪	C310	磁鐵架板
A120	培林 6009ZZ	C311	磁鐵
A121	培林 623ZZ	C312	插管座底板
A122	成品滑槽	C313	右護片
		C314	左護片
B200	模具座	C315	上壓片
B201	模具蓋	C316	上壓片座
B202	右切刀推軸	C317	導軌架板
B203	左切刀推軸	C318	底部蓋板
B204	切刀		
B205	右成型推軸	D400	電源開關
B206	左成型推軸	D401	模式選擇開關
B207	右模具	D402	啓動按鈕
B208	左模具	D403	馬達速度控制器
B209	右陽刀	D404	振動盤開關
B210	左陽刀	D405	振動盤速度控制器
B211	壓塊	D406	保險絲座
B212	陽刀蓋		
B213	成型推軸培林座		

RT-500 Spare Part List

Part NO.	Part name	Part NO.	Part name
A10	Main housing frame	B214	Bearing 634ZZ
A100	Cam-Cover	B215	Spring-mold
A101	Frame	B216	Stick hold spring
A102	Camshaft	B217	Fender-shaft
A103	Hands-turning shaft	B218	Fender-plate
A104	Inside plate	B219	Fender-right
A105	Tooth belt	B220	Fender-left
A106	Gear-motor	B221	Spring
A107	Eccentric wheel	B222	Part-plastic
A108	Belt-power transmission		
A109	Belt-motor	C300	Track-right
A110	Bearing base	C301	Track-left
A111	Bearing 6202ZZ	C302	Chute shaft
A112	Bearing 608ZZ	C303	Chute base
A113	C-ouch	C304	Down chute base
A114	Flat key	C305	Plate-chute
A115	Flat key-single arc	C306	Adjustment knob
A116	Motor	C307	Elevating screw
A117	Bearing 6003ZZ	C308	Plate-micro switch
A118	Hand-turning wheel	C309	Micro switch
A119	Cam	C310	Magnet-support bracket
A120	Bearing 6009ZZ	C311	Magnet
A121	Bearing 623ZZ	C312	Holding-plate
A122	Products runner	C313	Guide plate-right
		C314	Guide plate-left
B200	Mold base	C315	Material inlet pressing plate
B201	Cover of mold	C316	Inlet pressing plate base
B202	Knife shaft-right	C317	Track support bracket
B203	Knife shaft-left	C318	Base
B204	Cutter		
B205	Forming shaft-right	D400	Power switch
B206	Forming shaft-left	D401	Function switch
B207	Mold set-right	D402	Start regulator
B208	Mold set-left	D403	Motor speed
B209	Blade-right	D404	Vibrator on/off switch
B210	Blade-left	D405	Variable speed control knob
B211	press-cake	D406	Fuse
B212	Cover blade		
B213	Forming shaft bearing base		



