

(3)



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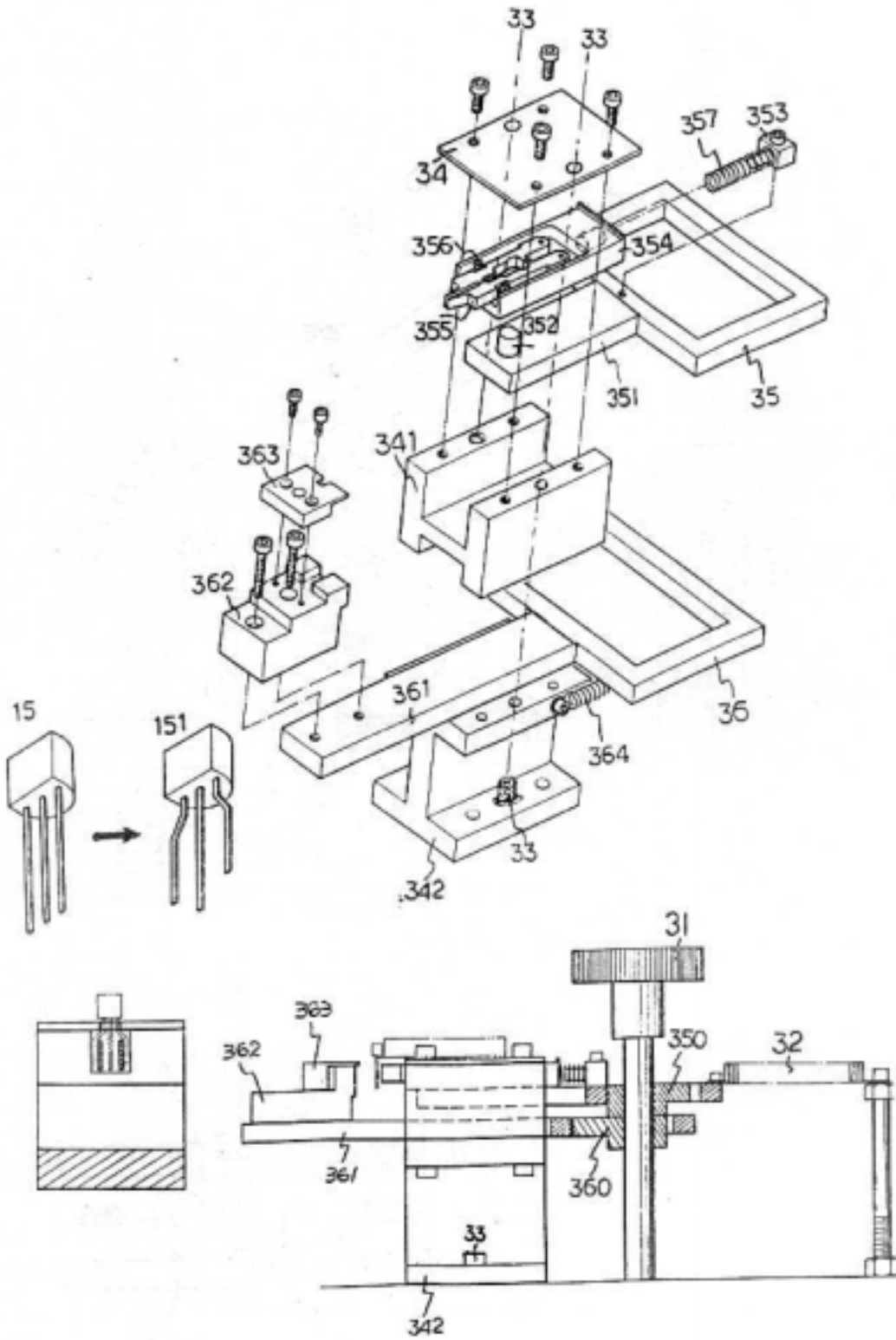


FIG-4

(4)



