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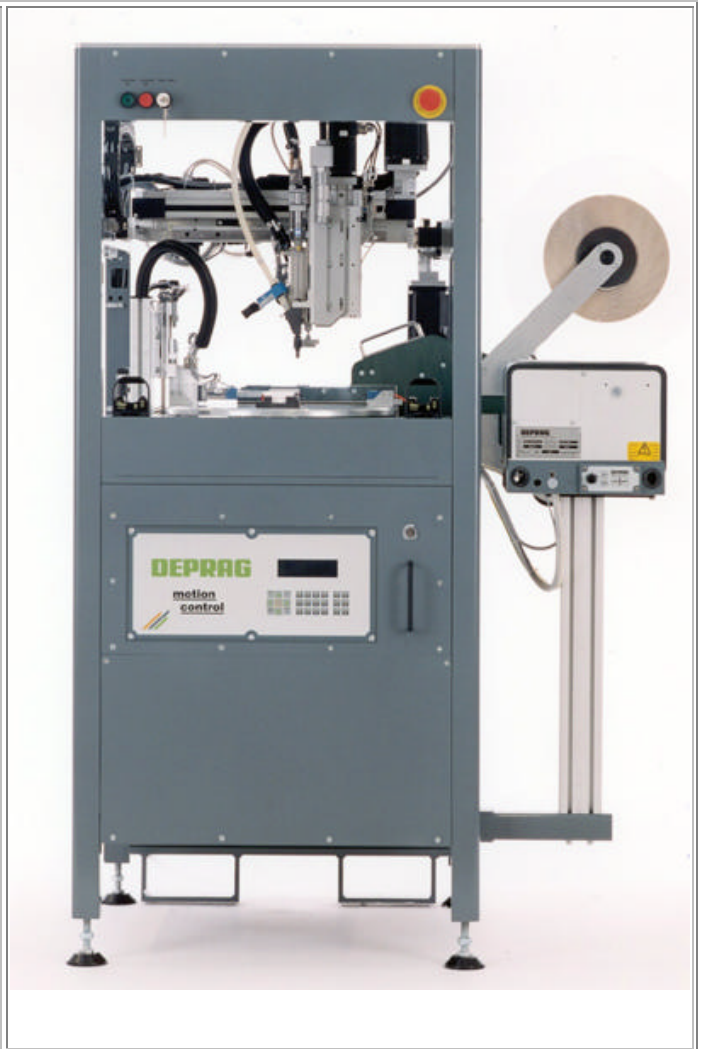
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## DEPRAG Tape Measure Assembly Station

driving 3 screws and placing 1 label

Unlike traditional DCAM's (DEPRAG Compact Assembly Modules) that have an aluminum profile frame, this machine has a frame of rectangular steel tubing. The supply hoses and electrical wiring are routed through this tubing to protect them and to give the machine a cleaner appearance. The machine has an index table with two part fixtures spaced 180° apart, each fixture having a part presence sensor to confirm that a part has been placed into it. A single spindle that is fitted for automatic screw feeding and is attached to an integrated 3-Axis linear motion system is used to insert the three screws. The application of the label is done with a gripper module, a vacuum pick and place, and a tape-on-reel feeder. The complete system is controlled by a DEPRAG Motion Controller MC183, which is housed in the frame's substructure.

The assembly cycle is as follows. The operator loads a tape measure, face down, into the closest part-fixture and activates the 2-hand start. The rotary table indexes 180°, moving the new tape measure to the workstation and bringing the finished tape measure to the operator. The spindle automatically drives the three screws into the rear of the tape measure. The gripper then lifts the tape measure, turns it over, places it in the part fixture face up and secures it. The tape-on-reel feeder indexes a label into the pickup location, a vacuum pickup arm lifts it and presses it onto the front of the tape measure. The gripper then retracts and when the machine is cycled again, the rotary table indexes to bring the completed tape measure back to the operator.



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