

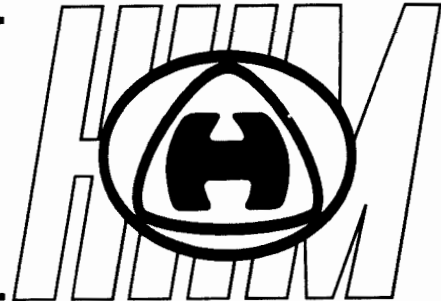
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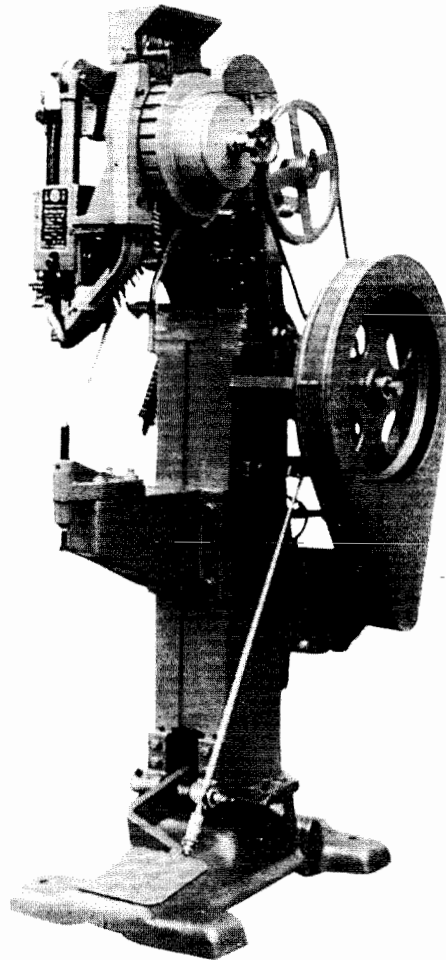
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MANUFACTURER OF AUTOMATIC FASTENING
MACHINE FOR SNAP FASTENERS RIVETS &
EYELETS.



HM-612MF
HM-612CF

二冲程重型鉚釘機
RIVETING MACHINE



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前 言

本公司手冊由何宏明企業股份有限公司印製，專供使用人對本公司生產的鉚釘機實施保養時之參考以及請購零件時的正確依據。

此機器是屬於二冲程重型鉚釘機，不僅速度快，而且操作方便、安全可靠，頗受國內外的顧客歡迎，業已享譽國際數十年。

一般使用說明

一 機器裝設：

1. 馬達： $\frac{1}{2}$ HP。
2. 電壓：110 與 220 伏特兩用或 220 三相，50~60HZ。
3. 適合打的鉚釘長度 15~32^m、線徑 4.5 ~ 5^m、面徑 8.5 ~ 10^m。
4. 適合之工作物：嬰兒車、鋁製樓梯板、閉合式海灘椅、特殊工具箱等。
5. 喉徑：10"。
6. 毛重：210 kg
7. 包裝尺寸：24" × 34" × 63"。

二 更換鉚釘長度及線徑（腳管徑）所須注意事項：

1. 本機使用鉚釘長為（15~32^m），鉚釘長在（15~22^m）用一種上夾頭及下模，鉚釘長在（23~32^m）用另一種上

夾頭及下模只要您使用的鉚釘長由（ 15 ~ 22^m）改變為（ 23 ~ 32^m）或要由 23 ~ 32^m）改變成（ 15 ~ 22^m）時，則需更換上夾頭及下模。

2. 如果鉚釘的線徑（腳管徑）更改時則須要換全套選料另件，如有以上兩點之情況則希望能與本公司連繫，以助您順利完成換釘工作。

三開機時應注意事項：

1. 使用電動操作前務必先作安全檢查，使用電壓是否與馬達電壓及簽約之電壓一樣。
2. 未接電源時，先手轉動調整上下模之適當距離然後手動將飛輪轉動一週，以防不測而損壞機件。
3. 各零件有油孔處要加機油，有黃油杯處要加黃油以供零件潤滑以保正常運轉。
4. 零件損壞時，請記下目錄內之零件號碼，例：A-15 或 B-03 與本公司連絡以便能正確且快速的將所需之零件寄上。

ODUCTION

THIS BOOKLET IS PUBLISHED BY HO HUNG MING ENTERPRISES CO., LTD, TO PROVIDE THE USERS WHO HAVE PURCHASED THE HM-512CF MACHINES FOR PERFORMANCE AND PARTS SUPPLY.

THIS MACHINE IS A TWO-STROKE HEAVY RIVETING MACHINE, ITS SPEED IS FAST AS WELL AS SAFETY IS PERFECT. OUR PRODUCTS HAVE GOOD SALE, COMMENTS AND CONFIDENCE FROM USERS OF HOME AND ABROAD RECENTLY FOR A DECADE.

GENERAL DESCRIPTION

1.DATA :

(1)MOTOR : 1/2HP.

(2)VOTAGE : 110V, 220V, 3PH, 50-60HZ.

(3)THE SUITABLE REVIT IS 15-32^{m/m} LENGTH. \ 4.5-5^{m/m} SHANK. \ 8.5-10^{m/m} FACE DIAMETER.

(4)SUITABLE WORKING PIECES :

LEATHER GOODS : ALUMINUM LADDER PLATE, FOLDING BEACH-CHAIR, SPECIAL TOOL-BOX, BABY CARRIAGE.

(5)THROAT DEPTH : 10"

(6)GROSS WEIGH : 210KG

(7)PACKING SIZE : 24" × 34" × 63"

2. CAUTIONS :

(1) THE LENGTH OF RIVETS IS FITTED THIS MACHINE FROM $15\frac{m}{m}$ TO $32\frac{m}{m}$ WITH PROPER UPPER JAWS AND LOWER DIE. IF LENGTH IS FROM $23\frac{m}{m}$ TO $32\frac{m}{m}$ THE PROPER UPPER JAWS AND LOWER DIE MUST BE CHANGED. IN OTHER WORDS, IN DIFFERENT LENGTH OF RIVETS MUST BE FITTED WITH PROPER UPPER JAWS AND LOWER DIE.

