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WATER-PICK SCREWDRIVING MACHINE

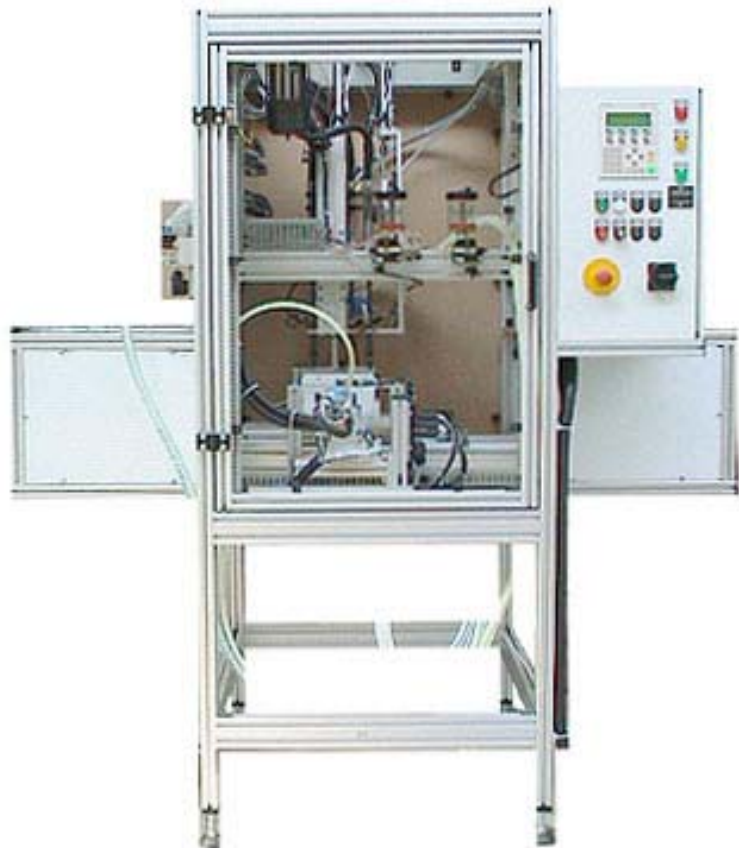
This Assembly Station was designed for the assembly of a Water-Pick housing with four- or three screws in vertical axis and one screw in horizontal axis. Our customer supplied the conveyor and the lift/locate station.

Machine Components:

- Base Frame with inlet- and outlet opening for the conveyor.
- **Triple SFM-Module** in vertical position with vacuum system
- **Single SFM-Module** in vertical position with vacuum system
- **Single SFM-Module** in horizontal position
- **Five [5] DEPRAG-Minimat Screwdriver Spindles**
- Filter-Regulator with Point-of-Use Lubricator
- **Screwfeeder** with **Hopper**
- Pallet Locking-Device

Machine Cycle Description:

The Water-Pick housing is securely positioned in the pallet and the conveyor transports the pallet to the machine. Prior to reaching the assembly location, a pre-stopper allows only one pallet at a time to enter the assembly area. The main-stopper, equipped with sensors indicates when the pallet is ready for the lift/locate station. The lift/locate station moves the pallet underneath the screwdriving location. One sensor verifies that a Water-Pick housing is in the pallet and another sensor recognizes the type of the housing and gives a signal to the controller, which screwdriving program needs to be activated. According to the selected program, the SFM-modules [Screwdriver-Function-Modules] start the assembly, driving either three or four screws in a vertical axis and one screw in a horizontal axis. After the assembly, the lift/locate station returns to its base position. The pallet locking-device releases the lock between the Water-Pick housing and the pallet and the conveyor moves the pallet downstream where the completed housing may be unloaded.



Water-Pick Screwdriving Machine