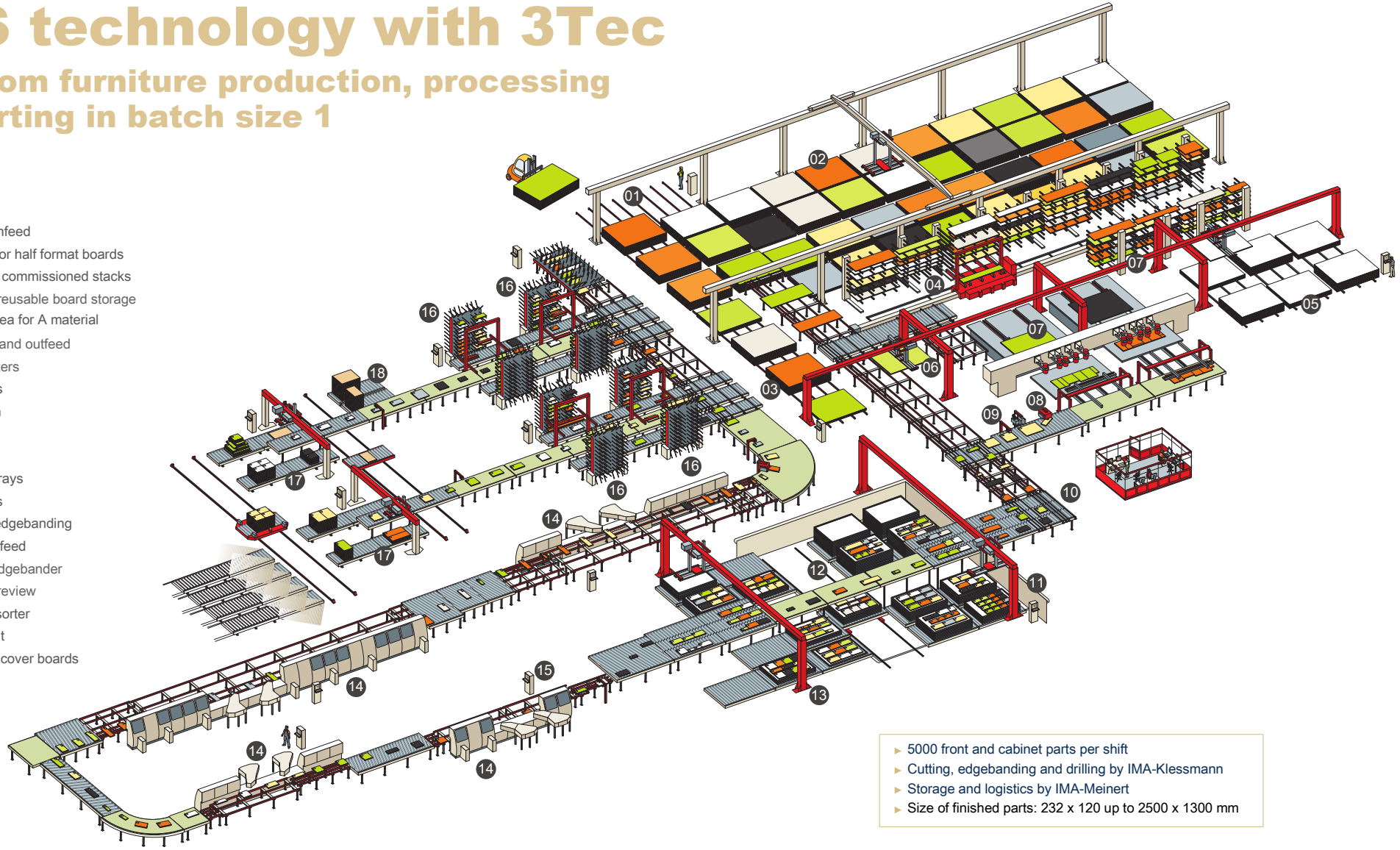
MES technology with 3Tec

Bathroom furniture production, processing and sorting in batch size 1

01 Storage area infeed
02 Floor storage for half format boards
03 Buffer area for commissioned stacks
04 Direct access reusable board storage
05 Preparation area for A material
06 Double infeed and outfeed for cutting centers
07 Cutting centers
08 Turning station
09 Label printer
10 Pre-sorting
11 Unit for filling trays with 3 outfeeds
12 Buffer before edgebanding
13 Edegbander infeed
14 Single-sided edgebander
15 Edgebander preview
16 Double-sided sorter
17 Unstacking unit
18 Preparation of cover boards



- 5000 front and cabinet parts per shift
- Cutting, edgebanding and drilling by IMA-Klessmann
- Storage and logistics by IMA-Meinert
- Size of finished parts: 232 x 120 up to 2500 x 1300 mm

Automation | Information | Transparency

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Bathroom furniture production, processing and sorting in batch size 1

- **Production of cabinet parts (fronts, sides and transverse) from half format and reusable boards**
- **Cutting Centers for raw board processing**
- **Labelling of component parts**
- **Pre-sorting and intermediate buffering in trays**
- **Edgebanding and drilling**
- **Sorting according to various criteria, e.g. final assembly sequence, part size**
- **Unstacking of various different stack types**

Production data import and preparation

- All data relevant to production is imported from the ERP system
- Production data stored in MS-SQL database
- Cutting plan optimization with production simulation for optimal use of buffers and sorting units
- Creation of cutting plans for the cutting centers
- Data preparation for edgebanding and drilling
- Edgebander preview and edge material administration
- Handling of re-productions and quick shots

Control system

Warehouse management and control

- Automatic floor storage (B material sorted, C material chaotic)
- Automatic storage of reusable boards
- Manual pre-storage

Stack control system

- Stock movement from pre-storage to automated
- Preparation of edge material
- Preparation of A material

Material flow control

- Tracking of individual parts
- Connections to production machines
- Labelling
- Monitoring via barcode scanning

System-wide display elements

- Operator guidance
- Diagnostics and error recovery

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