

## Feeding Technology



## Feeding systems for handheld tools

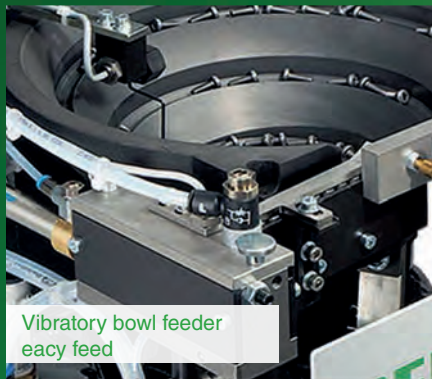
**Efficient and intelligent feeding with eacy feed,  
the new generation vibratory bowl feeder.**

- Approx. 80 % energy savings
- Efficiency and worldwide application - one design for all markets

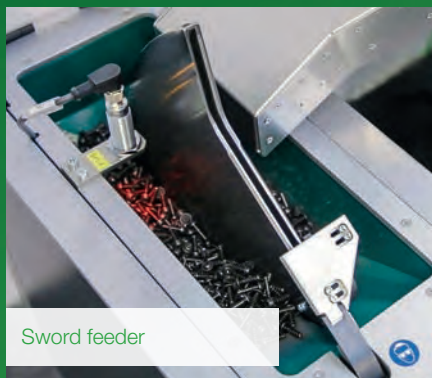
Our feeding systems consist of modules that are adapted to each other: one feeder with integrated controller, a handheld screwdriver or press-insertion devices and all other add-on components that fit the customer's application.

This proven system with an extreme high feed rate, allows a rational and process-optimized assembly.





Vibratory bowl feeder  
easy feed



Sword feeder



Pick-and-Place  
feeding system



Screw dispenser

## OUR RANGE OF FEEDING SYSTEMS FOR HANDHELD TOOLS

### Vibratory bowl feeder

The vibratory spiral feeder can be used in automated assembly systems as well as manual operations with handheld screwdrivers. It is a versatile product which facilitates reliable component feeding in diverse production environments.

→ Technical data can be found on [page 6](#).

### Sword feeder

Sword feeders or segment feeders are particularly suitable for use in cleanroom environments. One advantage of the sword feeder is the very gentle, low abrasion part feeding.

→ Technical data can be found on [page 7](#).

### Pick-and-Place feeding system

Feeding to a Pick-and-Place position is often the most attractive solution for screws with very short shafts, rivets with large collar diameters, and parts with complex external geometries.

→ Please contact us if you are interested in this individual solution.

### Screw presenters / Screw dispenser

Screw presenters  
Screw dispenser

→ [Catalog D3840](#)  
→ [Catalog D0066](#)

### Screwdrivers for the feeding system

Our feeders can be used in combination with almost any electric or pneumatic screwdriver of the MICROMAT/MINIMAT range. Additionally we also offer screwdrivers with ESD compliance.

→ Technical data can be found on [page 8](#).

### More feeding systems from our range

Step feeder  
Mini Screw Feeder  
Storage devices

→ [Catalog D3835](#)  
→ [Catalog D3836](#)  
→ [Catalog D3850](#)

The overview catalog for [DEPRAG feeding technology D3810E](#) provides additional information on DEPRAG feeding systems.



Screwdrivers for the  
feeding system

## CLEAN FEED – THE DEPRAG CONCEPT FOR TECHNICAL CLEANLINESS

In particular with the handling of small, sensitive components, the subject of Technical Cleanliness is becoming more in demand, for example in the manufacturing of light electronic or hydraulic products. In response to the rising trend of Technical Cleanliness we now offer a program of specifically designed solutions.

The assembly of critical parts, components and systems in conjunction with Technical Cleanliness is done in the so-called clean production environment. DEPRAG offers proven components that meet the requirements of Technical Cleanliness in automatic parts feeding and assembly. Particles are minimised using friction and/or vacuum with the help of a range of methods and components.

**Your Advantage:** Integrated concept for Technical Cleanliness! The complete program of all required components from a single source.