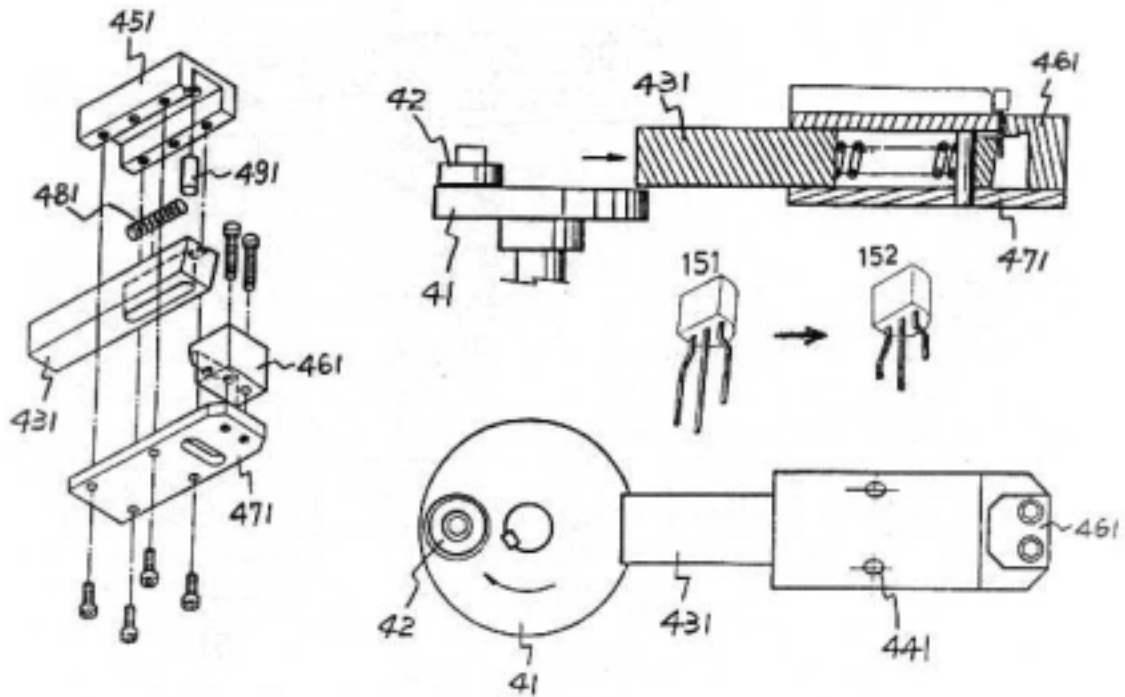


FIG-5

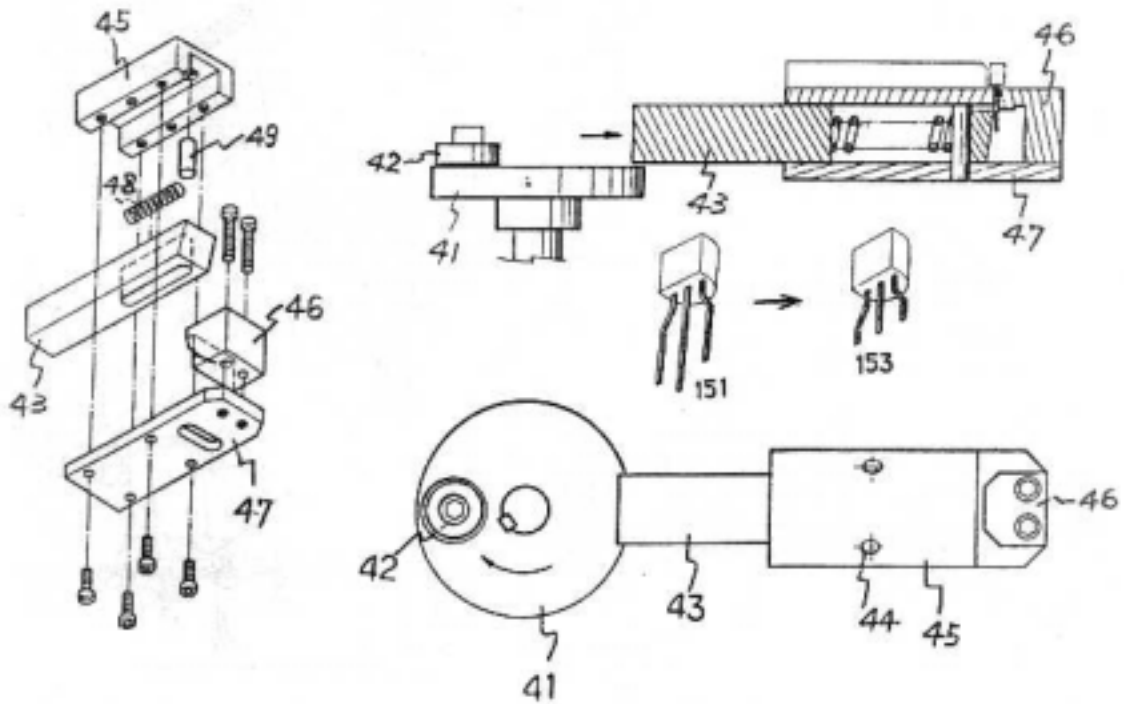


FIG-6

(5)



