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## Assembly Unit for Vacuum Cleaner Housing

This 7-Spindle "inverted" Screwdriving Station was delivered to VORWERK in Wuppertal, Germany. The product assembled is the plastic housing of a vacuum cleaner; in which a total of seven screws are tightened simultaneously. Due to the proprietary nature of this product, we are not allowed to show a picture of it.

The screwdriving station is integrated onto a conveyor with a lift-locate system for the part pallet. A pneumatic hold down restrains the work piece during the assembly cycle. Seven Minimat Screwdriver Spindles insert the screws, Model # 346-528-31, mounted in a single construction unit on a linear guide carriage suspended from the aluminum-profile machine base. The M3.5 x 40mm screws are fed directly to the spindles, using two extra-large capacity feeders, one equipped with a four-position distributor and the other with a three-position distributor. Both feeders have level detectors and refill hoppers. The complete construction unit can be moved out of the machine base, allowing quick and easy access for setup and maintenance.

A Siemens S/-314 PLC controls the machine. Each spindle is equipped with a "point-of-use" oiler in addition to the central filter/regulator. The total assembly time, including pallet lift cycle, is 10 seconds. So far, one machine is in operation and a 2nd machine will be delivered by the 2nd quarter of 2002

