Workpiece pallet selection

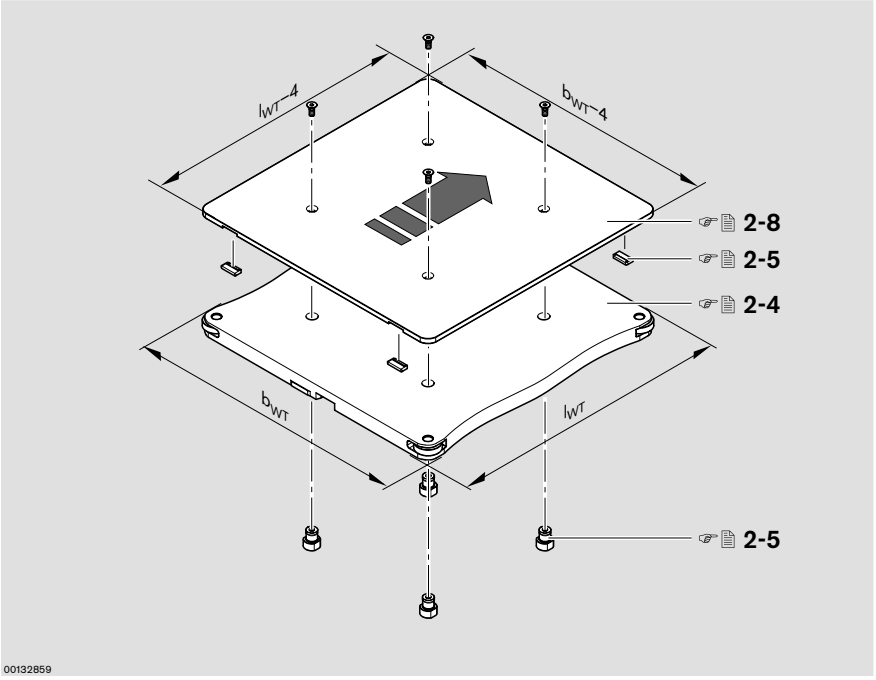
Application and functions

The workpiece pallet transports the workpiece in the transfer system as it goes through the processing stations.

- Defined positioning of the supported workpiece in the processing station is enabled through integrated positioning bushings.
- Integrated damping elements help to avoid noise and damage when workpiece pallets run into each other.
- Workpiece-related information can be transferred with the workpiece during processing using optional data tags. The information can then be evaluated locally and updated.

The orientation of the workpiece pallet on the conveyor section must strictly be observed:

- Traveling through curves/diverters is only possible in a longitudinal conveyor direction (see arrow on workpiece pallet).
- Separating workpiece pallets is only possible in a longitudinal conveyor direction (see arrow on workpiece pallet). A WT can also be brought cleanly to a halt on the outside of a transverse conveyor.
- In order to read out data tags, the workpiece pallet must cross the reader in the proper position.



Versions

The workpiece pallet is a modular system consisting of a base pallet, damping elements, carrying plate, and positioning bushings.

- Workpiece pallet in 6 standard sizes.
- Side rollers reduce friction, particularly in curves, diverters, and junctions.
- Aluminum carrying plates in 2 thicknesses and with variable dimensions. The carrying plate may extend beyond all sides of the base pallet.

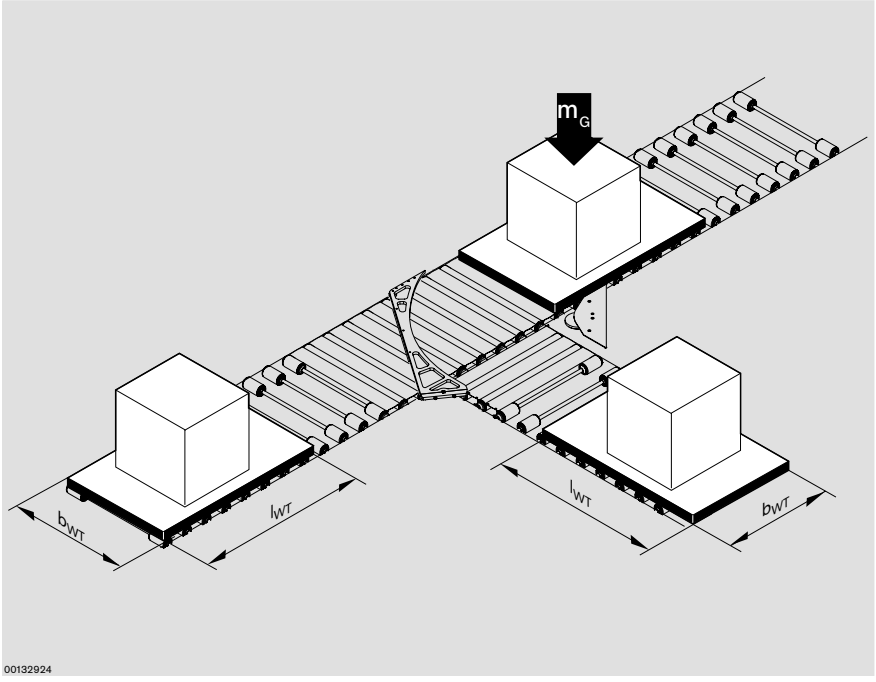
Size and load carrying capacity

The total mass of a workpiece pallet m_G is the sum of the

- Base pallet mass
- Carrying plate mass
- Workpiece support mass
- Workpiece mass
- Identification system mass

Depending on the total mass m_G of the workpiece pallet, the transport system can be set up with various parameters:

- Roller spacing
- Load class of the conveyor unit



Permissible gravity center position

In order to absorb acceleration forces without any problems when separating and changing the direction of the pallets (in curves, when changing to transverse conveyors), the location of the load center position on the workpiece pallet must be noted.

We generally recommend:

1. Loading the workpiece pallet as close as possible to the center
2. do not let the loading center of gravity at height h_S exceed 1/2 b_{WT} (where $b_{WT} \leq l_{WT}$)

Limits with junctions and diverters
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