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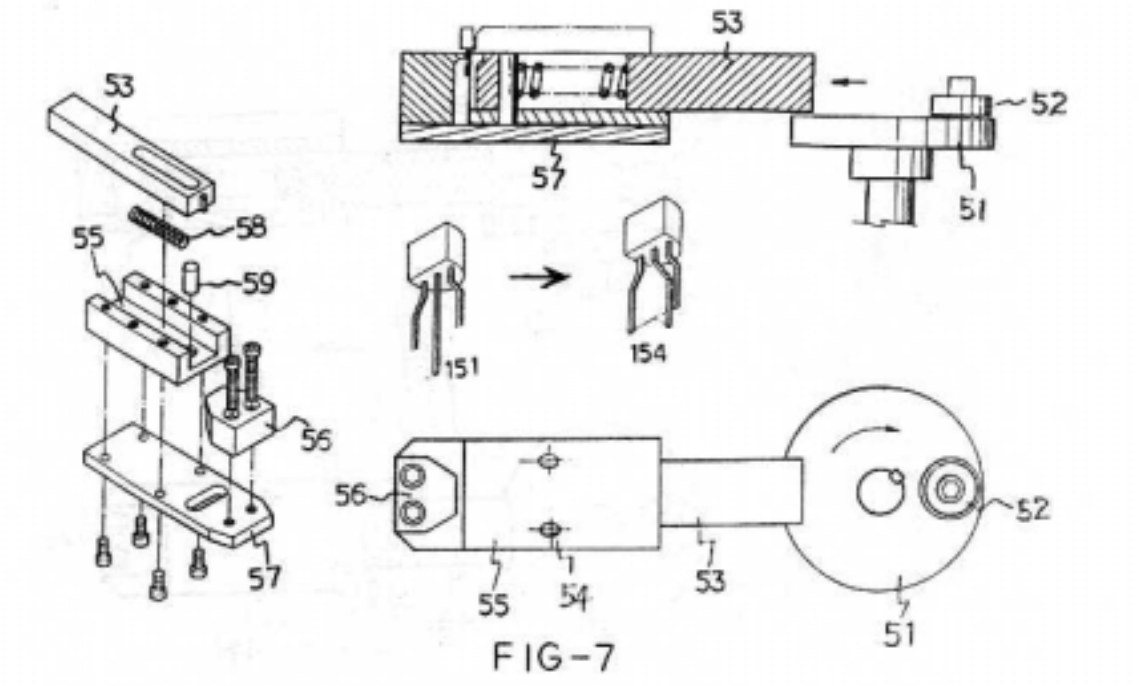


