

**AUTOMATIC FILLING CENTRE WITH 48 STATIONS FOR LOADING AND UNLOADING FILLED RESISTOR RODS**



## **AUTOMATIC FILLING CENTRE WITH 48 STATIONS FOR LOADING AND UNLOADING FILLED RESISTOR RODS**

This machine has been developed from the OR-042 and has been designed and produced for the automatic filling of a great quantity of resistors. However it also provides easy solutions for adjusting equipment for filling rods of different lengths. Thus, even small quantities of resistor rods can also be easily filled.

A new axis has been added to the machine for verification and control of element length, which corresponds to the characteristics described above.

A hook-on system for spirals can also be added, using simple hooks of the type used on traditional filling machines for 25 or 30 rods, which have been suitably modified.

In this way, the system applied to the present model has been greatly simplified, allowing the operator to easily substitute the hooks and therefore considerably reduce costs.

The filling centre is composed of:

- Automatic rod feeder which orients the rods for pick-up by the mechanical loading hand.
- Device for transferring the rods from the loading position to the filling position by means of mobile bars controlled by the CNC.
- 48 rod filler with oxide tub, proportionate to the length of the rod to be filled, from a minimum of 210 mm to a maximum of 2000 mm, and quick change of the rods to be filled.
- Automatic loading pincer for spirals and end pins for 48 pieces.
- Oxide feeder having a 300 Kg capacity and automatic dispenser on the oxide tub of the feeder. The tub can be easily loaded from the ground.
- Automatic checking of unhooked ends by means of laser sensors.
- Automatic oxide levelling and resistor plugging device.
- Unloading from the transfer and horizontal placement of filled resistors by means of a mechanical hand.
- Device for unloading filled resistors onto an high voltage tester with sorting out of rejects.
- Feed into a rolling mill with electronic rate counter and unloading into a container.
- Collection bin for finished pieces when rolling mill is inoperative for a prolonged period of time.
- PLC and Numeric Control board with control system for production data and self-diagnosing of machine operation, all of which can be run from an industrial PC equipped with a 14" LCD monitor and keyboard.
- Oleo-dynamic and electro-pneumatic systems installed on the machine.



**GENERAL TECHNICAL SPECIFICATIONS:**

Diameter of resistor rod to be filled	mm	7.5 ÷ 10
Length of resistor rod to be filled	mm.	300 ÷ 2000
Rod feeder capacity	pieces	about 800
Oxide tub capacity	Kg	300
Average filling rate	mm./min.	600 ÷ 900 $\phi$ 10 400 ÷ 600 $\phi$ 7,5
Average production capacity (per element l=1000 mm.)	pieces./h	1100 ÷ 1200 $\phi$ 10 700 ÷ 800 $\phi$ 7,5
Time required to adjust equipment for different rod length	min.	5
Installed electric power	kW	6
Electric power supply	V.	3x400+N, 50 Hz
Pneumatic power supply	bar	6
Dimensions	mm.	6000x4500x8000H
Weight	Kg.	6000