(2) IF THE RIVET LENGTH IS CHANGED FOR $15-32\frac{m}{m}$ ITS SHANK MUST BE CHANGED, THEREFORE A SET OF FEEDING SYSTEM PARTS MUST BE CHANGED FOR THE RIVETS WHICH YOU WANT. ANY PROBLEM, PLEASE NOTIFY US TO HELY YOU.

3. CAUTIONS OF OPERATION :

(1) BEFORE OPERATION, YOU SHOULD CHECK THE VOTAGE AS YOUR MOTOR'S.

(2) BEFORE SWITCHING THE POWER, YOU SHOULD CHECK THE PROPER DISTANCE BETWEEN UPPER AND LOWER DIES BY TURNING THE FLYWHEEL IN ONE COMPLETE TURN WITH HAND.

(3) TO DROP THE OIL INTO THE HOLES TO LUBRICATE THE MOVING PART, AND PUT THE GREASE INTO THE CUP.

(4) WORNOUT PARTS MUST BE RESUPPLIED FROM OUR COMPANY AS YOU SEND TO US THE CORRECT PART NUMBERS, AS SHOWN A-15, B-03 AS SOON AS POSSIBLE.



BASE SEAT SYSTEM EXPLODED VIEW (FIG. 1)

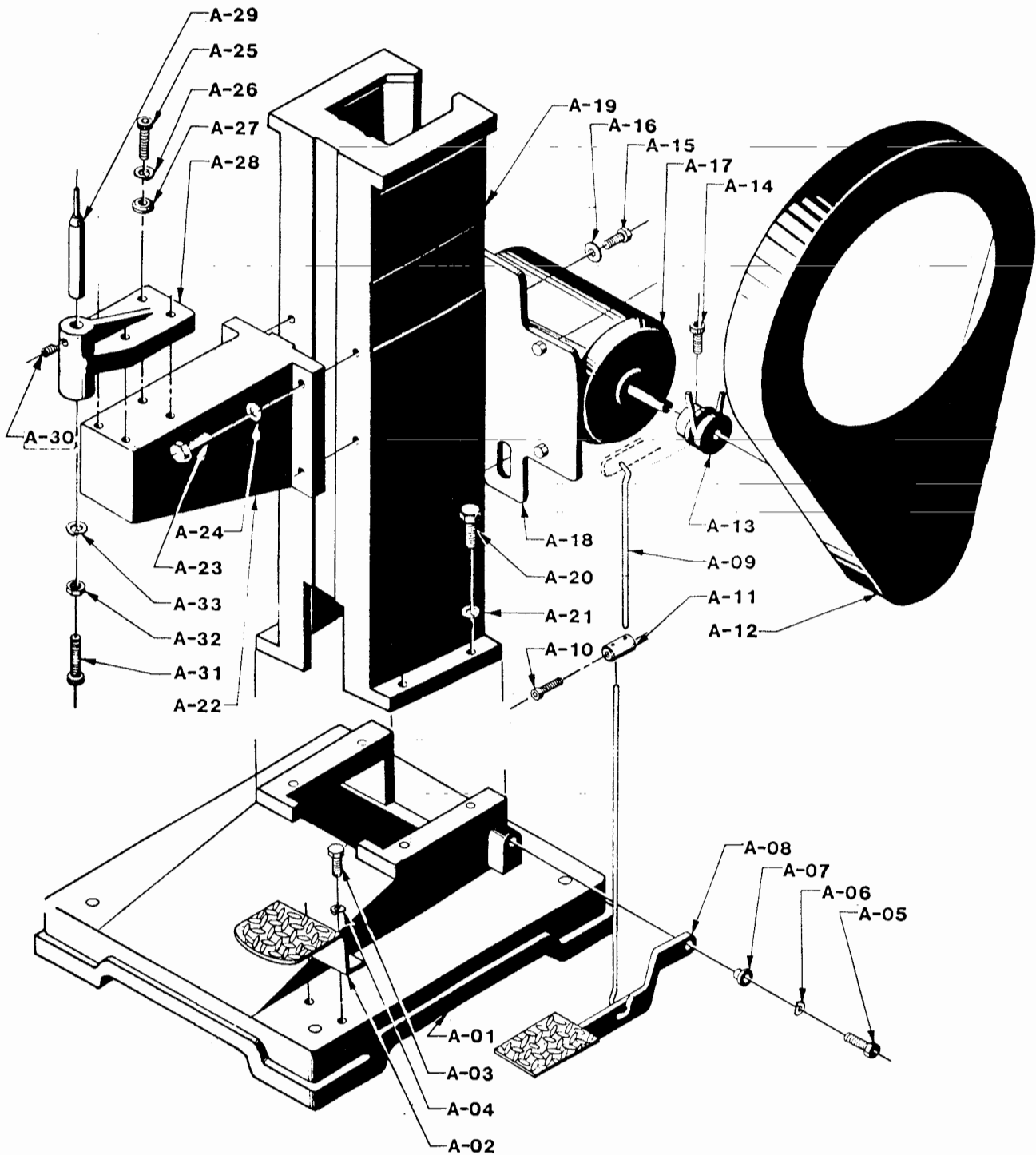




圖1 零件表

組別 項次 Group Item	名 稱 Description	數量 Qty	附 記 Remarks
A-01	底座Base seat	1	
A-02	踏板Pedal stop plate	1	
A-03	螺絲Screw	2	3/8"φ × 5/8" l
A-04	彈簧墊圈Spring washer	2	3/8"φ
A-05	螺絲Screw	1	3/8"φ × 1 1/4" l
A-06	彈簧墊圈Spring washer	1	3/8"φ
A-07	腳踏襯套Pedal bush	1	
A-08	腳踏Pedal	1	
A-09	控制勾頭Control rod	2	
A-10	螺絲Screw	2	5/16"φ × 1/2" l
A-11	接頭勾套Connector	1	
A-12	安全護蓋Cover (flywheel)	1	
A-13	馬達皮帶輪Motor pulley	1	
A-14	馬達輪固定螺絲Pulley screw	1	5/16"φ × 3/4" l
A-15	馬達輪固定螺絲Motor bearer screws	3	3/8"φ × 1 1/4" l
A-16	平墊圈Flat washer	3	3/8"φ
A-17	馬達Motor	1	
A-18	馬達固定板Motor bearer	1	
A-19	台身Body	1	
A-20	固定螺絲Fixed screw	4	1/2"φ × 1 1/4" l
A-21	彈簧墊圈Spring washer	4	1/2"φ
A-22	下模座Lower die seat	1	
A-23	下模座固定螺絲Lower die seat screw	4	1/2"φ × 2 1/2" l
A-24	彈簧墊圈Spring washer	4	1/2"φ
A-25	螺絲Screw	4	3/8"φ × 1 1/2" l
A-26	彈簧墊圈Spring washer	4	3/8"φ
A-27	平墊圈Flat washer	4	3/8"φ
A-28	下模固定座Lower seat fixed	1	
A-29	下模組Lower die	1	
A-30	下模固定螺絲Lower die fixed screw	1	5/16"φ × 5/16" l
A-31	下模調整螺絲Lower die adjusting screw	1	1 3/8"φ × 3" l
A-32	螺帽Nut	1	3/8"φ
A-33	彈簧墊圈Spring washer	1	3/8"φ



UPPER SEAT SYSTEM EXPLODED VIEW (FIG. 2)

