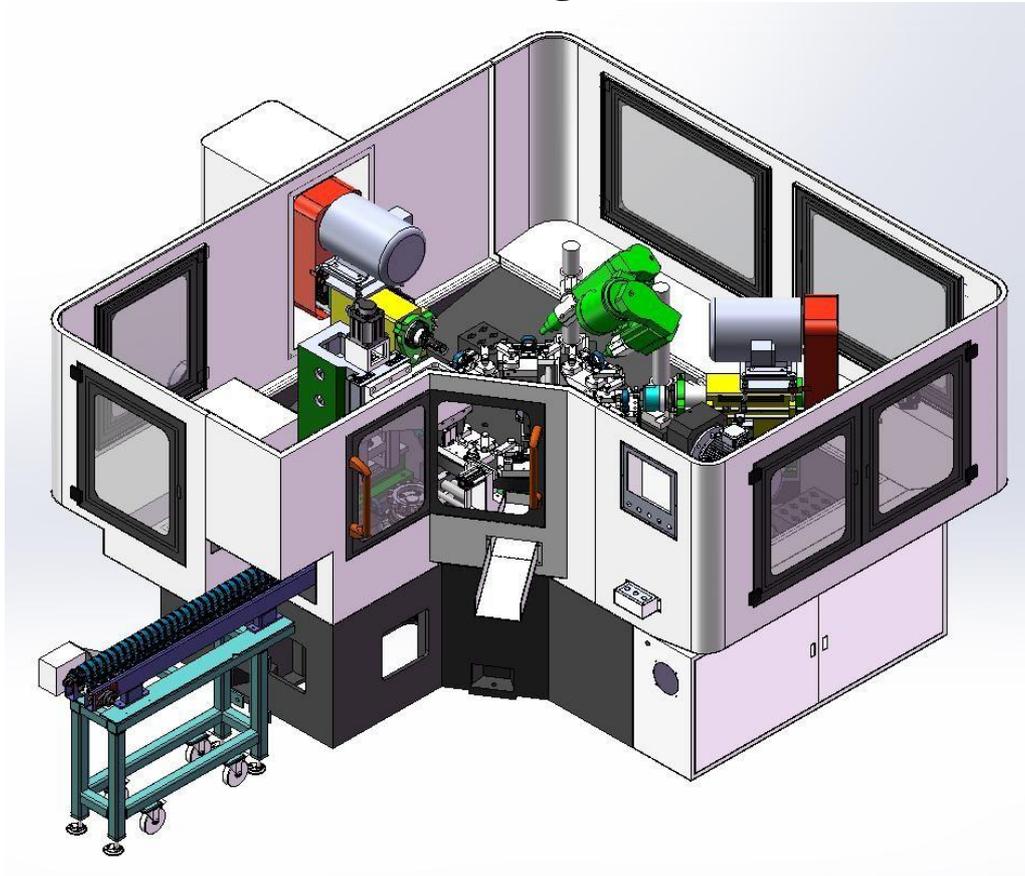
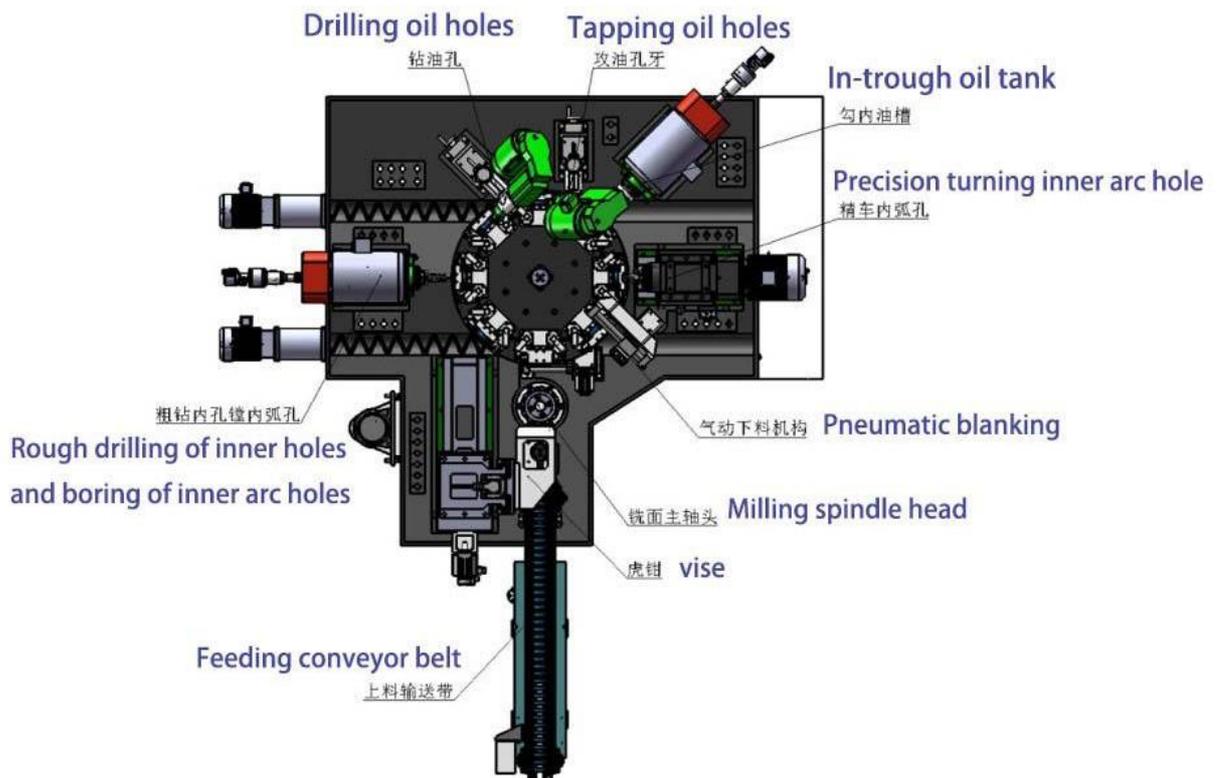


