

Example 1 Part

2 Op Rectangular Part

Raw Material

6061-T6 Aluminum
1" x 4" x 6.12" Cut Length



Op1 Complete

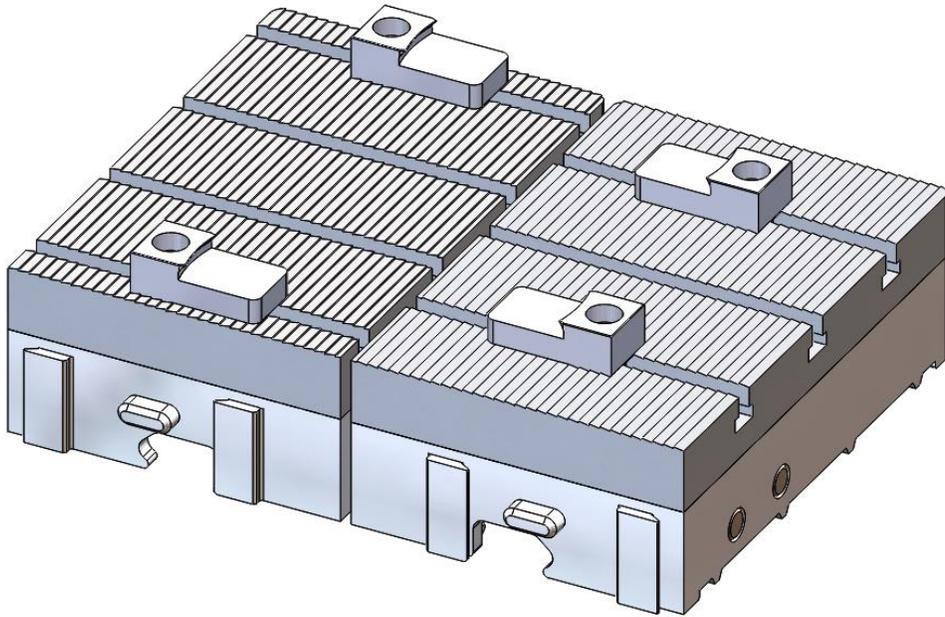


Finished Part



Op1 Jaws

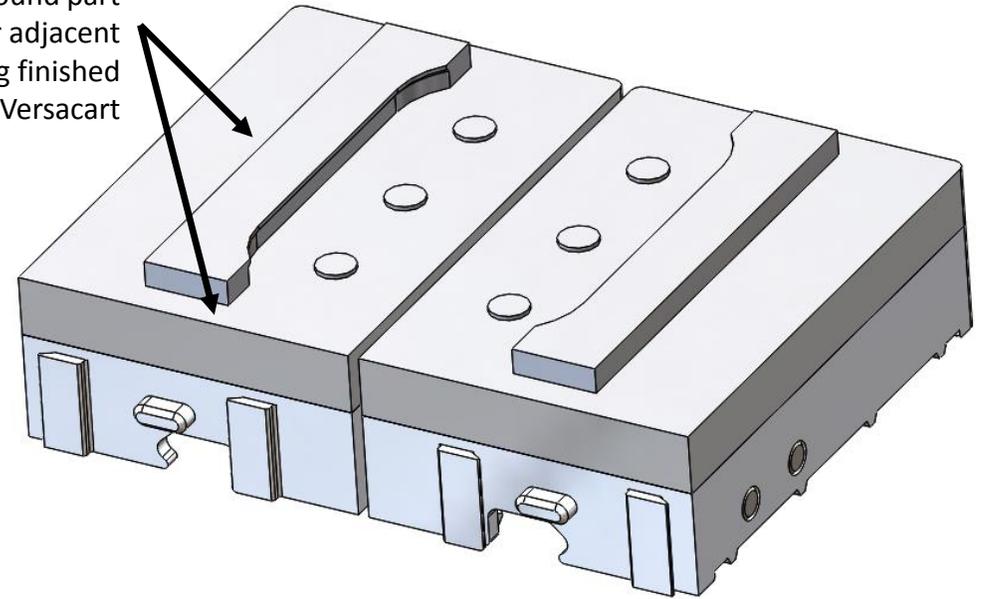
Universal Op1 Jaw Tops (5003968)
w/ OD Jaw Bases (5004027)



