#34 MULTI-SPINDLE DRILL
ROBOTICS 550 TRIP CELL
PRODUCTION PROCEDURES

PRODUCING A QUALITY PART

Note: Do not make any adjustments to this drill. This includes air pressure, reamers, jig location, material clamps, etc...

1. Turn on the main power switch.
2. Ensure the drill jig is free of metal chips. If not use a chip hook or debris brush to clean the jig surfaces.
3. Insert the part into the jig. Ensure it is located properly. The ends of the part should be under the material clamps and the 'V' on the part should match the 'V' on the jig.
4. Push the cycle button on the control panel.

The drill will automatically:

- clamp the part.
- start the coolant flow.
- start the spindles rotation.
- the turning reamers will feed to the material surface, proceed through the part and return to the start position.
- stop spindles.
- stop coolant flow.
- unclamp the part.

1. Remove the part from the drill jig.
2. Clean the jig with a chip hook or debris brush.
3. Insert a new part into the drill jig.
4. Push cycle start on the control panel.
5. Check the part for accuracy, using the go/no go gauges.
6. Repeat cycle process until desired number of quality parts are produced.

Caution: When advancing the reamers manually downwards toward the material make sure you do not bump the rotating reamers against the material.