



Sorting and Feeding of Bolts with a Flat Feeder

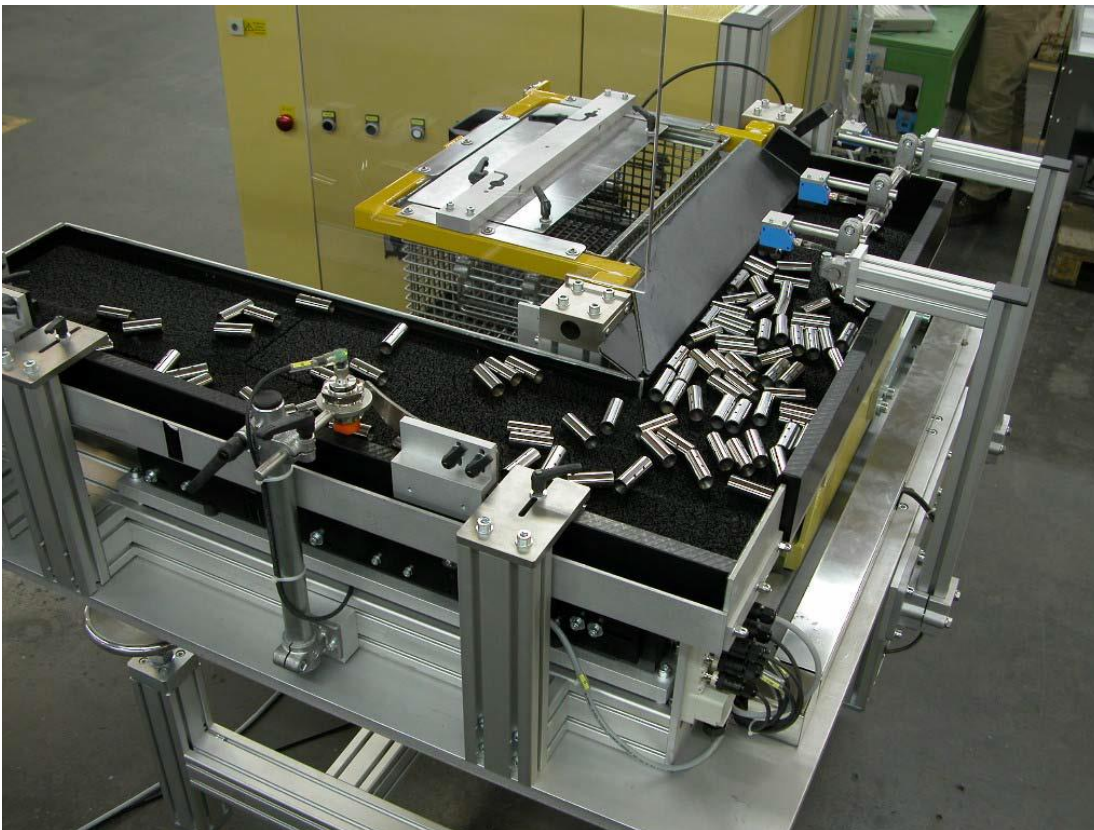


Feeding & Handling System

Ref. 204



Ø 10–25 mm, Length 30–100 mm



Description:

Sector

Automotive suppliers (epicyclical gear bracket bolts for automatic transmission)

Component

Bolts \varnothing 10-25 mm, length 30-100 mm

Technical Requirements

The bolts should be dosed to the feeder automatically out of standard containers. The delivery is carried out lengthwise in the direction of the axis to an inspection automate (inspection of surface and structure). Since the bolts are ground to a installation-ready state, a meticulous handling to safeguard the pieces during the feeding is required.

Discharge Position

Lengthwise, behind one another in the direction of the axis.

Operation Description

Standard containers with the bolts are used in the loading installation. The loader passes the bolts into the dosing bowl of the flat feeder. Only the currently required quantity of pieces is passed from the dosing hopper into the sorting unit. The entire sorting is covered with a brush layer to safeguard the pieces and all parts which come in contact with the pieces are manufactured with industrial plastic. The flat feeder passes the sorted bolts to a V-conveyor which acts as interface to the inspection automates.

Performance

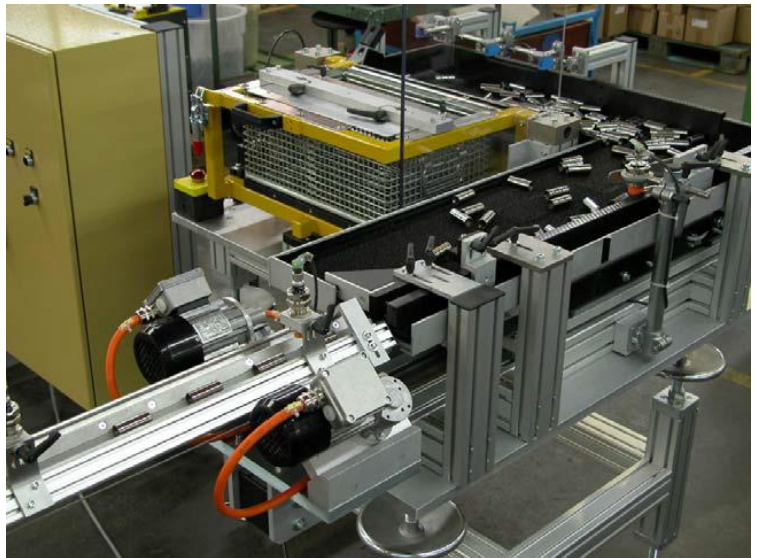
30 pieces per minute (length 60 mm)
40 pieces per minute (length 100 mm)

Control

Control unit with PLC Siemens S7/300.
Specifications according to customer requirements.

Elements of the Feeding System

Box loader, flat feeder, V-conveyor as accumulator, control unit.



Flat feeder sorting and V-conveyor accumulator