Application of the following equipment can help to produce the optimal results:

- Pre-cleaned assembly components (e.g. Arnold Cleancon® screws) - fewer particulates due to an additional cleaning process
- DEPRAG HSF Sword Feeder - vibration free part feeding and therefore less particle generation
- DEPRAG-inverted screw assembly unit - use gravity to your advantage – inverted screwdriving with the DEPRAG-inverted screw assembly unit
- DEPRAG Particle Killer - debris in the autoseed process is reduced selectively
- DEPRAG BitCleaner - suction of metallic abrasion  
Say goodbye to annoying particles during the fully automatic tightening process!  
The DEPRAG BitCleaner is the latest addition to our CleanFeed concept and removes unwanted particles that occur during the engagement process (connection of the bit with the screw drive) and can stick to the bit. Through a cyclical cleaning process, this innovative tool significantly improves Technical Cleanliness.
- DEPRAG SFM-V vacuum screwdriving module - debris created during the assembly process is extracted using vacuum sources

### AVOID ABRASION



Low abrasion, component friendly feeding of connection elements with a DEPRAG sword feeder.

### REDUCE ABRASION



Particle Killer

### REMOVE ABRASION


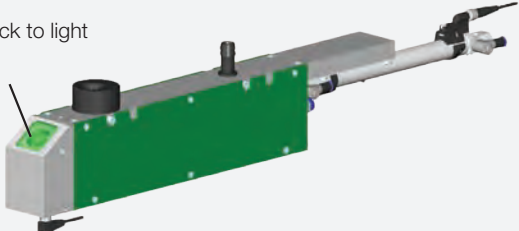


Vacuum suction

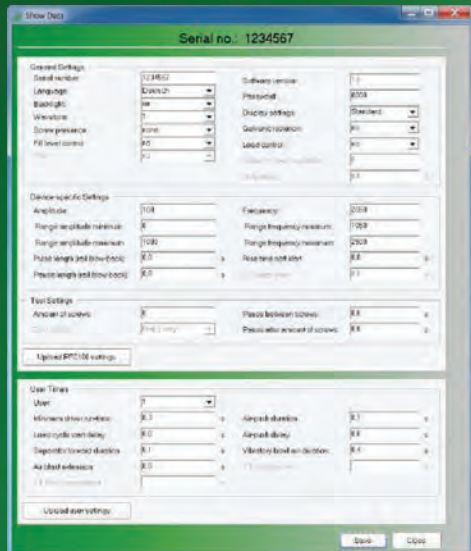
### SUCK OFF ABRASION



DEPRAG BitCleaner

Technical data	Inline Variant	Pick&Place Variant
Required control components	Pneumatic Valve/Vacuum Generator	Pneumatic Valve/Vacuum Generator
Connections	24VDC PNP	24VDC PNP
Dimensions mm (LxWxH)	170 x 30 x 120 (without hoses)	540 (due to 160 mm load stroke) x 50 x 125 (without hoses)
		<p>Pick to light</p> 





## SOFTWARE SOLUTIONS

### PFC100 Manager – the parameterisation software for PFC100 controllers

The PFC100 Manager facilitates the reading and saving of parameters as text files for every PFC100 controller. Saved parameters can be transferred to any PFC100 controller quickly and simply using the PFC100 Manager.

**The connection cable 385520B required to connect the PC and PFC100 must be ordered separately.**

The software download is available from the myDEPRAG customer portal ([my.deprag.com](http://my.deprag.com)). Registered users can activate the activation code and manage licences in MY ACCOUNT > DEPRAG Apps.

Available languages: German and English

Part number:  
PFC100 Manager, activation key, part no. 122000

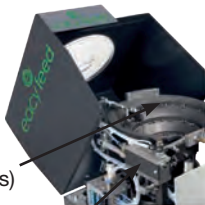
Further information can be found in our catalog D3900E or on our website [www.deprag.com](http://www.deprag.com)

## STRUCTURE OF A DEPRAG FEEDING SYSTEM

DEPRAG feeding systems consist of the feed bowl unit, screw separator, an air connection and air maintenance unit, a mains power switch and electronic controller, 2 m standard length hose set, the mouthpiece guide and the mouthpiece as well as an appropriate screwdriver receiver (adapter) and a sound enclosure cover.

