

Automotive Knobs

Decorating Application:

Fully automated pad printing system for one or two color automotive knob printing.

Featured Machine:

Servo controlled pad printer with up to two color printing.

Special Features:

- Robot loaded and unloaded parts
- Two servo controlled pad printers for one or two color operation
- Interchangeable tooling for changeover between 3 parts
- Quick change tooling on ½ index of dial table
- Parts double printed for enhanced wear resistance
- Production rate: 2100 pph
- Vision system with part reject and part makeup
- High powered curing unit

Sequence of Operation:

1. Operator stacked trays of parts separated and sent to load area via conveyor.
2. Parts loaded onto 2-up, 12-stop dial fixture designed to fit 3 kinds of parts. Part presence checked and parts seated in fixture.
3. Parts indexed to first printer for printing of first color, then indexed to second printer, rotated 90° for second color. Pad cleaner ensures excess ink removed.
4. Parts indexed to curing station with heat ducted out of area.
5. Vision system inspects print and rejects misprinted parts. Acceptable parts loaded into tray and part makeup ensures fully loaded tray.
6. Trays stacked for operator unloading.

Artwork:

One color and two color prints with letters and images

Cliché: 100 x 215 mm

Substrate: Nylon

Ink: Type B

