



Assembly Device



Type 100.27.40: 100 workpiece carriers **Type 50.60.73:** 50 workpiece carriers

General Information

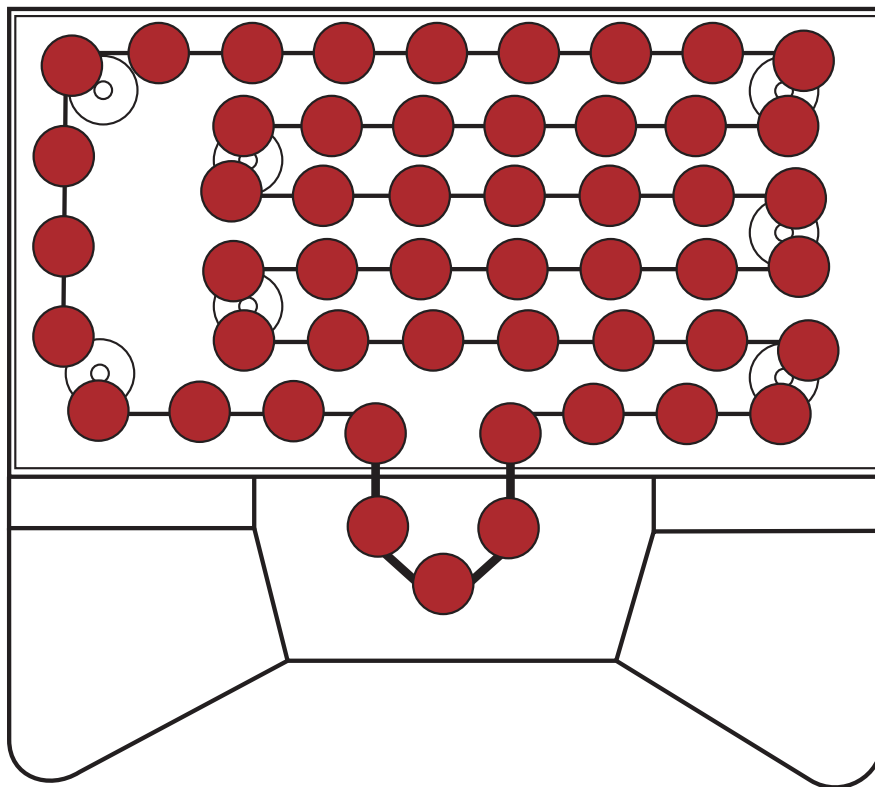
- This system has been demonstrated to be a cost-effective solution for the efficient assembly of small parts.
- It was developed over 80 years ago and has been repeatedly validated through practical applications.
- The Lanco assembly apparatus is a single workstation system that has been shown to reduce assembly times and improve quality in production of small assemblies, thanks to its simplicity and minimal investment.
- The apparatus's instructions are brief, and its design is intended to require minimal maintenance, allowing for a broad range of applications, including scenarios where skilled labor is not readily available.

The Principle

The rationalization effect of the Lanco assembly machines is based on the time saved due to the repetitive working method.

50 or 100 pallets circulate on a table. The pallets are advanced one by one by means of an ergonomically designed knee switch. This leaves the operator's hands free to perform assembly operations that are repeated 50 or 100 times.

Repetition optimizes the work flow. The activity is repeated reflexively, saving assembly time.



Assembly Unit with 50 Tool Carriers

The Lanco assembly unit type 50.60.73, equipped with 50 workpiece carriers, offers a high degree of customisability to suit specific requirements.

