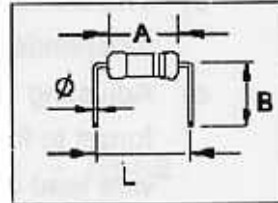


**A. Brief introduction for RT-80 and RT-80S,
Manual taped axial lead former,**

1. A hand crank unit with compact and solid design to form and cut the taped axial lead components. 1,000 pieces per minute working capacity are possible in this high production efficient model; with advantage of easy maintenance, adjustment and simple operation procedure.



2. **RT-80**, Standard model, The best structure.

$B=3.6\sim 15(\text{mm})$, $\text{Ø}W=0.35\sim 1.00\text{mm}$

$L=A+2.4+\text{Ø}W(\text{Minimum Pitch})$,

for example

$A=3.6\text{mm}$ $\text{Ø}W=0.5$

$3.6+2.4+0.5=6.5\text{mm}=L(\text{Adjustable Pitch between } 6.5\text{mm}\sim 40\text{mm})$

3. **RT-80S**, Slim model, for small pitch requirement. It's not suitable for lead wire over $\text{Ø}0.8$. The structure is same as standard model except more thinner forming wheel.

$B=3.6\sim 15(\text{mm})$, $\text{Ø}W=0.35\sim \text{Ø}0.8$

$L=A+1.2+\text{Ø}W(\text{Minimum Pitch})$,

for example

$A=3.6\text{mm}$ $\text{Ø}W=0.5$

$3.6+2.4+0.5=5.3\text{mm}=L(\text{Adjustable Pitch between } 5.3\text{mm}\sim 40\text{mm})$

4. This model is for cutting and bending the taped (boxed or reeled) axial lead components only. Such as resistors. Diodes, conductors etc.
5. The bench clamp is included in the package, which will help to fix the machine to the side of the bench or working table.
6. The Pitch gauge is available which is optional in ordering (Ref. Sketch E63)

B. Operation instructions

1. Adjusting procedure

- a) Releasing the C27 screw then adjusting the forming wheels of C21&C22 until reaching the required pitch.(The pitch is equal to two distance of

Ren Thang Co., Ltd.

TEL: +886-2-82011187、 22021205

FAX: +886-2-22039391、 22021204

www.renthang.com

©All copyright reserved.
版權所有，翻印必究。

E-mail: renthang@renthang.com

- forming wheel with the wire diameter) · Don't forget to tight the screws released.
- b) Adjusting the cutting distance by moving both the C25&C26 Cutting wheel after releasing the screw C28. The Cutting discs C29 & C30 will be moved synchronously by the action. The distance between forming wheels (C21&C22) and cutting wheels (C25 &C26) is the lead length after forming. Both side of lead length are to be adjusted independently.
 - c) The distance of Bending tool (D34 & D35) are to be adjusted independently by both side of the adjusting knobs(D49).
 - d) Adjusting the pitch of the leads by the bending tool D34 & D35. Don't forget to fix the screws D44 after adjusting. A space of one working wire lead diameter must be maintained in between the forming wheel and bending tool.
 - e) Placing one component in between the forming wheels C21 & C22, Moving the hand crank slowly to form and cut the components. Re-adjusting is required if unsatisfactory
 - f) Setting up the Plastic guide B1 & B2 when the adjusting procedure is finished. Adjusting the distance between the plastic guide. Make sure the taped component will be running smoothly in it.

2. Application

- a) Feeding : Sliding the taped components into the plastic guide B1 & B2 until the first components is placed in the slot in between the cutting and forming wheels.
- b) Cutting / Forming : Moving the hand crank clockwise. The taped components will be cut and formed efficiently.
- c) Ejecting : The components will be ejected and fallen into the part's bin by the ejectors B15 in the forming wheels C21 &C22 after formed and cut.
- d) Tape Waste : Guiding the tape out the part's bin when moving hand crank to cut and form the parts.

C. Caution:

1. Never knocking the forming wheel C21, C22 or cutting wheels C25 & C26 by steel especially during adjustment. It's easy to damage the sharp edges of the wheel. Adjusting the distance by pulling/pushing the wheels gently.

2. The cutting discs need to be re-grinned or replaced when burr is created or cutting incompletely.
3. The bending tool D 3 4 & D 3 5 is calibrated in set. Replacing it contemporaneously when it is wear off.
4. Replacing the whole set of cutting wheel (C 2 1 & C 2 2) and forming wheel (C 2 5 & C 2 6) when one of them is wear off. Since they are calibrated as one set.
5. Keep the taped components sliding smoothly in the plastic guide B 1 & B 2 that never too tight to interfere the feeding.
6. The Reel B51 must be installed when processing reel packed components. Assisting the moving of the reel by hand when it is cut and formed.
7. Lubricating the forming shaft C 2 0 and cutting shaft C 3 to ensure running freely.