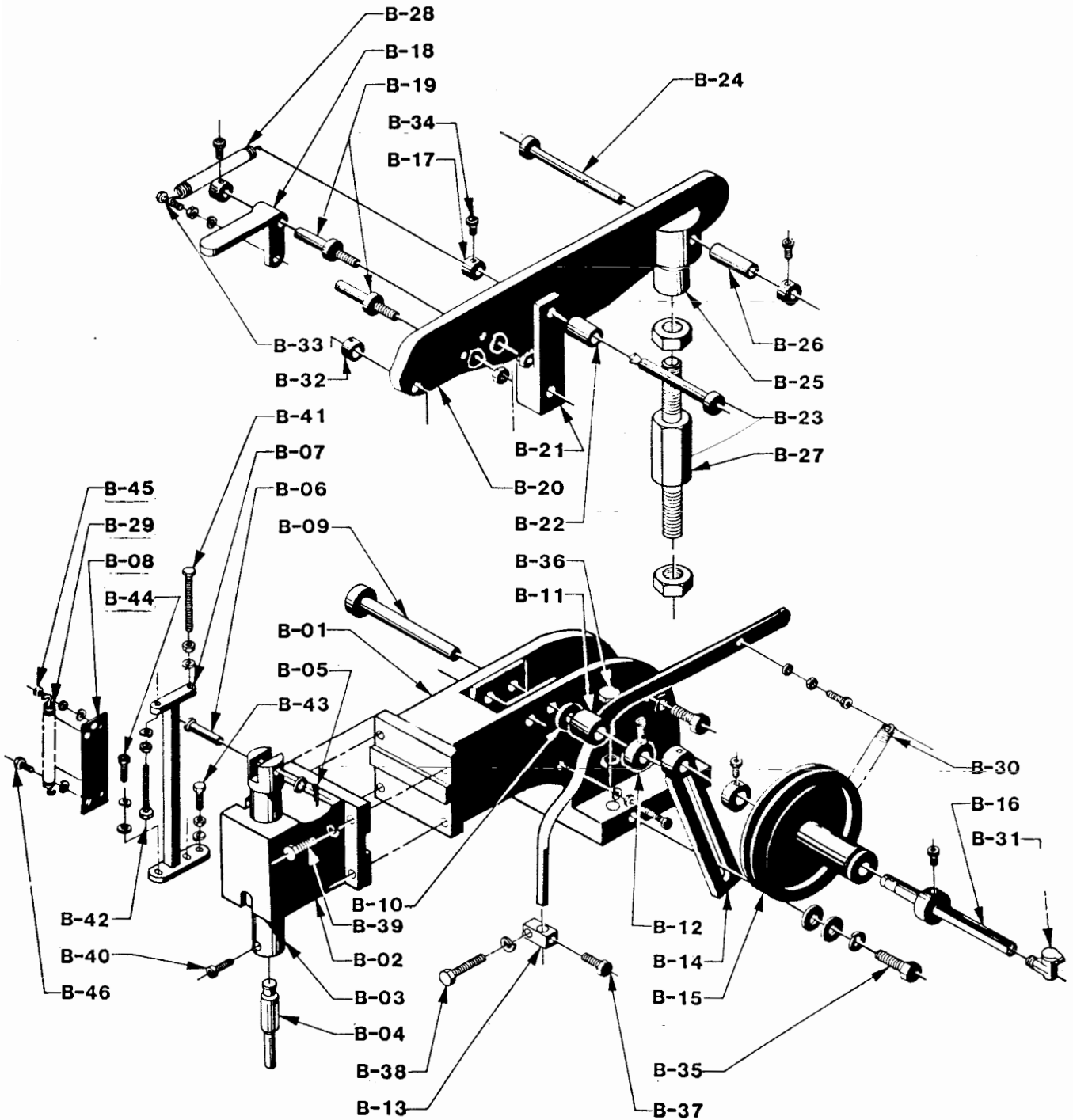




圖2 零件表

組別 項次 Group Item	名稱 Description	數量 Qty	附記 Remarks
B-01	上座Upper seat	1	
B-02	機頭Working head	1	
B-03	上模管身Upper die seat	1	5/8"
B-04	上模Upper die	1	
B-05	開口梢Pin, cutter	1	2"×40 ℓ
B-06	固定梢Pin	1	
B-07	四角滑條Square sliding bar	1	
B-08	滑條蓋板Cover sling bar	1	
B-09	固定柱Long bolt	1	
B-10	環套Spacer	1	1 1/4"×5/8"×10"
B-11	控制進料桿Controlling handle, feeding	1	
B-12	固定環套Ring lock with screw	1	
B-13	固定控制進料桿方鐵Block, feeding controller	1	
B-14	皮帶輪支持架Pulley support	1	
B-15	傳動皮帶輪Driving pulley	1	
B-16	皮帶輪支持軸Pulley shaft	1	5/8"×200 ℓ
B-17	固定環套Ring lock with screw	4	
B-18	拍動板Patting control plate	1	
B-19	固定螺柱Shafting pin	2	
B-20	壓板Pressing plate	1	
B-21	U形槽方鐵U-slot block	1	
B-22	墊套Fixed sleeve	1	1"×1/2"×1 1/4" ℓ
B-23	固定柱Shaft bolt	1	
B-24	固定柱Shaft bolt	1	1/2"×145 ℓ ~150 ℓ
B-25	傳力接頭U-slot adopter	1	
B-26	滑套Sliding sleeve	1	
B-27	傳力六角螺柱Screw pin-ended	1	
B-28	彈簧Spring	1	18.5"×2"×116 ℓ
B-29	彈簧Spring	1	11"×1.3"×108 ℓ
B-30	彈簧Spring	1	15"×2"×145 ℓ
B-31	油杯Grease cup	1	1/8"
B-32	襯套Bush	2	3/4"、5/8"各一個
B-33	螺絲Screws	3	5/16"×1/4" ℓ
B-34	螺絲Screws	6	5/16"×1/2" ℓ
B-35	螺絲Screws	1	1/2"×1 1/2" ℓ
B-36	螺絲Screws	4	1/2"×2" ℓ
B-37	螺絲Screws	1	3/8"×3/4" ℓ
B-38	螺絲Screws	1	3/8"×2" ℓ
B-39	螺絲Screws	4	3/8"×1 1/4" ℓ
B-40	螺絲Screws	1	3/8"×1" ℓ
B-41	螺絲Screws	1	5/16"×2" ℓ
B-42	螺絲Screws	1	5/16"×3"
B-43	螺絲Screws	1	5/16"×1" ℓ
B-44	螺絲Screws	2	1/4"×3/4" ℓ
B-45	螺絲Screws	1	3/16"×3/4" ℓ
B-46	螺絲Screws	4	1/4"×5/8" ℓ



FLY-WHEEL CLUTCH AND TRANSFER SYSTEM EXPLODED VIEW

(FIG. 3)