P Seat Pillow Block Housing Combined Processing Line

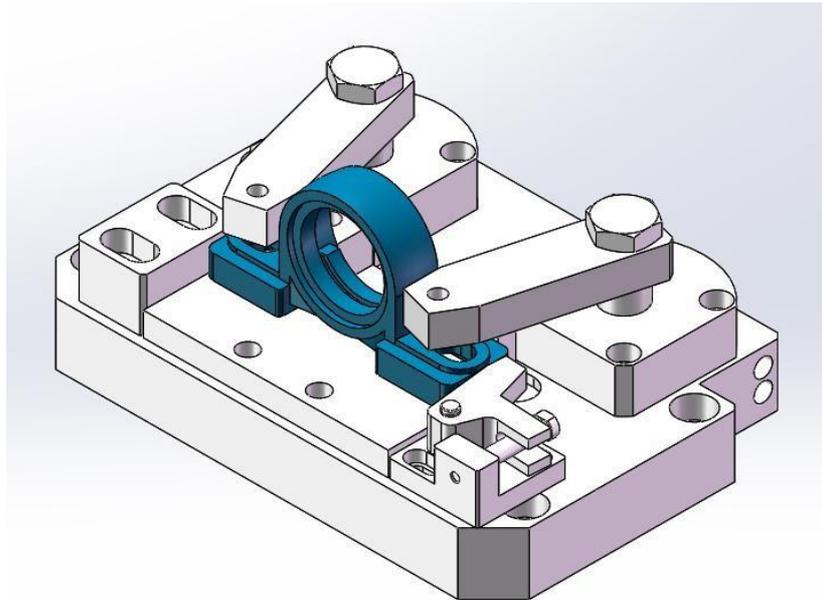


一、 Description of automatic assembly line process flow



- 1) First manually arrange the workpieces on the feeding conveyor belt.
- 2) The workpiece is sent out via the feeding conveyor belt to the induction area for positioning.
- 3) The workpiece is clamped by the vertical vise after being sensed and milled to the bottom surface, and then sent to the machine tool fixture for clamping processing. The rough bonding inner hole, boring inner arc hole, oil drilling hole, oil tapping hole, hook inner oil groove, and fine finishing are completed in sequence. Arc hole in car.
- 4) After the workpiece is processed, the pneumatic unloading mechanism will send the workpiece to the unloading port and drop it into the unloading box.

二、 Tooling diagram



三、 Process plan

Station	1# axis Milling power head	2# axis Drilling power head	3# axis Drilling power head	4# axis Tapping power head	5# axis Knife display power head	6# axis Fine boring power head
1#	Automatic feeding					
2#	Milling the lower plane					
3#		Coarsely reamed inner hole and Rough turning				

		arc inner hole				
4#			Drilling oil holes			
5#				Tapping oil hole		
6#					Oil groove inside hook	
7#						Precision turning arc inner hole
8#	Automatic blanking					
Note: The processing cycle time is about 30 seconds						