FIG-7

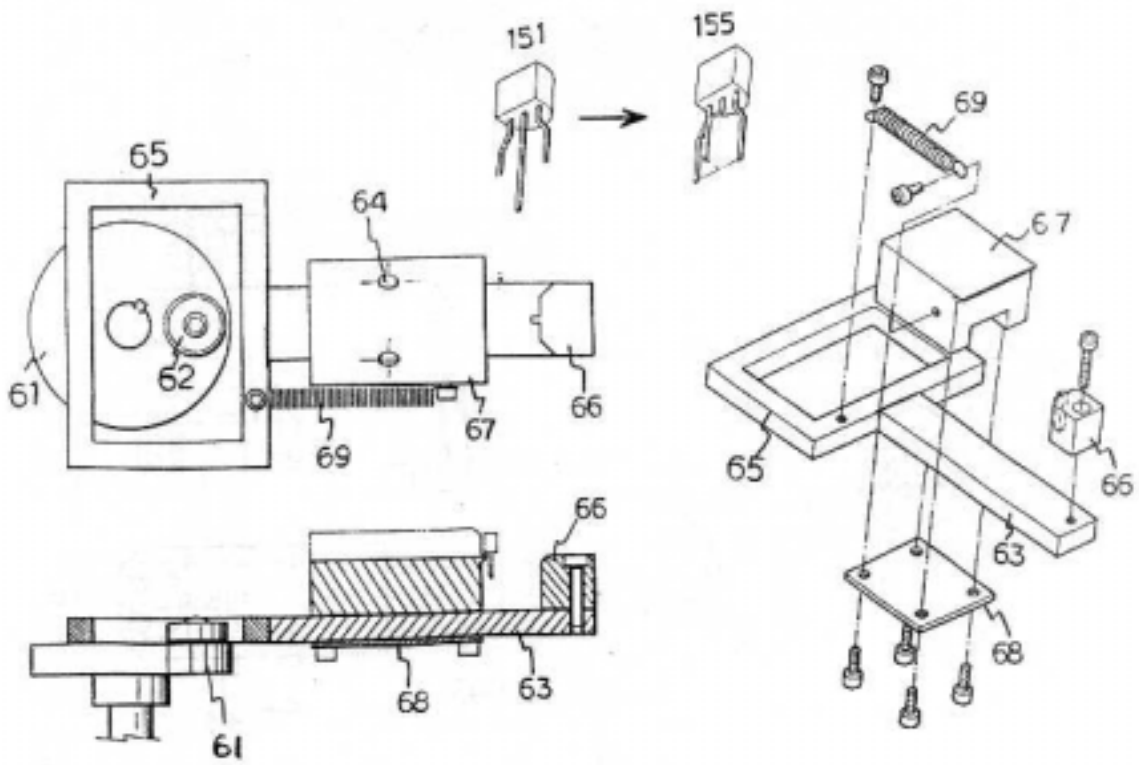


FIG-8

(6)

