

LEVER **ASSEMBLY SYSTEM**

SPECIFICATIONS WAPRO LEVER ASSEMBLY SYSTEM

| | |
|------------------|------------------------|
| Supply | 400 VAC / 16 A / 50 Hz |
| Performance | 1200 pcs/h |
| Autonomy | 1:00 AM |
| Dimensions LxWxH | 2.7 m x 1.7 m x 2.0 m |

DESCRIPTION

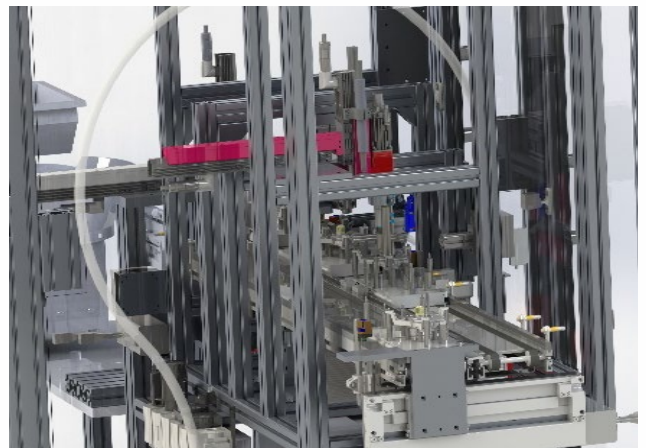
The Lever assembly line station is integrated between two systems from the customer. The first system delivers a housing to the station, who then presses a gear into it and punches a hole pattern into it. It then passes the fully assembled housing on to the next system. The gears are separated as bulk material in a spiral conveyor and then blown into position through a hose. The station is designed to process several types of gears and punch patterns.



Housing and gear

FIELD OF APPLICATION

The system is integrated into an assembly line in the automotive industry, where the gears are pressed onto servo motors.



Gear assembly and punching unit



FEATURES

- Integrated in assembly line
- Autonomously running system
- Dimensions of system adapted to assembly line
- PLC control integrated in assembly line
- Precise motion sequences
- Very short cycle time of 3 sec.
- High repeatability
- Integrated Vision System

ELECTRONICS

A Siemens PLC with integrated HMI that is attached to the system as a swivel arm panel is used to control the lever assembly system. The control system was integrated into the assembly line via IOs. The programming of the PLC, the planning of the electronics and pneumatics as well as the operating concept were designed and realised in-house to meet the customer's needs.



Integrated HMI as swivel arm panel

COMPLETE SYSTEM



Complete system Lever assembly system