D Function extension of model RT-80

- 1 Automatic enhancement from hand crank **RT-80** → **RT-82**
 - a Order one set of MT-1 motor drive.
 - b Dismantling the C10 crank. Placing the RT-80 on the platform of MT-1, assembling and tightening the screws.
 - c Connecting the power source and turn it on. The model is upgraded from **RT-80** → to motorized **RT-82**
 - 2 Upgrading the model for handling both components in bulk and in taped **RT-82** → **RT-86**
 - a a. Ordering RT-10 loose feeder.
 - b b. Fixing the loose feeder RT-10 by 3 screws to the right/left wall A8 \ A9
 - c Adjusting the forming wheel according the actual requirement of components.
- RT-82** → model for both bulk and taped components **RT-86**
- 3 Upgrading to model for automatic handling components in bulk and in taped **RT 86** → **RT90**
 - a Ordering RT-10 loose vibrating feeder
 - b Alighting the outlet of VP-87 to the hopper of RT-86, the machine is ready for automatic bulk feeding

Find below the figure for detailed explanation

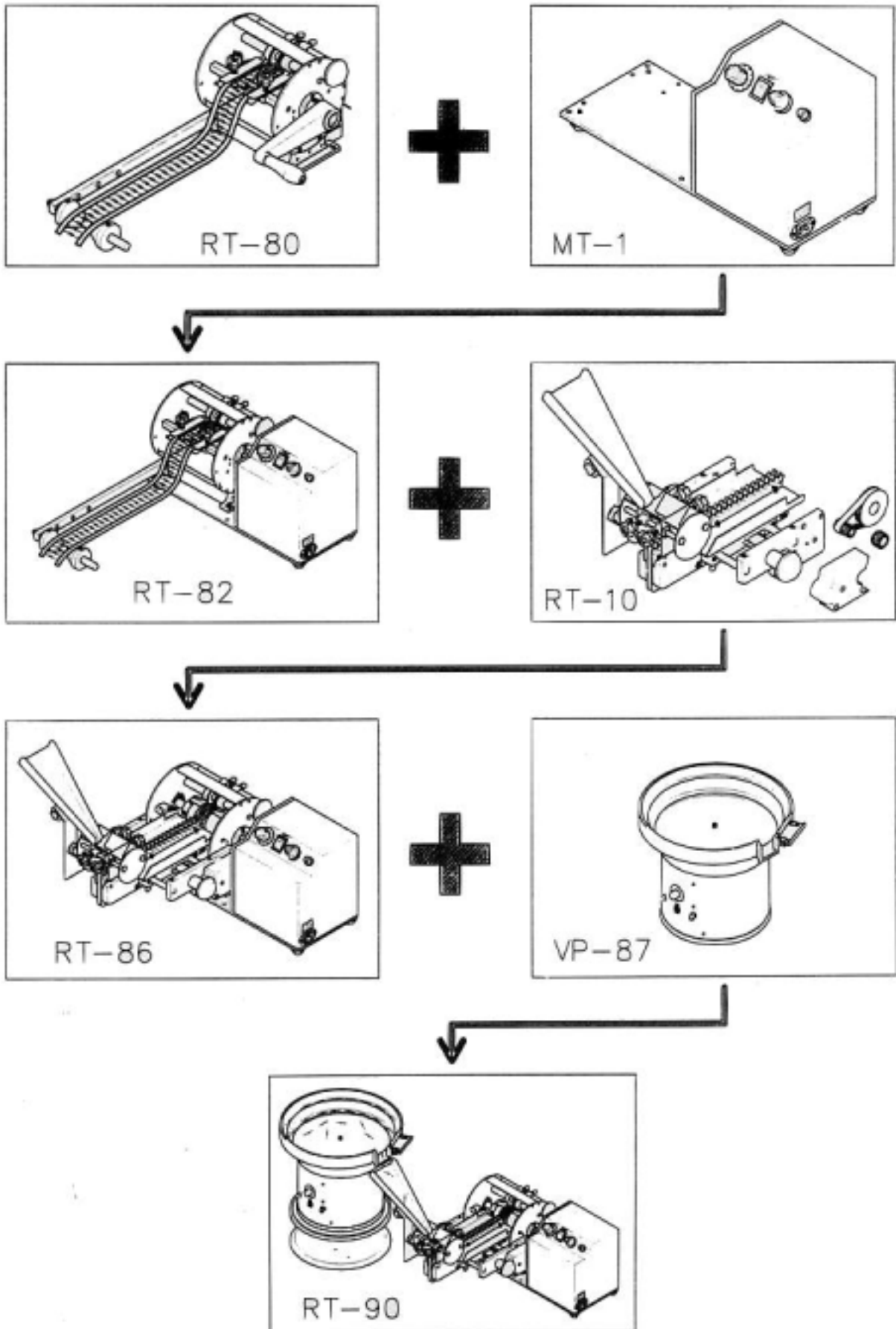
Please tell us part number that shown in the drawings if ordering spare parts is necessary. Contact us for any unclear or assistant needed. It's our pleasure to serve you at all time.