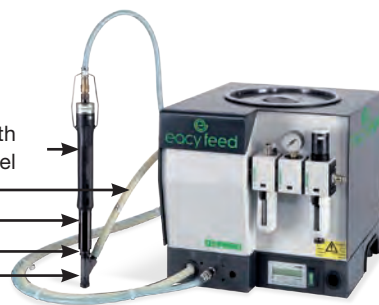
**With either vibratory bowl feeder or sword feeder**

With single or double spiral bowl (for one or two screwdrivers)



With single or double separator system

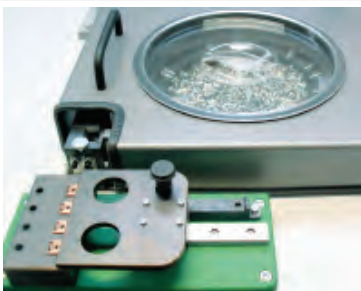
Can be combined with any screwdriver model  
Hose set  
Mouthpiece guide  
Mouthpiece  
Nosepiece single/split type or ball type



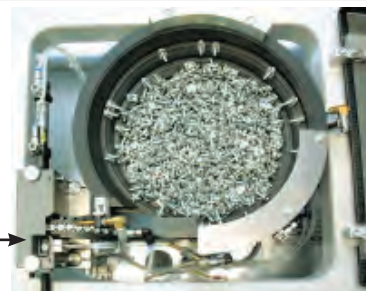
With hopper and sort segment for one feed rail

Sword feeder with separator

**If feeding with a hose system is not possible, we offer special solutions, such as the pick-and-place procedure**



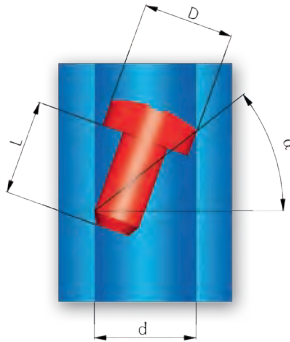
Defined pick position with integrated screw pick control option



## GUIDELINE FOR THE SELECTION OF A SUITABLE FEEDER

### STEP 1: Feeding criteria

Basically all "shaft-heavy" screws with a head which fulfils the following criteria are suitable for processing with our feed systems:



**Feeding criteria:**  
 $\alpha > 30^\circ$

$d \sim D + 0.5 \text{ mm}$

**Approximate formula:**

$L > D + 2 \text{ mm}$

d = Internal diameter  
feed hose  
D = Screw head diameter  
L = Screw shaft length

### STEP 2: Screw quality

For reliable feeding machines a DIN quality standard (allowable 3% bad parts) is not always sufficient.

Higher levels of screw/fastener quality improve the feeder's reliability.

The goal should be a quality grade of 10 ppm ("parts per million"). I.e. in every 100,000 screws there can be 1 bad part.

### STEP 3: Which feeding principle is best suited to your application?

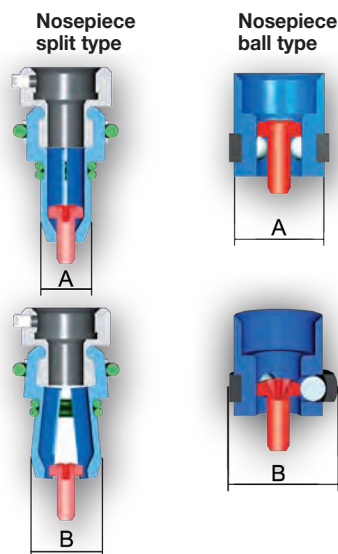
A vibratory spiral bowl is particularly suited to screws with awkward dimensions or those with special feed rate requirements.

The sword feeder is applied when extremely gentle handling of the parts is required or when very low noise level is a must.

If feeding with a hose system is not possible we also offer pick-and-place procedure.

### STEP 4: Determining the screw receiver

At the end of the mouthpiece there is a nosepiece ball type (1 or 2 rows) or a nosepiece split type, mounted to receive and position the screw.



