

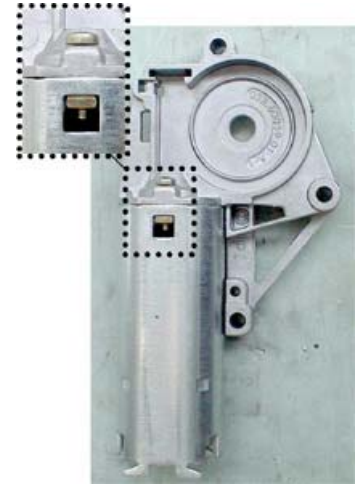
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Electric Actuator Assembly Unit

This machine was manufactured for Siemens; it assembles a gear head to the base of a small electric actuator, which is used in an automotive application. The assembly unit is capable in handling three different variations of motor and gears. The main task requires the feeding and assembly of two nuts and screws. The screwdriver of choice is the **NEW** DEPRAG EC-Electric Screwdriver Spindle with AST-30 controller.



1. Manual loading of actuator base and the appropriate gear into a sliding part fixture.
2. 2-Hand-Start Buttons are activated; sliding part fixture moves into the machine, the safety door closes and is locked.
3. To keep both parts (motor and gear) from moving during the assembly, a cylinder actuated down-holder moves over the gear head.
4. A centering device, which is also actuated by a cylinder, moves up from underneath to align the motor shaft.



Actuator with assembled Nut + Screw

5. The nuts are fed into an indexing device.
6. The indexing device moves to the assembly and is simultaneously used to center the motor housing.
7. The nuts are inserted.
8. The screws are fed into the nosepieces.
9. Both screws are assembled as needed.
10. During the screw-assembly, the unit also performs a thread verification.
11. All cylinders return to their base position.
12. The sliding part fixture returns and the safety door opens to allow unloading of the completed part.



Screwfeeder with Twin-Distributor



Full View