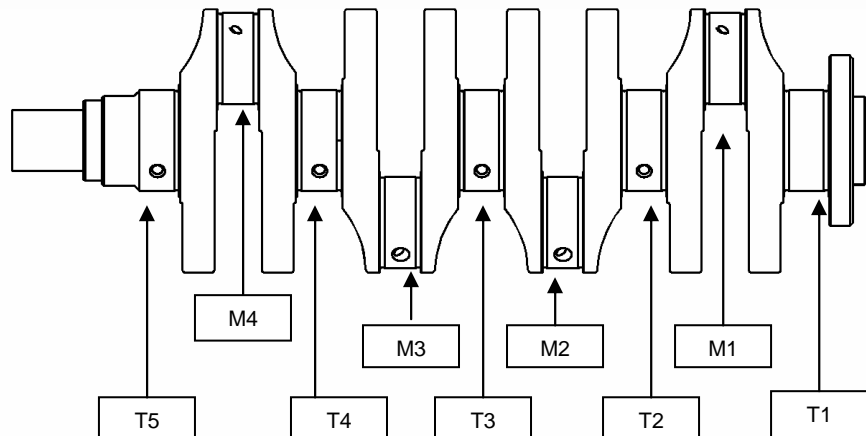
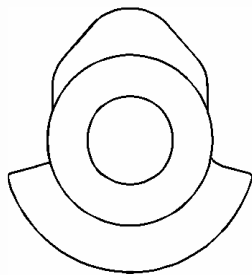


FLEXIBLE LINE FOR DRILLING DEEP HOLES IN CRANKSHAFTS

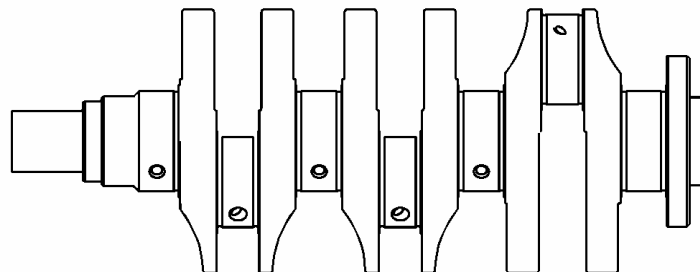
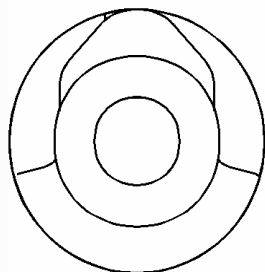
FUNCTION

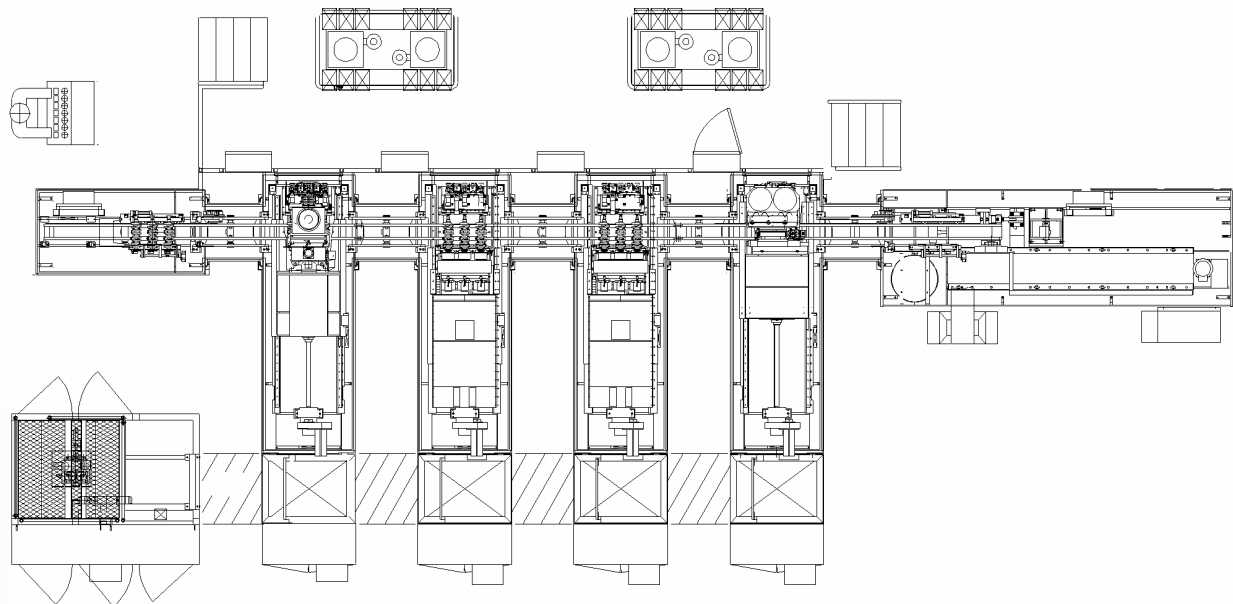
- This machine enables the deep drilling of oil holes in crankshafts 3 or 4 cylinders.
- The following machinings are carried out :
 Deep drilling of bearings oil holes (T1-T2-T3-T4-T5).
 Deep drilling of crankpins oil holes (M1-M2-M3-M4).
 Chamfering of bearings and crankpins oil holes.
 Intersection holes deburring, lubricating system rinsing.
 Cooling, spinning, blasting.

4 cylinders crankshafts



3 cylinders crankshafts





- The line consists in a transfer system and six stations (one loading, one unloading and four machining stations).
- It is designed to automatically bore 3 crankshafts by sequence and in a total time of 2,52 min.
- A bridge crane sets the crankshafts in threes onto transfer bars that feed the 4 machining stations by a lift and transfer movement.