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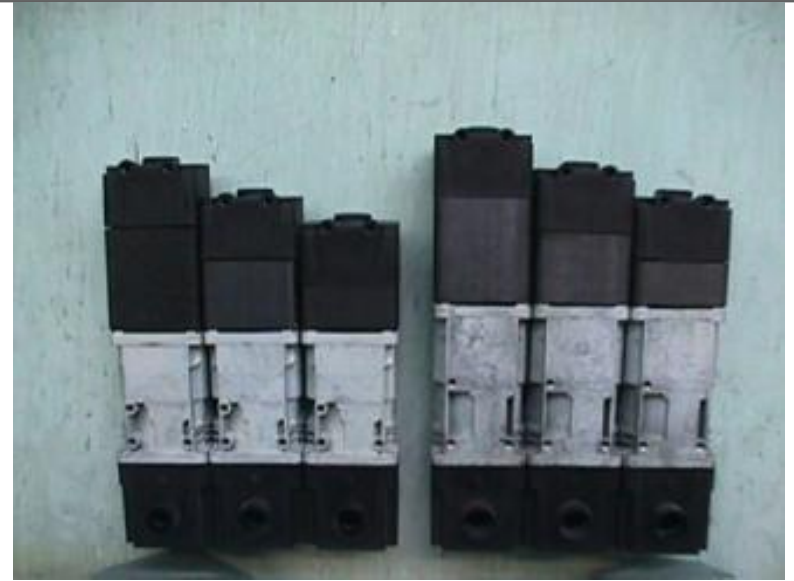
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DEPRAG automatic Screwdriving Station

Product to be assembled: Venetian Style Mini Blinds

This automated screwdriving station assembles the cord recoil mechanism used in Venetian style mini-blinds. It has been integrated directly into an existing production conveyor.

The cord recoil mechanism includes a housing with four Ensat M4x6 threaded inserts installed to an exact depth ($\pm 0.05\text{mm}$), and a cover that attaches to it with four M3.5 x 12 screws. Because the screws are very close to the housing wall, automatic assembly is only possible by mounting the screwdriver spindles at a 6-degree angle relative to the housing.



Picture: cord recoil mechanism



Two feeders are used, both model SZG 0511-4 EP/0.75 with a standard filling capacity of 0.75 liters and a quad-distributor to feed four screws or threaded inserts simultaneously. The controller is a Siemens PLC S7 314. The machine-dependent cycle-time is 20 seconds.