



鞋釦五金操作要點說明書

鞋眼、釘、釦腳長設定方法
機器選用及打釦操作



鉅舜工業股份有限公司
JEY SUN INDUSTRIAL CO., LTD.



品質保證、誠信服務
客戶滿意、永續經營
Quality Guarantee, Sincere Service
Customer Satisfaction, Permanent Business



鉅舜工業股份有限公司
JEY SUN INDUSTRIAL CO., LTD.



東莞鉅舜五金塑膠製品廠
DONG GUAN JEY SUN INDUSTRIAL CO., LTD.



群泰實業有限公司
CHUN TAI INDUSTRIAL COMPANY



客戶的滿意・是我們的目標 客戶的權益・是我們的責任

*THE SATISFACTION OF CUSTOMER IS OUR GOAL
THE RIGHTS AND INTERESTS OF CUSTOMER IS OUR DUTY*

創立日期：1979年

登記資本額：2,204萬

廠房：2,640 M²

員工：120名

廠房：23,000 M² (中國廠)

員工：1000名 (中國廠)

主要產品：鞋眼、登山釦、空心釘、撞釘、鋅鎂錠、四合釦及皮件、女鞋飾釦

DATE OF ESTABLISHMENT: 1979

REGISTRATION CAPITAL: NT.22.04 MILLION

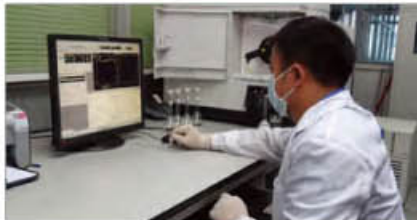
AREA OF FACTORY: 2,640 M²

EMPLOYEES: ONE HUNDRED TWENTY

AREA OF FACTORY: 23,000 M² (CHINA)

EMPLOYEES: ONE THOUSAND (CHINA)

MAIN PRODUCTS: EYELET, SHOE BUCKLE, HOLLOW RIVET, RIVET, ZINC BUCKLE, SNAP BUTTON & ACCESSORIES FOR LEATHER AND LADIES SHOES ORNAMENTS.



鉅舜公司為生產各式五金配件，針對鞋業皮件的主力產品為鞋眼、飾釦等各種產品，月產量達七億八千萬粒，年營業額達拾貳億，市場行銷遍及東南亞及世界各地。

鉅舜公司為配合一貫作業加工流程，如焊接、拋光、組裝、振動、點漆等製造過程，而擁有全自動電腦控制設備、自動沖床、壓鑄機、焊接機、烤漆設備、耐酸設備、電鍍設備、模具、壓力機（甩模機）等專業機械多項設備。

為了強化公司體質及產品品質穩定與水平，公司於1999年通過ISO 9002國際品質認證，並於2001年通過ISO 9001:2000新版品質認證。2005年因應內需市場需要，成立東莞二廠群泰實業有限公司。2007年起陸續添購全自動立式壓鑄機、4模4沖螺絲成型機、感應耦合電漿放射光譜儀器來監測產品有毒物質含量、鞋眼耐磨測試機，設置自動包裝線和全自動烘房烤漆設備；2011年設置自動排釘機和實施LCD電腦看板管理系統、持續以精益求精，永無止境改善，創新服務客戶為目標。

鉅舜公司在面對市場上同業競爭，目前致力於產品品質與服務品質的提昇，業務上更以成立據點的方式分佈台北、台中及大陸廣東分公司、中山服務所、福建辦事處、越南聯絡處，盡可能提供客戶完善服務。自動化生產，大量節省人力，使價廉物美，品質穩定、優良的服務，是鉅舜公司在市場上致勝的原因。

INTRODUCTION

In Jey Sun, we manufacture all kinds of hardware accessories. Primary products for shoes and leather are eyelets, ornamental accessories, and etc. Our monthly capacity is 780 million pieces, and the yearly turnover is 1.2 billion. We've exported our products to Southeast Asia and worldwide.

Production equipment of JEY SUN CO., LTD. We have automatic punching machine, computer controlled die-casting machine, welding machine, automatic painting equipment, corrosion proof equipment, electrical plating equipment, molding machine, and sample instant molding machine to operate with production process flow of welding, polishing, assembling, vibratory finishing, touch up paint, and etc.