Op2 Jaws

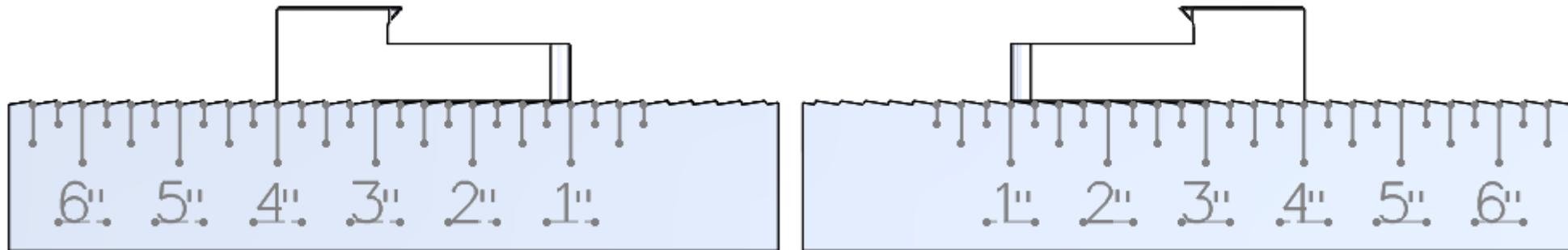
Machined 1.5" Jaw Tops (5002752)
w/ OD Jaw Bases (5004027)

Note relief around part
pocket to clear adjacent
parts when placing finished
parts on Versacart



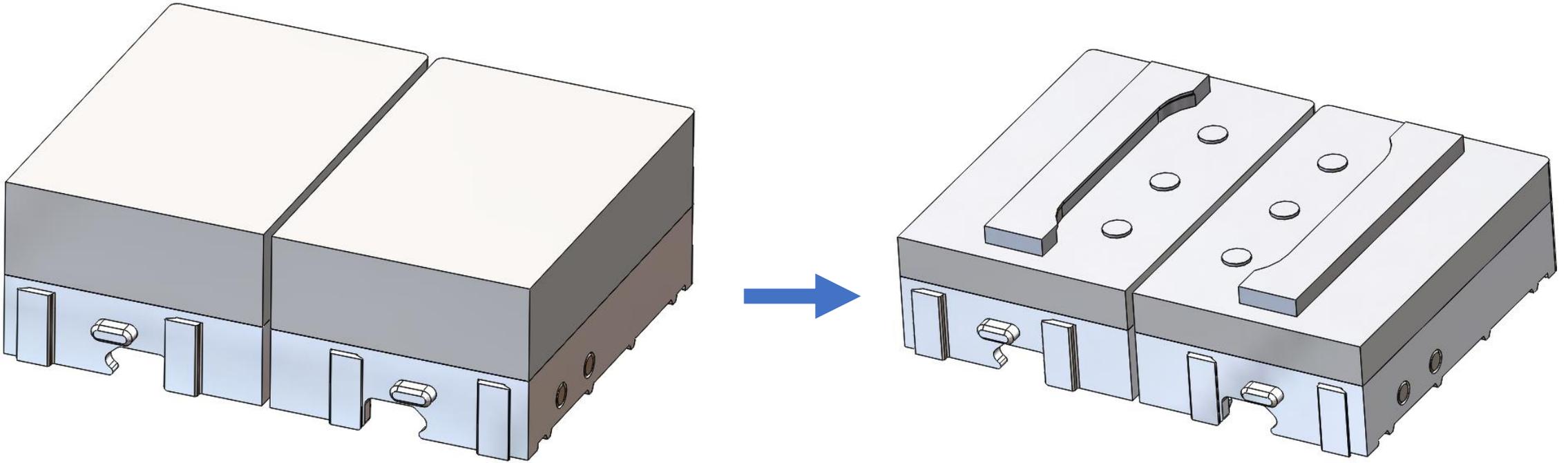
Op1 Jaws

Set Position of VersaBites (5008114)
to 4" part width location by aligning back
of VersaBite with etching on back side of
Universal Op1 Jaw Tops