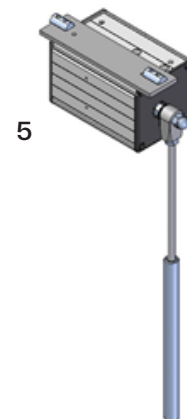
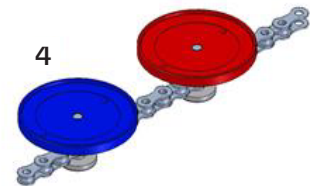
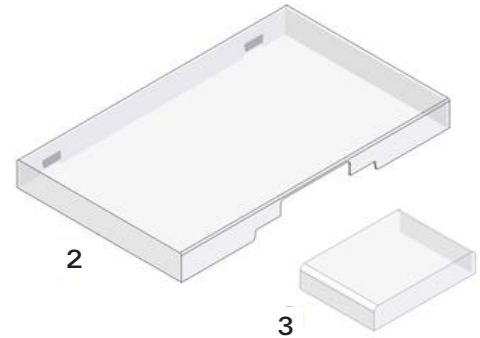
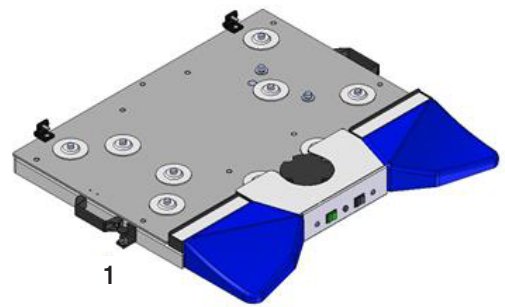
The module **(1)** comprises a robust aluminium frame, the drive unit, and the ergonomically designed blue arm rests.

The cover **(2)** can be left closed, ensuring protection of the workpiece throughout the machining process.

Lanco provides covers **(2)** of varying heights to accommodate workpieces of different dimensions. In instances where the assembly machine is not utilised for an extended period, the protective hood **(3)** fulfils the function of covering the work surface.

The chain **(4)** is available with workpiece carriers measuring 27 mm or 60 mm in diameter, with the maximum diameter of the workpiece for both variants being 73 mm.

The knee switch **(5)** enables the operator to index the workpiece carriers simply by using their knee, obviating the need to change their posture.



Technical Data

Type		50.60.73
Dimensions	Width	810 mm
	Depth	770 mm
Weight		26 kg
Number of discs		50 pieces
Internal disc diameter		60 mm
Max. workpiece diameter		73 mm
Max. usable height		30 to 180 mm
Motor power		25 W
Electrical connection		230V 50/60 Hz
Max. cycle rate per minute		80 pieces
Permissible temperature range		10-40 °C

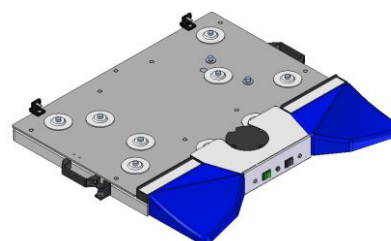
Assembly Unit with 50 Tool Carriers

Functions

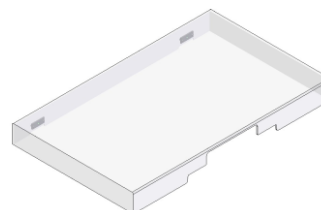
- Switch: On/off and clockwise/anticlockwise rotation
- Castors for moving the appliance
- Locking mechanism
- AC drive with 230V 50/60Hz
- Electrical connection 230V 50/60Hz

Order numbers

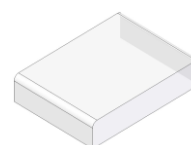
Basic module	
Type designation	Art. No.
Mounting device Basic module	33-0050



Cover	
Usable height	Art. No.
30 mm	33-0182
45 mm	33-0183
65 mm	33-0184
90 mm	33-0185
120 mm	33-0186
150 mm	33-0187
180 mm	33-0188



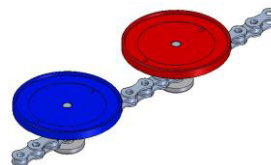
Protection	
Usable height	Art. No.
30 mm	33-2142
45 mm	33-2143
65 mm	33-2144
90 mm	33-2145
120 mm	33-2146
150 mm	33-2147
180 mm	33-2148



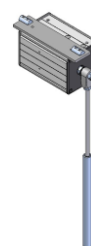
Assembly Unit with 50 Tool Carriers

Chain				
Number WT	WT Inner Ø	Max. Workpiece	WT Material	Art. No.
50	60 mm	73 mm	aluminum	33-0123
50	60 mm	73 mm	aluminum colored*	33-0124
50	27 mm	73 mm	POM white	33-0125

* 10x white, 10x black, 10x blue, 10x red, 10x yellow.