For the purpose to enhance the scale of our company and the stable and level of product, we were granted ISO 9002 international quality accreditation in 1999. Seeking for the approval of ISO 9001:2000 new revision in 2001*To meet the growing domestic market demands, factory 2: Chun Tai Industrial Company was set up in 2005 in Dong Guan. From 2007, we've upgraded our production equipments such as automatic standing casting machine, 4-mold & 4-punch bolt former machine, ICP optical emission spectrometer to monitor the restricted substances in materials, eyelet abrasion tester, automatic packing line, and automatic computer-controlled painting equipment. In 2011, we have set up the Automatic Eyelet Arranging Machine and implemented LCD E-Kanban management system. Through ever seeking improvements, and professional abilities, we deliver the most innovative products and sincere service to our customers as top priority.*

JEY SUN INDUSTRIAL CO., LTD. devotes to promote the quality of products and service at present time for the market competition.

The sales offices are separately established in Taipei and Taichung, and also branch office in Guang Dong, China, and Chung Shan office, Fujian office, Vietnam office offer the best service for customers. The reasons for JEY SUN INDUSTRIAL CO., LTD. to win the market are due to auto-producing, massively man- power saving, competitive price, stable quality and the excellent service etc.

鉅舜五金本著強韌創業理念與提升服務品質，並能方便客戶快速交貨；嚴格品質管制並大規模生產，從代客設計、開發、沖製、電鍍、烤漆、包裝一貫作業。

挑戰困難、突破瓶頸，鉅舜五金屹立於五金界之領導地位，共創佳績，創造未來。

In view of many shoes and bags factories that had been translocated in Mainland China, and being easier to furnish services and deliveries, we had established the Dong Guan Jey Sun Industrial Co., Ltd. in Guang Dong in 1996. It is an integrated factory specialized in manufacturing, designing for customers, developing, punching, electroplating, painting, and packing. Mass production, serious quality control are making the company to have a leading position in the field of hardware.

At the same time, the company is always to keep a strength concept of engagement to challenge and overcome the difficulties and to have merit future.



追求合理化之經營

台灣總公司創立於1979年，1996年鑒於鞋廠、皮件廠等產業外移中國大陸，為配合客戶方便及提升服務品質，故在東莞設廠。

公司名稱：東莞寮步鎮廈鉅舜五金塑膠製品廠

創立日期：1996年

地址：東莞市寮步鎮鎮廈管理區

主要產品：(1) 鞋類五金：鞋眼、鞋釦、登山釦、空心釘、飾釦

(2) 皮件五金：開叉釘、中空釘、撞釘、鋅合金

(3) 其他：女鞋五金、飾品等各類五金、塑膠釦之設計製作

本公司於1999年通過 ISO 9002 品質認證。

2001年通過 ISO9001:2000 新版品質認證。

明定公司品質目標、品質承諾及品質管理之組織與職掌，以確保品質系統能正常運作。

PURSUANCE OF REASONABLE OPERATION

The head office in Taiwan was found in 1979, DONG GUAN plant was established for providing convenience and promote service quality to our customers in 1996 due to moving of shoes manufacturers and leather factories.

Company: DONG GUAN JEY SUN INDUSTRIAL CO.,LTD.

Date of founding: 1996

Address: Lin-Hsia District Liao-Pu Town, Dong Guan City, Guang Dong, CHINA.

Main products:

- (1) SHOES HARDWARE: EYELET, SHOE BUCKLES, HOLLOW RIVETS, ORNAMENTS.
- (2) LEATHER HARDWARE: BIFURCATED RIVETS, CENTER EMPTY RIVETS, RIVETS.
- (3) OTHER: HARDWARES FOR LADIES SHOES, ORNAMENTAL ACCESSORIES, STATIONERY, METAL BUTTON ETC.

We were granted ISO 9002 international quality accreditation in 1999, of perfect ISO9001:2000 new revision in 2001, which expressly set the quality target, quality commitment and quality management organization and responsibility, in order to ensure the normal operation of the quality system.