Op2 Jaws

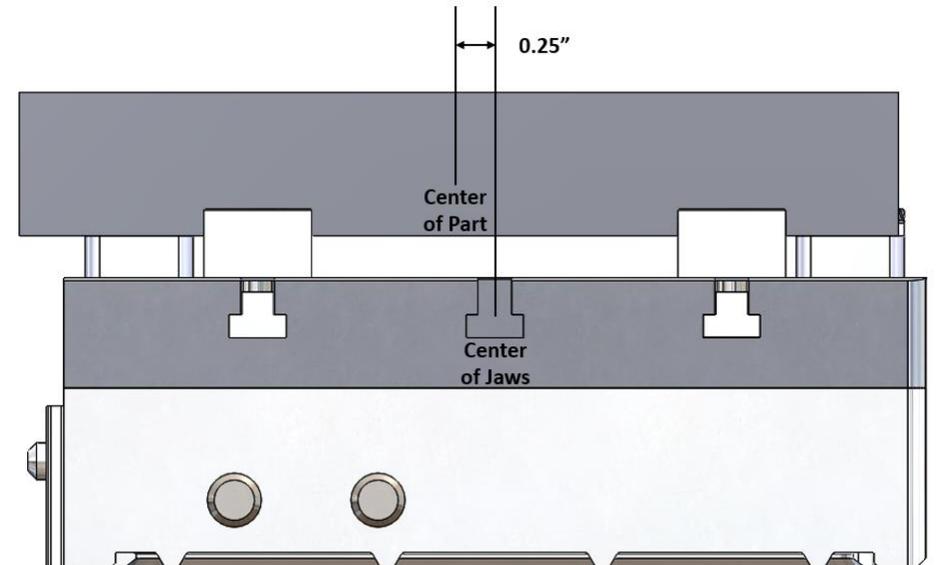
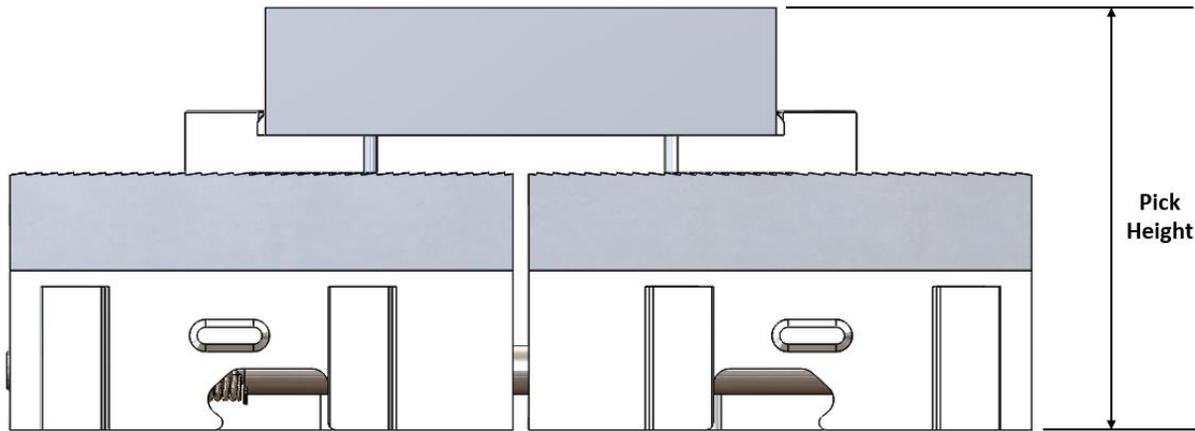
Machine pocket in jaws with 0.125" gap
between left and right jaw, clamped in
vise



