

## ASSEMBLY TURNTABLE FOR TOLERANCE ADJUSTERS

The machine concept is a round table with four stations and manual feeding of single parts. The operator is manually preassembling the three parts and insert two of them in the fixture. By pushing a start button, the turntable moves (safety by light curtain). The screwing process is driven by two servo motors. The torque is indirectly measured by current consumption. The screwing depth is checked by two sensors from the bottom. In the third station we check the presence of the washer and mark the parts by a dot (by cylinder force). The last station is for automatic removal of OK and NOK parts.

### ■ REQUIREMENTS

- Cycle time 5 seconds per piece
- Screwing depth tolerance  $\pm 0.5\text{mm}$

### ■ PROCESS

- Loading with sensor detection
- Screwing in with way measurement
- Marking by needle pin
- OK/NOK handling

### ■ MACHINE DATA

Place of manufacture: China

Industry: Automotive

Operating location: China

Year of construction: 2019

