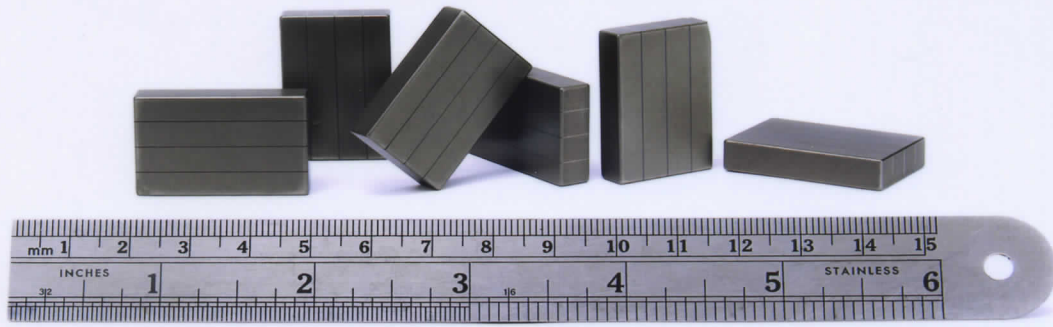


Delicate Magnet Blanks Are...

...unloaded, weighed, distributed and presented to robots for assembly into motors for electric vehicles.

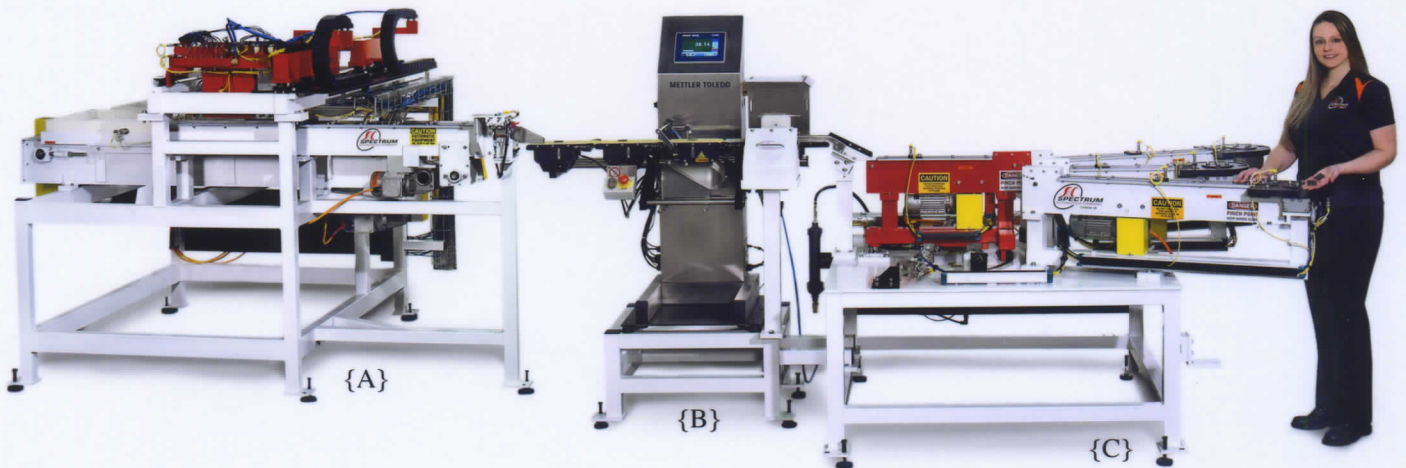


A Robot places a tote of parts on Spectrum's conveyor which moves and locates it for unloading. Totes hold five trays, each having 96 nested blanks.

{A} A gantry moves vacuum pick-up heads between the tray and a dual path take-away conveyor. When a tray is emptied, the gantry action uses a vacuum pick to move the tray to an adjacent empty tote. When one empty tray remains in a tote, it is shuttled to the adjacent exit conveyor and held to receive four more emptied trays. The tote is then conveyed back to the robot.

{B} The discharge conveyor feeds 108 pieces per minute via dual paths to a merge device. Parts are released to a conveyor for on-the-fly weight inspection. Parts exceeding +/-2 gram tolerance are ejected.

{C} Pieces move to a distribution conveyor which pivots to get the pieces to three final conveyors. Presentation escapements get the pieces to three robots which pick-and- place them into rotor assemblies.



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