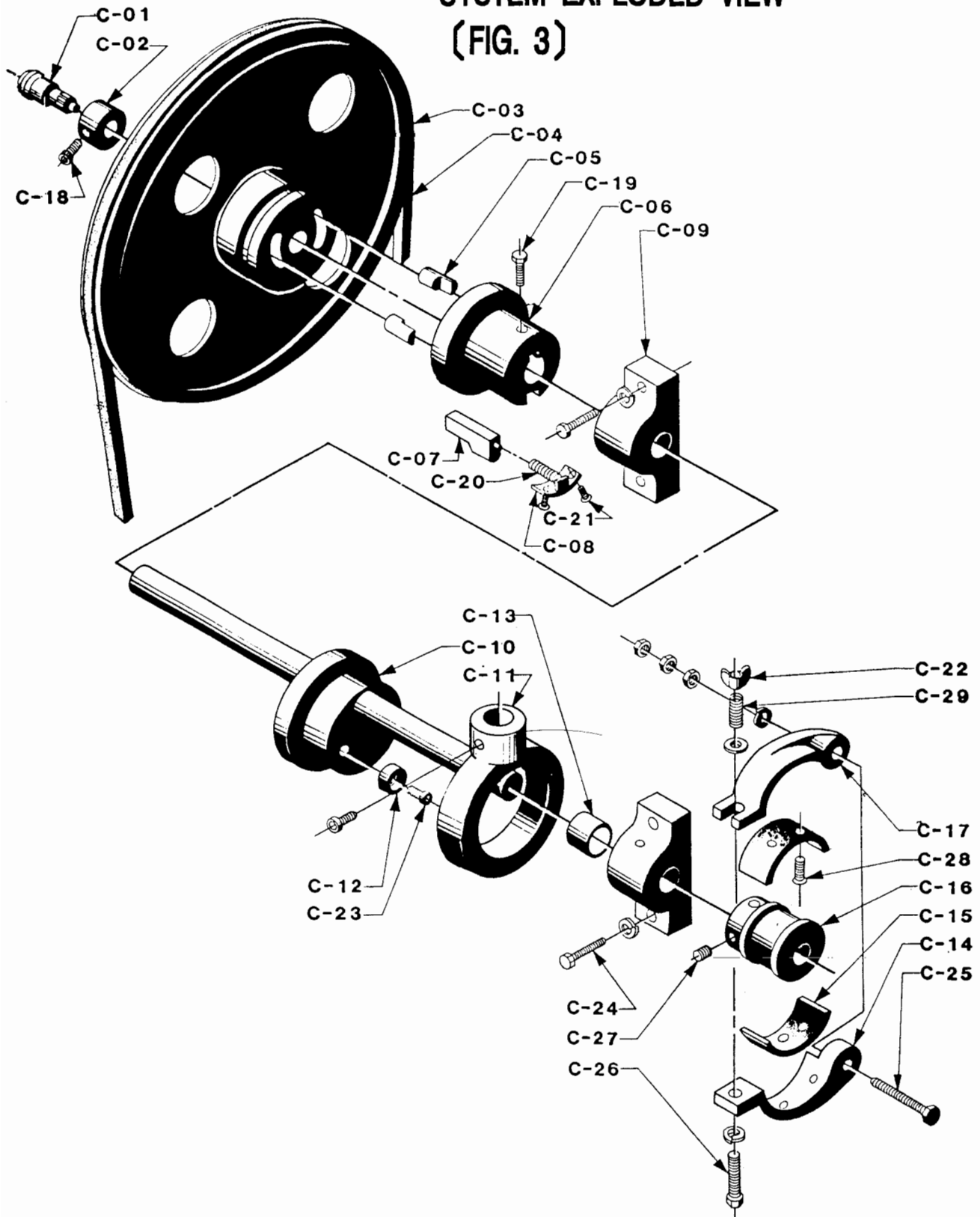




圖3 零件表

組別 項次 Group Item	名稱 Description	數量 Qty	附記 Remarks
C-01	黃油杯Grease cup	1	1/8"
C-02	固定環套Collar, with screw	1	1 1/2"×1"×16'
C-03	主傳動飛輪Fly wheel	1	
C-04	皮帶Belt	1	A-57
C-05	飛輪梢Inserts, fly wheel	2	
C-06	離合器卡姆Clutch cam	1	
C-07	離合梢Clutch cam key	1	
C-08	止擋片Stop plate	1	
C-09	軸座Shaft seat	2	
C-10	偏心輪軸Cam crank	1	
C-11	傳動環Ring sleeve	1	
C-12	固定墊環Fixing ring	2	
C-13	墊套Bush	1	1 1/4"×1"×10'
C-14	剎車弓仔Brake lining frame	1	
C-15	剎車皮Brake lining	2	
C-16	剎車輪Brake wheel	1	
C-17	剎車弓仔Brake lining frame	1	
C-18	螺絲Screws	1	5/16"×1/2"l
C-19	螺絲Screws	2	3/8"×3/4"l
C-20	彈簧Spring	1	1°×12°×40l×4.5"
C-21	螺絲Screws	2	1/4"×5/8"l
C-22	蝶形螺姆Thumb-nut	1	3/8"
C-23	螺絲Screws	2	3/8"×1"l
C-24	螺絲Screws	4	3/8"×1 3/4"l
C-25	螺絲Screws	1	1/2"×2 5/8"l
C-26	螺絲Screws	1	3/8"×3"l
C-27	螺絲Screws	2	3/8"×1/2"l
C-28	螺絲Screws	4	3/16"×1"l
C-29	彈簧Spring	1	10°×2.2°×5°×40l



CLUTCH CONTROLLING SYSTEM EXPLODED VIEW (FIG. 4)