Knee switch	
Type designation	Art. No.
Electrical 230V	33-0500



Assembly Unit with 100 Tool Carriers

The Lanco assembly unit type 100.27.40, equipped with 100 workpiece carriers, offers a high degree of customisability to suit specific requirements.

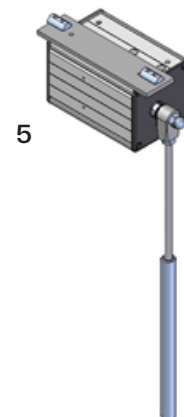
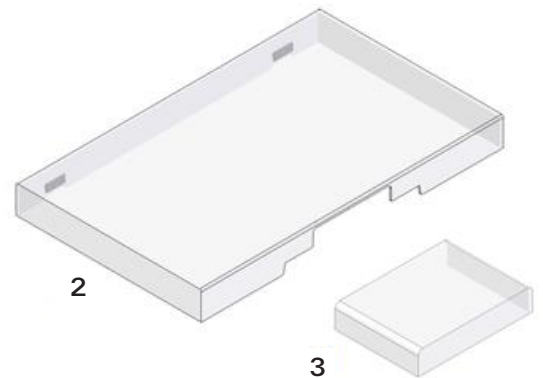
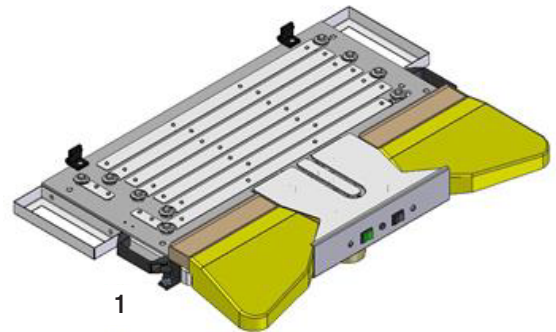
The module **(1)** comprises a robust aluminium frame, the drive unit, and the ergonomically designed blue arm rests.

The cover **(2)** can be left closed, ensuring protection of the workpiece throughout the machining process.

Lanco provides covers **(2)** of varying heights to accommodate workpieces of different dimensions. In instances where the assembly machine is not utilised for an extended period, the protective hood **(3)** fulfils the function of covering the work surface.

The chain **(4)** is available with 100 workpiece carriers measuring 27 mm in diameter, with the maximum diameter of the workpiece for both variants being 40 mm.

The knee switch **(5)** enables the operator to index the workpiece carriers simply by using their knee, obviating the need to change their posture.



Technical data

Type		100.27.40
Dimensions	Width	795 mm
	Depth	655 mm
Weight		19.5 kg
Number of discs		100 pieces
Inner plate diameter		27 mm
Max. workpiece diameter		40 mm
Max. usable height		30 to 180 mm
Motor power		15 W
Electrical connection		230V 50/60 Hz
Max. cycle rate per minute		80 pieces
Permissible temperature range		10-40 °C

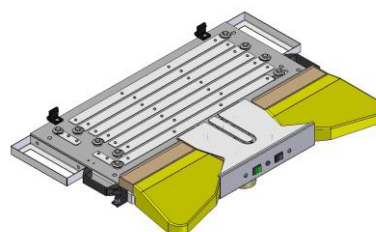
Assembly Unit with 100 Tool Carriers

Functions

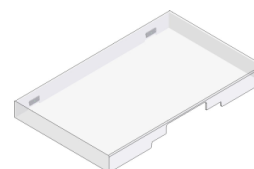
- Switch: On/off and clockwise/anticlockwise rotation
- Castors for moving the appliance
- Locking mechanism
- AC drive with 230V 50/60Hz
- Electrical connection 230V 50/60Hz

