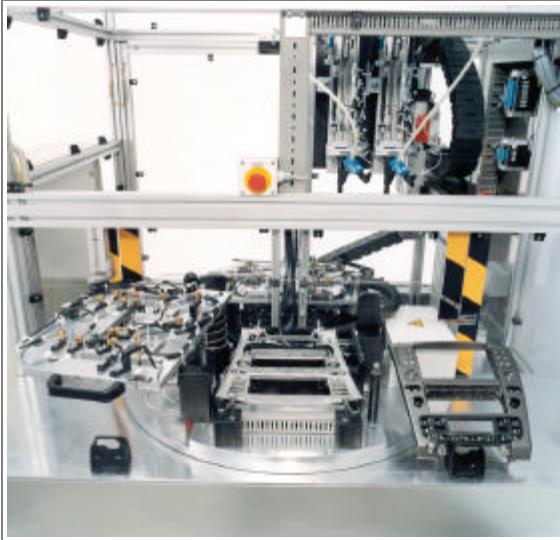


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DEPRAG X-Y (Z) Screwdriving Station

for the assembly of an automotive console fascia for a passenger car.

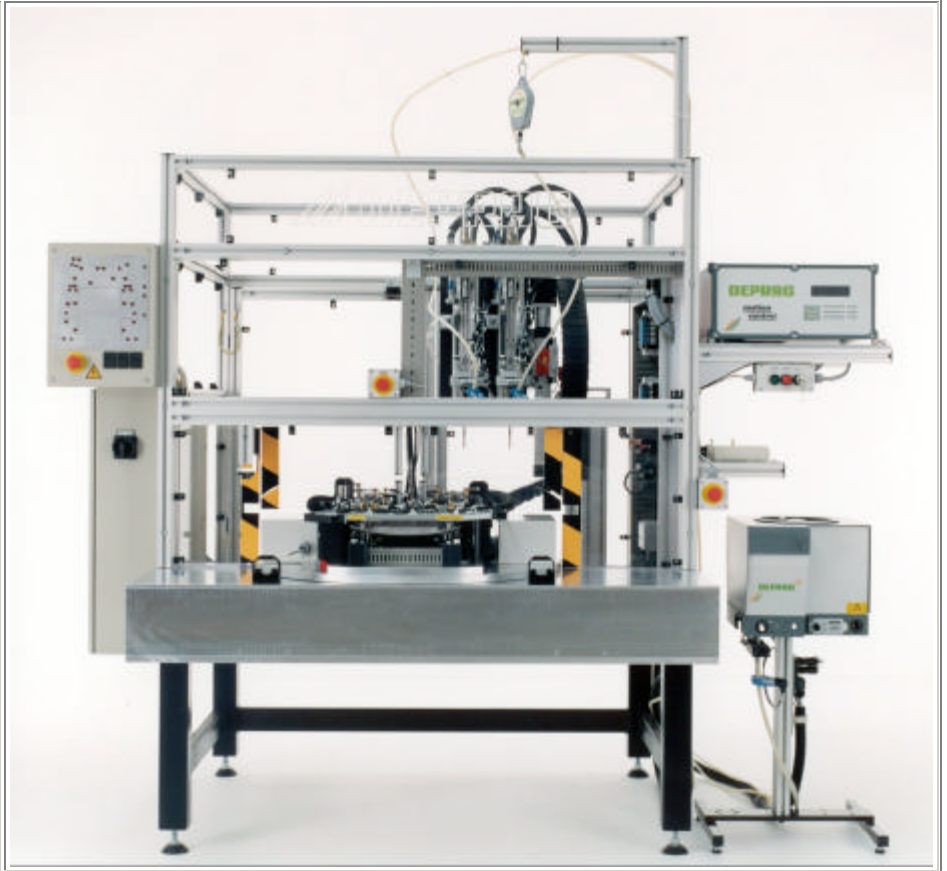


A DEPRAG linear screwdriving robot with XYZ axes is used for the assembly of a pc-board, diaphragm and housing frame. Assembly consists of driving screws (length: 22mm x head Ø: 7mm with a Torx "Plus" drive into plastic and a magnesium casting.

We use two screwdriving robots, size-1, which can be slanted by 7° to access certain screw positions. Additionally, we use a Twin Screwfeeder SZG 0511-2-EP with a double-distributor and a MC183 controller.

The Operator loads the individual parts into the parts fixture. The parts fixture has a hinged cover, which keeps the individual parts positioned and assures that all necessary parts are present. If parts are missing, or if they are incorrectly positioned, the display located on the left side of the unit registers an error.

The indexing table rotates by 180° after the 2-hand safety start buttons are triggered and the screwdriving process starts. Up to 39 screws are inserted and the maximum allowable cycle time for one screw assembly is 2.5 seconds. After correct assembly, the operator opens the hinged cover of the parts fixture, removes the completed part and reloads the parts fixture with new parts. Errors are indicated on the display and are simultaneously printed for the purpose of rework.



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