

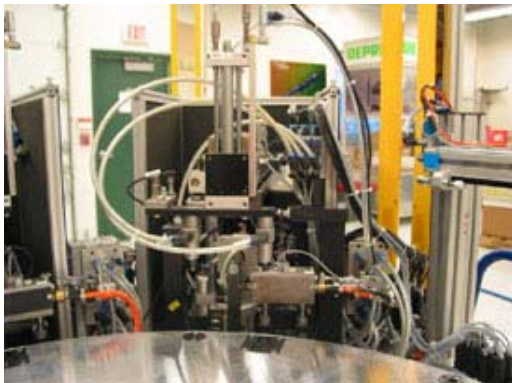
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## DEPRAG & AGME - A "RIVETING" COMBINATION

This month's E-News showcases an assembly station, which was designed and manufactured by DEPRAG for a major US-manufacturer of electrical distribution and industrial control products. Into this station we integrated the DEPRAG feeding/automation technology and combined it with the radial riveting technology from AGME!



This fully automatic station was designed to automatically feed and assemble one metal plate with three rivets (two different rivet sizes). The illustration on the left shows the individual parts, prior to assembly; on the right is the completed part.



The main component of this station is the rotary index table with multiple handling systems. Three individual feeders are designed to feed one metal plate, two of the small rivets and one large rivet with the subsequent assembly of all parts into one complete component. Each feeder is supported by a belt-driven hopper to reduce refilling intervals.



A total of three **AGME** radial riveting machines assemble one small and one large rivet each vertical from top and one small rivet from underneath (inverted riveter). The radial riveting process assures that all rivets are securely attached and that the surface of the metal-plate is unmarred. The radial riveting process also guarantees a better fiber settlement for a stronger rivet.



The complete assembled part will be removed at the unloading station and dropped - through a hole in the index table - into one of the three supplied parts-bins on wheels. The machine is programmed for part counting, which will let the operator know when the parts-bin is full. This allows for a timely removal of a full bin and the replacement with an empty bin.



The machine has two light-curtains integrated with reflective mirror panels to protect the entire work area. A Magelis™ Operator Terminal informs the Operator about the machine status and a Modicon® PLC controls the complete machine sequence.  
**Total cycle time for one completed part is 6-seconds!**