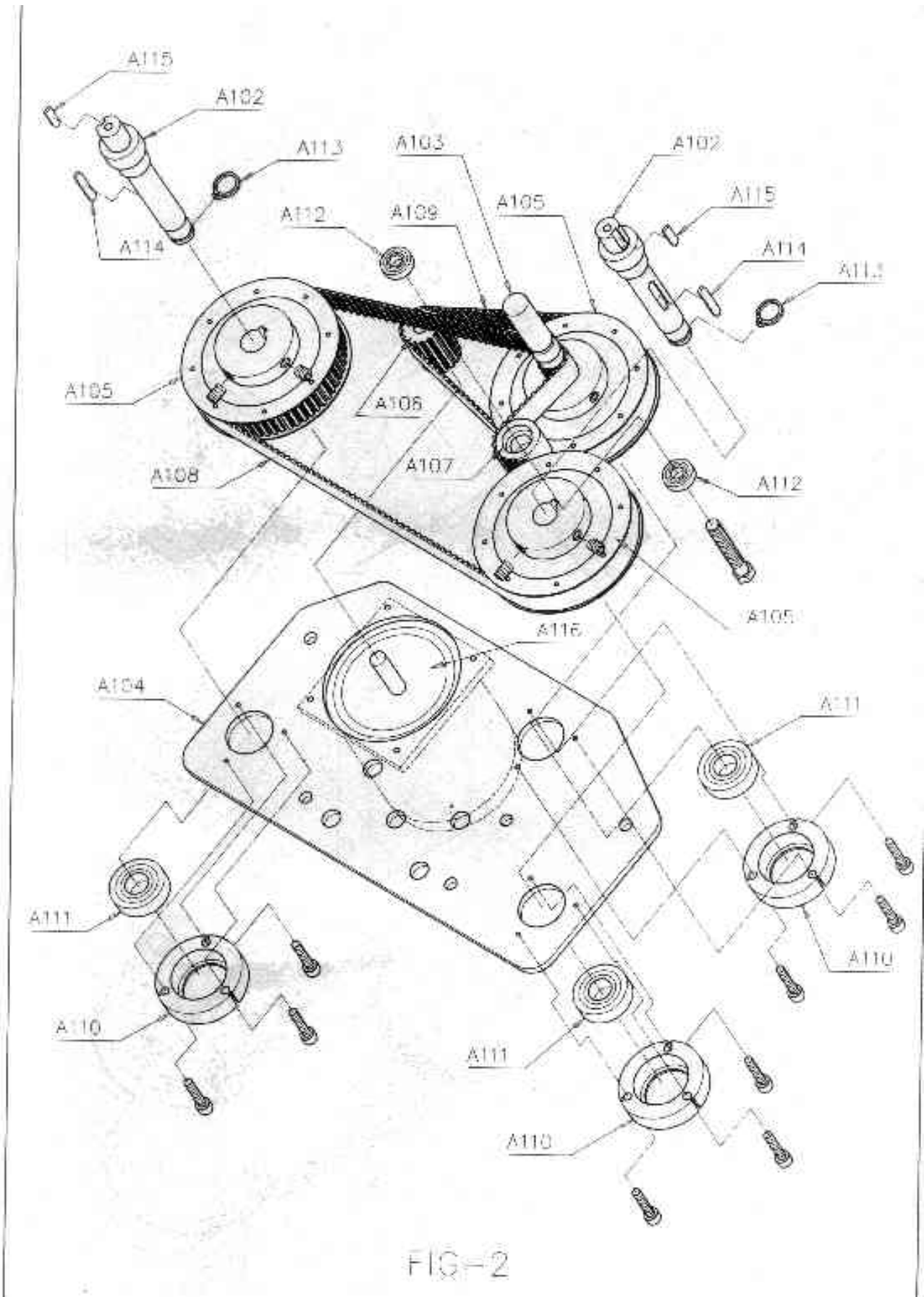


FIG-2

