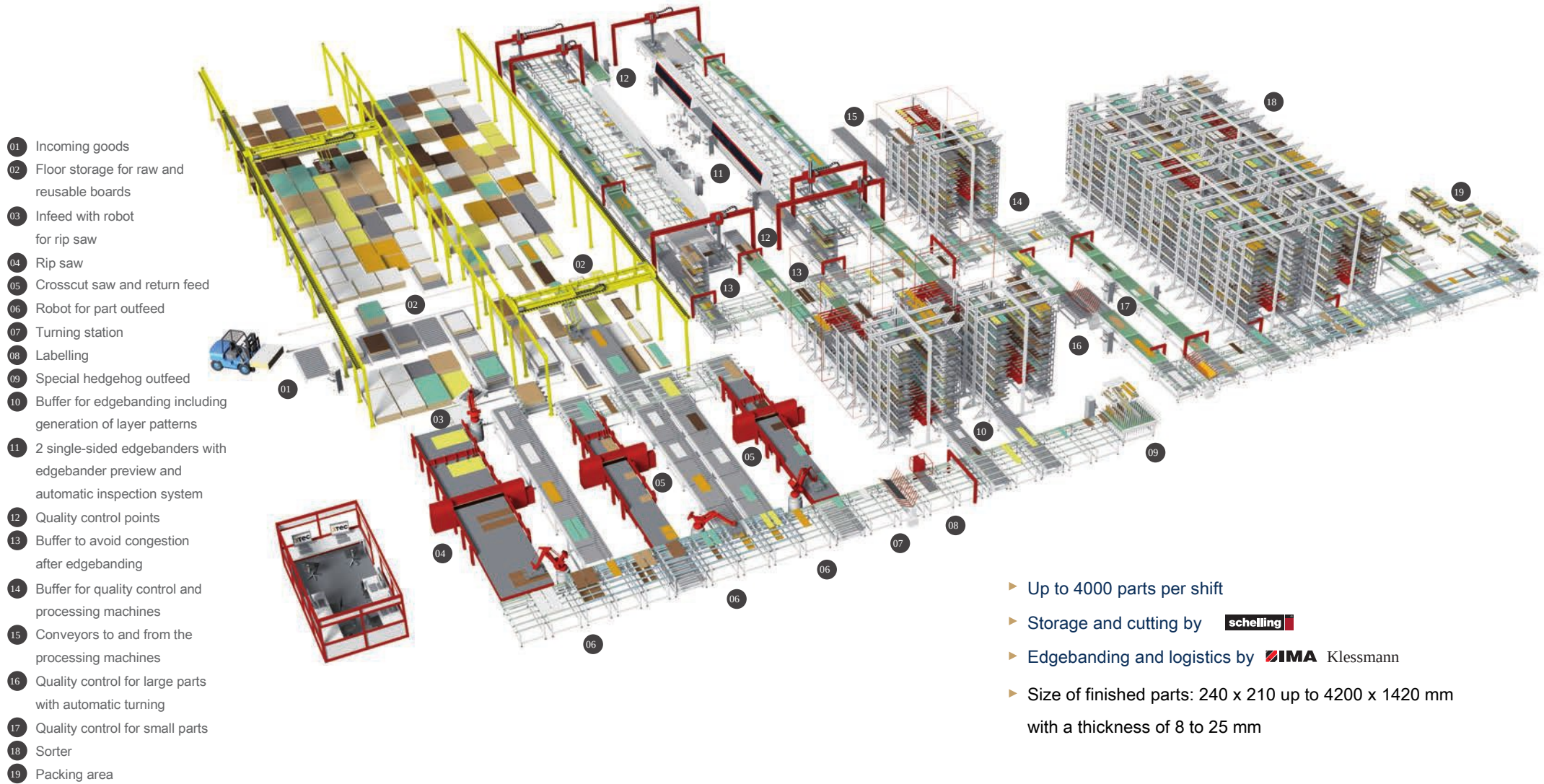


MES technology with 3Tec

Special kitchen parts production in batch size 1



- ▶ Up to 4000 parts per shift
- ▶ Storage and cutting by **schelling**
- ▶ Edgebanding and logistics by **IMA** Klessmann
- ▶ Size of finished parts: 240 x 210 up to 4200 x 1420 mm with a thickness of 8 to 25 mm

MES technology with 3Tec

Special kitchen parts production in batch size 1

- ▶ **Automatic floor storage for raw and reusable boards**
- ▶ **3 saws with multiple passes**
- ▶ **Labelling of component parts**
- ▶ **Planning of production orders**
- ▶ **Automatic layer pattern generation for optimal edgebander use**
- ▶ **Buffer and pre-sorting before edgebanding**
- ▶ **Single-sided edgebanders with automatic return feed**
- ▶ **Automatic edgebander inspection system**
- ▶ **Buffer for manual checking and processing machines**
- ▶ **Separate quality control for large and small parts**
- ▶ **Sorter for packing**

Production data import and preparation

- ▶ All data relevant to production is imported from the ERP system
- ▶ Production data stored in MS-SQL database
- ▶ Planning of production orders
- ▶ Communication with cutting plan optimization
- ▶ Data preparation for cutting, edgebanding and inspection system
- ▶ Edgebander preview and edge material administration
- ▶ Handling of re-productions and quick shots

Control system

Warehouse management and control of automatic floor storage system

Material flow control

- ▶ Tracking of individual parts
- ▶ Labelling
- ▶ Buffer management
- ▶ Connections to production machines
- ▶ Edgebander flow control
- ▶ Monitoring via barcode scanning

Quality control and inspection

- ▶ Display of specifications, edgebander inspection photos and error messages
- ▶ Re-productions
- ▶ Creation of automatic repair requirements

Inter-process feedback

Production status display for all production steps

System-wide display elements

- ▶ Operator guidance
- ▶ Diagnostics and error recovery