

# Flexible Multiple Operation Cell



## Products Used

- 6 FANUC 6-axis robots
- 4 FANUC RoboDrills with 4<sup>th</sup> axis FANUC indexers
- 4 FANUC RoboDrills with 5<sup>th</sup> axis Tsudahoma indexers
- 8 servo-driven door openers
- Tsune TK5C cold saw
- 60' NL conveyor
- 3 pin markers
- 4 part regrip stations
- 4 part dunk tanks & air blow off stations



## Challenge

A local OEM wanted to decommission two dated large inline transfer machine for manufacturing steel manifolds of about 100 part numbers.

## Solution

The system we supplied manufactures four part numbers simultaneously, starting from bar stock to bin packing, with the part time attendance of an operator. Raw stock is loaded into the cold saw and cut to proper length. A robot unloads saw and loads a four-lane conveyor, which conveys cut stock to each of four, two VMC machine cells. Each cell consists of an OP10 VMC, a OP20 VMC and a robot between both VMCs. When manifolds are machined complete, the robot places manifolds onto the four-lane conveyor and conveys parts to pin marking and bin loading. A packing robot at the end, stamps the part ID and loads it into wooden crates.