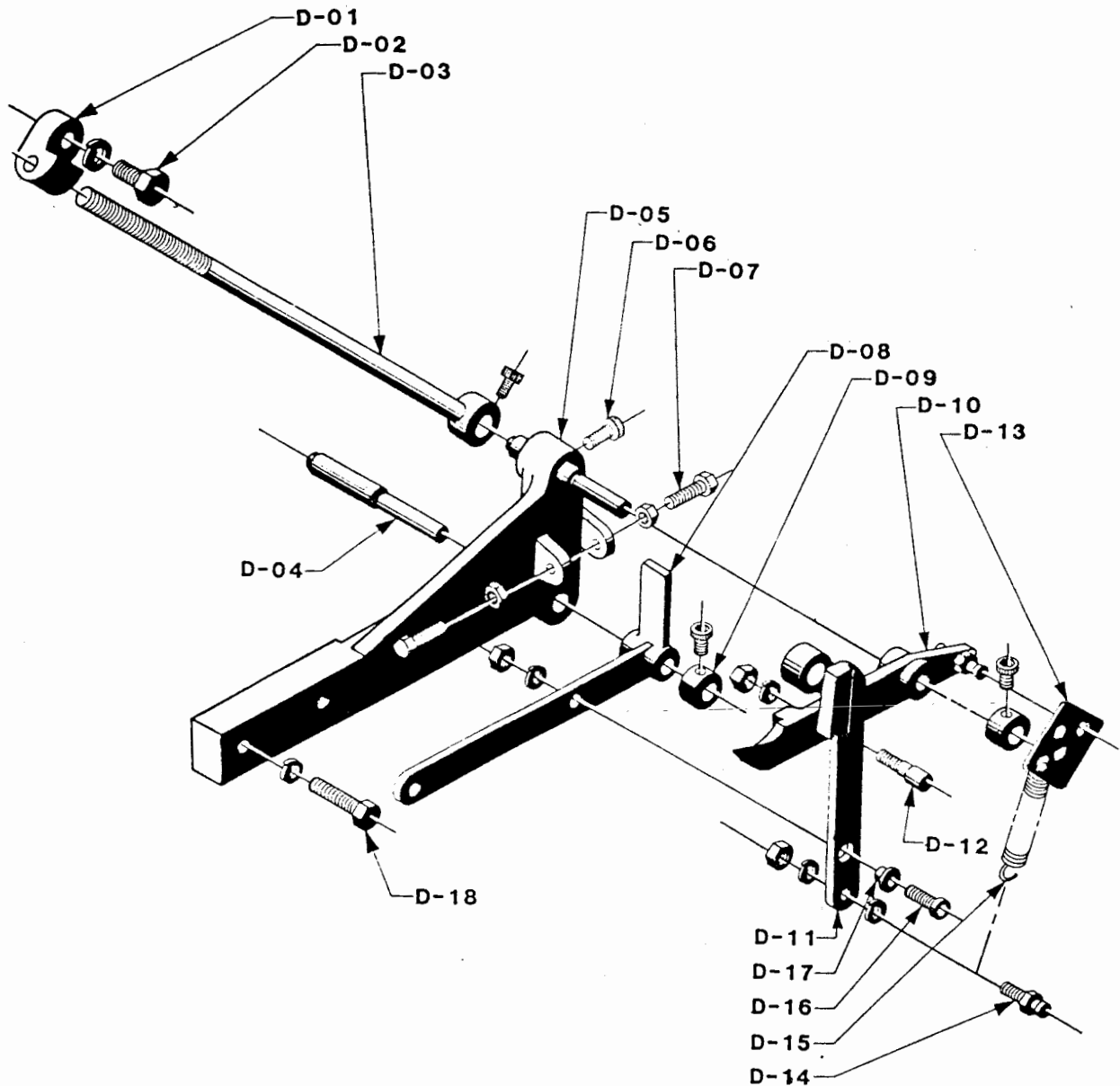




圖4 零件表

組別 項次 Group Item	名稱 Description	數量 Qty	附記 Remarks
D-01	固定塊Fixed block	1	
D-02	固定螺絲Screw, Fixed Block	1	1/2"×1 1/4"l
D-03	固定螺柱Fixed Post	1	
D-04	固定柱Pin	2	115l
D-05	支架Bracket	1	
D-06	固定螺絲Screw, bracket	2	5/16"×5/8"l
D-07	調整螺絲Adjusting screw	1	5/16"×1 1/4"l
D-08	控制板Rocking rod arm	1	
D-09	固定環套Ring collar with screw	2	
D-10	斧頭Clutch lever	1	
D-11	離合器勾頭Clutch lever hook	1	
D-12	勾頭固定螺柱Clutch lever pin	1	
D-13	勾彈簧板Hook plate	1	
D-14	勾彈簧螺柱Spring holder	2	
D-15	彈簧Spring	1	2°×16°×78l
D-16	固定螺絲Fixing screw	1	3/8"×1"l
D-17	離合器勾頭襯套Hook bush	1	
D-18	固定螺絲Screw, Bracket	2	3/8"×1 1/2"l

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FEEDING SYSTEM EXPLODED VIEW

(FIG. 5)

