



## ASSEMBLY AND TEST CARTRIDGE

27	GREASE system componetes	1
26	Protection	1
25	Station N°-210 ( Unloading of the ASSEMBLED CARTRIDGE with bad pieces separation )	1
24	Station N°-200 ( Checking 2nd three LOBED GASKET on the base )	1
23	Station N°-190 ( Loading of 2 OR on the BASE )	1
22	Station N°-180 ( 2nd three LOBED GASKET on the base )	1
21	Station N°-170 ( BASE + CERAMIC transferring and insertion inside the BODY )	1
20	Station N°-160 ( Dispensing GREASE on the CERAMICS )	1
19	Station N°-150 ( CERAMIC DISCS loading )	1
18	Station N°-140 ( ORING loading on the BASE )	1
17	Station N°-130 ( Checking 1st three LOBED GASKET presence )	1
16	Station N°-120 ( 1st three LOBED GASKET on the base )	1
15	Station N°-110 ( Base loading )	1
14	Station N°-100 ( Checking the ORING presence )	1
13	Station N°-90 ( OR loading on the HOLDER )	1
12	Station N°-80 ( HOLDER loading )	1
11	Station N°-70 ( Dispensing of the GREASE on LEVER + LEVER BASE )	1
10	Station N°-60 ( Transferring of the assembled LEVER + LEVER BASE inside the BODY )	1
9	Station N°-50 ( PIN Insertion Ø4 L=18 )	1
8	Station N°-40 ( Loading of the LEVER )	1
7	Station N°-30 ( Loading of the LEVER BASE )	1
6	Station N°-20 ( Dispensing of the GREASE inside the BODY )	1
5	Station N°-10 ( Loading of the BODY )	1
4	Fixture of the MIXER CARTRIDGE	20
3	Rotary table assembling the LEVER with LEVER BASE	1
2	Conveyor belt with 40 pallet	1
1	Base	1
POS.	DESCRIPTION	Q