

Technology:

Workpiece	Bearing out ring(No. CG-GAC110S/K.01-LG1)
Annual yield estimation	12 months×26 days×20 hours×3600 seconds×0.85 Utilization rate/85 seconds(Automatic line cycle time)= 224640 pieces.

Specification:

ITEM	UNIT	AD15	AD25X	
CAPACITY	Swing over bed	mm	440	520
	Max turning diameter	mm	300	420
	Maximum cutting diameter of gap	mm	255	360
	Max turning length	mm	450	530
TRAVEL	X-travel	mm	180	230
	Z-travel	mm	480	590
	spindle speed	rpm	50-4500	35-3500
SPINDLE	spindle nose		A2-6	A2-8
	chuck size	Inch	8"	10"
	spindle hole	mm	62	87
	turret working position		8	12
TURRET	indexing time	s	0.58	1
	section of tool shank	mm	25×25	25×25
	Diameter of bore shank	mm	40	40

The movement of the manipulator and the Takt time:

No	Action process	Takt Time (s)	Remark
1	Take material from feeding device	5	
2	Moving it to 1st lathe	2	
3	1st lathe Reloading	15	Lathe waiting for 6.6s
4	Walking to Rotation station	2	
5	Workpiece flip	2	
6	Take material from Flip station	2	
7	Moving to 2nd lathe	2	
8	2nd Reloading	15	Lathe waiting for 11.4s
9	Moving to 3rd lathe	2	
10	Manipulator waiting	12.6	
11	3rd Reloading	15	
12	Return to baiting	5	