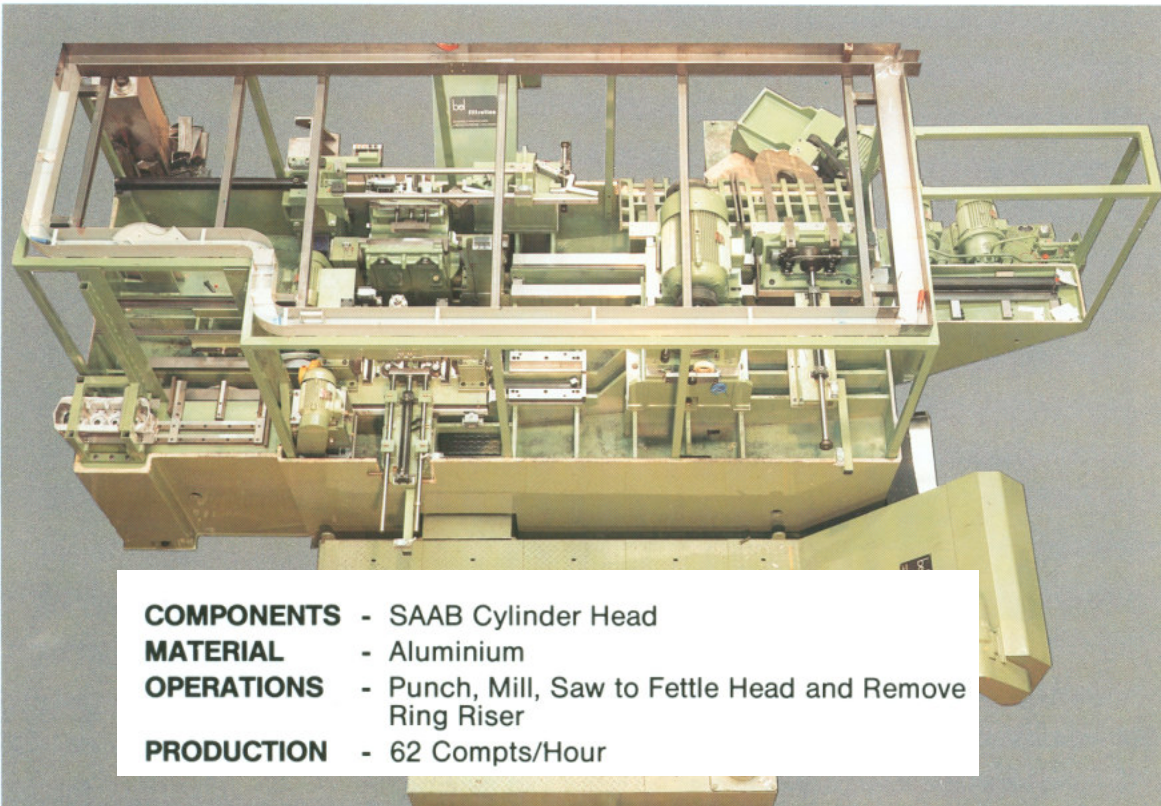




Moss Group Automation

CYLINDER HEAD FETTLING TRANSFER MACHINE



- COMPONENTS** - SAAB Cylinder Head
- MATERIAL** - Aluminium
- OPERATIONS** - Punch, Mill, Saw to Fettle Head and Remove Ring Riser
- PRODUCTION** - 62 Compts/Hour

MACHINE DESCRIPTION AND PROCESS

The machine is a Fully Automated Cylinder Head Fettling Machine. The component is loaded in its cast state at **STATION ONE** where it is put through a gauge to check the maximum profile dimensions of the component. At **STATION TWO** the valve holes are punched to ensure they are not covered by flash, before transferring the component through two milling units, machining the exhaust and inlet faces. At **STATION THREE** the component is transferred to a trunnion fixture, which turns through 90° sawing the water jacket face at the same time. At **STATION THREE** the component is transferred through a sawing unit, removing the ring riser, which then slides out of the machine to a bin. At **STATION FOUR** the component is automatically ejected from the machine to an unload position.