鞋眼、钉、扣脚长设定方法

机器选用及打扣操作说明书

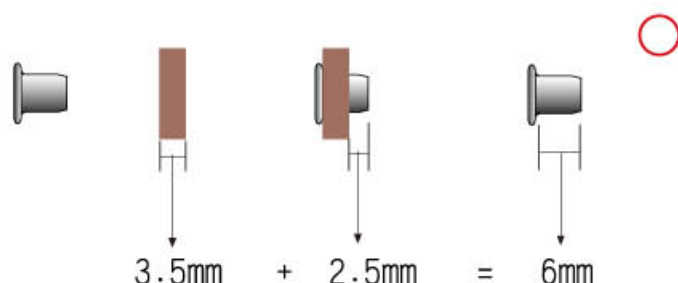
一. 鞋眼及钉扣脚长设定

1. 鞋眼样式多种，但其脚长设定方式都一样：

先测出鞋面厚度（鞋面需打扣的地方用游标卡尺卡紧鞋面）

其鞋眼脚长需超出鞋面实际厚度2~2.5mm。

例如：鞋面实际厚度3.5mm+2.5mm, 就应选用6mm脚长鞋眼使用最适合。



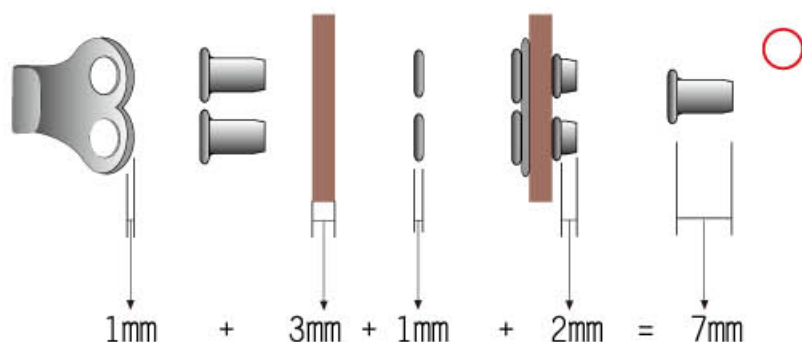
2. 空心钉、中空钉、虎骨类

先测出鞋面厚度是多少（鞋面需打扣的地方用游标卡尺卡紧鞋面）

其钉类脚长需超出鞋面实际厚度2mm。

例如：鞋面实际厚度3mm，主件厚度1mm，

下套或华司1mm，就应选用7mm脚长钉类产品最合适。

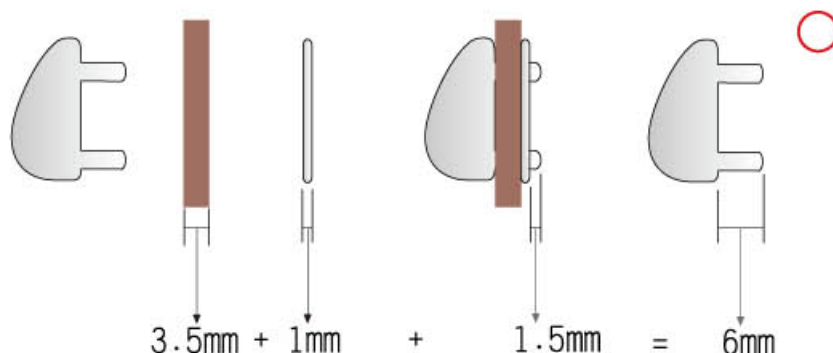


3. 锌合金产品及需铆脚类

先测出鞋面厚度（鞋面需打扣的地方用游标卡尺卡紧鞋面）

其鞋扣脚长超出鞋面实际厚度1-1.5mm即可。

例如：鞋面实际厚度3.5mm，下套或华司厚度1mm，就应选用6mm脚长最合适。



二. 打扣模具之选用：

产品材质及规格的不同，必须选择相对应的打扣模，例如铜眼与铝眼虽规格完全相同，但因材质的区别不可混用或共用打扣模。

三. 正确选用打扣机器的重要性：

机器种类繁多，打扣之前必先确定打扣机器压力是否足够，适合打那一类的扣子，像鞋眼、空心钉类的扣子，使用全自动机台，轻巧又带碗公上下套一次成型，效率好。腰型扣、中空钉、虎骨扣、锌合金扣需铆脚的鞋扣，就应选用半自动机台或铆钉机器才适合，因半自动型机台力道足，打扣才能一次到位达到预期效果。如选用全自动机台打力道不足又很容易使机械损坏，而压力不足，打出来扣子卷脚及所需紧度不能一次到位，像鞋眼及空心钉产品如用半自动机器操作速度太慢，等於大材小用。所以正确选用机器打扣对于品质及工作效率有绝对的重要性。

四. 打扣操作要点说明：

1. 鞋扣放入机器流到碗公内，自行运转时需检查机器配件是否与鞋扣匹配，以避免造成鞋扣刮伤掉漆或挤压变形。此类异常轻则导致鞋扣报废比例高，重则导致鞋子成型後再做繁琐的返工动作。

2. 打扣之前需做好首件操作确认工作，机器压力要调试至恰到好处，上下模对准後，鞋扣先空打确认卷脚是否良好，不能误认压力调紧鞋扣才能打紧，操作不当会造成鞋扣变形、断裂等不安全的隐患。

3. 确定模具、机器完好及动作正常，才能保证打扣品质，试打鞋扣表面不变型、无刮伤、抬脚、卷脚良好，拉力测试合格後，才可安排打扣量产作业。

4. 试打扣或量产打扣作业过程中，如发现鞋扣品质异常或打扣异常时，应立即停止相关作业，或谘询自己厂内相关技术人员或与东莞钜舜联络，东莞钜舜将以最快服务速度给予妥善处理。

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