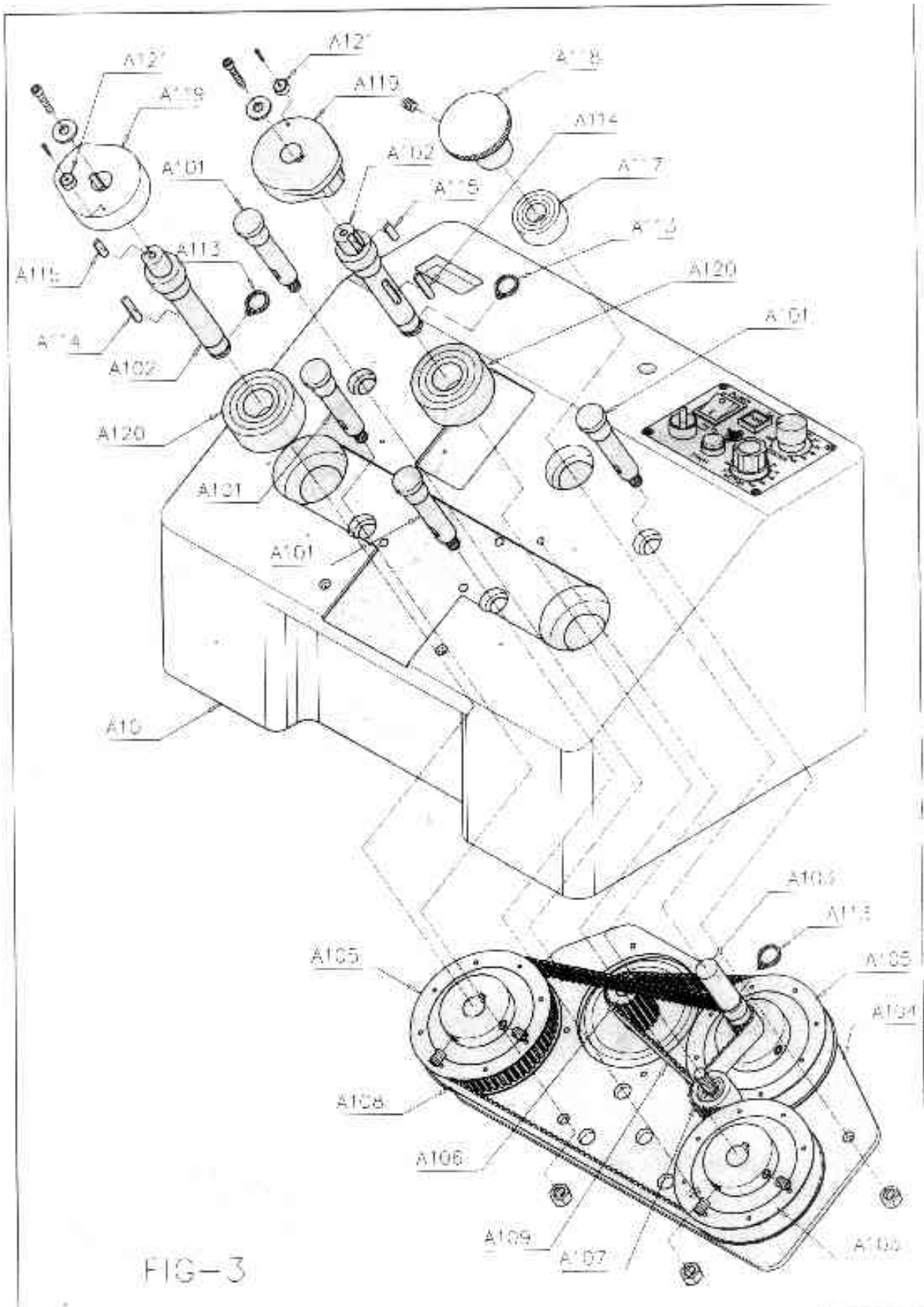
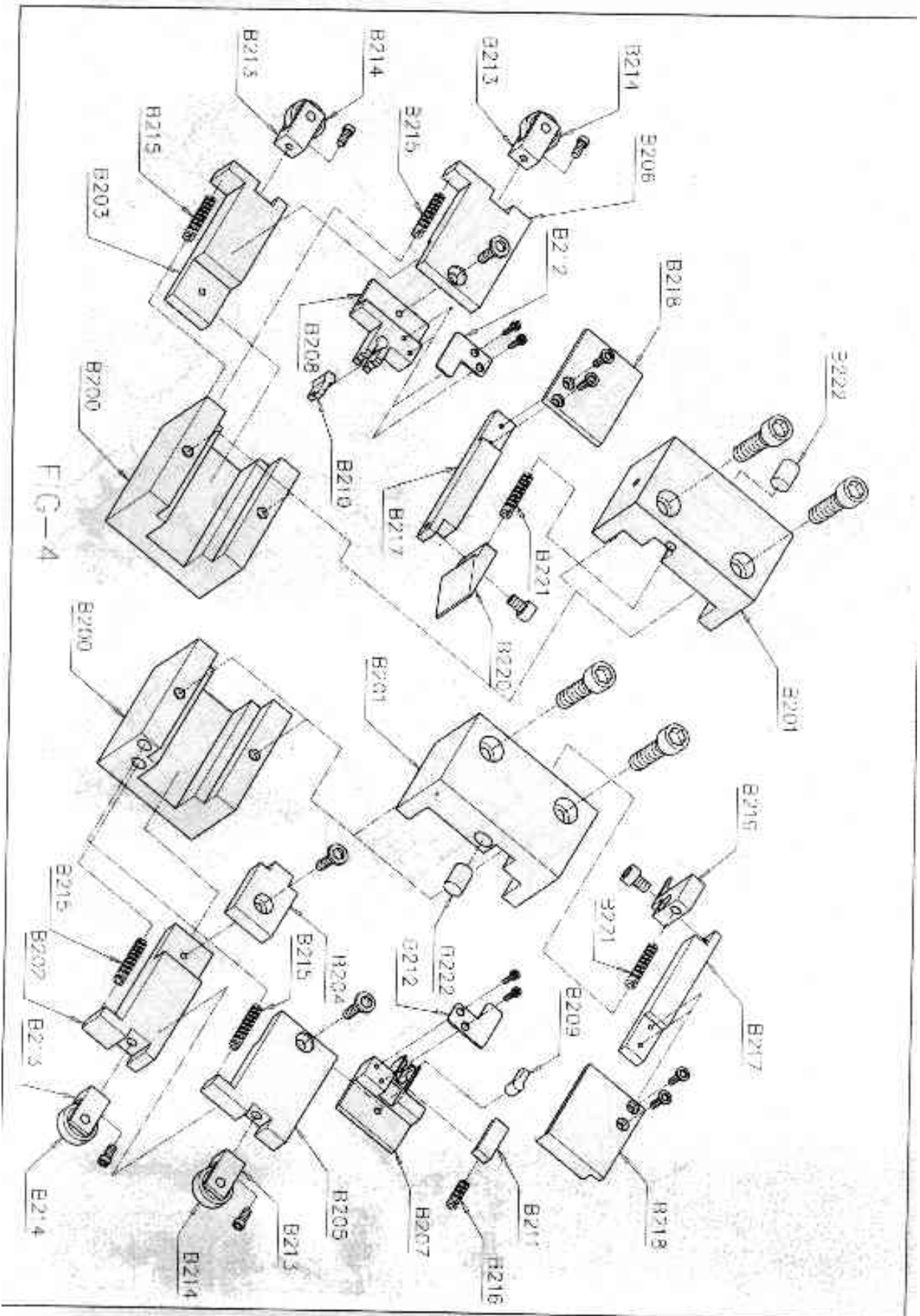


