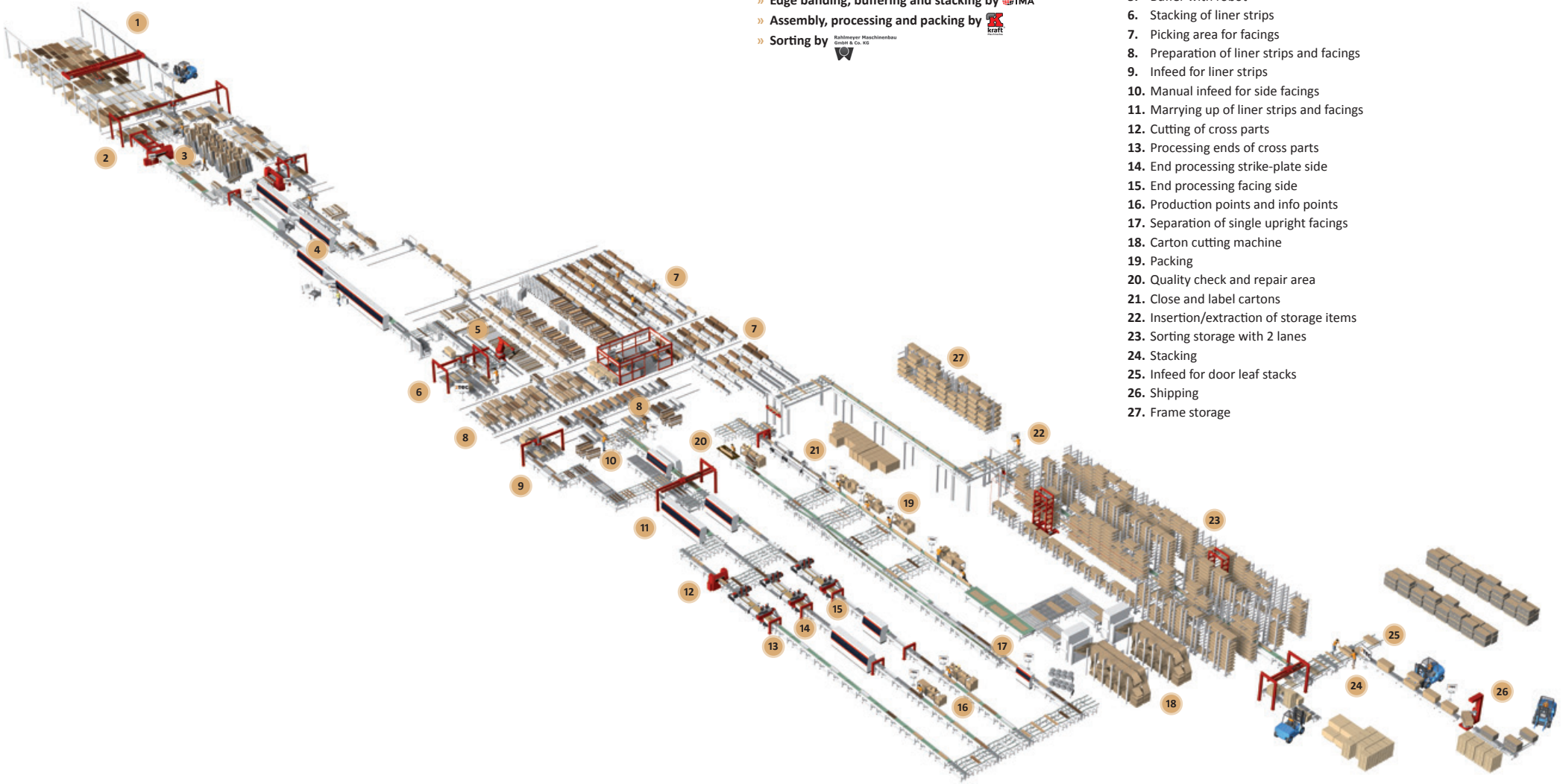
MES technology with 3tec

Frame production in batch size 1 - from raw board to shipping stack

- **Part range: facings, liners, frames**
- **2000 frames in 8 hour shift**
- **Board storage by SCHELLING**
- **Cutting by**
- **Edge banding, buffering and stacking by IMA**
- **Assembly, processing and packing by kraft**
- **Sorting by Rahlmeyer Maschinenbau GmbH & Co. KG**

1. Floor storage
2. Infeed and multi-blade saw
3. Manual remnant storage
4. Edge banding with preview
5. Buffer with robot
6. Stacking of liner strips
7. Picking area for facings
8. Preparation of liner strips and facings
9. Infeed for liner strips
10. Manual infeed for side facings
11. Marrying up of liner strips and facings
12. Cutting of cross parts
13. Processing ends of cross parts
14. End processing strike-plate side
15. End processing facing side
16. Production points and info points
17. Separation of single upright facings
18. Carton cutting machine
19. Packing
20. Quality check and repair area
21. Close and label cartons
22. Insertion/extraction of storage items
23. Sorting storage with 2 lanes
24. Stacking
25. Infeed for door leaf stacks
26. Shipping
27. Frame storage



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Frame production in batch size 1 - from raw board to shipping stack

- Production of liner strips
- Floor storage by Schelling
- Cutting with multi-blade saw by Becker
- Label application
- Edge banding and stacking by IMA
- Production of facings for storage
- Picking of facings
- Fully automated frame production by Kraft
- Sorting by Rahlmeyer
- Packing of frames
- 3Tec-Optimization for stack creation
- Move frames from storage according to optimization results
- Creation of stacks for shipping

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 jobs
- Optimization of liner strips by the 3Tec-Optimization kernel
- Label application and transfer of processing data to all production machines
- Edgebander management and preview
- Generation of picklists for facings
- Handling of reproductions and quick shots

Control system

- Material flow control
- Tracking of individual parts
- Commissioning
- Connections to production machines
- Logistics

Production status display for all production steps and machine visualization

- Operator guidance
- Diagnostics and error recovery

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