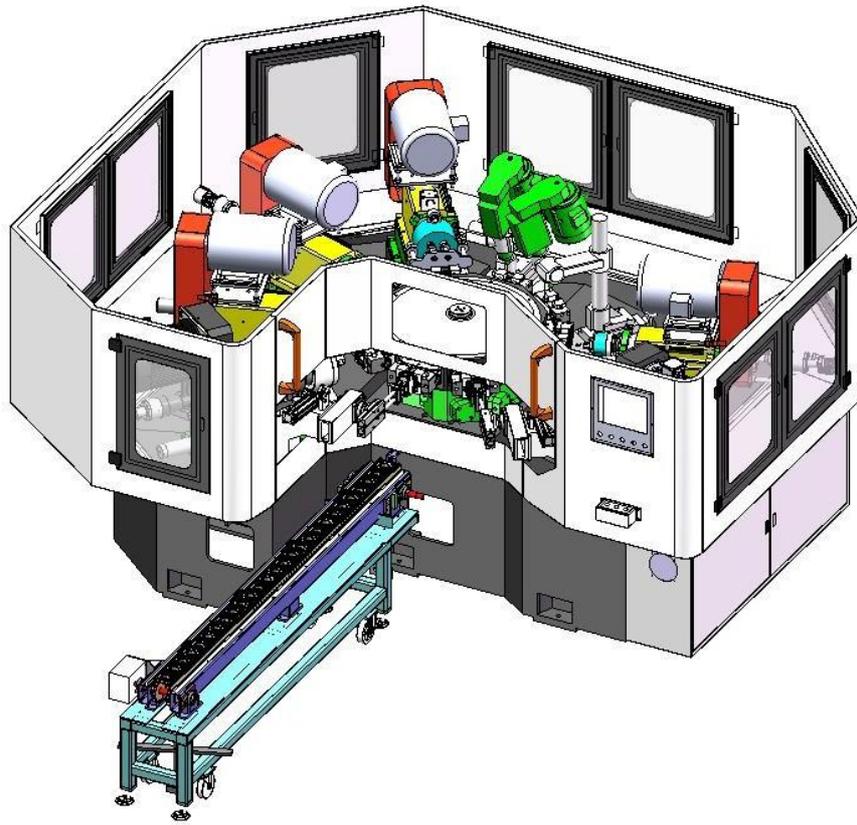
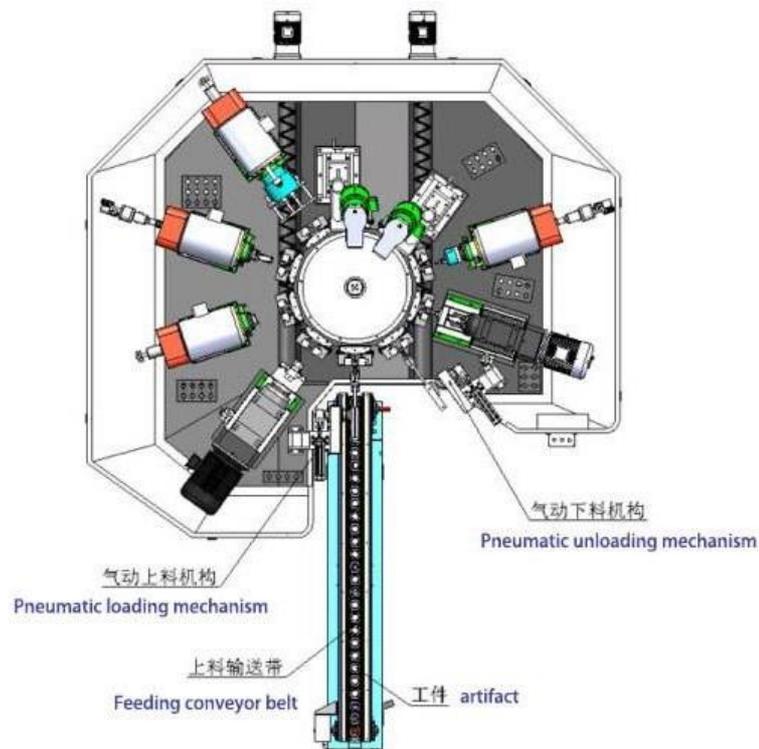