Ren Thang Co., Ltd.

TEL: +886-2-82011187、22021205
FAX: +886-2-22039391、22021204
www.renthang.com

©All copyright reserved.
版權所有，翻印必究。

E-mail: renthang@renthang.com



Ren Thang Co., Ltd.

TEL: +886-2-82011187、22021205

FAX: +886-2-22039391、22021204

www.renthang.com

©All copyright reserved.
版權所有，翻印必究。

E-mail: renthang@renthang.com

**Spare Part list RT-80/ RT-80S
Manual Taped Axial Lead former**

Part No.	Part Name	Part No.	Part name
A8	Side wall, Right	C21	Forming wheel
A9	Side wall, Left	C22	Forming wheel
A10	Base	C23	Key
A11	Parts bin	C25	Cutting Wheel
A57	Screw	C26	Cutting Wheel
A7	Arc bracket	C27	Screw
A82	Screw	C28	Screw
A83	Screw	C29	Cutting disc
A91	Logo	C30	Cutting disc
		C31	Shaft, Cutting disc
B1	Plastic guide	D34	Bending tool, left
B2	Plastic guide	D35	Bending tool, Right
B3	Screw, rail	D37	Screw
B5	Square bar, plastic guide	D40	Stop washer
B57	Screw	D42	Shaft, bending tool
B15	Ejector	D44	Screw
B16	Screw	D49	Knob, bending tool
B50	Components	E60	Fixing rod.
B51	Reel	E61	Clamp
B53	Shaft, reel	E62	Nut
B54	Screw	E63	Pitch gauge
B55	Nut		
B56	Screw		
C10	Crank arm		
C101	Handle		
C102	Screw		
C17	Base, bearing		
C171	Screw		
C19	Key		
C20	Shaft, forming		
6003	Bearing		

Ren Thang Co., Ltd.

