

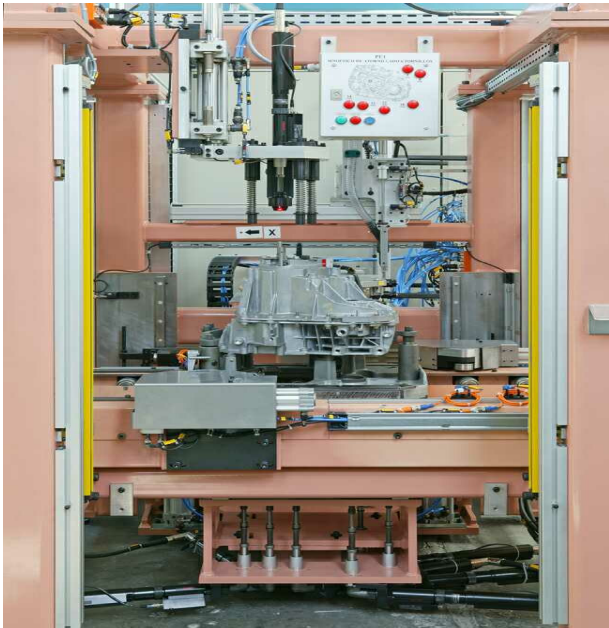
GEARBOX ASSEMBLY



Gearbox

OPREATION SEQUENCE		AUTOMATION LEVEL
1	Model Identification	Automatic
2	Oil seal assembly in clutch housing	Automatic
3	Bearing assembly in clutch housing	Automatic
4	Dowel pin assembly in clutch housing	Automatic
5	Pin insertion in clutch housing	Automatic
6	Bearing and circlip assembly in gear housing	Automatic
7	Bolt tightening Gearbox casing	Automatic

GEARBOX ASSEMBLY



Screwing station



Pin insertion station

TECHNICAL SPECIFICATIONS

Weight/Part dimension: 30??

Diversity: 6

Line dimension: *Many positions*

Production data

Cycle Time: 24 seg.

Number of shifts: 3

Process control

- Insertion with electro mechanical press
- Bolt tightening with torque and angle control.
- Poka Yoke
- Control with artificial vision.

STANDARD EQUIPEMENT

- JANOME electro mechanical press
- YAMAHA Robots.