

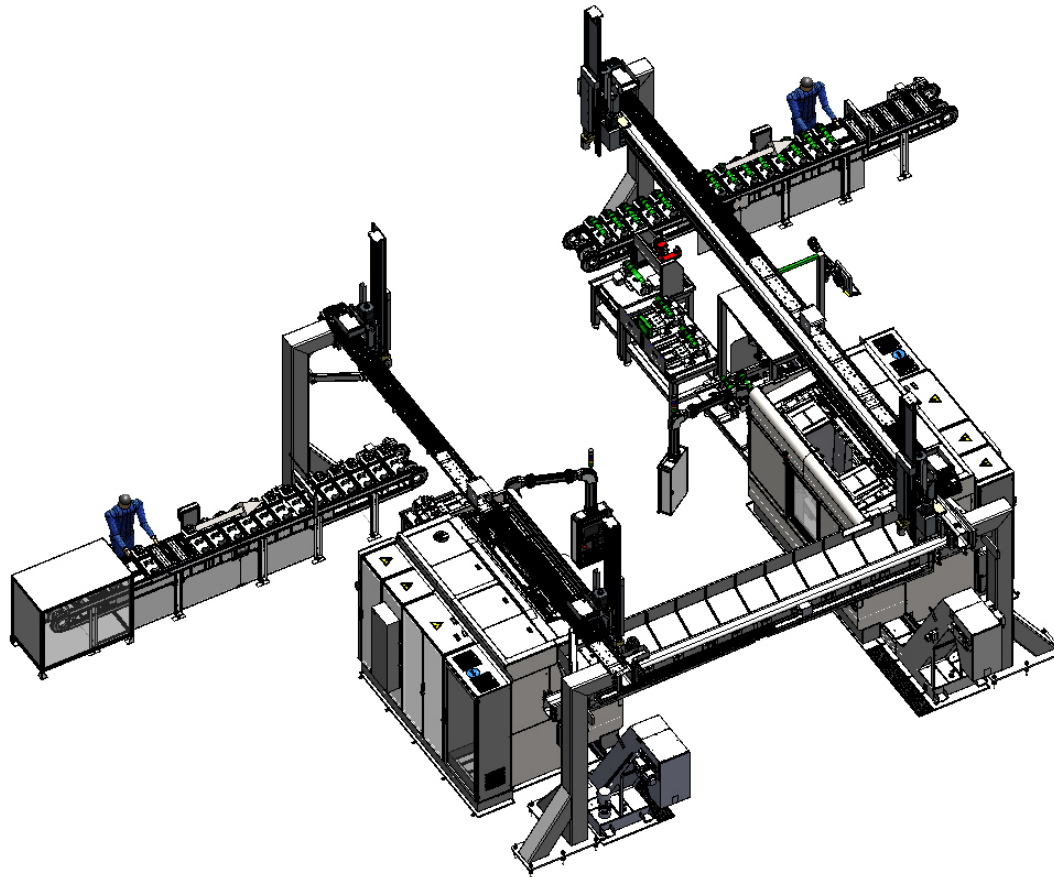


V300: Truck transmission shafts

Automated turning

- › Complete turning machining of truck transmission shafts in one system
- › Cycle 3 to 3.5 min
- › Changeover in 30 min
- › Automatic measuring and marking
- › Automatic corrections
- › Easier operation thanks to specially adapted HMI





Complete turning machining of truck transmission shafts in an automated system

Various truck transmission shafts are completely finished turned on this plant. The forging blanks are loaded from the input pallet conveyor by a gantry loader into the first machine. There, the ends of the workpieces are machined in the centre drive and partially through-hole deep holes are set.

The parts are then removed from the first machine and loaded into the second machine by means of a transverse shuttle. There they are clamped between the spindle and the tailstock and the centre diameters are machined.

Afterwards, the workpieces are marked and measured in a measuring machine. The measured values are fed back and used for correction. A gantry loader finally places the workpieces on the output pallet conveyor.