D = Head diameter  
d = Shaft diameter  
n = Space required to open

$A = D + 2.5 \text{ mm}$   
 $B = A + D - d/2$

$B = 3D - 2d + 5 \text{ mm}$

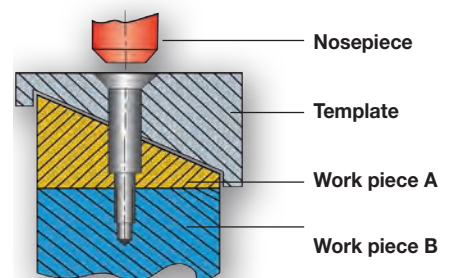
$n = A \times B$

$n = \varnothing B$

### STEP 5: Space available on the component

For effective use of the handheld screw feeders the space available around the screw head on the assembled components is very important.

There is a certain space requirement for the nosepiece split type and ball type. An even surface simplifies the positioning and handling of the tool. Slanted surfaces with small diameter recessed screw-holes can only be accessed with templates which are available as optional equipment.



### STEP 6: Single or multiple feeding / screwdrivers?

Using a dual spiral vibratory bowl (type 11022) one feeding machine can supply two separate screw outlet positions/screwdrivers. Compared to the investment of two single feeding machines, investment in a twin device saves approximately 25 %.

### STEP 7: Specification

For the correct specification of your screw feeding machine the following data is required:

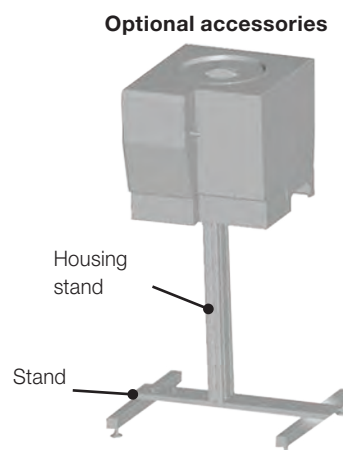
- Voltage / frequency
- Choice of screwdriver model (torque and speed)
- Screw dimension and screw type (if available – DIN no.)
- Torque (if known)
- Details dimensions of assembly components
- Hose length (if over the standard length of 2 m).

To process your order we require sample screws (approx. 1 feed bowl volume) and if possible some samples of the part to be assembled.



