This automated assembly unit has been designed as a cam-controlled rotary transfer system featuring 36 stations and simple press tools.

The supply systems deliver the individual components required for the assembly process to the appropriate stations in the form of bulk material. These individual components are then assembled by cam-controlled handling machinery. After proceeding through all of the stations, the assembled “OK” parts are inscribed, counted and forwarded to cartons by a conveyor belt.

### 105-pin plug

Comprising the following individual components

- Retaining plate
- Silicone seal
- Contact upper section

- Radial seal
- Slider
- Contact lower section
Station 3
Deliver radial seal and insert in upper section
A pneumatic gripper extracts the seals from the separator gate and a cam-controlled handling unit inserts them in the upper section.

Station 9
Press in lower section
A cam-controlled toggle press inserts the lower section in the upper section.

Station 15
Deliver silicone seal and insert with correct orientation
Following separation, the silicone seal is deposited in an intermediate tray where a camera determines its orientation. A swivel unit rotates the silicone seal to the correct installation position and then inserts it in the upper section.
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With its own e-fleet, photovoltaic system, storage battery and charging station, sustainable e-mobility is in daily use at teamtechnik since 2013 and is part of the business model. Today, teamtechnik is leading in test benches for e-drive systems used in e-vehicles. Additionally, teamtechnik supplies assembly and test systems for batteries as well as PV stringers.