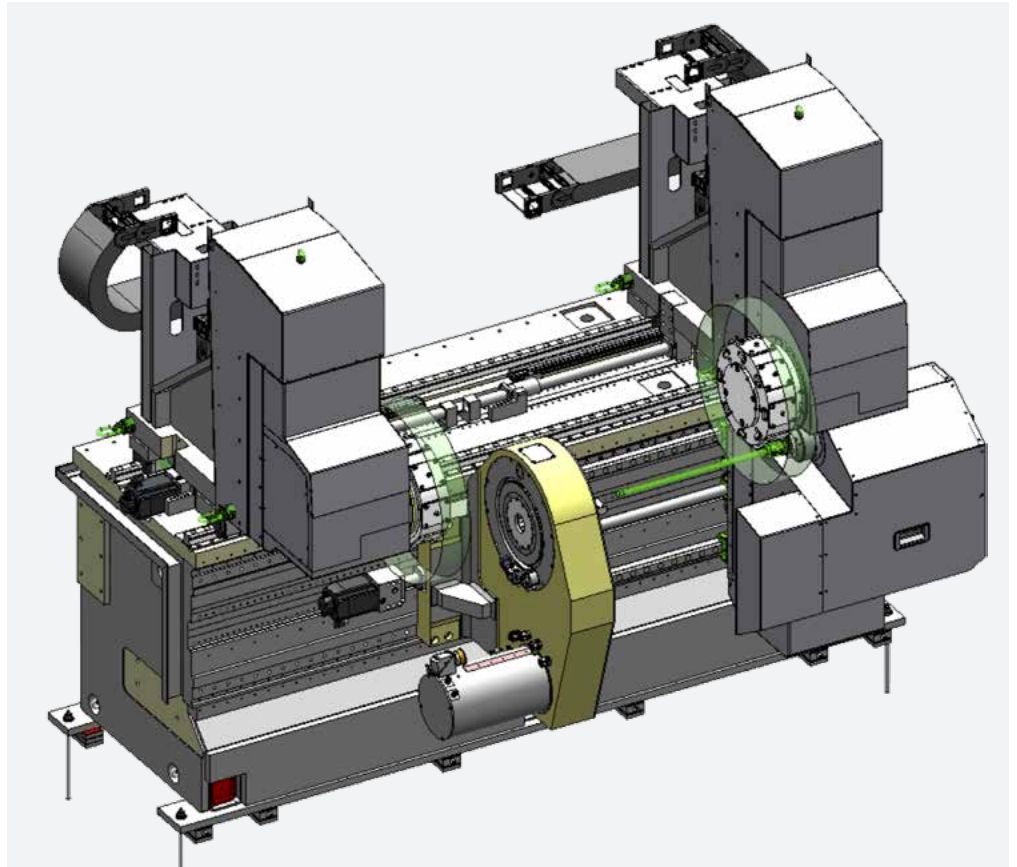
The system can be changed over to another workpiece in 30 minutes.

Workpieces

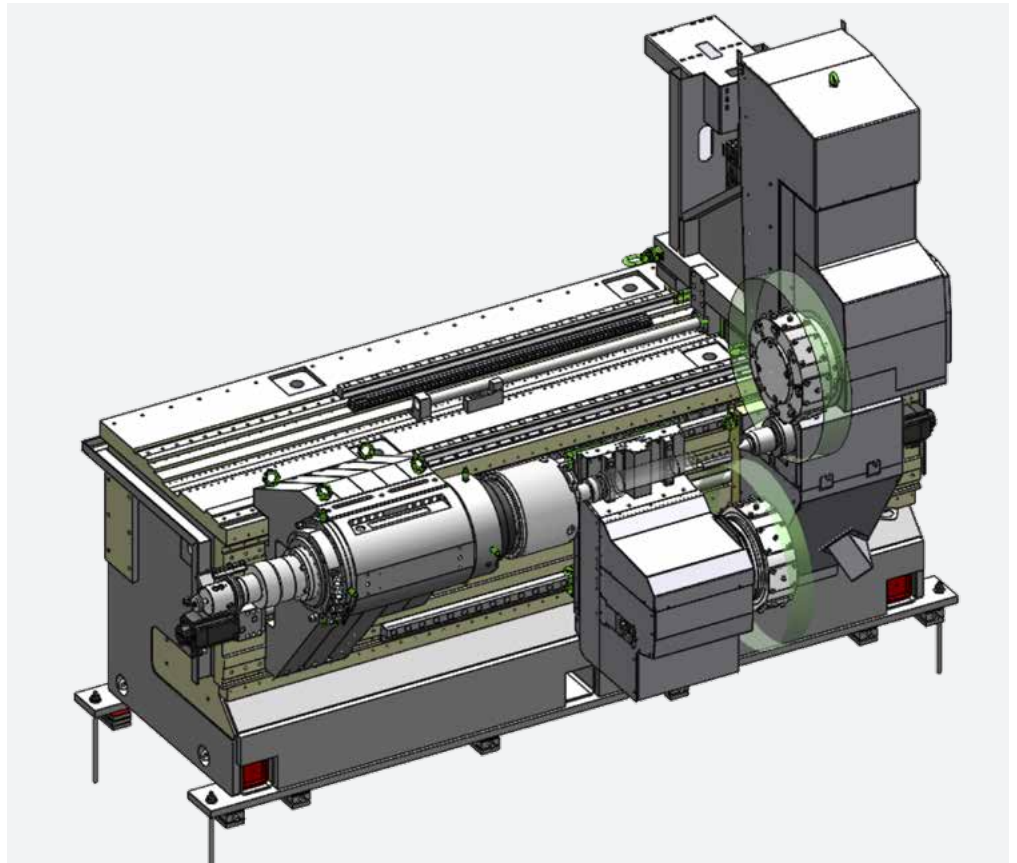
Length [mm]	600 mm
Diameter [mm]	250 mm
Weight [kg]	50 kg
Cycle [min]	3:00 bis 3:30