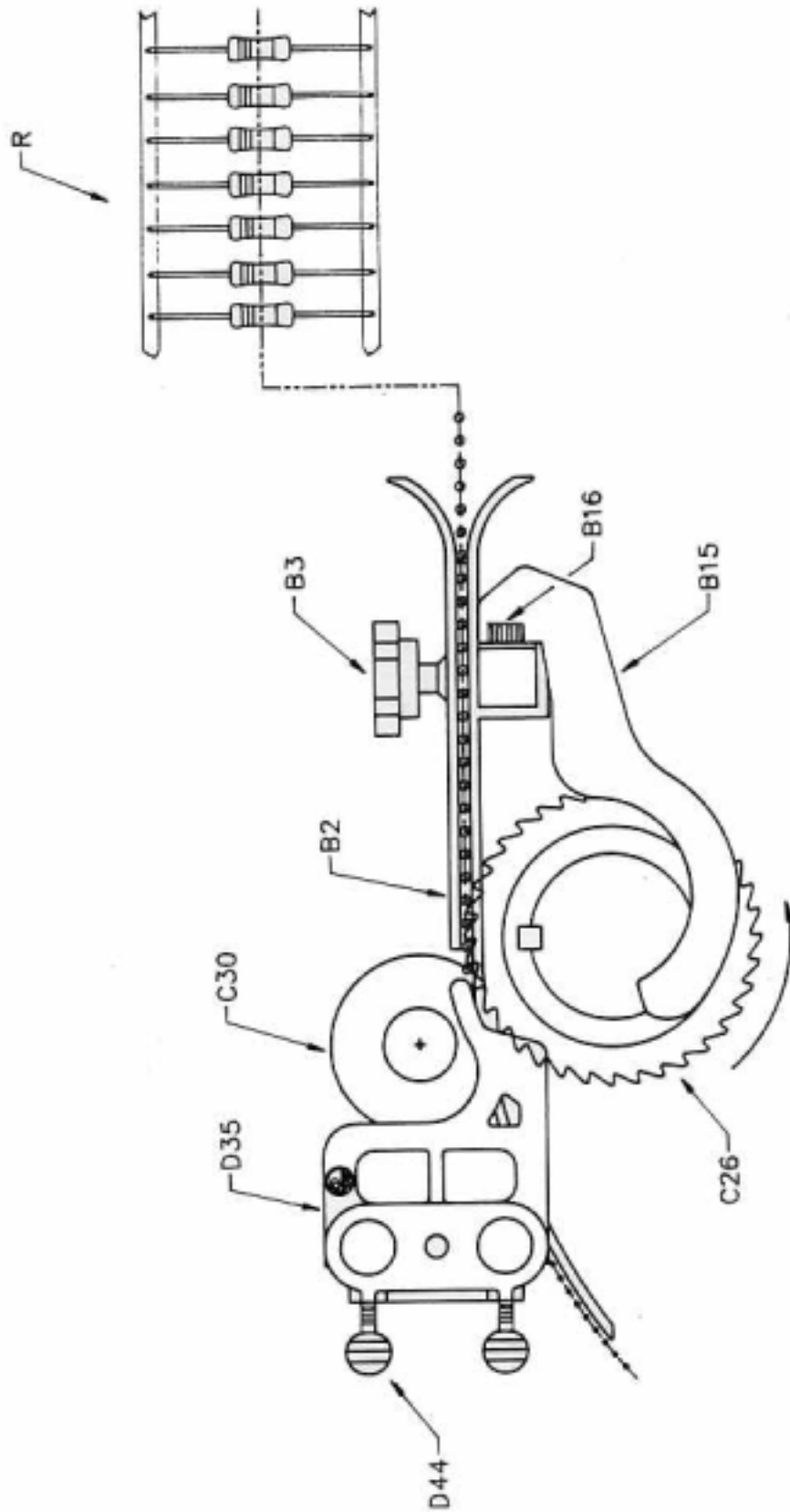
TEL: +886-2-82011187、22021205

FAX: +886-2-22039391、22021204

www.renthang.com

©All copyright reserved.
版權所有，翻印必究。