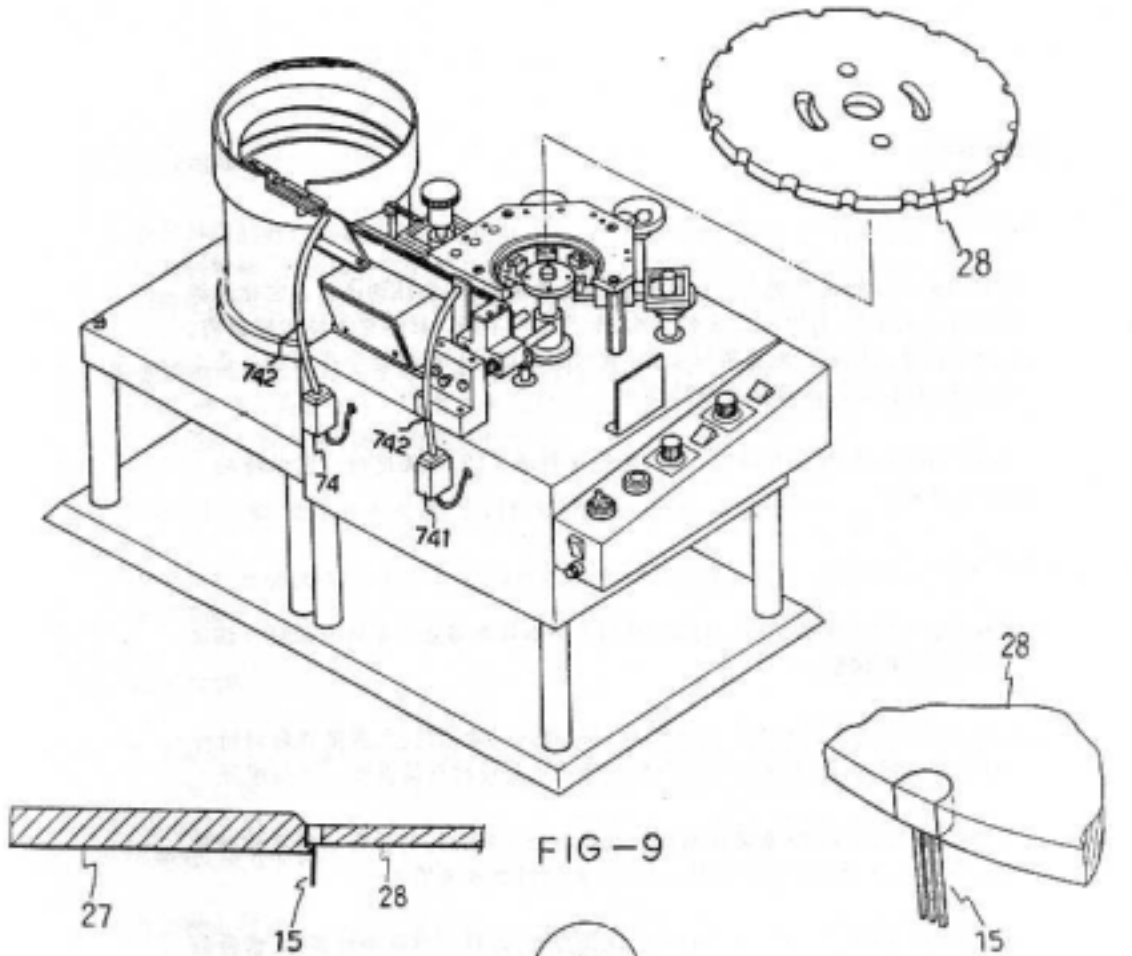


FIG-9

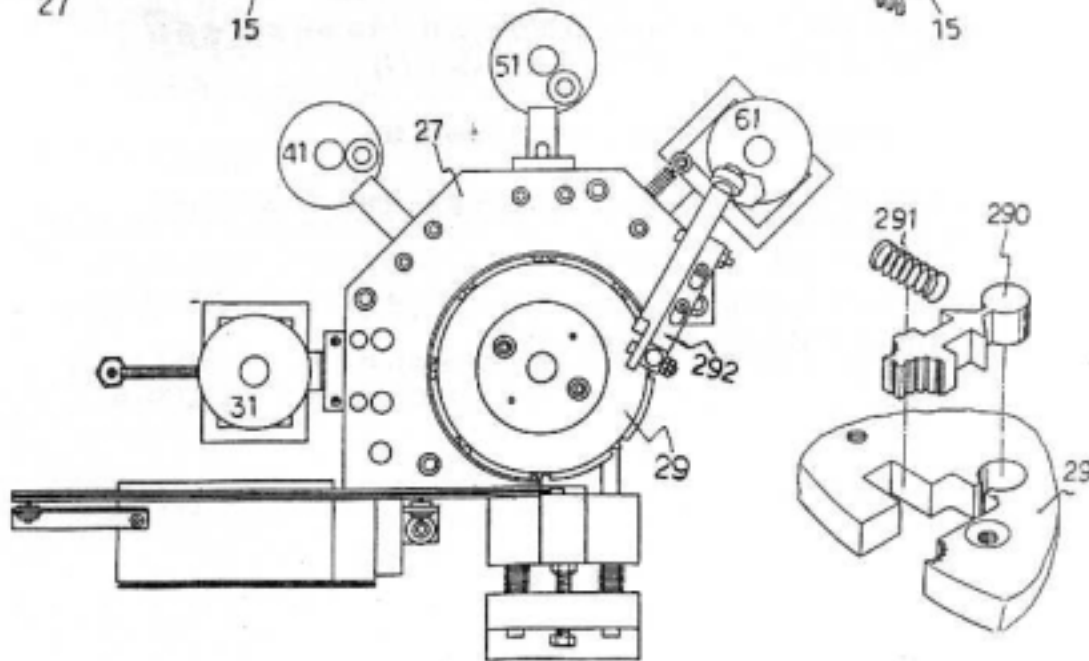


FIG-10 (7)



## YF-900 Automatic Transistor Forming Machine

### Part List

Part No.,	Description	名稱
1	Vibrant Bowl Feeder	震動送料機
11	Plate - Slot adjusting	調整片
12	Screening Hole	選別片
13	Junction	交接點
14	Screw	螺絲
15	Components	零件
2	Linear Feeder	平面送料機
21	Cover, Linear Feeder	震動蓋
221	Vibrator	振動器(火牛)
23	Screw	螺絲
25	Vibrating Plate	震動片
26~269	Feeding Device	入料機組
26	Feeding Block, Fixed	入料座
260	Bearing Block	培林座
261	Screw	螺絲
262	Feeding Block, Removable	入料座
263	Feeding Inject	入料口
2631	Cover	蓋板
264	Locating block	定位器
265	Cam - Feeding	凸輪
266	Shaft - Support	滑行桿
267	Spring	彈簧
268	Pin Bearing	針狀培林
269	Component Locating Plate	定位片
27	Protective Cover	護弓
271	Part's remover	退料器
272	Parts Bin- Formed	成品盒
273	Blanket- Parts Bin	料架
28	Part Delivery Plate	送料盤
281	Location adjusting Hole(Oval)	橢圓螺絲孔

