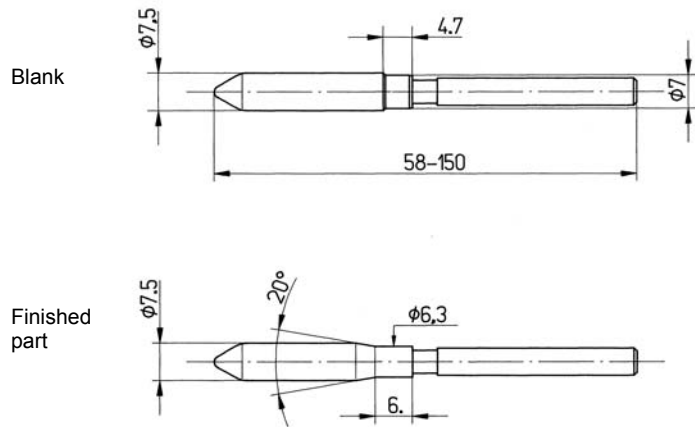


Components produced by Precision Rotary Swaging:
Assembling Glow Pin and Glow Tube



95-0175/M

Workpiece:

Material: INCONEL 601
 NICROFER 6025 HT

Blank: pre-assembled glow pin and glow tube
 workpiece length 58 to 150 mm and
 dia. 6.2 to 7.5 mm

Manufacturing requirement:

Automatic handling and Rotary Swaging Machine for assembling of glow pins and glow tubes in one operation

Previous technique:

unknown

Operation sequence:

1. Position workpiece
2. Release workpiece clamping
3. Pick up first glow pin and insert in swaging machine
4. Swaging glow pin to dia. 6.3
5. Eject glow pin into transfer receptacle
6. Insert second glow pin into swaging machine
7. Swaging glow pin to dia. 6.3
8. Eject glow pin into transfer receptacle
9. Place workpiece carrier onto conveyor
10. Change workpiece carrier

Advantages:

- Good dimensional accuracy
- Excellent surface finish
- Vertical processing of workpiece
- Safe sealing of inner magnesium powder
- Fully automatic forming on one station
- Very long die lifetime

Machine description:

Automatic Handling and Rotary Swaging Machine consisting of:

- 1 lifting turning unit
- 1 swing arm
- 1 holding gripper
- 1 release device
- 1 lifting device
- 1 Rotary Swaging unit
- 1 feed unit
- 1 workpiece output

Production rate:

Cycle time: approx. 5 sec.
 (= 12 pieces/min.)

Machine:

Model: SE 26

Required floor space without sound enclosure: (L x W x H)
 approx. 1,250 x 950 x 2,140 mm

Weight: approx. 1,800 kg

Required power: approx. 3 kW