FIG-3



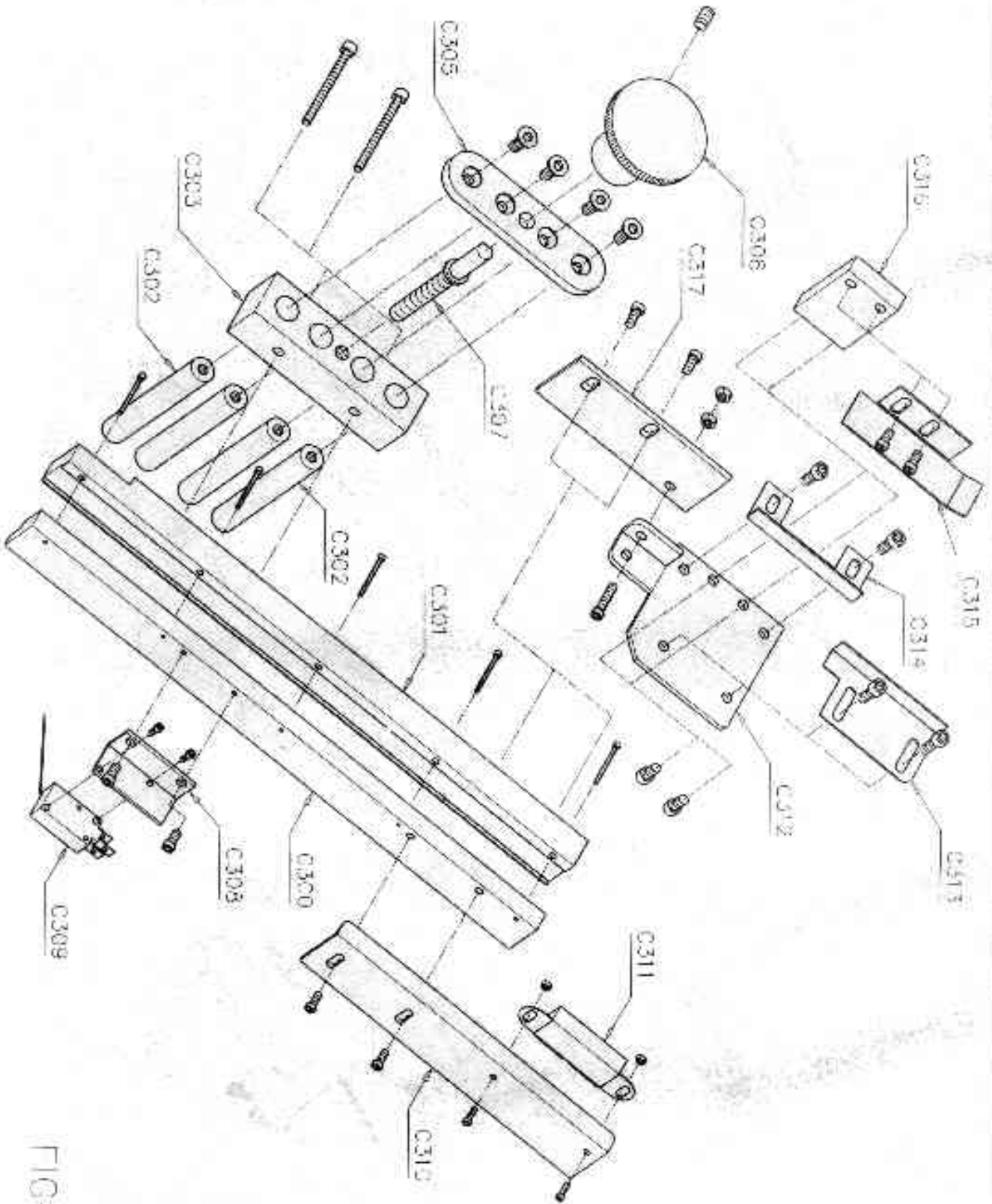


FIG-5