E-mail: renthang@renthang.com



Ren Thang Co., Ltd.

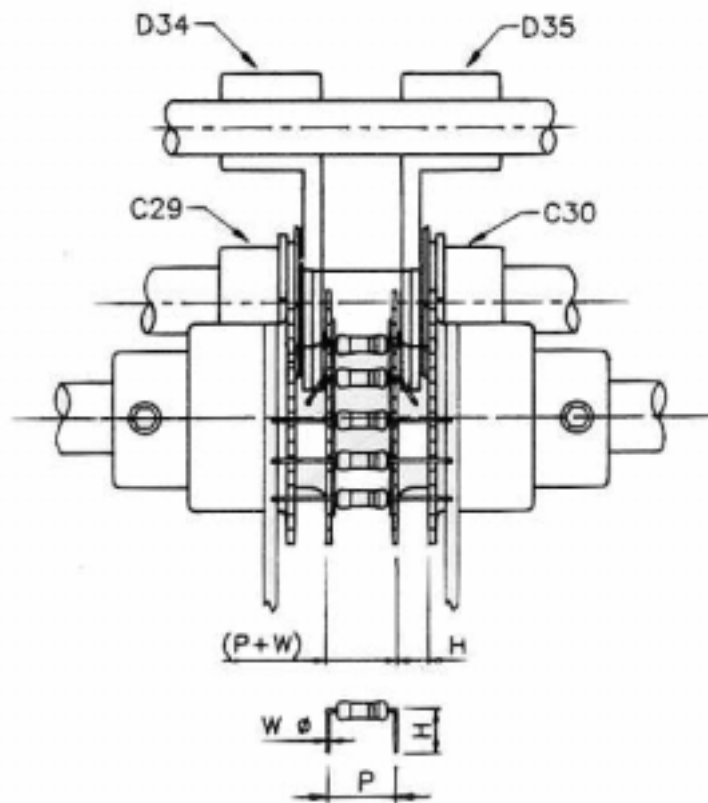
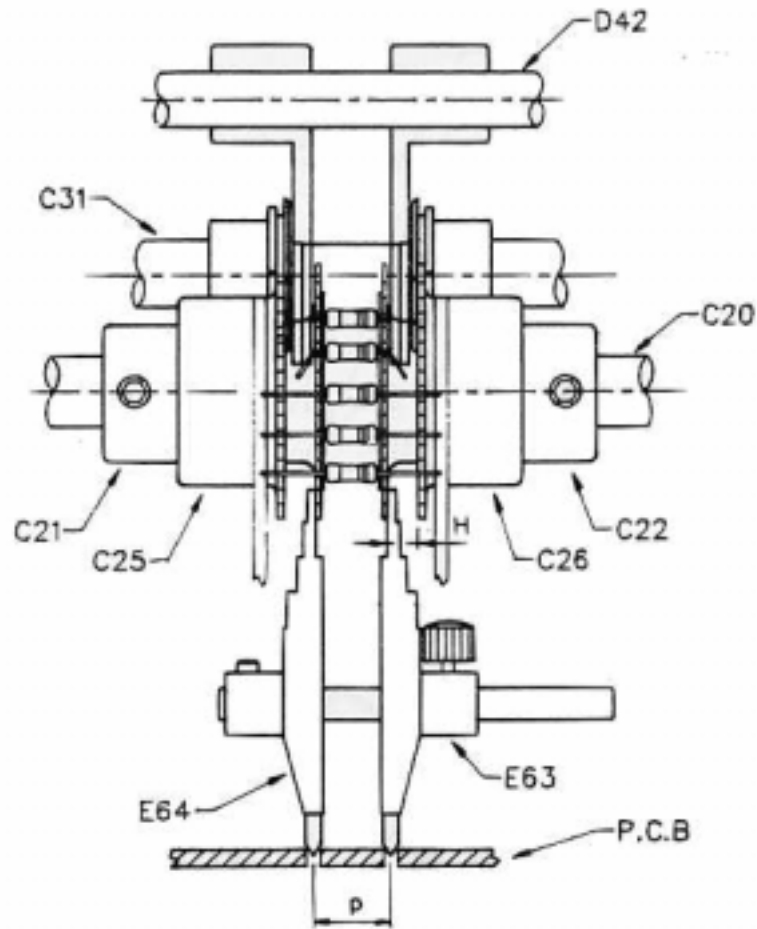
TEL: +886-2-82011187、22021205

