

Pressure Judge

プレッシャー ジャッジ

Model: FS-PJ-1.0

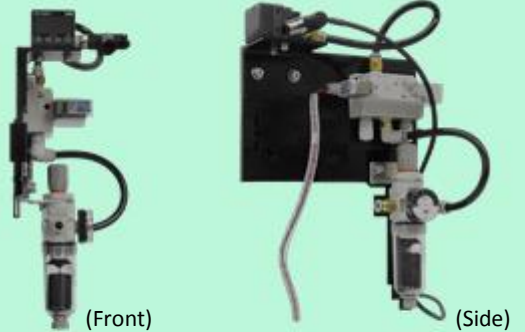
It is possible for the detection of a front and a reverse of a washer (with projection), a collar (with projection), a hex nut (with pilot), which are difficult to corresponding with a conventional detector. Further, it is possible for the detection of a size difference of a bolt, a projection difference of a bolt. It is possible for the more quality improvement with a combination of existing detector.

Controller



Approx. W:180 D:250 H:130 (unit = mm)

Pressure sensor unit

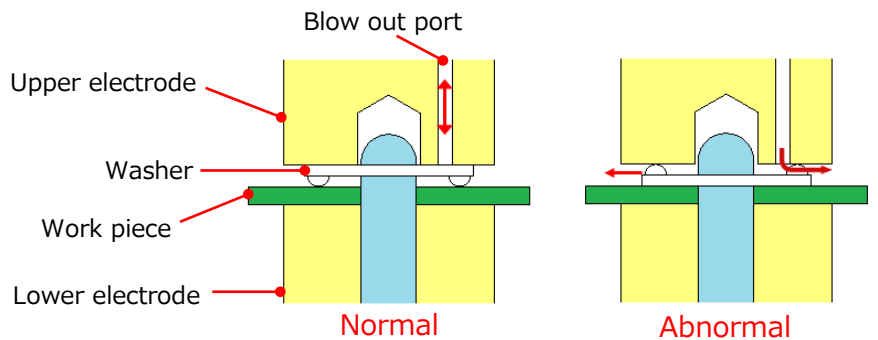


Approx. W:80 D:180 H:220 (unit = mm)

※ The controller and pressure sensor unit is sales as one set. (The dedicated electrode is not included in this set.)

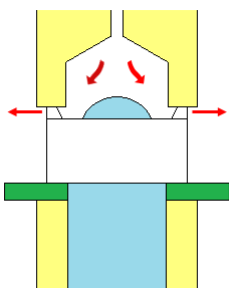
Detection method

The detection of good or bad is judged by the measurement of air pressure to be air-blown from the upper electrode.

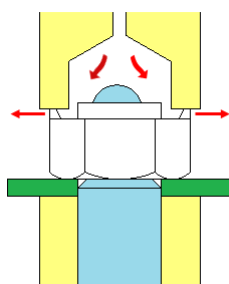


Detection Example

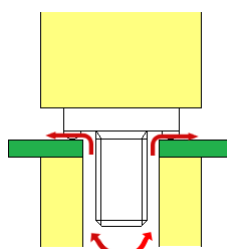
Collar reversed



Hex nut (with pilot) reversed



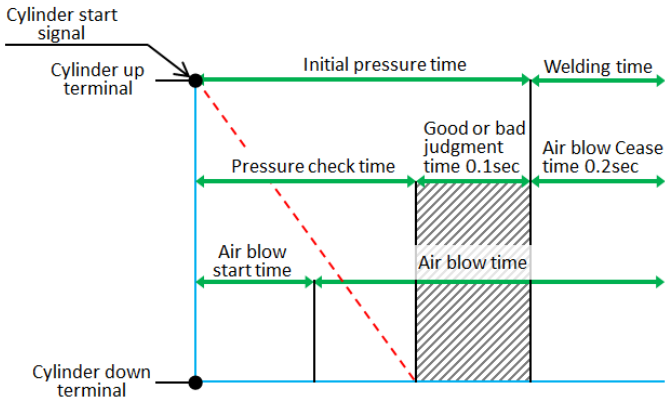
Bolt size difference



Projection difference



Timer Setting TIME



Calculation of Pressurization check time

Initial pressure time - Judgment time of good or bad

Calculation of Air blow time

Initial pressure time - Air blow start time + Air blow cease time

Example)

In case of Initial pressure time 30 cycle (60Hz)

• Pressure check time 0.4[sec] = 0.5 - 0.1

• Air blow start time 0.2[sec] (Initial setting value)

• Air blow time 0.5[sec] = 0.5 - 0.2 + 0.2

Detection items comparative table

Detection item	Detection Equipment			
	Nut Runner	Bolt Runner	Height Indication Mr. X003	Pressure Judge
Hex Nut (with Pilot) Reversed				○
Hex Nut (without Pilot) Reversed	○		※1	○
Square Nut Reversed	○		※1	○
Nut size difference	○		○	
Without Nut	○		○	
Without Workpiece	○		○	
Workpiece overlapping	○		○	
Workpiece deviation	○			
Centering deviation	○			
Nut projection abnormal	○		○	
Nut double pile			○	
Bolt projection shape difference				○
Bolt size difference				○
Bolt length difference		○		
Without Bolt		○	○	
Without Workpiece		○	○	
Workpiece overlapping		○	○	
Bolt projection abnormal		○	○	
Washer reversed (with projection)				○
Without Washer			○	
Without Workpiece			○	
Workpiece overlapping			○	
Washer double pile			○	
Washer projection abnormal			○	
Collar reversed (with projection)	※2			○
Without Collar	※2		○	
Without Workpiece	※2		○	
Workpiece overlapping	※2		○	
Collar double pile			○	
Collar projection abnormal			○	

※1: It is possible to be detected by the use of reversed protection tip, Electrode cover.

※2: It is possible to be detected by the use of the stepped guide pin.

■ Manufacturer

 **FEEDER SYSTEM Co.,Ltd.**

66 Komohara-Cho, Nishi-Ku, Nagoya-city, Aichi
452-0824, Japan

TEL:81-52-504-5181 FAX:81-52-504-5182

■ Agency

 **SHINKOKIKI Co., Ltd.**

4-11 Nakaotai Nishi-Ku, Nagoya City, Aichi
452-0822, Japan

TEL:81-52-504-5150 FAX:81-52-504-5158

Home page <http://www.shinkokiki.co.jp>