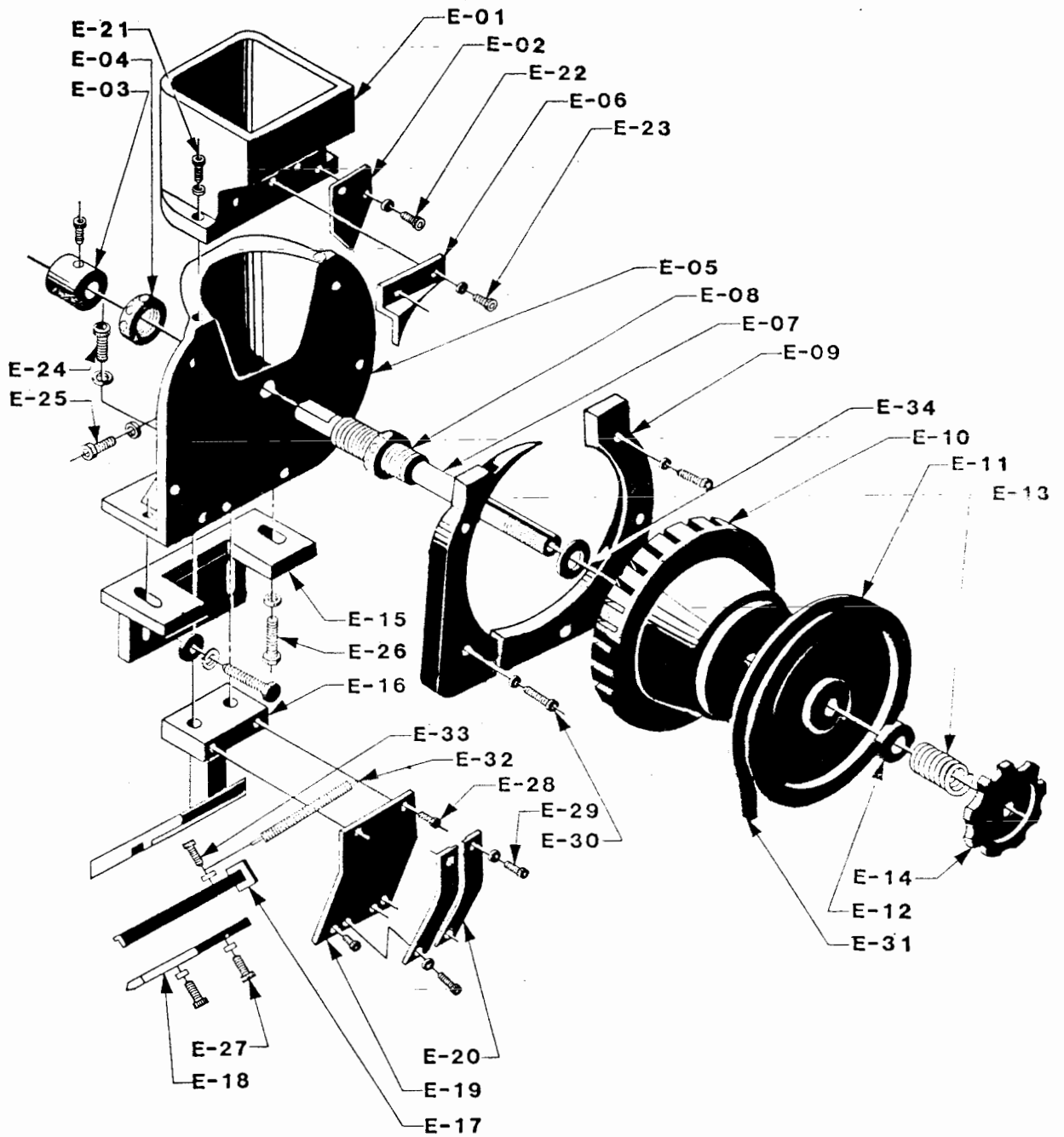


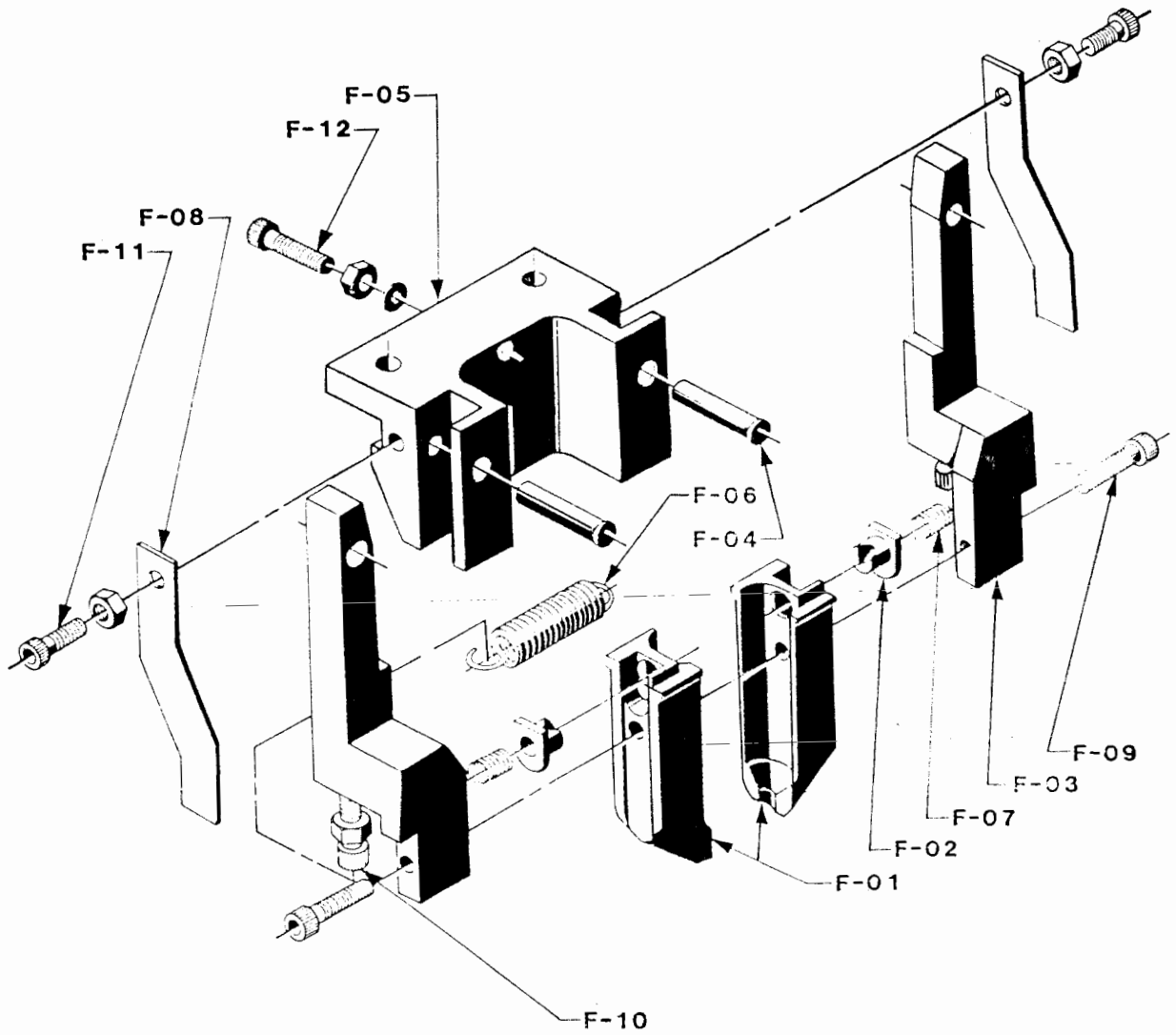


圖5 零件表

組別 項次 Group Item	名 稱 Description	數量 Qty	附 記 Remarks
E-01	漏斗入口Hopper	1	
E-02	擋片Stop plate	1	
E-03	固定圓套Fixing sleeve	1	
E-04	固定螺姆Ring nut	2	
E-05	漏斗板Chuting plate	1	
E-06	擋片Stop plate, (hshape)	1	
E-07	心軸Spindle	1	
E-08	螺紋套Threaded pipe	1	
E-09	四角環Square ring shield	1	
E-10	選料齒輪Hopper cone	1	
E-11	皮帶輪Pulley	1	
E-12	圓套Ring spacer	1	
E-13	壓縮彈簧Press spring	1	4"×25"37 <i>l</i>
E-14	漏斗把手Support handle	1	
E-15	漏斗支架Hopper support	1	
E-16	下流道固定支架Lower track holder	1	
E-17	控制片Controller	1	
E-18	下流道Lower track	1	
E-19	填板Feeding plate	1	
E-20	上流道Upper track	1	
E-21	螺絲Screws	2	1/4"×1 1/2" <i>l</i>
E-22	螺絲Screws	2	1/4"×3/8" <i>l</i>
E-23	螺絲Screws	2	1/4"×5/8" <i>l</i>
E-24	螺絲Screws	2	3/8"×1 1/2" <i>l</i>
E-25	螺絲Screws	1	5/16"×1" <i>l</i>
E-26	螺絲Screws	2	3/8"×1 1/2" <i>l</i>
