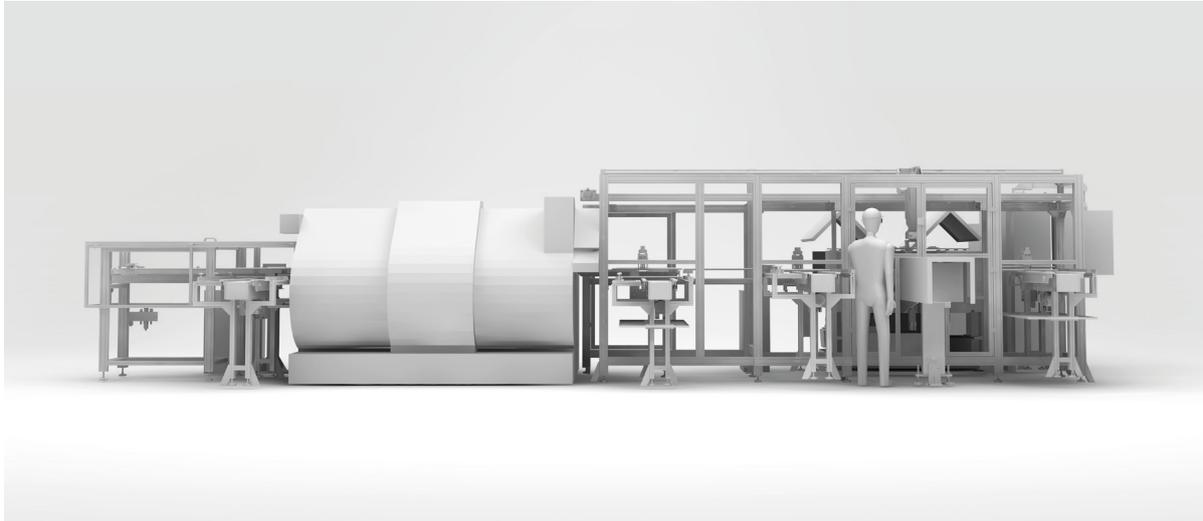


## Handling for machine concatenation



### Task

Parts need to be transported between a turning machine and a knurling machine. The raw objects must be automatically supplied to and withdrawn from the turning machine. After turning, the product must be passed on to the knurling machine. This concatenation is supposed to be connectable and disengageable. This requires the outward transfer of the products after turning, to ensure that the knurling machine can also be operated autonomously. The knurling machine is also supposed to be equipped with a feed and discharge system.

### Solution

A rake feed system transports the raw turning objects to the insertion station in front of the turning machine. The inserter pushes the raw object through the guide tube into the chuck of the turning machine. After the turning operation, the removal handling device removes the workpiece from the unit. At the removal position, the portal handling device removes the product with a double gripper and transports it to the knurling machine, where it is turned 90 degrees and inserted into the gripping jaw. After the knurling process, the product is removed by the finished part gripper and a new workpiece is inserted with the raw piece gripper. The workpiece is then placed onto the cycling out device with the handling device, which supplies the operating personnel with the finished product.

### Result

Thanks to the rake feed system at the feeders and dischargers, forty pieces can be up- and down streamed until the operating personnel has to intervene. This enables the operating personnel to carry out other tasks. Concatenation lets the system run autonomously for up to twenty minutes. The respective input and output stations in front of every processing station enable individual operation during machine revisions or re-fitting works.

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