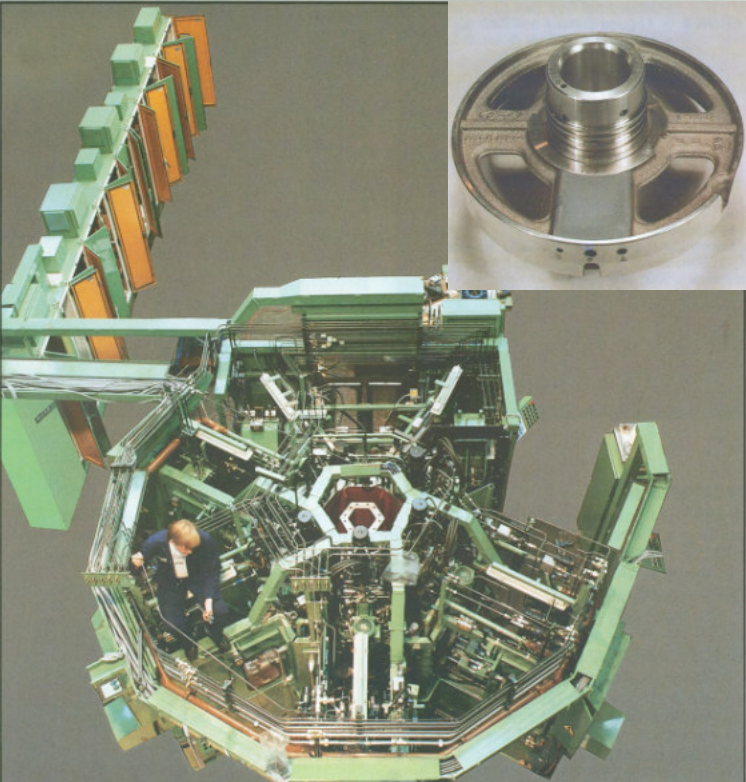




# Moss Group Automation

## 6 STATION CENTRE COLUMN ROTARY TRANSFER MACHINE

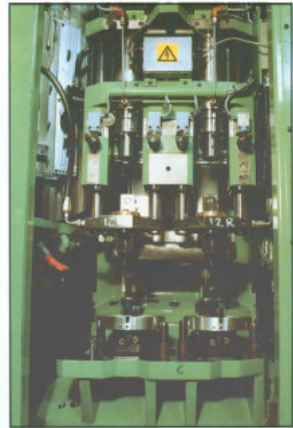


**COMPONENT MATERIAL OPERATIONS**

- Support Trans Centre
- Aluminium Alloy
- Gun Drill, Dimple, Drill and Ream Various Holes

**PRODUCTION**

- 189 Compts/Hour



**MACHINE SPECIFICATION AND PROCESS:**

- STATION 1** - Auto Load/Unload (2) components per cycle
- STATION 2** - Vertical Gun Drill (2) holes Ø4,0mm
- STATION 3** - Vertical Gun Drill (2) holes Ø4,0mm
- Horizontal Gun Drill (2) holes Ø4,8mm
- STATION 4** - Vertical Gun Drill (2) holes Ø3,0/4,0mm
- Horizontal Gun Drill (2) holes Ø5,8mm
- STATION 5** - Vertical Ream/Chamfer (4) holes Ø4,85 index spindles
- Horizontal Gun Drill (2) holes Ø3,0mm
- STATION 6** - Angular Dimple and Drill (2) holes Ø4,9/2,05mm
- Horizontal Drill (6) holes Ø4,0mm 3 position index spindles

**MACHINE DESCRIPTION:**

The machine is a fully automated Centre Column Rotary Transfer, with five vertical and four horizontal working stations. There are six two position workholding fixtures mounted to a Ø1600mm rotating ring table, components are auto loaded, unloaded and mechanically clamped/unclamped at station number one via a nutrunner.