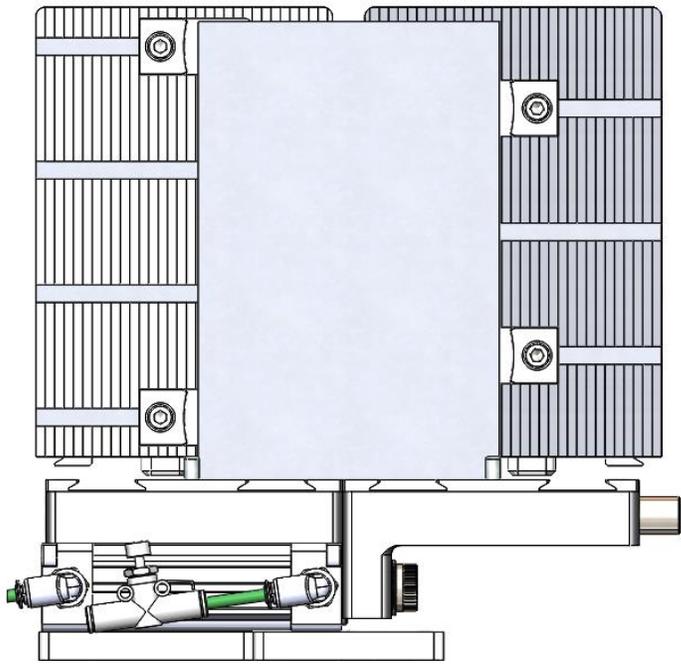
Pick Raw Material

Pick Height = 3.312"

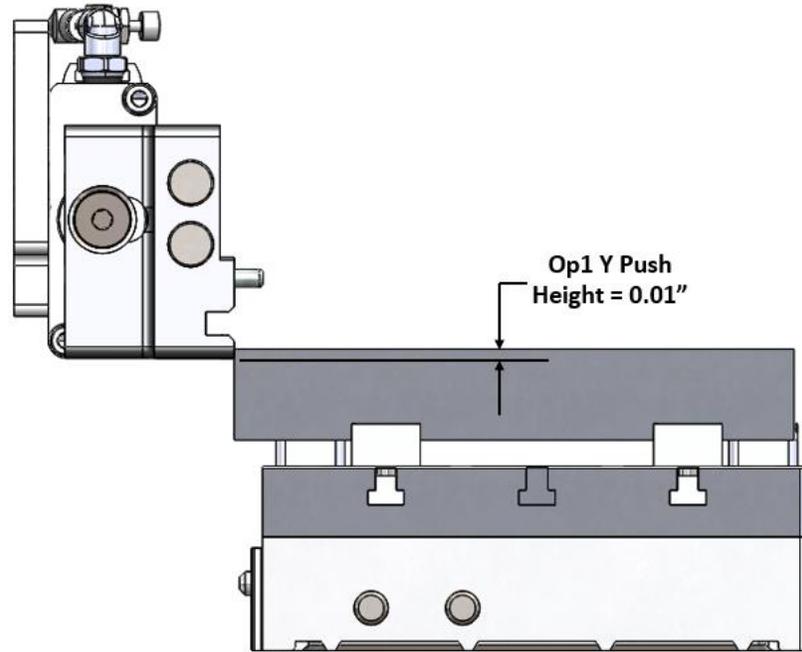
Offset Pick = -0.25"