(11)



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8

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Part No.,	Description	名稱
29	Parts Delivery Plate - Clamp Type	夾料式送料盤
290	Clamp Finger	夾片
291	Retaining Spring	彈簧
292	Formed Parts Remover	活動退料器
3	Lead Forming Device	整腳機構
31	Hand move Knob	手轉輪
32	Spring	彈簧
33	Adjusting Hole	調整孔
34	Cover	蓋板
341	Block for Forming Frame	滑桿座
342	Main Block - forming	整腳固定座
35	Forming Frame	整腳框
350	Cam-Forming	整腳凸輪
351	Sliding Rod - Forming	滑桿
352	Post - Forming	張腳棒
353	Compress bar	壓縮桿
354	Push Rod - Forming	張腳推桿
355	Forming tool	張腳刀
356	Spring	彈簧
36	Frame- Forming	固定框
360	Cam - fix location	固定凸輪
361	Pull Rod	拉桿
362	Block - Leads Opening	張腳座
363	Plate - Lead opening	張腳固定板
364	Spring	彈簧
4	Lead Cutting Device	剪腳機構
41	Cutting Drive Wheel	轉輪
42	Bearing	培林
43-49	Surface Cutting Device	平腳刀機構
43	Surface Cutter	平腳切刀
44	Screw	螺絲
45	Block - Cutter	刀座
46	Cutter - Fixed	固定刀

(12)



Part No.,	Description	名稱
48	Spring	彈簧
49	Pin	插銷
431-491	Shape Cutting Device	長短腳刀機構
431	Shape Cutter	長短腳刀
441	Screw	螺絲
451	Block - Cutter	刀座
461	Block - shape Cutter	長短腳 刀座
471	Base Plate	底板
481	Spring	彈簧
491	Pin	插銷
5	Snap in Device	前踢成型機構
51	Driven Wheel	轉輪
52	Bearing	培林
53	Blade - Forming	成型刀
54	Screw	螺絲
55	Block - Forming	成型座
56	Fixed Blade	固定刀
57	Fixed Plate	固定板
58	Spring	彈簧
59	Pin	插銷
6	Snap Out Device	後踢成型機構
61	Driven Wheel	轉輪
62	Bearing	培林
63	Pull Rod	拉桿
64	screw	螺絲
65	Forming Frame	成型框
66	Forming Blade	成型刀
67	Block - Forming	成型座
68	Cover	蓋板
69	Spring	彈簧
7	Electric System	電路系統
71	Power on/off Switch	電源開關

(13)



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10

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Part No.,	Description	名稱
73	Manual/Auto Switch	手動自動切换開關
731	Start	啟動
732	Speed Regulator - linear	平送 VR 調速器
734	Linear feeder - Switch	平送開關
735	Speed Regulator - Vibrant Bowl Feeder	震動送料機 VR 調速器
736	On/off Switch Bowl Feeder	震動送料機開關
74	Photo-Electric Sensor	光纖感測器
741	Photo-Electric Sensor	光纖感測器
742	Optic Fiber	光纖線
75	Motor	馬達
8	Main Construction	機身結構
81	Post	柱子
82	Base Plate	底板
83	Castor	輪子
84	support Frame - Bowl Feeder	震動機墊板
85	Case	機身板

(14)



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11

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# User's Guide

## Auto Transistor Forming Machine

### Model- YF900

#### Contents

1. Vibrating Feeding Device	-----
2. Horizontal Feeding Device	-----
3. Lead Forming Device	-----
4. Lead Cutting Device	-----
5. Lead Forming Device - Forward	-----
6. Lead Forming Device - Backward	-----
7. Switch - Control/Electric Power	-----
8. Trouble-shooting	-----
9. Maintenance	-----





## 1. Vibrating Feeding Device

- A. Placing the components into the container Around 600pcs once that are the most suitable lot for treatment.  
Starting VR Speed Regulator then the components will moving up by the side of container. The rail will sorting out components with wrong Direction automatically. The components with correct director will keep Moving up and through the double direction checking D Hole(11).
- B. 0.5mm distancese have to be keep between Vibrating feeding Device(1) and Horizontal feeding Device.

