



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、鋅鎂釦、四合釦及皮件、女鞋飾釦

DATE OF ESTABLISHMENT: 1979

REGISTRATION CAPITAL: NT.22.04 MILLION

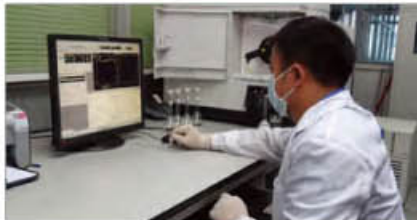
AREA OF FACTORY: 2,640 M²

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：東莞寮步鎮廣鉅舜五金塑膠製品廠

創立日期：1996年

地址：東莞市寮步鎮鎮廣管理區

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.



METHOD FOR SETTING THE FOOT LENGTH OF EYELETS, RIVETS AND SPECIAL SHOE BUCKLES HOW TO SELECT THE EYELET MACHINE AND SET BUTTONS

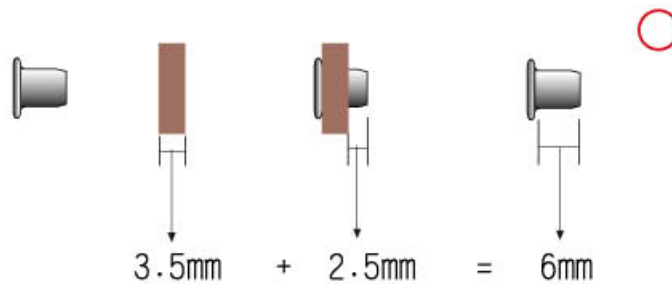
I. Set the foot length for Eyelets , Rivets and Special Shoe Buckles

1. There are many Eyelets styles, but the foot length setting is the same:

First measure the thickness of the upper (Wherever an eyelet needs to be set, tighten the upper with a caliper)

The foot length for the eyelet needs to exceed the actual thickness by 2 ~ 2.5mm.

For example: If the actual upper thickness is 3.5mm +2.5 mm, then 6mm foot length is suitable for the eyelet.

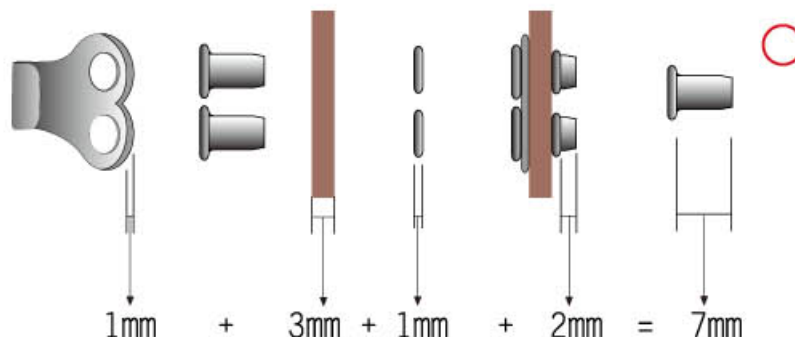


2. Hollow rivets, Semi-Tubular rivets and Hook

First measure the thickness of the upper (Wherever a rivet needs to be set, tighten the upper with a caliper)

The foot length for the rivet needs to exceed the actual thickness by 2 mm.

For example: If the actual upper thickness is 3mm, and the thickness of the main piece is 1mm, then 7mm foot length would be most suitable for 1mm washer.

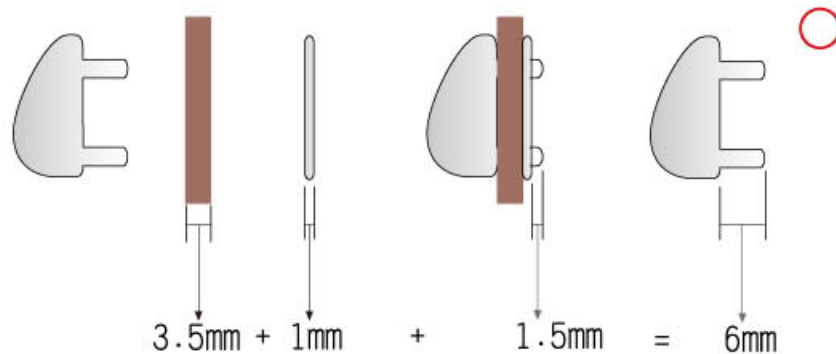


3. Zinc alloy products and rivets

First measure the thickness of the upper (Wherever a buckle needs to be set, tighten the upper with a caliper)

The foot length for the special shoe buckle needs to exceed the actual thickness by 1-1.5 mm.