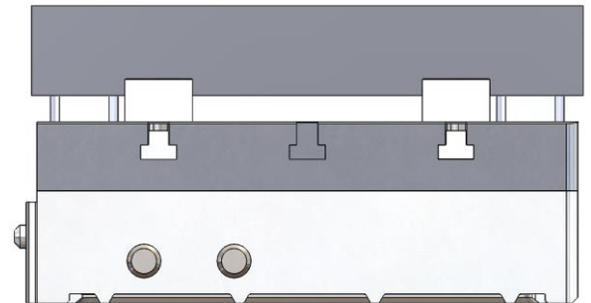
Robot place in Vise & Y-Push
OP 1 Y Push Height = -0.10"



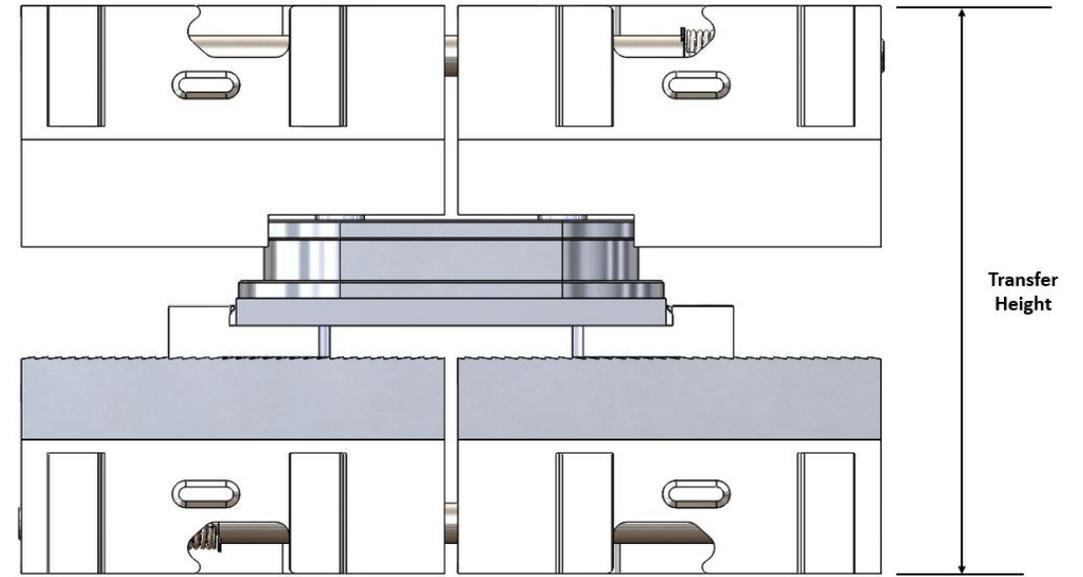
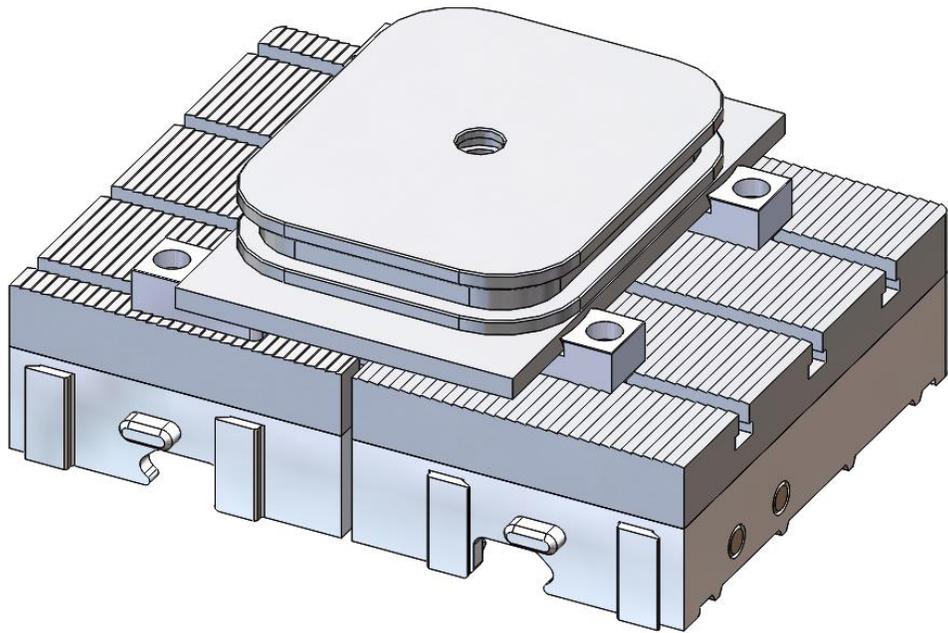
Top View