F&FL Seat Pillow Block Housing Combined Processing Line

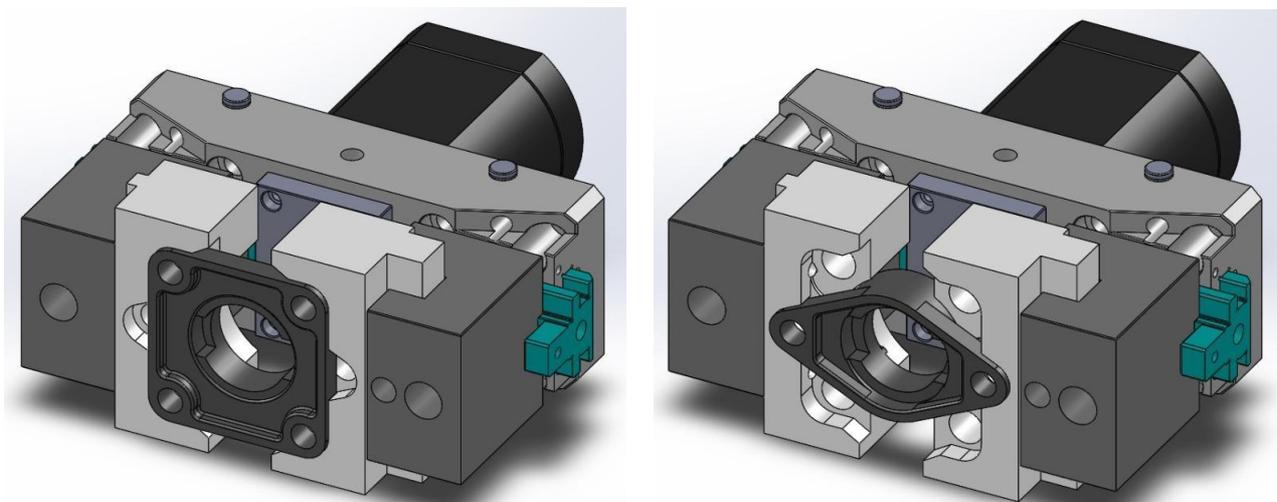


一、 Description of automatic assembly line process flow

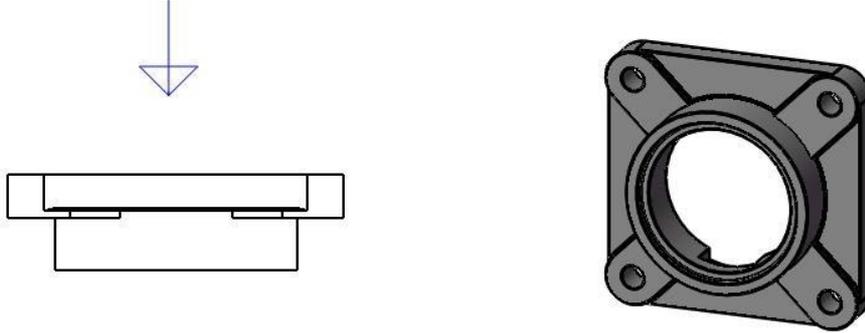


- 1) First manually arrange the workpieces on the loading conveyor belt.
- 2) The workpiece is sent out via the feeding conveyor belt to the induction area for positioning.
- 3) The workpiece is sent to the machine tool fixture for clamping and processing by the pneumatic loading mechanism through induction.
- 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 Car surface power head	2# axis Drilling power head	3# axis Drilling power head	4# axis Drilling power head	5# axis Drilling power head	6# axis Tapping power head	7# axis Knife display power head	8# shaft Fine boring power head
1#	Automatic feeding							
2#	car plane							
3#		Roughly reamed inner hole						
4#			Roughly reamed arc inner hole					
5#				Drill four holes				
6#					Drilling oil holes			
7#						Tapping oil hole		
8#							Exhibition oil tank	
9#								Precision hinged arc inner hole
Automatic blanking								