

Machine Features

- **HIGH PRODUCTION—900 TO 1400 COMPLETE ASSEMBLIES PER HOUR**
- **RESISTANCE TEST ENSURES ALL PIN/COIL ASSEMBLIES ARE IN TOLERANCE**
- **PROVIDES CONSISTENCY FOR BOTH THE ASSEMBLY AND THE WELD**
- **HIGHLY RELIABLE MACHINE WITH LITTLE DOWNTIME**
- **WILL ACCOMMODATE WIRE DIAMETERS FROM 0.2 TO 0.6mm (.008" TO .023")**
- **FLEXIBLE DESIGN ALLOWS YOU TO SELECT FEATURES TO MEET YOUR REQUIREMENTS**

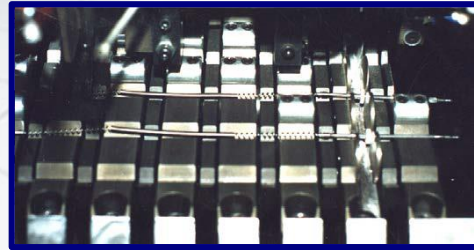


Coil Pickup and Feed Station

The **Oakley Automatic Pin to Coil Welder** is a high production machine for assembling and welding pins and coils. Our small appliance model accommodates coil lengths from 50 to 330mm (2" to 13") and terminal pin lengths from 47 to 100mm (1.875" to 4"). Our major appliance model accommodates coil lengths from 50 to 800mm (2" to 31.5") and pin lengths from 47 to 200mm (1.875" to 8"). Both models accommodate wire diameters from 0.2 to 0.6mm (.008" to .023").

The machine uses a walking beam to transfer the parts. Stations can be added or subtracted to customize the machine to meet individual requirements. The standard stations normally supplied are: 1) Coil Hopper; 2) Upper Pin Hopper; 3) Upper Pin Assembly; 4) Upper Pin Weld; 5) Cross Transfer; 6) Lower Pin Hopper; 7) Lower Pin Assembly; 8) Lower Pin Weld; 9) Lower Pin Plug Insert; 10) Resistance Test Station; and 11) Sorting Device to Remove Bad Parts.

The machine is equipped with a programmable controller, solid state welding controls, a weld monitor, and a message center that provides production statistics and machine diagnostics to aid in problem-solving. An optional laptop computer can be used to program the machine, trouble shoot problems, and download production information.



Pin/Coil Assemblies After Stretching

The following optional stations are also available:

- A second plug insert system for different diameter plugs
- A "Bump" station which flattens a section of the terminal pin to position and hold the plug
- A flexible "Stretch" device to place "Stretched" sections in the coils. Many small appliance elements require sections with a lower watt density. This device reduces the watt density by stretching a section or sections of the coil so they have a greater pitch than the normal close wound coil. This device can place a stretched section in the middle of the coils or can place a stretched section at both ends of the coils
- Both models may be supplied with either a **spot weld** or a **fusion weld**.

The production rate of these machines varies according to the stations being used and the length of the coil, but the normal rate is from 900 to 1400 assemblies per hour.

These machines are extremely reliable and will run consistently and efficiently with little maintenance or down time. Average production on our machine is higher than on similar machines. The consistency and quality of the welded assemblies produced is also superior to that produced by other available machines.

Machine Specifications

	<u>Small Appliances</u>	<u>Large Appliances</u>
Length:	2563mm (101")	Same
Width:	838mm (33")	1725mm (68")
Height:	1650mm (65")	Same
Weight:	907 kg. (2000 lbs.)	1248 kg. (2750 lbs.)
Electric Supply:	220v—1ph—50/60hz	Same
Air Supply:	5.6 bar (80 psi)	Same
Production Rate:	900 to 1400/hour	Same
Pin Lengths:	47 to 100mm (1.87" to 4")	47mm to 200mm (1.87" to 8")
Coil Lengths:	50 to 300mm (2" to 13")	50 to 800mm (2" to 31.5")
Wire Diameters:	0.2mm to 0.6mm (.008" to .023")	Same