Features

OP 10



OP 20

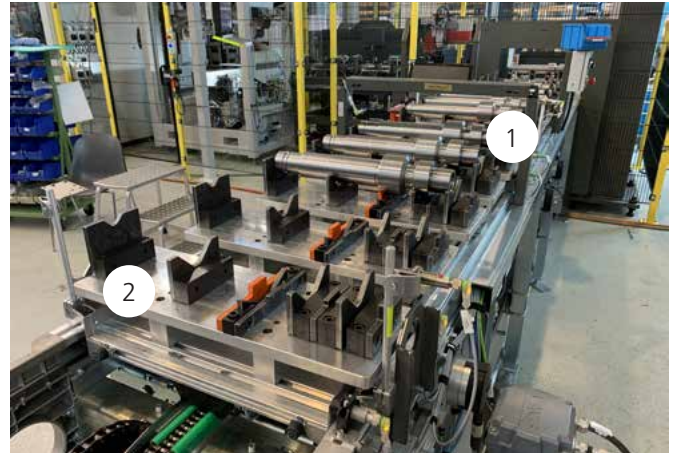


Features



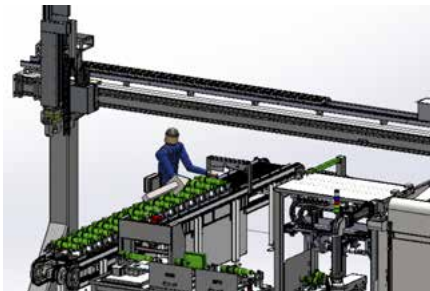
Gantry loader

To shorten the loading time and to operate the system components quickly, the linear gantries each have two slides.



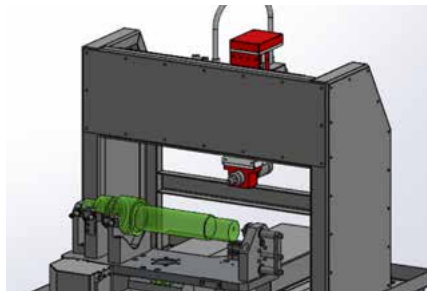
Input pallet belt

- ① The pallet belts are designed to be stowed.
- ② The workpieces are positioned via form-locking, unambiguous slides.



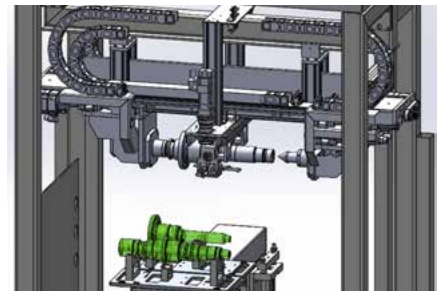
Output track with measuring station and marker

The workpieces were automatically measured on the output section. Any dimensional deviations were returned to the control system as correction values.



Marking station

The workpieces are labelled with the article number, the blank lot and the finished part lot.



Messstation

The NC measuring machine has an NC control. Diameters, lengths, concentric and axial runs can be measured. The measured values are evaluated in relation to cpk and cmk. Deviations are returned to the control.

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