For example: If the actual upper thickness is 3.5mm, then 6mm foot length would be most suitable for 1mm washer.



II. Selection of tool:

Due to the difference in product materials and specifications, you must select the right tool; For example, although brass eyelets and aluminum eyelets have the same specification, yet due to the difference in material, the tools cannot be mixed or shared.

III. Importance of correct selection of eyelet machine:

There are different types of machines. Before a button is set, you must first determine whether the eyelet machine's pressure is sufficient, and what kind of buttons are suitable. For example, for buttons such as eyelets, hollow rivets, you can use fully automatic machine with ease and finish the molding in just one step, with good efficiency. For shoe buttons such as Velcro eyelet, semi-tubular rivets, hook and zinc alloy buckle rivets, you should use a semi-automatic machine or a rivet machine, because the semi-automatic machine has good strength, thus achieving desired results with only one try. If the automatic machine has not enough strength and causes mechanical damage, and has insufficient pressure, then the setting button will hamper the foot rolled and has no required tightness. For eyelets and hollow rivets, if the semi-automatic machine is operated too slowly, it is a waste of machinery. Therefore, correct use of machinery, quality and efficiency are absolutely important.

IV. Major points in punching operation:

1. Button in the machine will flow into a bowl; while the machine is running, you need to check whether the machine parts match with the button, in order to avoid paint scratch or deformation. Such abnormalities can lead to a high scrap ratio, and if serious enough, it can lead to complicated repair work after the shoes are completed.

2. Before the punching operation, firstly make sure the operation work is well prepared, and the machine is adjusted to its right pressure. After the upper and lower mold is aligned, the button is first set on empty space, to see whether the foot rolled is good enough. Don't mistakenly think that the button can be set tightly only if there is tight pressure. Improper operation will lead to button deformation, fracture and other safety issues.

3. Only when the mold, the machine and the operation are all in normal condition, can the quality of setting button be assured; when there is no surface deformation, scratch and the foot rolled and strength test are all good, then you can start the punching operation.

4. During the punching trial or punching operation process, if you find there are abnormalities of punching or quality issues of buttons, you should immediately stop the operation, or consult with the technical staff in the factory, or contact Dongguan JEYSUN, for immediate support.

研發 · 品質 · 服務





鉅舜工業股份有限公司
JEY SUN INDUSTRIAL CO., LTD.
台灣 台中市大里區中興路2段73-9-1號
No.73-9-1, Sec.2, Chung Shing Rd., Ta Li, Taichung, TAIWAN
TEL:886-4-24834311.24834576
FAX:886-4-24830924
e-mail: jeysun@jeysun.com.tw
http://www.jeysun.com

越南連絡處：越香工業區
Vietnam Office: Viet Huong Industrial District
TEL:84-650-3715038
FAX:84-650-3715039
e-mail:jeysun@jeysun.com.tw
http://www.jeysun.com

東莞鉅舜五金塑膠製品廠
DONG GUAN JEY SUN INDUSTRIAL CO., LTD.
廣東省東莞市寮步鎮嶺廈管理區
Lin-Hsia District, Liao-Pu Town, Dong Guan City, Guang Dong, CHINA
TEL:86-769-83301411.83307199
FAX:86-769-83301412
e-mail: jeysun.dg@jeysun.com
http://www.jeysun.com

群泰實業有限公司
CHUN TAI INDUSTRIAL COMPANY
廣東省東莞市寮步鎮繆邊管理區鴻利路1號
No. 1, Hung-Li Rd., Mu-Pien District, Liao-Pu Town, Dong Guan City, Guang Dong, CHINA
TEL:86-769-88902943
FAX:86-769-88902942
e-mail: chuntai@chuntai.com.cn
http://www.jeysun.com

