Assembly & Swaging of Automotive Locks
SCHMIDT® Project No. 2002
Nr. 68.100.12 Hydro-Pneumatic Press Indexing Package
SCHMIDT® Nr. 68.100.12 Hydro-Pneumatic Press

Application, Requirements

- Swage center post to stamping.
- Automatic unloading of completed assembly.
- Verify proper combination of assemblies.

Concept Description

This concept is based on a 4-station index system designed to accommodate various assemblies. The tooling is interchangeable. To change over to a different style the operator is required to insure the correct nest assemblies are loaded. The assemblies are color-coded. Sensors are incorporated to sense presence of the parts. Two sensors accommodate all sizes. Tooling is designed to eliminate incorrect assemblies.

Operation

Station 1, Load station
- Manual loading of components
- Operator initiates cycle via Single hand palm button

Station 2, Part verification
- Check for correct presence of both components

Station 3, Press station
- Press forms neck of inner component with force based on pressure regulator setting.

Station 4, Part unload
- Via Pick & Place device

Equipment, Performance

- Press Nr 68.100.12
- Allen Bradley Custom Sequence Control
- 4-Station Roller Cam Indexer
- Auto Eject Station
- Full Guarding Package
- Poka Yoke Type Tooling

Production rate: 12-14 parts per minute