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DEPRAG Rotary-Index Assembly Station for the installation of Rivnuts and Bolts into protection covers for automotive Exhaust Systems

This month's machine was manufactured for an automotive sub-supplier. The **requirement** was the automatic feeding and processing of blind rivnuts and locking bolts (in vertical and horizontal plane). Both nuts and bolts are presented to the individual stations by automatic feed systems. Air-Motors are positioning the nuts and nine different air-hydraulic presses are processing the components. Every press operation is verified, using an integrated Process Control.



Total Machine View

Solution:

- 1 x DEPRAG Rotary-Index Assembly Station, consisting of the following components:
- 1 x 8-position Rotary-Index Table with 8 part fixtures
- 1 x Handling Station for Loading/Unloading
- 1 x [DEPRAG Feeder \(MZG\)](#) with [Hopper](#)
- 3 x [DEPRAG Air Motors Model 67-052Z](#)
- 2 x Load-Stations (3-fold and 6-fold)
- 1 x [DEPRAG OP-Interface TP2plus](#)
- 1 x DEPRAG custom PLC cabinet with S7
- 1 x Air-flotation conveyor system
- 9 x Air-hydraulic press systems with process control
- 3 x Insertion tools with collars
- 1 x Conveyor system to remove O.K. parts

The complete machine consists of eight (8) individual stations, as can be seen on the layout to the left.

Each station is described in detail on the following station-description links.

Please click on the name of the station you wish to read about:

[Station 1](#)

[Station 2](#)

[Station 3](#)

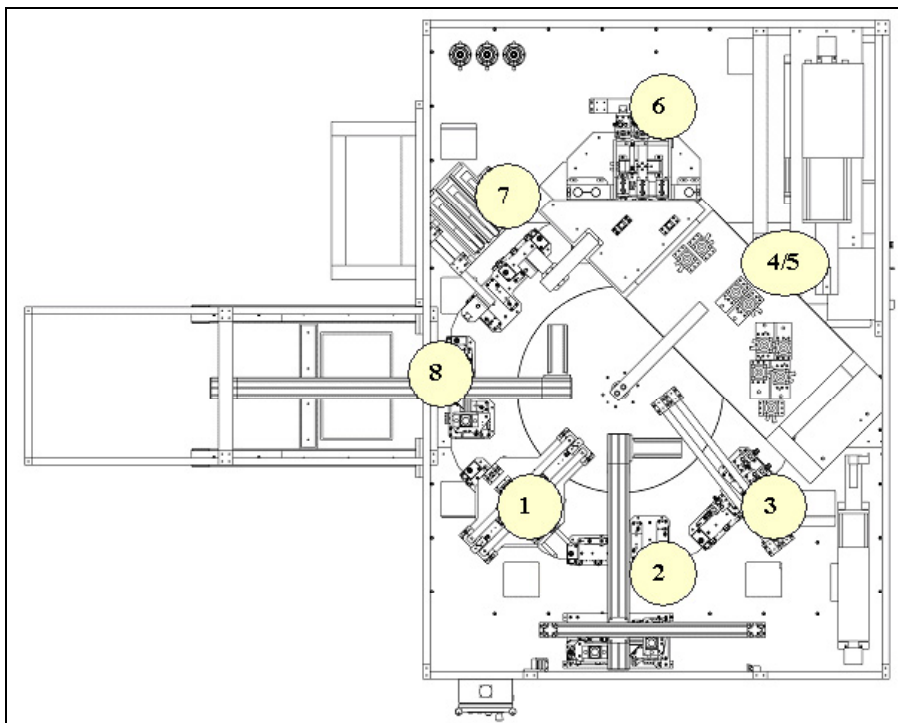
[Stations 4 + 5](#)

[Station 6](#)

[Station 7](#)

[Station 8](#)

[Additional Controls Information](#)



Layout with individual Stations