FAX: +886-2-22039391、22021204

www.renthang.com

©All copyright reserved.
版權所有，翻印必究。

E-mail: renthang@renthang.com



Ren Thang Co., Ltd.

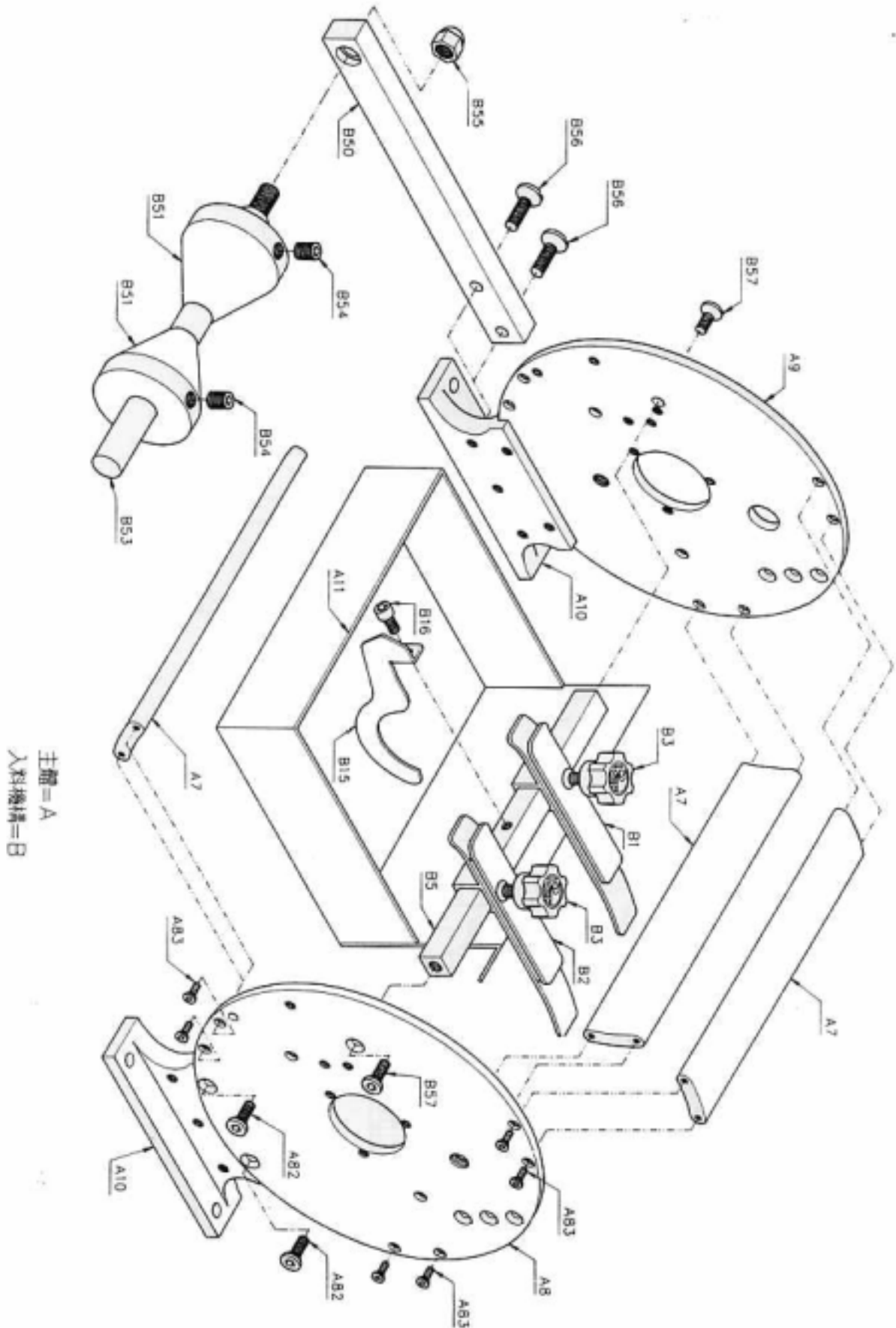
TEL: +886-2-82011187、22021205

FAX: +886-2-22039391、22021204

www.renthang.com

©All copyright reserved.
版權所有，翻印必究。

E-mail: renthang@renthang.com



Ren Thang Co., Ltd.