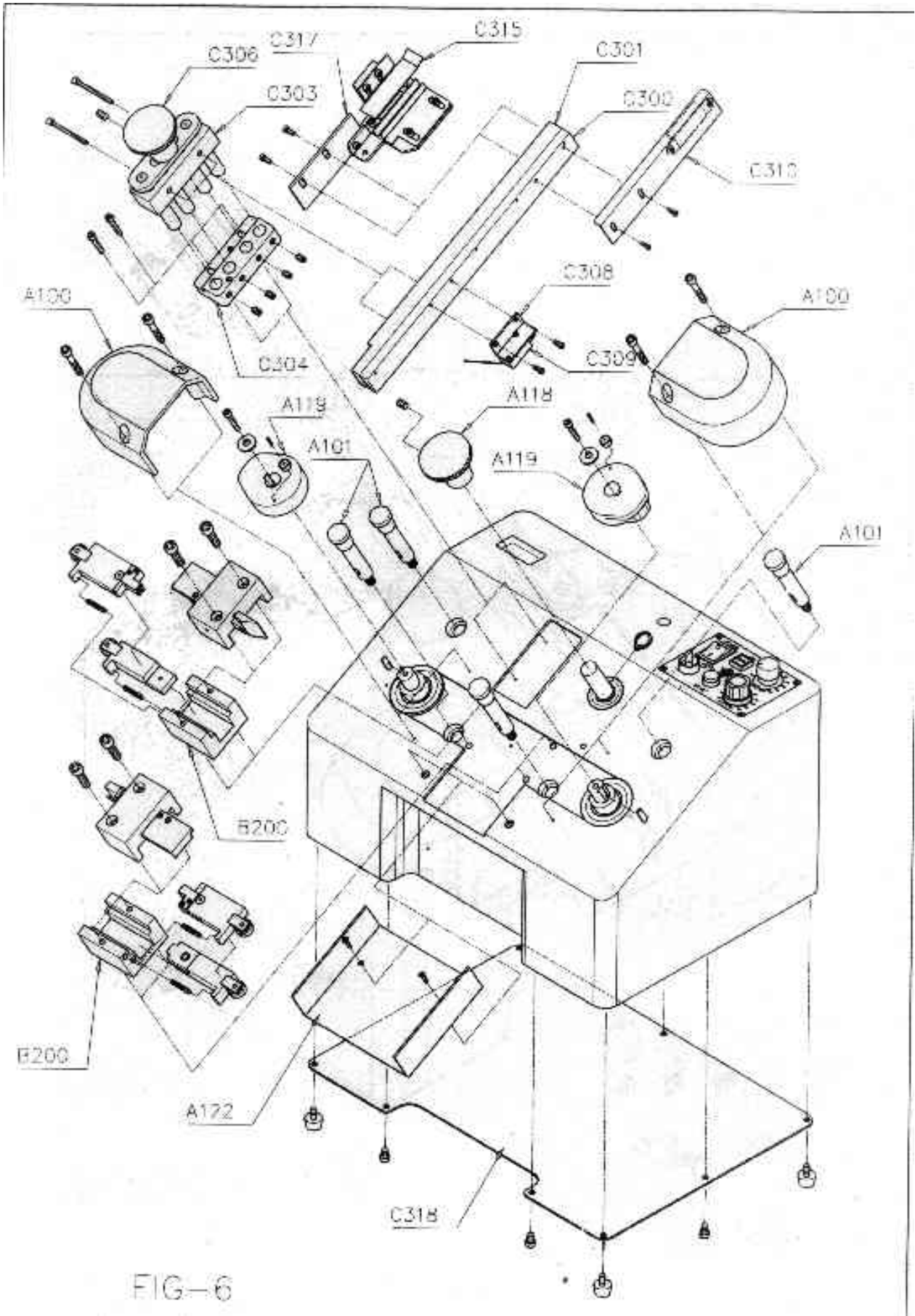


FIG-6