E-27	螺絲Screws	4	1/4"×3/4" <i>l</i>
E-28	螺絲Screws	4	3/16"×3/8" <i>l</i>
E-29	螺絲Screws	4	1/4"×1/2" <i>l</i>
E-30	螺絲Screws	5	1/4"×1 1/2" <i>l</i>
E-31	皮帶Belt	1	M-35
E-32	彈簧Spring	1	1"×3/8"×145" <i>l</i>
E-33	螺絲Screw	1	3/16"×3/4" <i>l</i>
E-34	特殊墊片washer	1	31.75"×16.5"×2" <i>m</i>



UPPER JAWS SYSTEM EXPLODED VIEW (FIG. 6)



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圖6 零件表

組別 項次 Group Item	名 稱 Description	數量 Qty	附 記 Remarks
F-01	上夾頭組Upper Jaws set	1	
F-02	活動支點Living point of support	2	
F-03	夾頭支架Jaw holder set	1	
F-04	圓梢Pin	2	
F-05	夾頭支架固定座Jaw fixing support	1	
F-06	彈簧Spring	1	1.5°×10°×30 <i>l</i>
F-07	彈簧Spring	2	0.3°×4°×7 <i>l</i> ×1.5°
F-08	彈簧鋼片Leaf spring	2	
F-09	螺絲Screws	2	3/16"°×3/4" <i>l</i>
F-10	螺絲Screws	2	3/16"°×3/4" <i>l</i>
F-11	螺絲Screws	2	3/16"°×3/8" <i>l</i>
F-12	螺絲Screws	1	3/16"°×5/8" <i>l</i>



