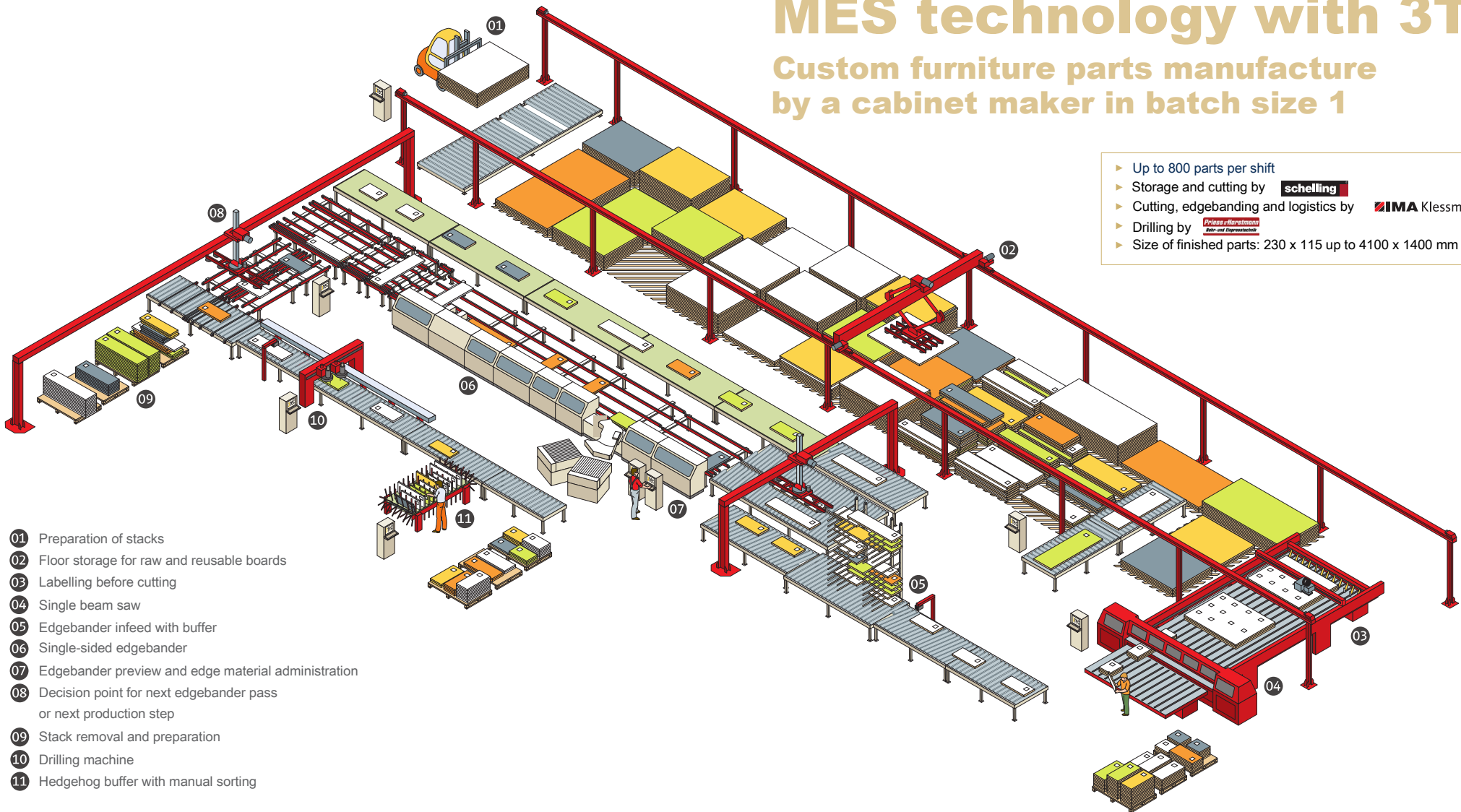


MES technology with 3Tec

Custom furniture parts manufacture by a cabinet maker in batch size 1

- ▶ Up to 800 parts per shift
- ▶ Storage and cutting by **schelling**
- ▶ Cutting, edgebanding and logistics by **IMA Klessmann**
- ▶ Drilling by **Praxiswerkstatt**
Praxiswerkstatt
- ▶ Size of finished parts: 230 x 115 up to 4100 x 1400 mm



- 01 Preparation of stacks
- 02 Floor storage for raw and reusable boards
- 03 Labelling before cutting
- 04 Single beam saw
- 05 Edgebander infeed with buffer
- 06 Single-sided edgebander
- 07 Edgebander preview and edge material administration
- 08 Decision point for next edgebander pass or next production step
- 09 Stack removal and preparation
- 10 Drilling machine
- 11 Hedgehog buffer with manual sorting

Automation | Information | Transparency

3Tec automation GmbH & Co. KG
 Wilhelmstraße 8
 D-32602 Vlotho
 fon+49.(0)57 33.87 12-0
 fax+49.(0)57 33.96 00 07
 info@3tec.de
 www.3tec.de

3TEC

MES technology with 3Tec

Custom furniture parts manufacture by a cabinet maker in batch size 1

- **Automatic floor storage for raw and reusable boards**
- **Labelling before cutting**
- **2-D cutting with a single beam saw**
- **Buffer for maximizing edgebander infeed**
- **Single-sided edgebander with automatic return feed**
- **Automatic drilling machine**

Production data import and preparation

- All data relevant to production is imported from the ERP system
- Production data stored in MS-SQL database
- Data preparation for cutting and edgebanding
- Planning taking account of multiple parts
- Edgebander preview and edge material administration
- Handling of re-productions and quick shots

Control system

Warehouse management and control of automatic floor storage system

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

Inter-process feedback

Production status display for all production steps

System-wide display elements

- Operator guidance
- Diagnostics and error recovery