## 2. Horizontal Feeding Device

- A. The components will be stand-by on the entrance(262)and goes into the rotary feeding Device(28) one by one.
- B. The Optical sensors(74)(741) are in controlling the feeding operation. When none of the components are checked by the sensor(741), it means the feeding speed can not catch on the Operation tempo. The main frame(28)will be terminated till the speed catching on.
- C. When the components are checked out by the sensor(74). It means The feeding can be slow down temporally and the Vibrating feeding device(1)will be stopped till the main frame need more components to operate.
- D. The distancese between sensor(74)and (741)is a buffer area to assuree operation smoothly of main frame and get rid of jaming.
- E. 0.5mm Distancese to be kept between (21)Horizontal feeding Device and feeding mechanism(262).
- F. Pay attention to the components which must be aimed at the entrance of rotary feeding device.
- G. Operation flow Chart  
Components(15)⇒⇒Rotary feeding device(28) ⇔⇔ Forming(3)  
⇔⇔cutting(4)⇒⇒2nd (5)⇒⇒FinalForming(6)⇒⇒Component  
Holding Device(271)⇒⇒Case(272)





### 3. Lead Forming Device

- A. The fixed frame will be pulling back by the Cam(36) when the components(15)via rotary feeding Device(28)carrying to the position.
- B. The components jamming in the Rotary feeding device(28) is the main reason of improper forming which causing incorrect position.  
Solution –Release screw(282) total 4 places then adjusting Hole(28)position and aim at the forming blade.
- C. Hand Wheel (31) is for pilot run and testing. Turning it around will drive the main frame.
- D. Adjusting lead wire forming device - Using hexagon handle(5mm) through hole(33) and releasing the screw then adjusting the Device.

### 4. Lead Cutting Device

- A. The components will be cut as reach the right position by pushing force from the bearing(42) and cutting by the blade(43).
- B. If unnecessary for cutting operation, dismantle the Bearing(42). The Blade(43)will idle in the place.
- C. Two traditional types for Transistor forming is using currently. 3 lead wire in axial - the blade is plan surface. If it is in triangle - the blade is in the shape of plan oconcave. The middle lead will be longer than others about 1.0 mm after cutting. That's because the middle one have to push forward or backward and become triangle shape.
- D. Replacing cutting blade - Dismantle screw(44) and replace the blade (43)easily.

### 5. Forming Device-Forward

- A. The lead will be pushed forward by the pushing force from the bearing (52)and Triangle is formed when the components are arrived the right position.
- B. If middle lead is unnecessary for forming or must be formed backward The blade(53)will be idled when the bearing(52) is dismantled.
- C. Only one set of Backward forming device or Forward forming device is selected for one machine. One set of bearing is attached. It shares the bearing(52)and (62).



## 6. Forming Device - Backward

- A. The middle lead will be pushed backward by the Fixed frame(65)which pushing by the bearing(52) when the components reach the forming position.
- B. If unnecessary for forcing the middle lead, dismantle the bearing(62).

## 7. Switch - Control/Electric Power

- A. Electric Power Switch (71)
- Fuse (72)
- Auto/Manual Switch (73)
- Start Switch (731)
- Horizontal Feeding Speed Switch (732)
- Horizontal Feeding on/off Switch (734)
- Vibrating Feeding Speed Switch (735)
- Vibrating Feeding on/off Switch (735)

## 8. Trouble Shooting

- A. The intersection(13) of Vibrating Feeding Device and Horizontal feeding Device must be made sure to be in a line. Otherwise, the components will be jamming in the place.
- B. The entrance (263)must aimed at the position hole(281)of Rotary feeding Device.
- C. The distance between base of entrance and guider must not exceed 0.5mm.
- D. The main reason for improper forming is causing by incorrect adjusting of Rotary feeding device(28). The Jamming of components will make the position offset.
- E. The blade has to be grinded , if is dull.
- F. It's easy to bend the lead wire if the component ejecting device(271) is working improperly.
- G. The sensors(74)(741) are sensitive and precisely. avoid to damage it by improper pushing and adjustment.

## 9. Maintenance

- A. Lubrication unnecessary for Vibrating Feeding Device and Horizontal Feeding Device. Lubricating the other construction regularly.
- B. Grease is need in Cam and Bearing (42)(52)(62) regularly.
- C. Oil the main shaft(28)on the hole.

Sincerely welcome your phone call for unclear questions. We are very pleased to serve you in operation and maintenance.

