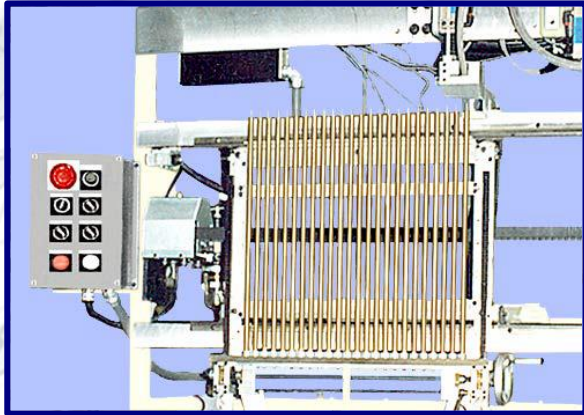
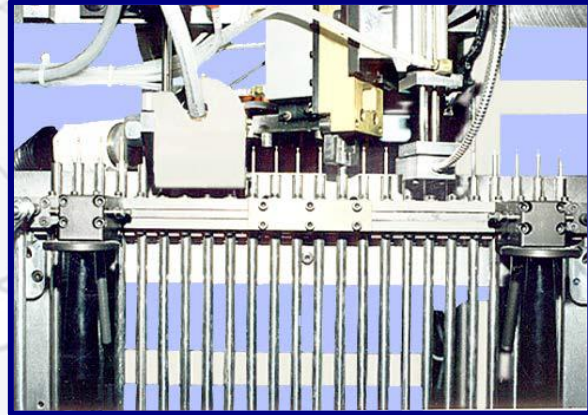


## Machine Features

- FAST INSERTION OF PLUGS INTO THE UPPER END OF THE ELEMENTS
- PNEUMATIC RACK IS USED TO LOAD FILLED ELEMENTS DIRECTLY INTO MACHINE
- **PRODUCTION UP TO 1000 PIECES PER HOUR**
- WITH 2 FEEDER SYSTEMS CHANGEOVER FOR A DIFFERENT DIAMETER TAKES ONLY SECONDS
- PLUGS ARE INSERTED TO A CONSISTENT LEVEL
- ELEMENTS WITHOUT PLUGS ARE AUTOMATICALLY REMOVED
- CAN BE SUPPLIED FOR ELEMENT LENGTHS UP TO 1.83 METERS (6 FT.)
- HIPOT (LEAKAGE CURRENT) TEST IS PERFORMED ON ALL ELEMENTS



24 Elements in Start Position  
Hand wheel Length Adjustment Shown at Lower Right.



Vacuum/Blowoff Station, Plug Insert Station,  
and Plug Inspect Station

The **Oakley In-Line Plug Insert Machine** can be loaded and unloaded manually or with the Oakley pneumatic rack. Either 18 or 24 elements are processed as a time. A stepper motor precisely moves the elements from station to station. A vacuum/blowoff device removes a pre-determined amount of MgO to create a cavity for the sealing plug. The plug is then inserted onto the terminal pin. A sensor is used to check for the physical presence of the plug. Any elements lacking a plug are automatically removed from the machine. The plug is then pressed into the element, and if required the element tube is constricted around the plug to hold it securely in place. The machine can be programmed so that the elements may be removed at either end. The machine provides for a highly consistent depth of the plug in the elements.

As standardly supplied, the machine is tooled for 1 element diameter with a maximum length of 1.83 meters (6 ft.). By adding an optional second vibratory feed system, for a different plug size, the changeover from 1 element diameter to another is reduced to a few seconds. In this case, the operator merely must turn a selector switch to convert the machine.

Length changeover is accomplished quickly by means of a hand wheel that drives a rack and pinion to move the clamping mechanism up or down to accommodate the new element length.

We also offer an optional hi-pot (leakage current) test station for this machine. Any elements failing the test are automatically removed from the machine.

Typical production is about 1000 pieces per hour when using our pneumatic rack and approximately 600 pieces per hour when manually loading and unloading the elements.

### Machine Specifications

**Length:** 2665mm (105")

**Width:** 914mm (36")

**Height:** 2108mm (83")

**Weight:** 408 kg. (900 lbs.)

**Electric Supply:** 115/220v—1ph—  
50/60hz

**Air Supply:** 5.6 bar (80 psi)

**Min. Diameter.** 6mm (.238")

**Max. Diameter:** 10mm (.394")

**Min. Element Length:** 216mm (8.5")

**Max. Element Length:** 1830mm (6 ft.)