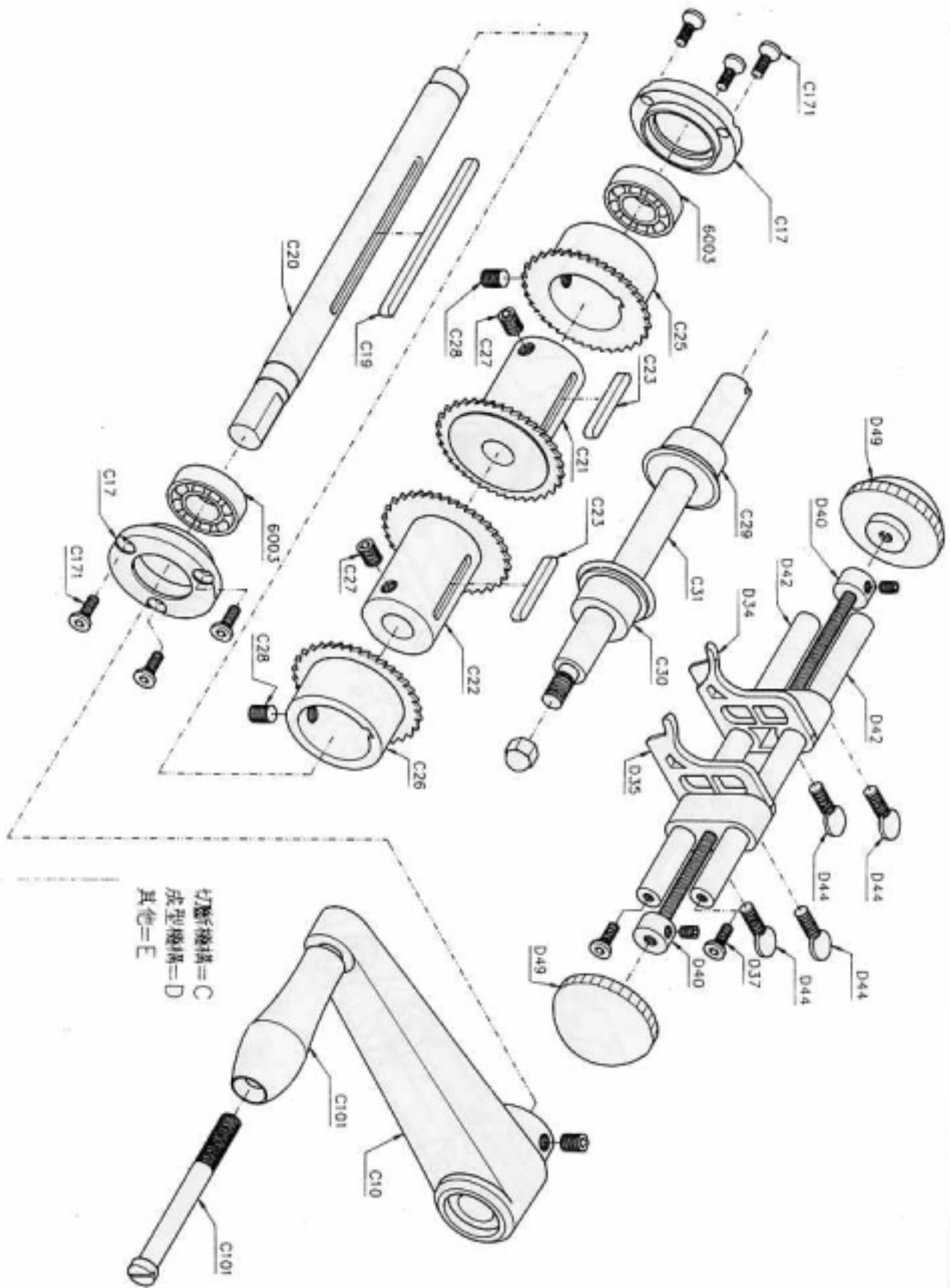
TEL: +886-2-82011187、22021205

FAX: +886-2-22039391、22021204

www.renthang.com

©All copyright reserved.
版權所有，翻印必究。

E-mail: renthang@renthang.com



Ren Thang Co., Ltd.

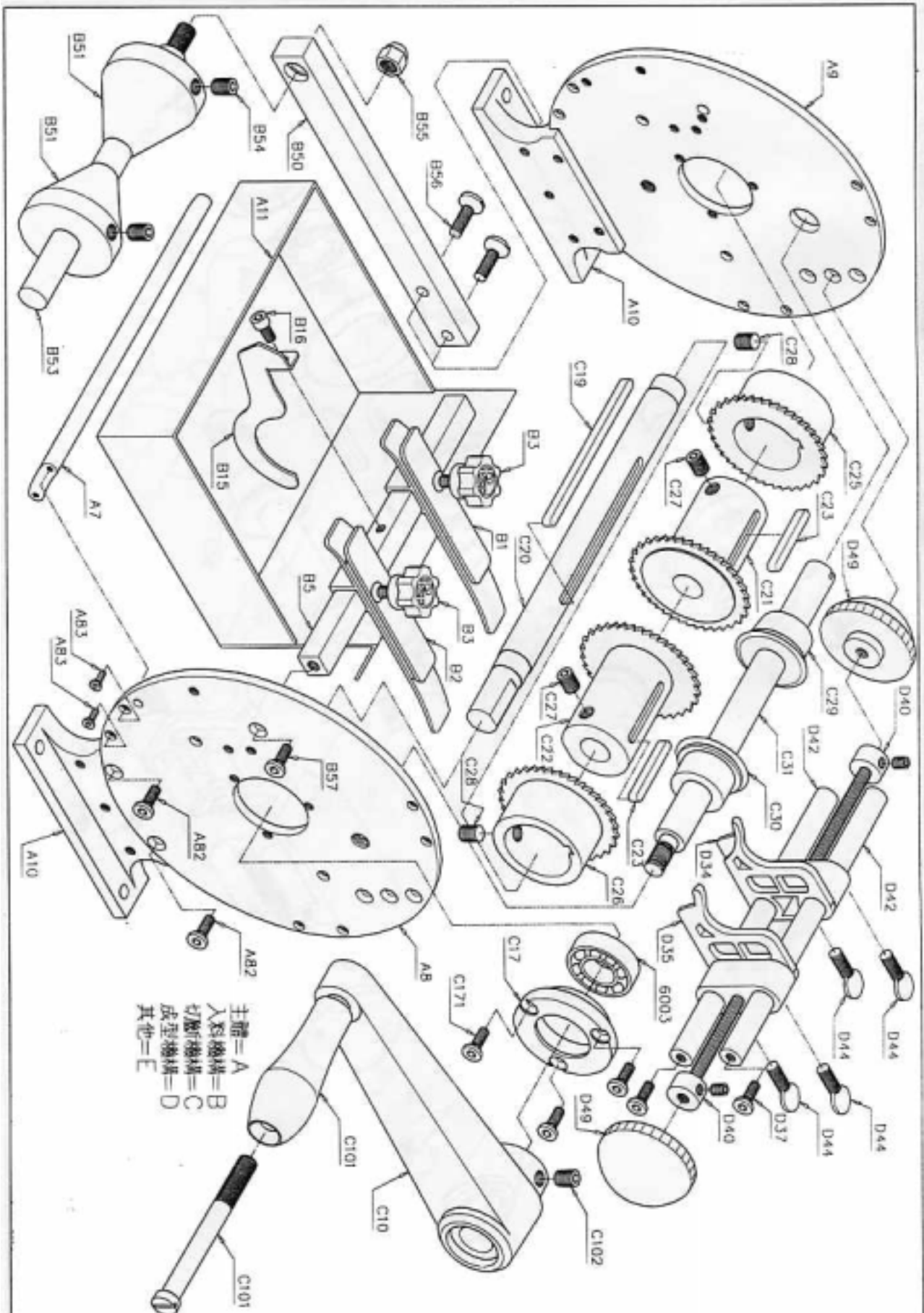
TEL: +886-2-82011187、22021205

FAX: +886-2-22039391、22021204

www.renthang.com

©All copyright reserved.
 版權所有，翻印必究。

E-mail: renthang@renthang.com



Ren Thang Co., Ltd.