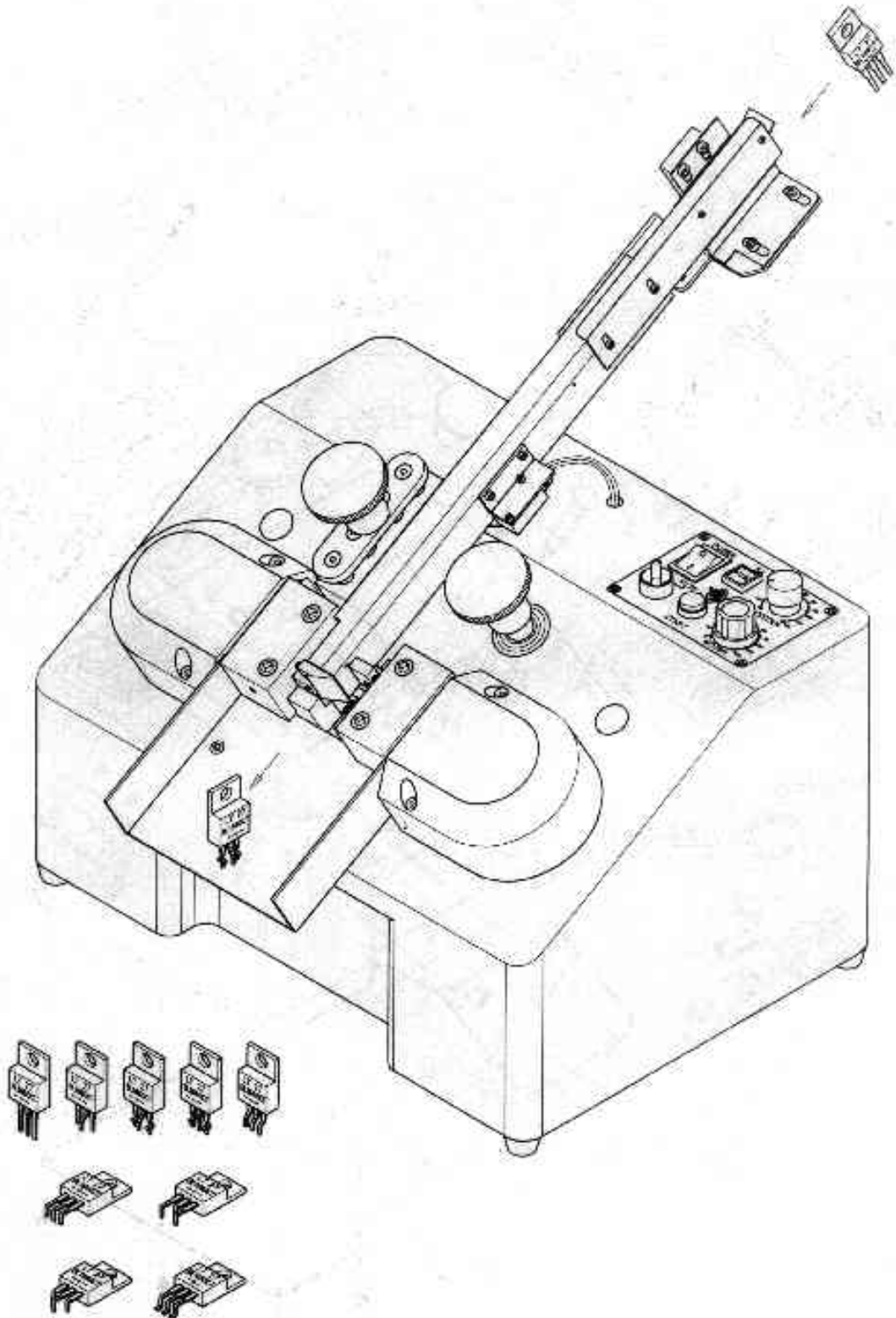


FIG-7

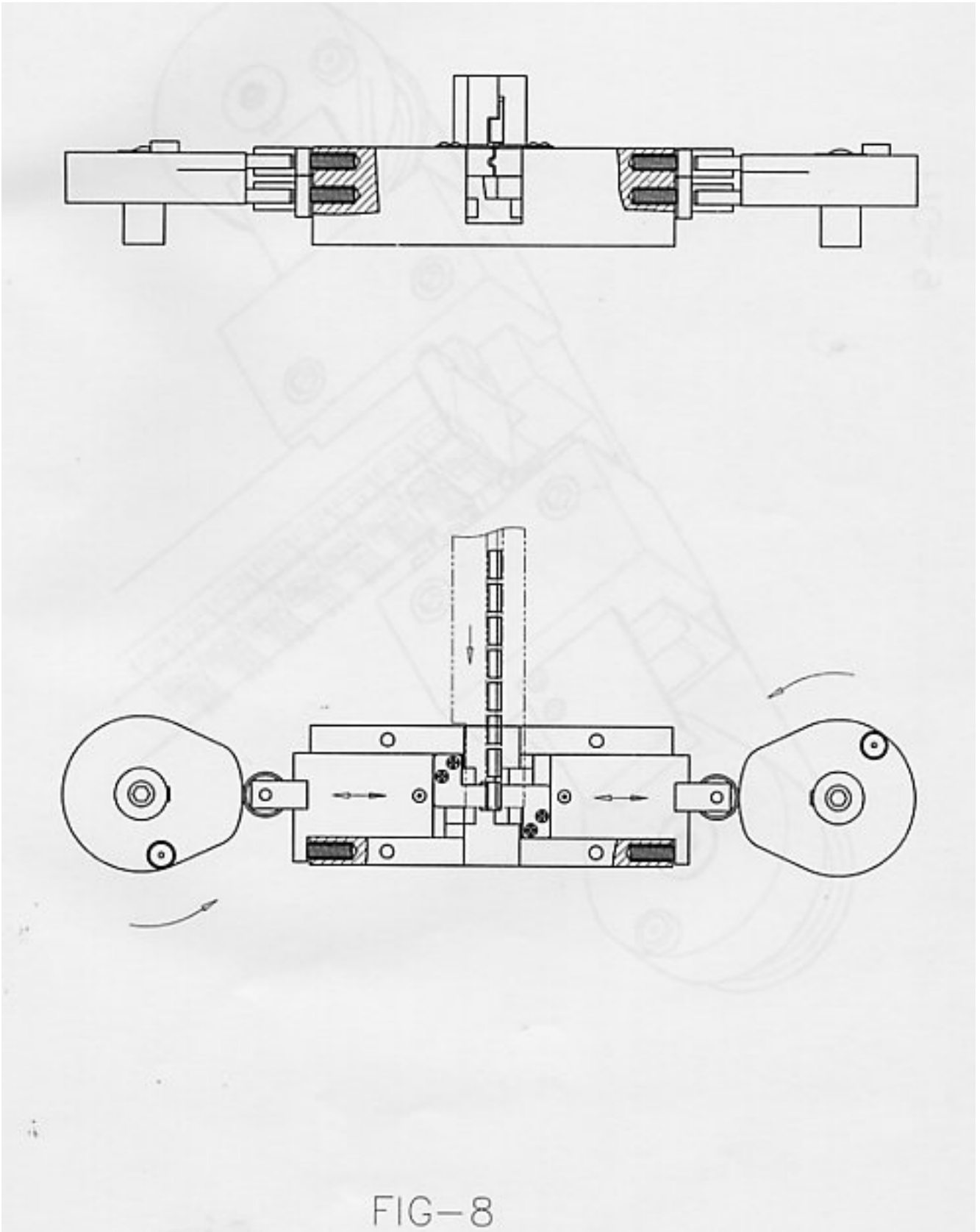
