



Sorting and Feeding of 1 Type of Flange- or 2 Types of Weld-Nuts M6 / M8



Feeding Systems

Project-No. 173

Fig.: 1 Sort of Flange-Nut and 2 Sorts of Weld-Nuts M6 and M8.



Operation Description:

Sector

Automobile Supplier Industry.

Performance Requirements

Three sorts of weld-nuts must be fed in correct positioning and transferred with a handling to the welding process.

Delivery Position

- Flange-Nuts: standing position on a surface of 36 x 36 mm, welding depression-face pointing downwards, fed sideways into the linear track.
- Weld-nut M8: lying flat, welding depression-face pointing downwards, running into the track with tool-fitting on tool-fitting.
- Weld-nut M6: lying flat, welding depression-face pointing downwards, running into the track with tool-fitting on tool-fitting.

Operation Description

The flange- and weld-nuts are sorted in a bowl feeder and subsequently accumulated on a linear feeder with correct positioning.

At the end of the linear feeder each of a flange- weld-nut is transversely shifted off.

From this position the nut will be taken on by a handling system. The handling drives the weld-nut to the welding position.

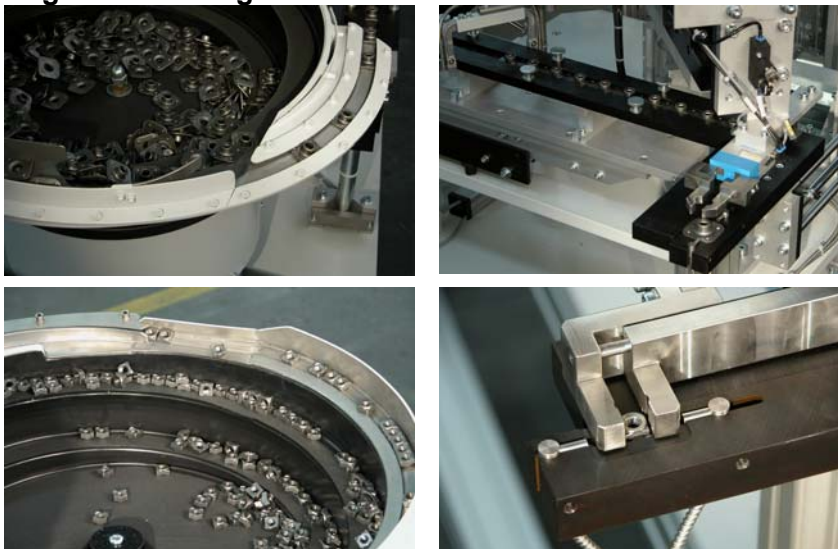
Feeding rate

ca. 12 pieces per minute per run.

Control

Control box ESG-2001, PLC-operation.

Sorting and Handling Transfer



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