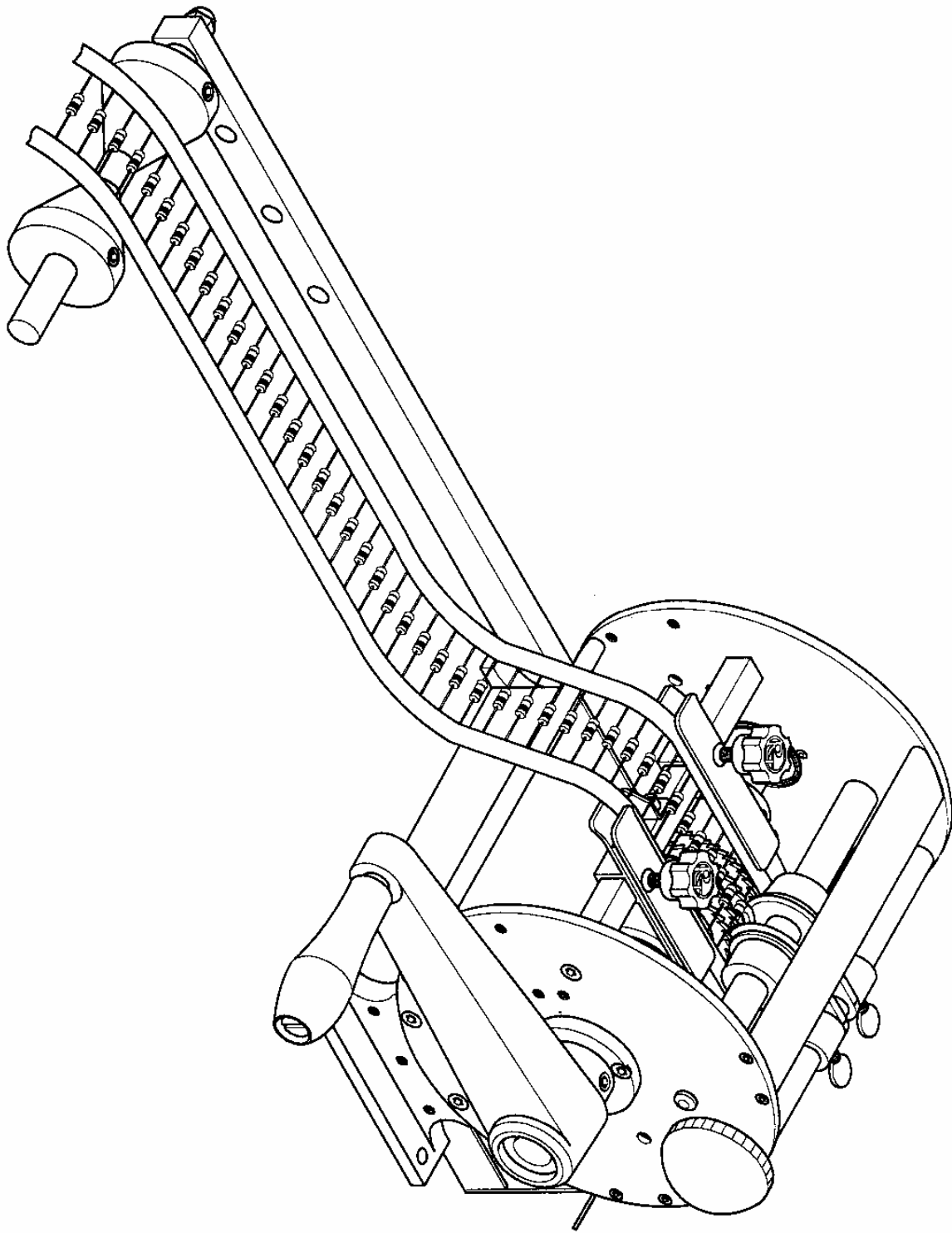
TEL: +886-2-82011187、22021205

FAX: +886-2-22039391、22021204

www.renthang.com

©All copyright reserved.
版權所有，翻印必究。

E-mail: renthang@renthang.com



Ren Thang Co., Ltd.

TEL: +886-2-82011187、22021205

FAX: +886-2-22039391、22021204

www.renthang.com

©All copyright reserved.
版權所有，翻印必究。

E-mail: renthang@renthang.com