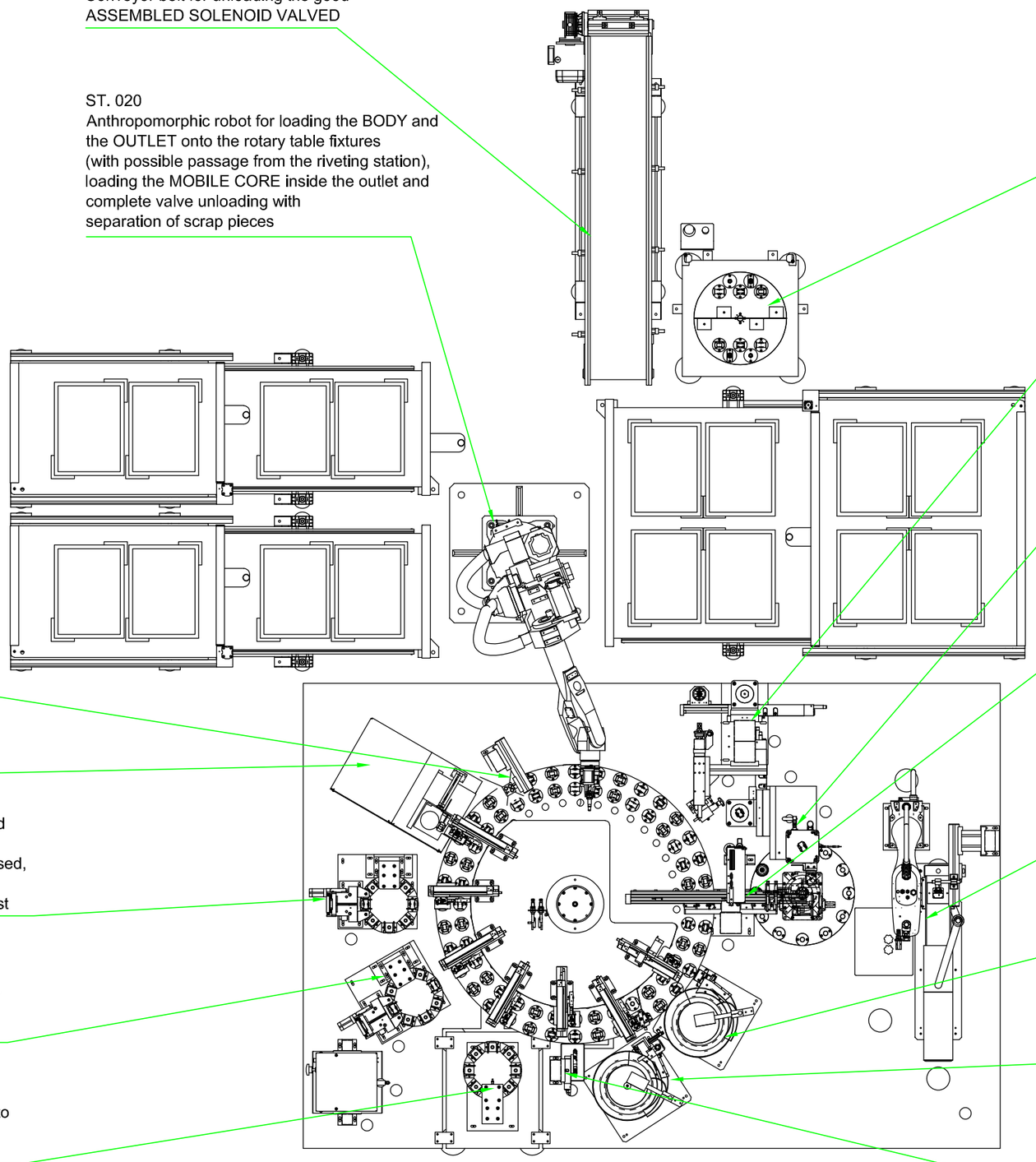
PRIMON
AUTOMAZIONI



ST. 150
Conveyor belt for unloading the good
ASSEMBLED SOLENOID VALVED

ST. 020
Anthropomorphic robot for loading the BODY and
the OUTLET onto the rotary table fixtures
(with possible passage from the riveting station),
loading the MOBILE CORE inside the outlet and
complete valve unloading with
separation of scrap pieces

ST. 010
Manual loading of the BODY, the OUTLET and
the MOBILE CORE inside the outlet
onto the transferring fixtures
(operating only for small production batches)

ST. 030
Automatic riveting station of the
OUTLET (if needed)

ST. 060
Planting of the SEATS into the body using an
electric press with pressing force control

ST. 040
Body transfering from the rotary table to the SEAT
pressing station and vice-versa,
with body measurement before and after insertion of the seat,
and possible passage from the typing station of the seats

ST. 140
Vision system for checking the
correct O-RING loading

ST. 130
Laser marking of the good valves

ST. 120
Valve transferring onto the second
external testing rotary table,
air leakage test with the valve closed,
possible execution
of the BOOSTER and the TUV test

ST. 110
Valve transferring
at the external testing rotary table,
air leakage test and flow test with
valve in opened position

ST. 100
Transferring the assembled valve to
noise test execution station,
and return to the main table

ST. 050
Automatic feeding of the seats
and loading onto the appropriate mould
with vision system for dimensional
and phasing control

ST.070
Automatic feeding and loading
of the O-RING into the body

ST.080
Automatic feeding and loading
of the O-RING for the outlet

ST.090
Grease dispensing onto the thread of the outlet;
transferring of the BODY onto the outlet and
screwing them from the bottom

AUTOMATIC SOLENOID VALVES ASSEMBLY AND TESTING MACHINE