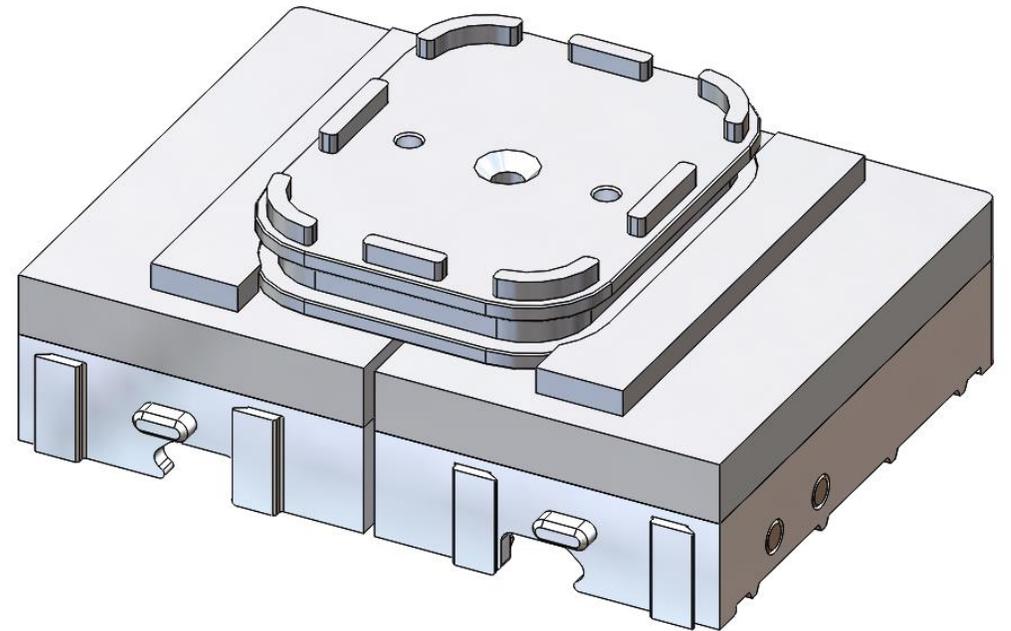
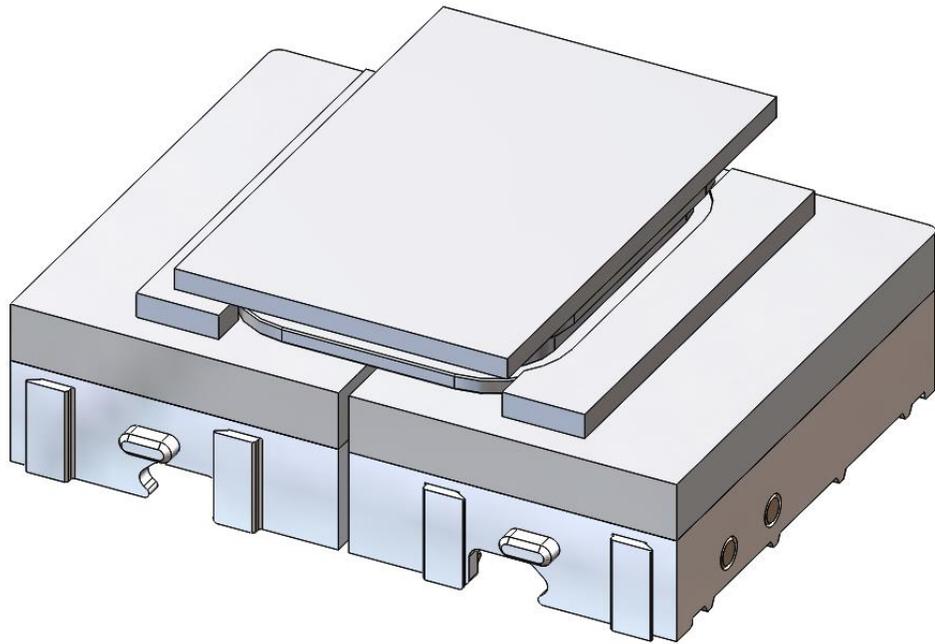
Side View



