

**TRANSFER MACHINE FOR ASSEMBLING TERMINAL PINS ON COILS
OF HEATING ELEMENTS**



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The machine is studied for the automatic production of resistive spirals complete of their terminal pins welded on and with plastic pugs mounted on.

The main part of the machine are:

- Working bench on anodised aluminium.
- Automatic stepping feeder for straight coils.
- Automatic feeder with fingers for long coils or not perfectly straight.
- Automatic feeder of terminal pins with quickly replacing of the containers.
- Feeding of plastic plugs by means of a vibrator and vertical guide of the plugs.
- Insertion of the terminal pins into the coils with rotation of the first ones.
- Mounting of the plugs onto the pins.
- Controlling system of the plug mounted.
- Spot welding of the coil onto the pin with fine positioning on the pin under the electrode.
- Inverter welding device operating with a frequency up to 25.000 Hz and 3000 A max.
- Controlling system of the welds.
- Fine calibrating adjustment of the pressure of the electrode onto the coil.
- Location of the plugs over the groove on the lower terminal pin.
- Ohmic test with fault selection and rejected elements on a separate wagon.
- Quickly set-up of the min-max ohm value.
- Complete diagnose system for all machine faults visualized on LCD screen.
- Visualization of all information regarding: timers, counters, variables.
- Lateral side of the machine free to access and monitored by light curtains.
- Handy box for executing manual cycles.

MAIN TECHNICAL CHARACTERISTICS:

Coil length on stepping feeder	mm	50-480
Coil length on fingers feeder	mm	50-1000
Coil diameter	mm	2-4
Coil wire diameter	mm	0.15-0.5
Pin length	mm	45-300
Pin diameter	mm	2-4
Capacity of coils container	Pz.	1000-1200
Capacity of pins container	Pz.	1000-1200
Medium cycle time	Sec.	3-3.5
Tooling changing time	Min.	5-6
Electrical supply	Volt	3x400x50Hz
Electrical power installed	Kw	20
Pneumatic supply	Bar	6
Overall dimensions	mm	3000x1900x2000H
Weight	Kg.	3000