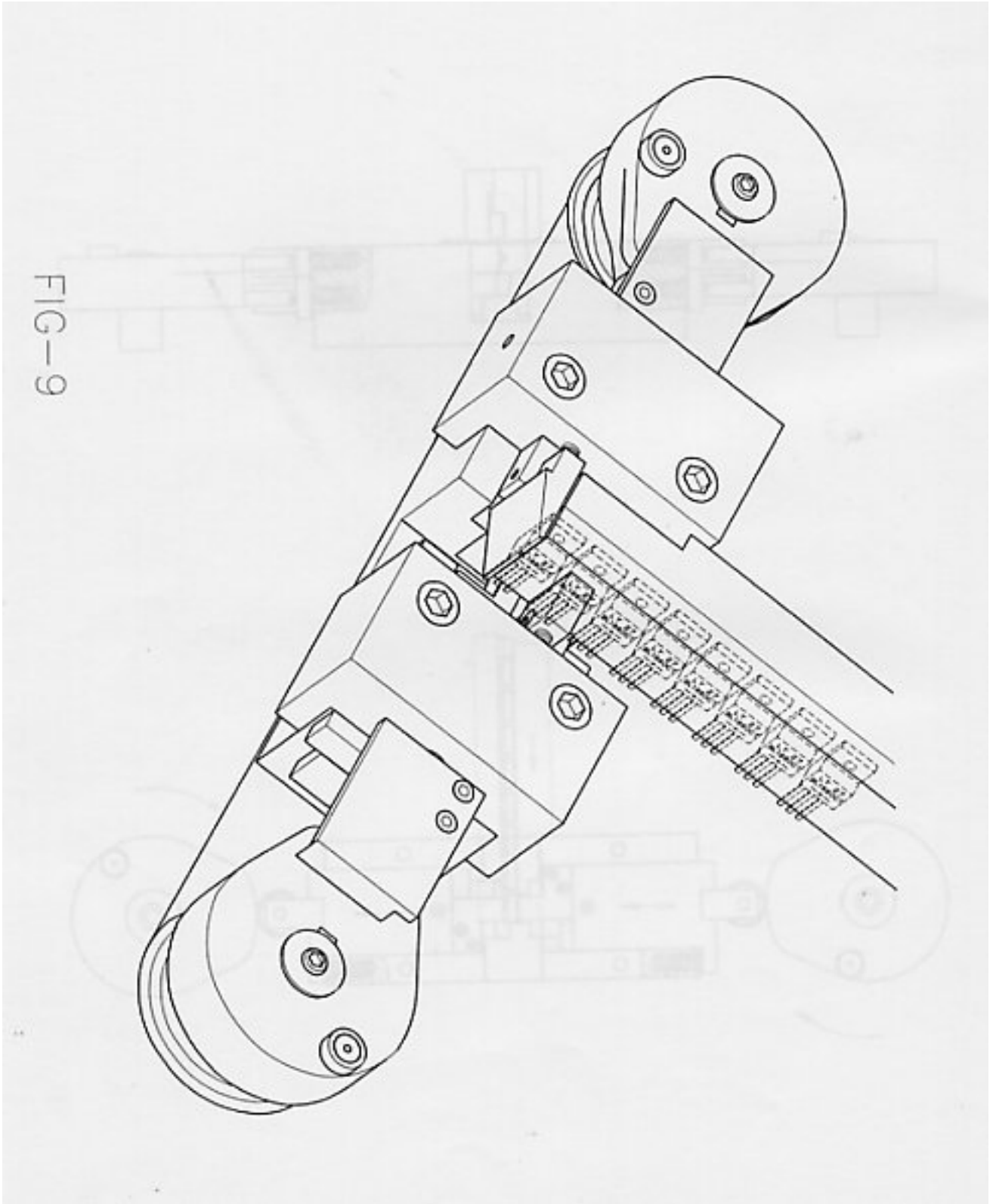


