



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

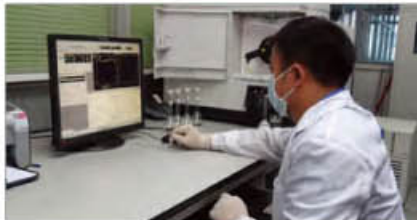
AREA OF FACTORY: 2,640 M²

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.



鞋眼、釘、釦腳長設定方法

機器選用及打釦操作說明書

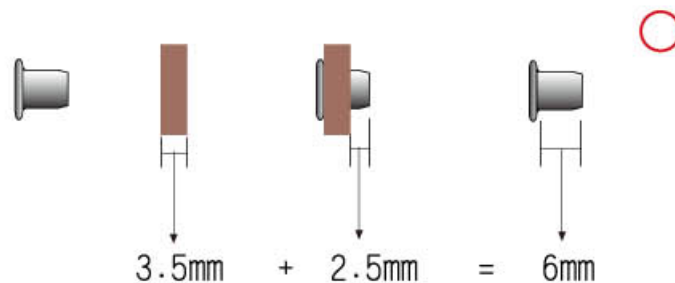
一. 鞋眼及釘釦腳長設定

1. 鞋眼樣式多種，但其腳長設定方式都一樣：

先測出鞋面厚度（鞋面需打釘的地方用游標卡尺卡緊鞋面）

其鞋眼腳長需超出鞋面實際厚度2~2.5mm。

例如：鞋面實際厚度3.5mm+2.5mm，就應選用6mm腳長鞋眼使用最適合。



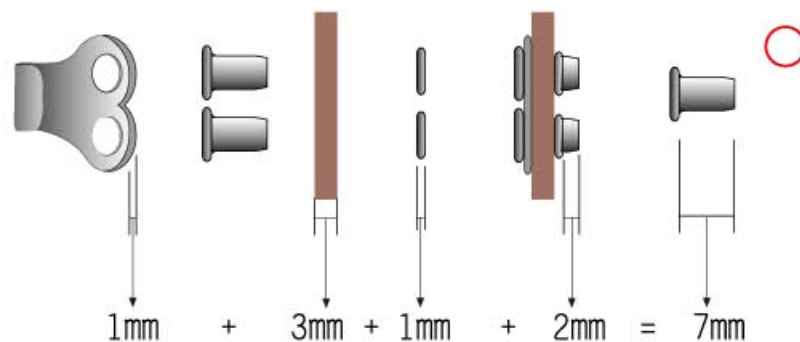
2. 空心釘、中空釘、虎骨類

先測出鞋面厚度是多少（鞋面需打釘的地方用游標卡尺卡緊鞋面）

其釘類腳長需超出鞋面實際厚度2mm。

例如：鞋面實際厚度3mm，主件厚度1mm，

下套或華司1mm，就應選用7mm腳長釘類產品最合適。

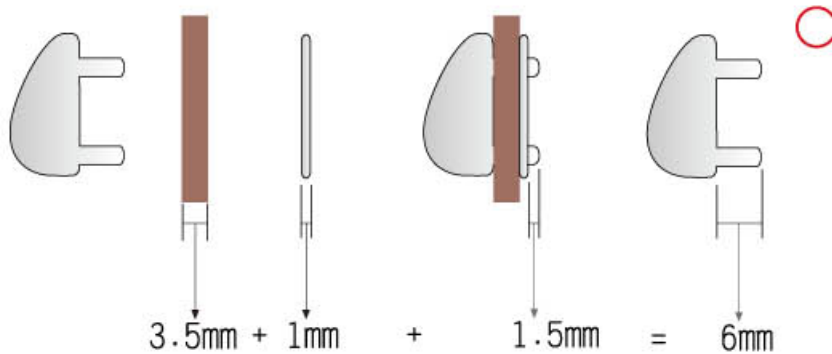


3. 鋅合金產品及需鉚腳類

先測出鞋面厚度（鞋面需打釘的地方用游標卡尺卡緊鞋面）

其鞋釘腳長超出鞋面實際厚度1-1.5mm即可。

例如：鞋面實際厚度3.5mm，下套或華司厚度1mm，就應選用6mm腳長最合適。



二. 打釘模具之選用：

產品材質及規格的不同，必須選擇相對應的打釘模，例如銅眼與鋁眼雖規格完全相同，但因材質的區別不可混用或共用打釘模。

三. 正確選用打釘機器的重要性：

機器種類繁多，打釘之前必先確定打釘機器壓力是否足夠，適合打那一類的釘子，像鞋眼、空心釘類的釘子，使用全自動機臺，輕巧又帶碗公上下套一次成型，效率好。腰型釘、中空釘、虎骨釘、鋅合金釘需鉚腳的鞋釘，就應選用半自動機臺或鉚釘機器才適合，因半自動型機臺力道足，打釘才能一次到位達到預期效果。如選用全自動機台打力道不足又很容易使機械損壞，而壓力不足，打出來釘子卷腳及所需緊度不能一次到位，像鞋眼及空心釘產品如用半自動機器操作速度太慢，等於大材小用。所以正確選用機器打釘對於品質及工作效率有絕對的重要性。

四.打釦操作要點說明：

1.鞋釦放入機器流到碗公內，自行運轉時需檢查機器配件是否與鞋釦匹配，以避免造成鞋釦刮傷掉漆或擠壓變形。此類異常輕則導致鞋釦報廢比例高，重則導致鞋子成型後再做繁瑣的返工動作。

2.打釦之前需做好首件操作確認工作，機器壓力要調試至恰到好處，上下模對準後，鞋釦先空打確認卷腳是否良好，不能誤認壓力調緊鞋釦才能打緊，操作不當會造成鞋釦變形、斷裂等不安全的隱患。

3.確定模具、機器完好及動作正常，才能保證打釦品質，試打鞋釦表面不變型、無刮傷、抬腳、卷腳良好，拉力測試合格後，才可安排打釦量產作業。

4.試打釦或量產打釦作業過程中，如發現鞋釦品質異常或打釦異常時，應立即停止相關作業，或諮詢自己廠內相關技術人員或與東莞鉅舜聯絡，東莞鉅舜將以最快服務速度給予妥善處理。

研發 · 品質 · 服務





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