Order numbers

Basic module	
Type designation	Art. No.
Mounting device Basic module	33-0062
Mounting device 24 V	33-0063



Cover	
Usable height	Art. No.
30 mm	33-0172
45 mm	33-0173
65 mm	33-0174
90 mm	33-0175
120 mm	33-0176
150 mm	33-0177
180 mm	33-0178

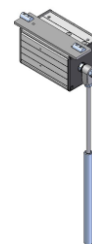


Protection	
Usable height	Art. No.
30 mm	33-2122
45 mm	33-2123
65 mm	33-2124
90 mm	33-2125
120 mm	33-2126
150 mm	33-2127
180 mm	33-2128



Assembly Unit with 100 Tool Carriers

Knee switch	
Type designation	Art. No.
Electrical 24V	33-1005
Electrical 230 V	33-0500



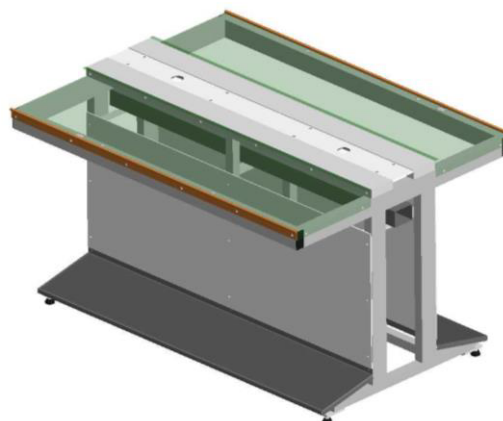
Chain			
WT Inner Ø	Max. Outer	WT Workpiece	Art. No.
27 mm	40 mm	POM white	33-0219

The size of the workpiece holder is Ø 27mm and the maximum workpiece diameter may be 40mm.



Accessories

Platform UB 1600/920		Art. No. 33-0516
Number of workstations	2	
Height of sliding surface	920 mm (+25mm adjustment range)	
Length	1600 mm	
Width	1204 mm (without mounting device)	



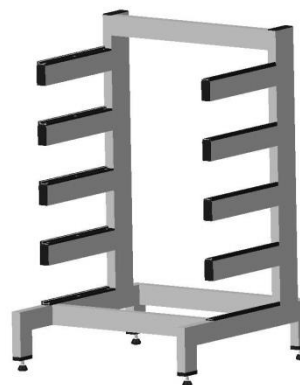
Swivel table SWT		Art. No. 33-0511
Capacity	1 assembly device max. 30kg	
Height of sliding surface	920 mm (+25 mm adjustment range)	
Width	1204 mm (without mounting device)	



Transport trolley TW1		Art. No. 33-0512
Capacity	1 assembly device max. 30kg	
Height of sliding surface	920 mm (+25 mm adjustment range)	
Length	1000 mm	



Rack GS5M		Art. No. 33-0513
Capacity	5 mounting devices, max. 30kg each	
Width	840 mm (without mounting device)	
Depth	850 mm (without mounting device)	
Height	1340 mm	



Accessories

Shelf Art. No. 33-0530	
Design	Profile construction with chrome steel sheet for two opposite workstations for mounting on the platforms UB1600 or UB2000
Mounting	For mounting in 8 mm profile grooves
Shelf surface	900x250
Capacity	max. 20 kg

Work light Art. No. 392-455-0301	
Type	SNE 118, daylight with glass
Data	230 V 50/60 Hz, 0.5A, cable 1.8 m with CH plug, IP20
Mounting	for mounting in 8mm profile slots

Socket strip (CH) Art. No. 15-2251	
Type	4 x T13
Voltage	230 V 50/60 Hz
Current	10A