UPPER SEAT SYSTEM EXPLODED VIEW
(FIG. 7)

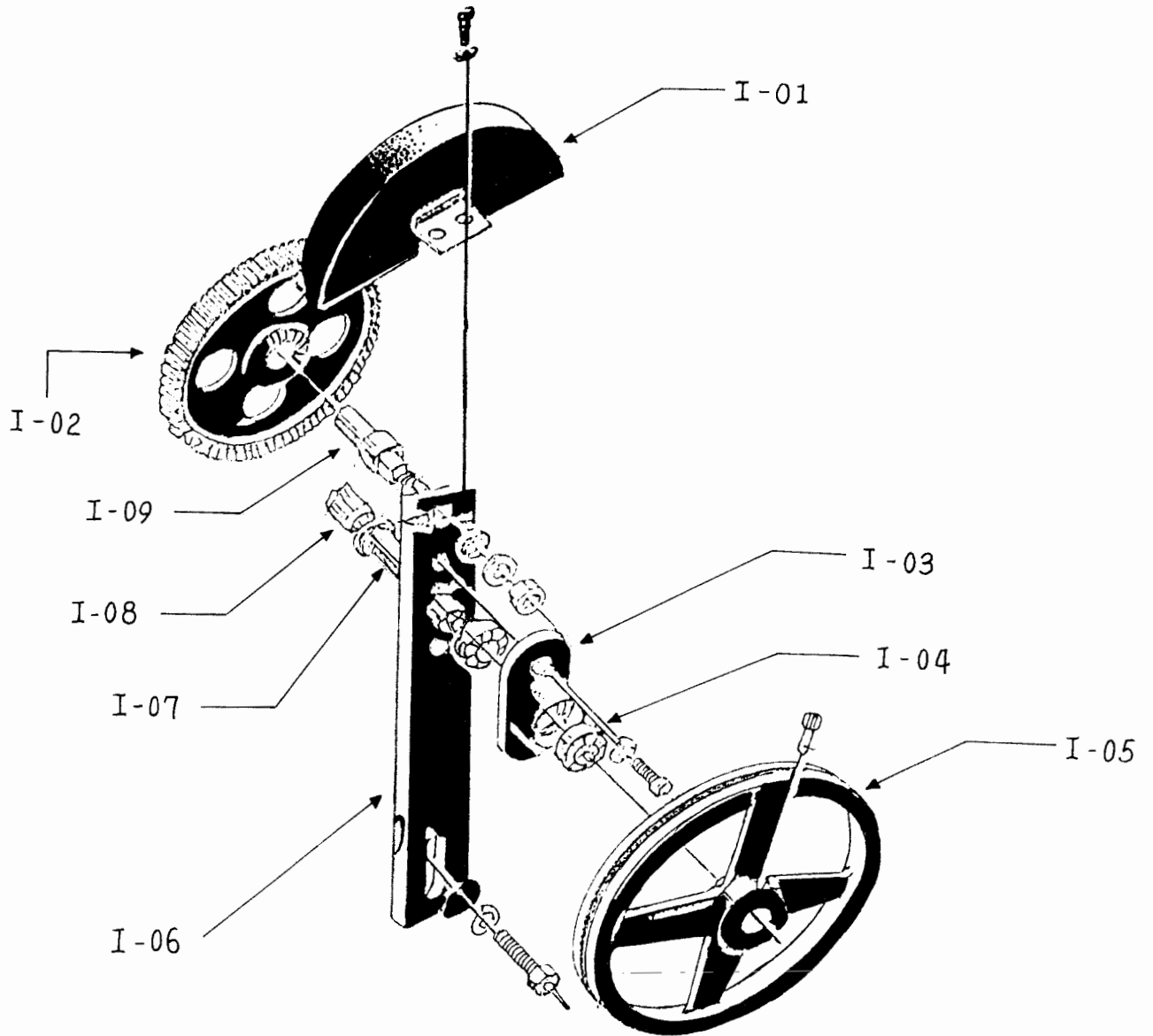
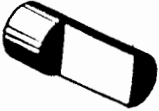
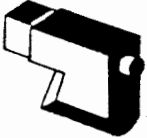



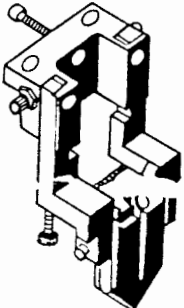




圖7 零件表

組別 項次 Group Item	名 稱 Description	數量 Qty	附 記 Remarks
I-01	蓋Cover		
I-02	齒輪Gear		
I-03	軸承座Bearing seat		
I-04	軸承Bearing		
I-05	皮帶輪Fly wheel belt		
I-06	支架Bracket treadle rod arm		
I-07	固定支柱Fixed spindle		
I-08	齒輪Gear		
I-09	固定支柱Fixed spindle		

正常損耗零件表
NORMAL WORNOUT PARTS

零件圖 Parts	組別 項次 Fig No.	名稱 Description	損耗 (工/時) Worn Out (W/Hr)	附記 Remarks
	C-05	飛輪梢 Flywheel Inserts	3000Hrs	注意飛輪離 合器之定期保 養。 With care of the flywheel, clutch, and shaft
	C-07	離合梢 Clutch Cam Key	3000Hrs	
	D-10	斧頭 Clutch Lever	3000Hrs	Lubricating performance in regular Maintenance
	B-04	上模 Upper Die		
	A-29	下模 Lower Die		
		夾頭 Jaws		夾頭組可以更換但要依釦子規格而定。 Jaws will be changeable, which are determined with the specifications of the buttons