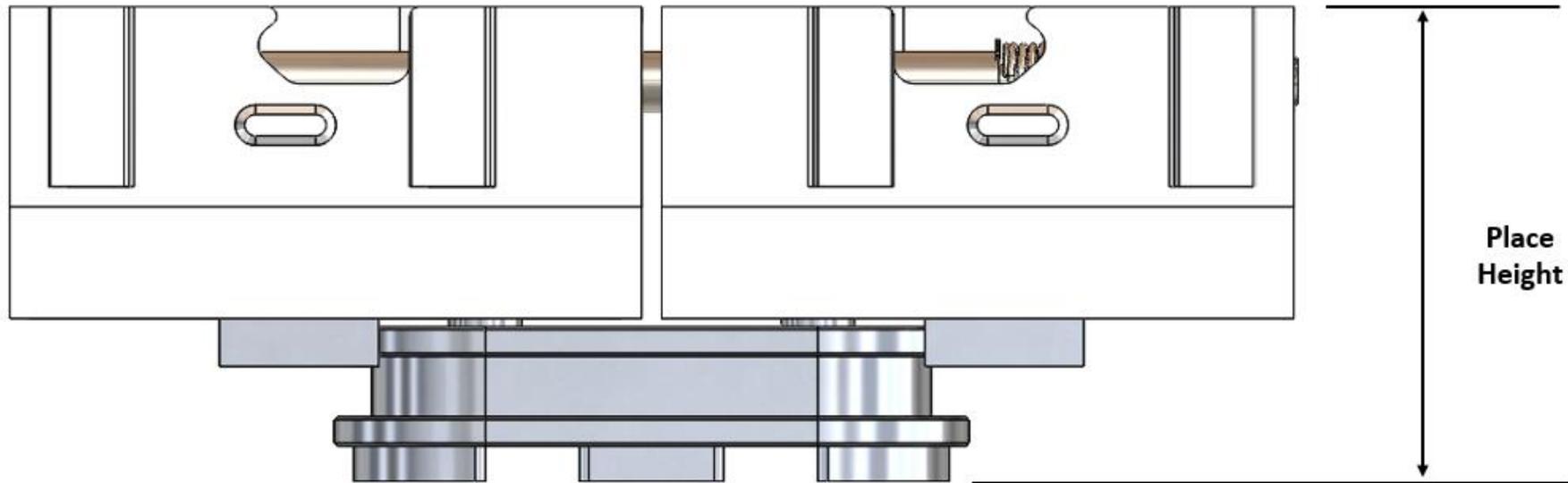
Op1 to Op2 Transfer
Transfer Height = 5.296"
Pick Op1 Complete Part with Op2 Jaws



Machine Op2



Place on Table
Place Height = 2.97"



