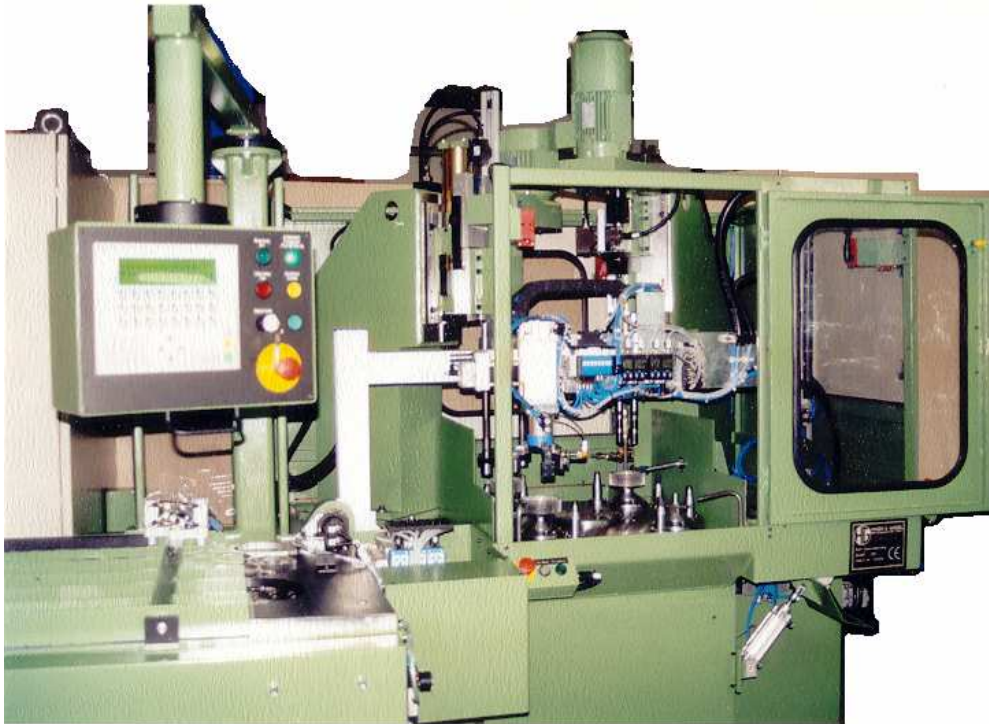




HAGEN & GOEBEL

Werkzeugmaschinen GmbH

Machine sample HG-808
**Special machine for automatic boring and tapping
of sintered metal teeth belt pulleys including
automatic loading and unloading system**



Kind of machining: boring of 4 holes and tapping of 4 tapps M8 into sintered metal type D30
Production capacity: 6 pieces per minute

Workpiece flow system:

- Unfinished workpiece magazine for production time 20minutes = 120 pieces
- Automatic orientation- and transfer system
- Automatic loading system with pneumatic handling
- Boring station with four spindles
- Tapping station with four spindles
- Automatic unloading system with pneumatic handling
- Unloading slide with pneumatic flap

Machining system:

Machine control: Type Siemens SPS S7 with control panel OP17

Boring unit: Electric motor (spindle) and hydropneumatic (slideway)

Tapping unit: Electric motor with leadscrew system

Handling: pneumatic system controlled by electric valves

Look for next page

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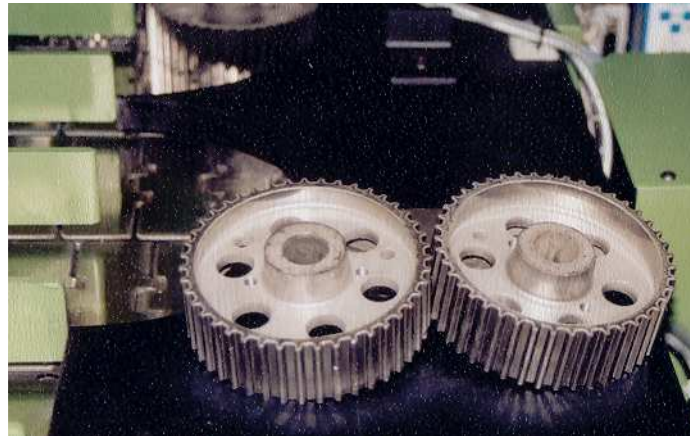
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Machine sample HG-808



Workpieces: Sintered metal teeth belt pulleys in different designs



In magazine the workpieces will be singled, pre-orientated and given to swing unit.

Look for next page

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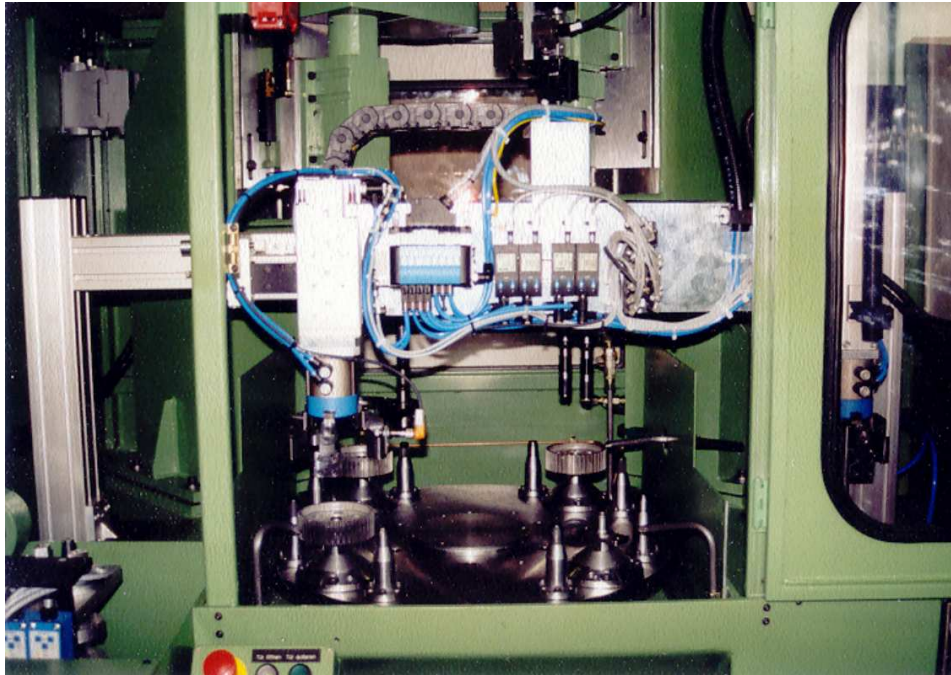
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Machine sample HG-808



From align system (far left) the workpiece will be loaded to the correct position on the rotary indexing table being set piece recording. By the 90 degrees indexing the workpiece reaches in succession to the boring station in the tapping station and the removal station.

By 2nd gripper unit the piece is into a shaft failure stored. For the gentle delivery of the pieces is the rubber coated pneumatic valve failure opens.



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