eacy feed  
11011-0.15 11011-1.2  
11011-0.75 11011-2.5

## TECHNICAL DATA VIBRATORY BOWL FEEDER



Material to be fed		Screws or nuts						
Standard version	Type	11011-0.15	11022-0.15	11011-0.75	11022-0.75	11011-1.2	11011-2.5	11022-2.5
Control unit		PFC100 Controller						
Transport principle		Vibratory bowl feeders *)						
Amount of connectable drivers		1	2	1	2	1	1	2
Feed rate	Parts/min	45	2 x 45	45	2 x 45	25	30	2 x 30
Filling capacity	liter/gal.	0.15 / 0.04	0.15 / 0.04	0.75 / 0.2	0.75 / 0.2	1.2 / 0.32	2.5 / 0.66	2.5 / 0.66
Voltage	V/Hz	24 Volt DC		24 Volt DC				
Power consumption	W	max. 50		max. 50		max. 150		
Air pressure requirement	bar/PSI	6 / 85.2		6 / 85.2				
Air connection size	mm/in.	10 / <sup>3</sup> / <sub>8</sub>	10 / <sup>3</sup> / <sub>8</sub>	10 / <sup>3</sup> / <sub>8</sub>	10 / <sup>3</sup> / <sub>8</sub>	10 / <sup>3</sup> / <sub>8</sub>	10 / <sup>3</sup> / <sub>8</sub>	10 / <sup>3</sup> / <sub>8</sub>
Dimensions W x D x H	mm in.	296 x 360 x 289 11 <sup>21</sup> / <sub>32</sub> x 14 <sup>3</sup> / <sub>16</sub> x 11 <sup>3</sup> / <sub>8</sub>		360 x 414 x 368 14 <sup>3</sup> / <sub>16</sub> x 16 <sup>5</sup> / <sub>16</sub> x 14 <sup>1</sup> / <sub>2</sub>			547 x 600 x 294 21 <sup>17</sup> / <sub>32</sub> x 23 <sup>5</sup> / <sub>8</sub> x 11 <sup>37</sup> / <sub>64</sub>	
Weight	kg/lbs	appr. 18/39.6	appr. 20/44	appr. 32/71	appr. 34/75	appr. 40/88	appr. 60/132	
Feedhose length standard	m/ft.	4 / 13.2	4 / 13.2	4 / 13.2	4 / 13.2	4 / 13.2	4 / 13.2	4 / 13.2
Feedhose length max.	m/ft.	8 / 26.4	8 / 26.4	8 / 26.4	8 / 26.4	8 / 26.4	8 / 26.4	8 / 26.4
Technical details on screws:								
Max. head diameter	mm/in.	5 / <sup>13</sup> / <sub>64</sub>	4 / <sup>5</sup> / <sub>32</sub>	12 / <sup>15</sup> / <sub>32</sub>	8 / <sup>5</sup> / <sub>16</sub>	12 / <sup>15</sup> / <sub>32</sub>	16 / <sup>5</sup> / <sub>8</sub>	14 / <sup>35</sup> / <sub>64</sub>
Max. shaft length	mm/in.	8 / <sup>5</sup> / <sub>16</sub>	8 / <sup>5</sup> / <sub>16</sub>	35 / <sup>1</sup> / <sub>8</sub>	25 / <sup>63</sup> / <sub>64</sub>	50 / <sup>1</sup> / <sub>32</sub>	60 / <sup>2</sup> / <sub>32</sub>	60 / <sup>2</sup> / <sub>32</sub>
Range of shaft diameter	mm/in.	1.2-2.5 / 0.048-0.1	1.2-2.5 / 0.048-0.1	1.5-7/0.06-0.27	1.5-7/0.06-0.27	3-7 / 0.12-0.28	4-8 / 0.16-0.31	4-8 / 0.16-0.31
Technical details on nuts:								
max. AF	mm/in.	4 / <sup>5</sup> / <sub>32</sub>	3 / 0.12	10 / <sup>3</sup> / <sub>8</sub>	8 / <sup>5</sup> / <sub>16</sub>	11 / 0.43	13 / 0.5	13 / 0.5
max. height	mm/in.	3 / 0.12	2 / 0.08	5 / <sup>13</sup> / <sub>64</sub>	4 / <sup>5</sup> / <sub>32</sub>	6 / 0.23	8 / <sup>5</sup> / <sub>16</sub>	8 / <sup>5</sup> / <sub>16</sub>
Included in delivery:		Power unit 105535A		Power unit 105535A		Power unit 2041061		
Required accessories:		Power cable 812587 (EU) or Power cable 812295 (US)		Power cable 812587 (EU) or Power cable 812295 (US)		Power cable 812587 (EU) or Power cable 812295 (US)		
Optional accessories:								
Housing stand		102483A		3641392A		3641392A	345680A	
Stand (required for housing stand)		994449		994449		994449	999309	
Fill level indicator		414965J		414965A		414965A	414965D	
Retaining plate		9198574		9198574		9198577	-	
More optional accessories:		Hopper (see catalog D3850E)						
		Special mouthpiece for critical screw head diameter to length relation						
		Part template for positioning						

\*) with plastic vibratory bowl

**i** Our software solutions undergo continuous improvements. We recommend that you regularly update your software. In this way you will always receive the most up-to-date security updates, upgraded features and drivers. With the most current version of the software you can be sure that your device is optimally prepared for Industry 4.0.

**!** A connecting cable is required to connect external controller with feeder. Part number will be assigned in case of an order.  
Every feeding system contains all required attachments for the screwdriver such as mouthpiece guide, mouthpiece, locking sleeve and bits.  
Various specialised versions are available depending on application and the screwdriver in use.