VB Part Config

***Asterisk* means program needs to be saved or data will be lost**

Save often

Universal Robots Graphical Programming Environment

PROGRAM vbMillApp*
INSTALLATION versabuilt*

New... Open... Save... Manual

6 7
9 F

VersaBuilt™ Part Configuration

Edit Configuration

Click Edit Configuration to add new part

For Technical Support contact support@versabuilt.com or (208)629-5914

Normal Speed 100% Simulation

VB Part Config

Universal Robots Graphical Programming Environment

PROGRAM vbMillApp*
INSTALLATION versabuilt*

Run Program Installation Move I/O Log New... Open... Save... Manual

6 7
9 F

> General
> Safety
> Features
> Fieldbus
▼ URCaps
VB Cart Config
VB Part Config
R2C Config

VersaBuilt™ Part Configuration

Save Configuration

Select Part: Select Part

Click "Select Part" and select "New Part"

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Normal Speed 100% Simulation

VB Part Config

Fill-in values
Refer to New Part Worksheet, shown on the following page and downloadable from <https://www.versabuilt.com/resources.html>

Universal Robots Graphical Programming Environment

PROGRAM vbMillApp*
INSTALLATION versabuilt*

Run Program Installation Move I/O Log

New... Open... Save... Manual 6 7 9 F

VersaBuilt™ Part Configuration

Save Configuration Delete Part Hide Adv Config

Part Name:	Part 1								
Number of Ops:	2	First Vise:	1						
Part Width:	0	Guarantee Jaw Clearance:	False						
Part Length:	0	OP 1 Y Push Height Offs:	-0.1						
Infeed Y Offset:	0	OP 1 Y Push:	False						
Raw Material Weight:	0	OP 1 Jaw Weight:	0	OP 1 Clamp:	OD				
OP 1 Jaw Weight:	0	Pick Height:	0	Pick Settle:	True	Pick Settle Angle:	0		
Pick Height:	0	OP 1 CNC Program:	0	OP 1 Vise Settle:	True				
OP 1 CNC Program:	0	After OP 1 Part Weight:	0	OP 2 Jaw Weight:	0	OP 2 Clamp:	OD		
After OP 1 Part Weight:	0	OP 2 Jaw Weight:	0	Transfer Height:	0	Transfer Settle:	True	Transfer Settle Angle:	0
OP 2 Jaw Weight:	0	Transfer Height:	0	OP 2 CNC Program:	0	OP 2 Vise Settle:	True		
Transfer Height:	0	OP 2 CNC Program:	0	After OP 2 Part Weight:	0	Bin Drop:	False		
After OP 2 Part Weight:	0	Place Height:	0	VBlast After Place:	True				
Place Height:	0	X Vise Transfer Offset:	0						
X Vise Transfer Offset:	0	Y Vise Transfer Offset:	0						
Y Vise Transfer Offset:	0								

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Normal Speed 100% Simulation

VB Part Config

New Part Configuration Worksheet

Part Name:	Square Piston
Number of Ops:	2
Part Width:	4
Part Length:	6.12
Infeed Y Offset:	-0.25
OP 1 Y Push:	TRUE
Raw Material Weight:	2.39
OP 1 Jaw Weight:	8.05
Pick Height:	3.312
OP 1 CNC Program:	5445
After OP 1 Part Weight:	1.85
OP 2 Jaw Weight:	5.13
Transfer Height:	5.296
OP 2 CNC Program:	5446
After OP 2 Part Weight:	1.24
Place Height:	2.968
X Vise Transfer Offset:	
Y Vise Transfer Offset:	

First Vise	1
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Guarantee Jaw Clearance	FALSE
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OP 1 Y Push Height:	-0.1
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OP 1 Clamp:	OD
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Pick Settle:	TRUE	Pick Settle Angle:	0
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OP 1 Vise Settle:	FALSE
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OP 2 Clamp:	OD
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Transfer Settle:	FALSE	Transfer Settle Angle:	0
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OP 2 Vise Settle:	TRUE
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Vblast After Place:	TRUE
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Bold = Standard Config, No Bold = Advanced Config