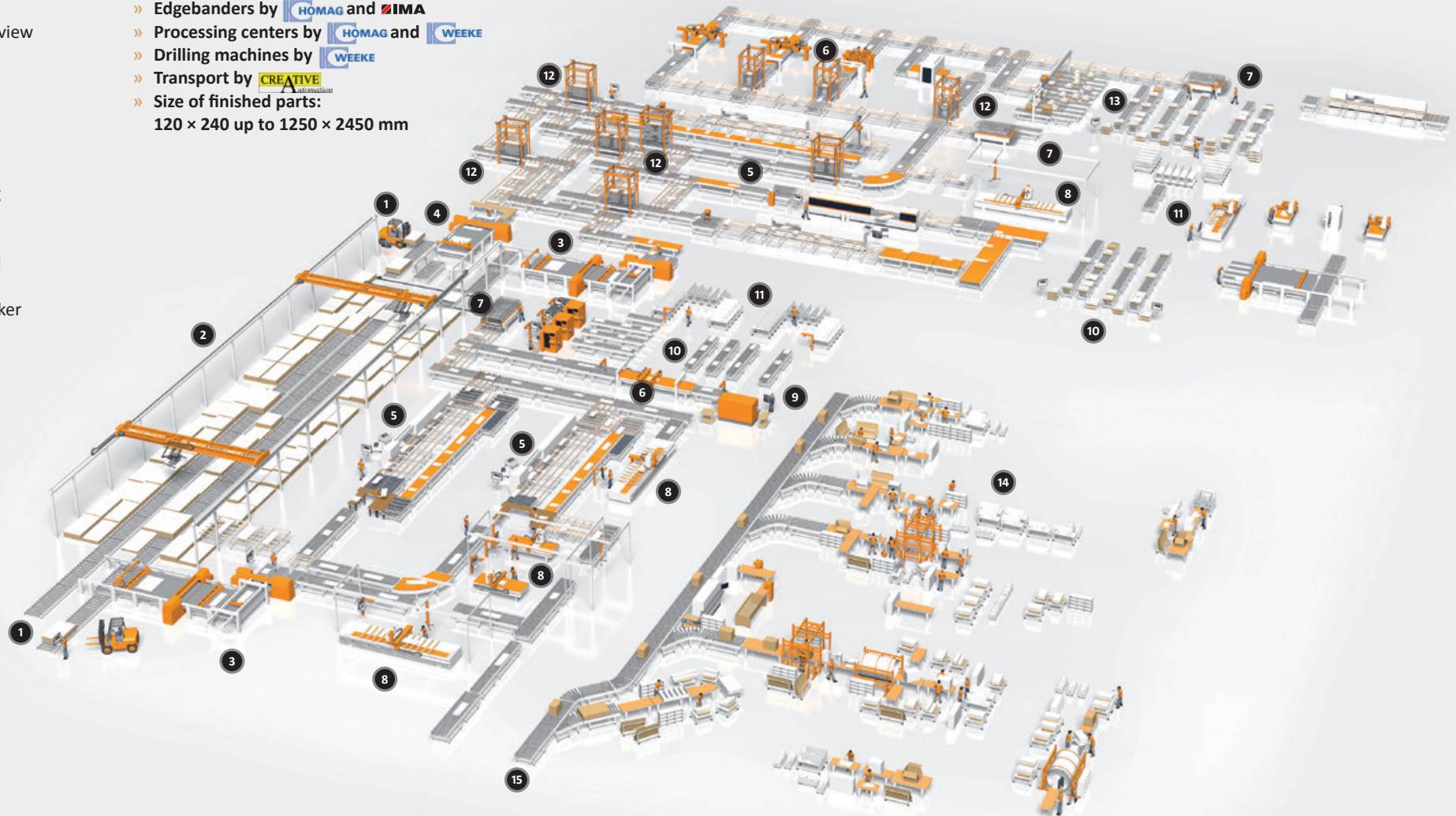# MES – technology with 3tec

Office furniture production in batch size 1

1. Storage system infeed
2. Floor storage with 2 overhead cranes
3. Angular saws
4. Single beam saw
5. Edgebanders with preview
6. Automatic drilling
7. Porcupine for manual drilling machines
8. Processing centers
9. Drilling and dowel inserting machine
10. Buffer areas for kitting
11. Kitting on trolleys for assembly lines
12. Buffers for sorting and avoiding congestion
13. Automatic sorter/stacker for larger parts
14. Assembly lines
15. Conveyor to shipping

» **2 production lines - automatic and semi-automatic**
» **3000 parts per shift automatic**
» **2000 parts per shift semi-automatic**
» **Floor storage and cutting by** schelling
» **Edgebanders by** HOMAG **and** IMA
» **Processing centers by** HOMAG **and** WEEKE
» **Drilling machines by** WEEKE
» **Transport by** CREATIVE Automation
» **Size of finished parts:**
   120 × 240 up to 1250 × 2450 mm

MES – technology with 3Tec

Office furniture production in batch size 1

» Automatic floor storage for raw and reusable boards

» 2-D cutting of component parts with Schelling FH6 and 2 AH6

» Labels applied to parts automatically

» Buffer before drilling

» Automatic edgebanding with 5 single-sided edgebanders

» Automatic drilling and dowel insertion

» Sorting for assembly lines

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

» Communication with the cutting plan optimizer

» Data preparation for storage system, cutting, edgebanding, drilling and assembly

» Edgebander preview and edge material administration

» Handling of reproductions and quick shots

Control system

» Warehouse management and control of automatic floor storage system

» Material flow control

» Tracking of individual parts

» Connections to production machines

» Sorting

» Logistics

Production status display for all production steps and machine visualization

» Operator guidance

» Diagnostics and error recovery