## TECHNICAL DATA SWORD FEEDER

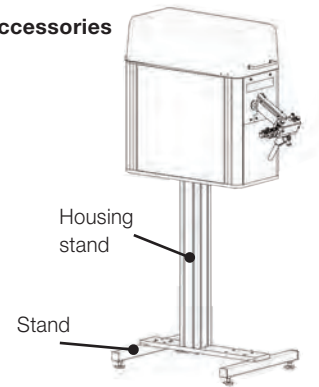


11811-1.5

Screws



Optional accessories



Material to be fed		Screws	
Sword Feeder with integrated controller	Type	1811-0.15-x*) Controller 6	11811-1.5 PFC18L Controller (insulation IP30)
Amount of connectable drivers		1	1
Feed rate	Parts/min	30	30
Filling capacity	liter/gal.	0.15 / 0.04	1.5 / 0.4
Voltage	V/Hz	230/50, 115/60	24 Volt DC
Power consumption	W	20	50
Air pressure requirement	bar/PSI	6.3 / 90	6 / 85.2
Air connection size	mm/in.	10 / <sup>3</sup> / <sub>8</sub>	10 / <sup>3</sup> / <sub>8</sub>
Dimensions W x D x H	mm	320 x 255 x 260	267 x 704 x 550
	in.	12 <sup>19</sup> / <sub>32</sub> x 10 <sup>3</sup> / <sub>64</sub> x 10 <sup>15</sup> / <sub>64</sub>	10 <sup>33</sup> / <sub>64</sub> x 27 <sup>23</sup> / <sub>32</sub> x 21 <sup>21</sup> / <sub>32</sub>
Weight	kg/lbs	12 / 26.4	approx. 30 / 66
Feedhose length standard	m/ft.	2 / 6.6	2 / 6.6
Feedhose length max	m/ft.	5 / 16.4	8 / 26.24
Technical details on screws:			
Max. head diameter	mm/in.	5 / <sup>13</sup> / <sub>64</sub>	12 / <sup>15</sup> / <sub>32</sub>
Max. shaft length	mm/in.	8 / <sup>5</sup> / <sub>16</sub>	25 <sup>63</sup> / <sub>64</sub>
Range of shaft diameter	mm/in.	1-2.5 / 0.04-0.1	2 - 6.3 / 0.08 - 0.25
Included in delivery:		-	Power unit 105535A
Required accessories:		-	Power cable 812587(EU) or power cable 812295(US)

\*) x = Voltage Supply (1: 230 V / 50 Hz, 2: 115 V / 60 Hz)

Optional accessories:		Hopper (see catalog D3850E)	
Additional function controls		screw presence control, inlet control, fill level height	-
Housing stand	Part no.	-	3641393A
Stand (required for housing stand)	Part no.	-	994449
Retaining plate	Part no.	-	9198574



A connecting cable is required to connect external controller with feeder. Part number will be assigned in case of an order.

Every feeding system contains all required attachments for the screwdriver such as mouthpiece guide, mouthpiece, locking sleeve and bits. Various specialised versions are available depending on application and the screwdriver in use.

## SPECIAL SOLUTIONS

Please contact our sales representatives if you cannot find a screwdriving technique suitable to your application in this description of our standard solutions.

As well as our standard solutions described in this catalog we also offer customer specific and application specific solutions.

## SCREWDRIVERS FOR FEEDERS

MINIMAT-EC-SERVO-SCREWDRIVER with highest processing control

MINIMAT-EC-SCREWDRIVER with processing control

ELECTRIC SCREWDRIVER with mechanical shut-off clutch

MICROMAT-Z/MINIMAT-Z - PNEUMATIC SCREWDRIVER

MICROMAT-FZ/MINIMAT-FZ - PNEUMATIC SCREWDRIVER with multi function control

SENSOMAT-Z - PNEUMATIC HANDHELD SCREWDRIVER with a mechanical clutch-function

## Technical information

→ [Catalog D3161](#)

→ [Catalog D3000](#)

→ [Catalog D3480](#)

→ [Catalog D3420](#) and [D3430](#)

→ [Catalog D3440](#)

→ [Catalog D3460](#)

# DEPRAG

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