FIG-9



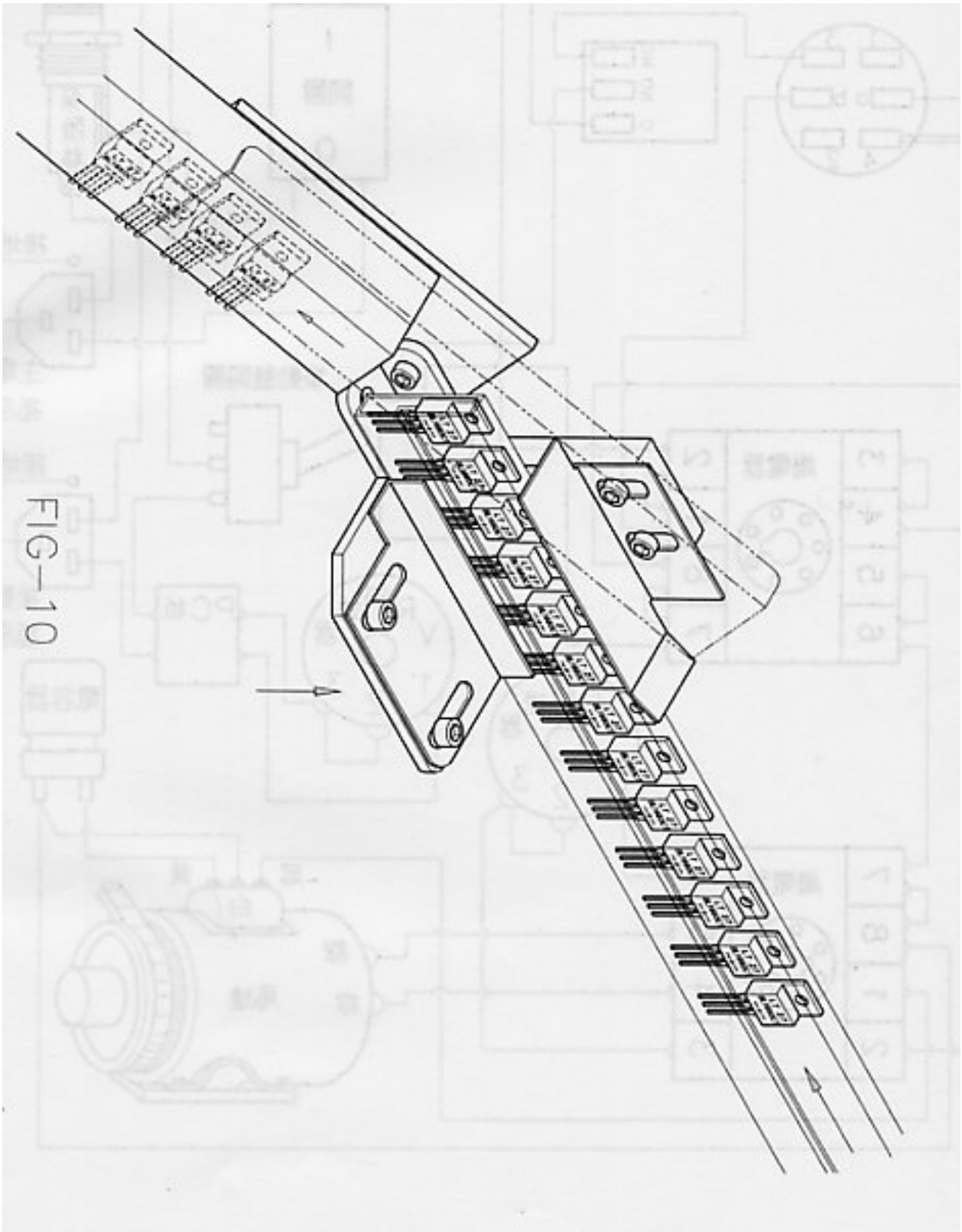
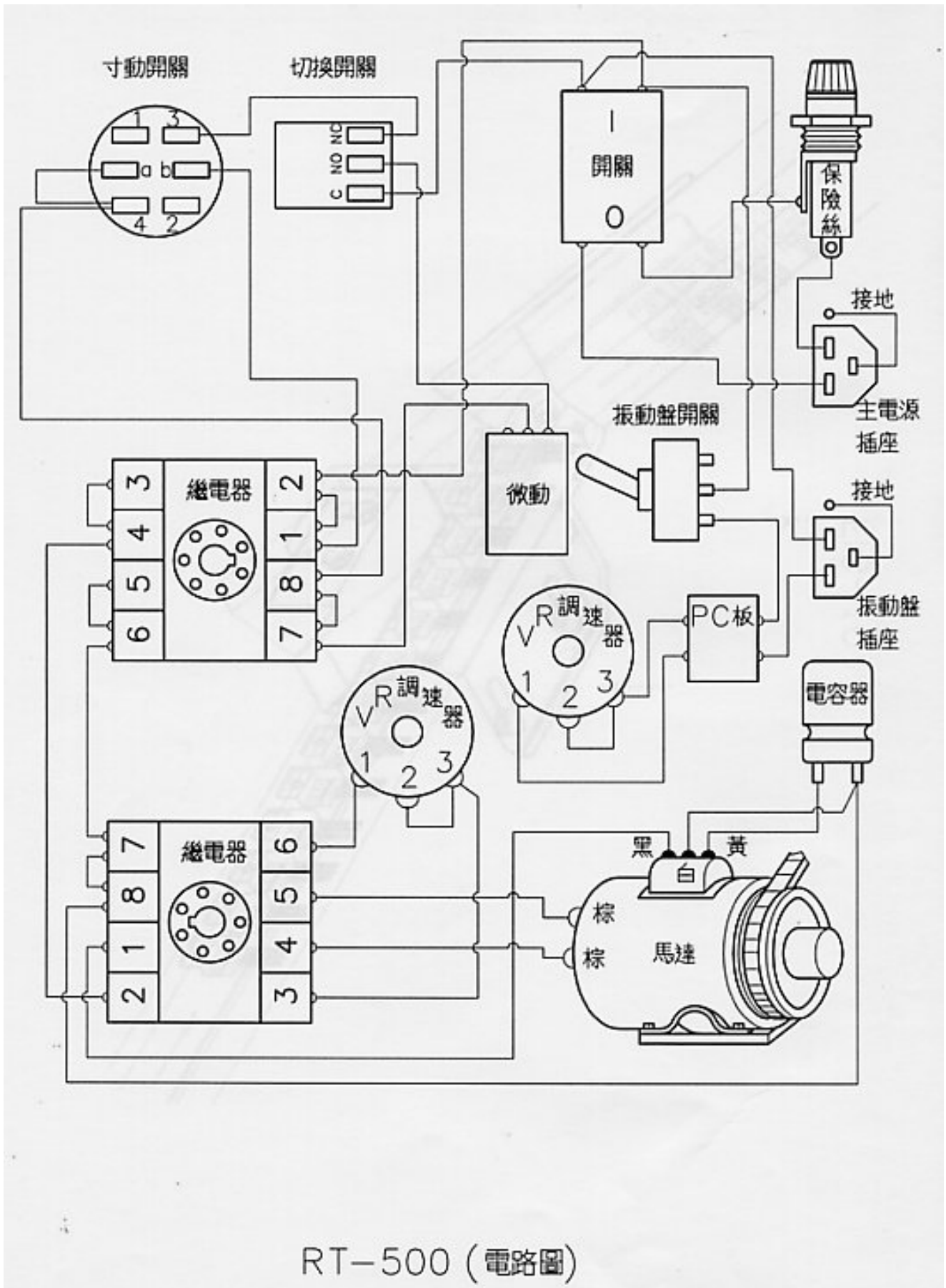


FIG-10



RT-500 (電路圖)