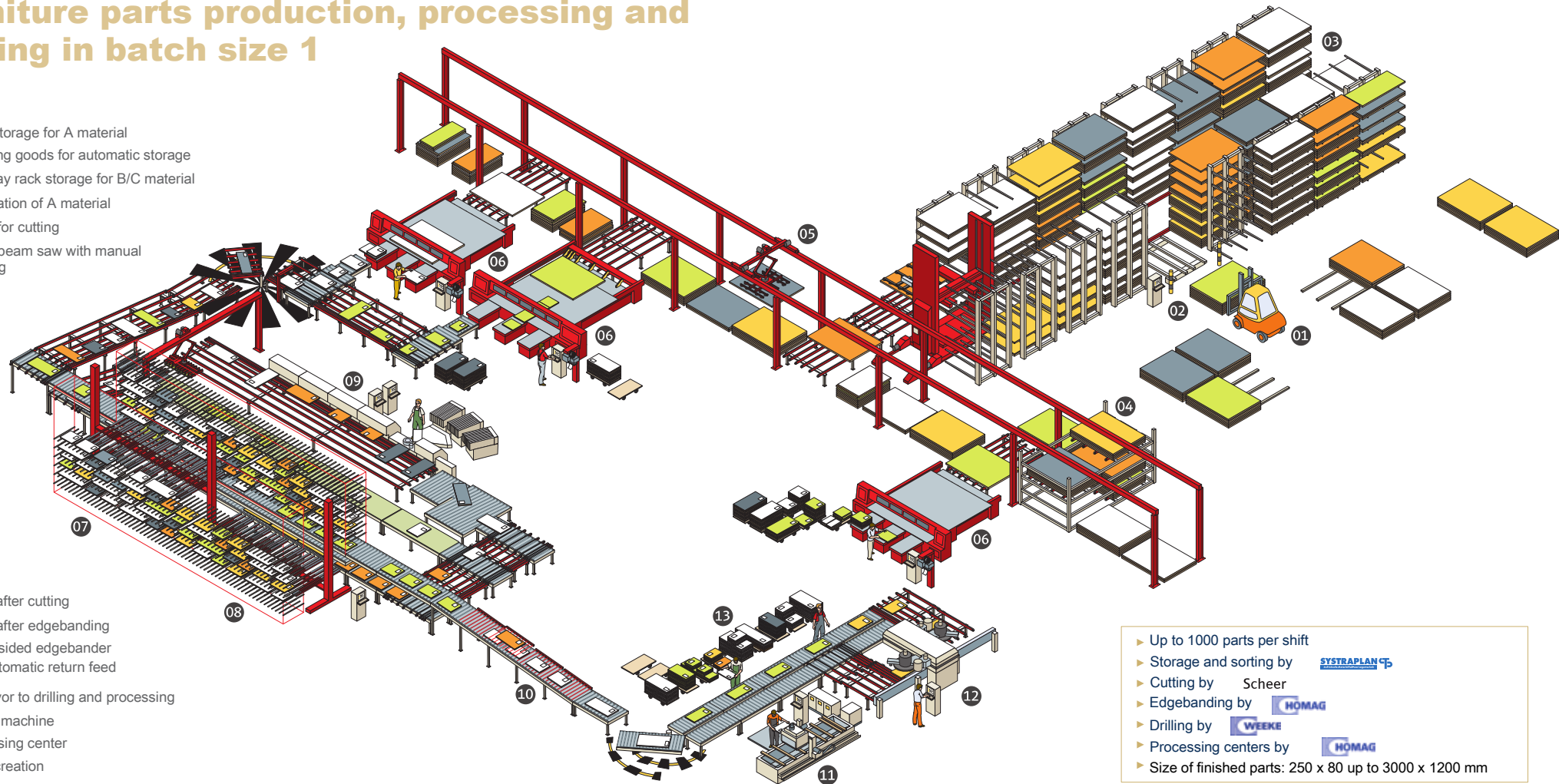


# MES technology with 3Tec

## Furniture parts production, processing and sorting in batch size 1

- 01 Block storage for A material
- 02 Incoming goods for automatic storage
- 03 High-bay rack storage for B/C material
- 04 Preparation of A material
- 05 Infeed for cutting
- 06 Single beam saw with manual labelling



- 07 Buffer after cutting
- 08 Buffer after edgebanding
- 09 Single-sided edgebander with automatic return feed
- 10 Conveyor to drilling and processing
- 11 Drilling machine
- 12 Processing center
- 13 Batch creation

- ▶ Up to 1000 parts per shift
- ▶ Storage and sorting by **SYSTRAPLAN**
- ▶ Cutting by **Scheer**
- ▶ Edgebanding by **HOMAG**
- ▶ Drilling by **WEEKE**
- ▶ Processing centers by **HOMAG**
- ▶ Size of finished parts: 250 x 80 up to 3000 x 1200 mm

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



# MES technology with 3Tec

## Furniture parts production, processing and sorting in batch size 1

- **Manual block storage for A material**
- **Automatic high-bay rack storage for B/C material**
- **2-D cutting with a single beam saw**
- **Labelling of component parts**
- **Pre-sorting and intermediate buffering after cutting**
- **Single-sided edgebander**
- **Final sorting and intermediate buffering after edgebanding**

### **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 edgebanding
- Edgebander preview and edge material administration
- Handling of re-productions and quick shots

### **Control system**

#### **Warehouse management and control of automatic rack storage system**

##### **Material flow control**

- Tracking of individual parts
- Buffer management
- Connections to production machines
- Labelling
- Monitoring via barcode scanning
- Destination-based sorting

##### **Inter-process feedback**

##### **Shop floor data collection**

##### **Production status display for all production steps**

##### **System-wide display elements**

- Operator guidance
- Diagnostics and error recovery