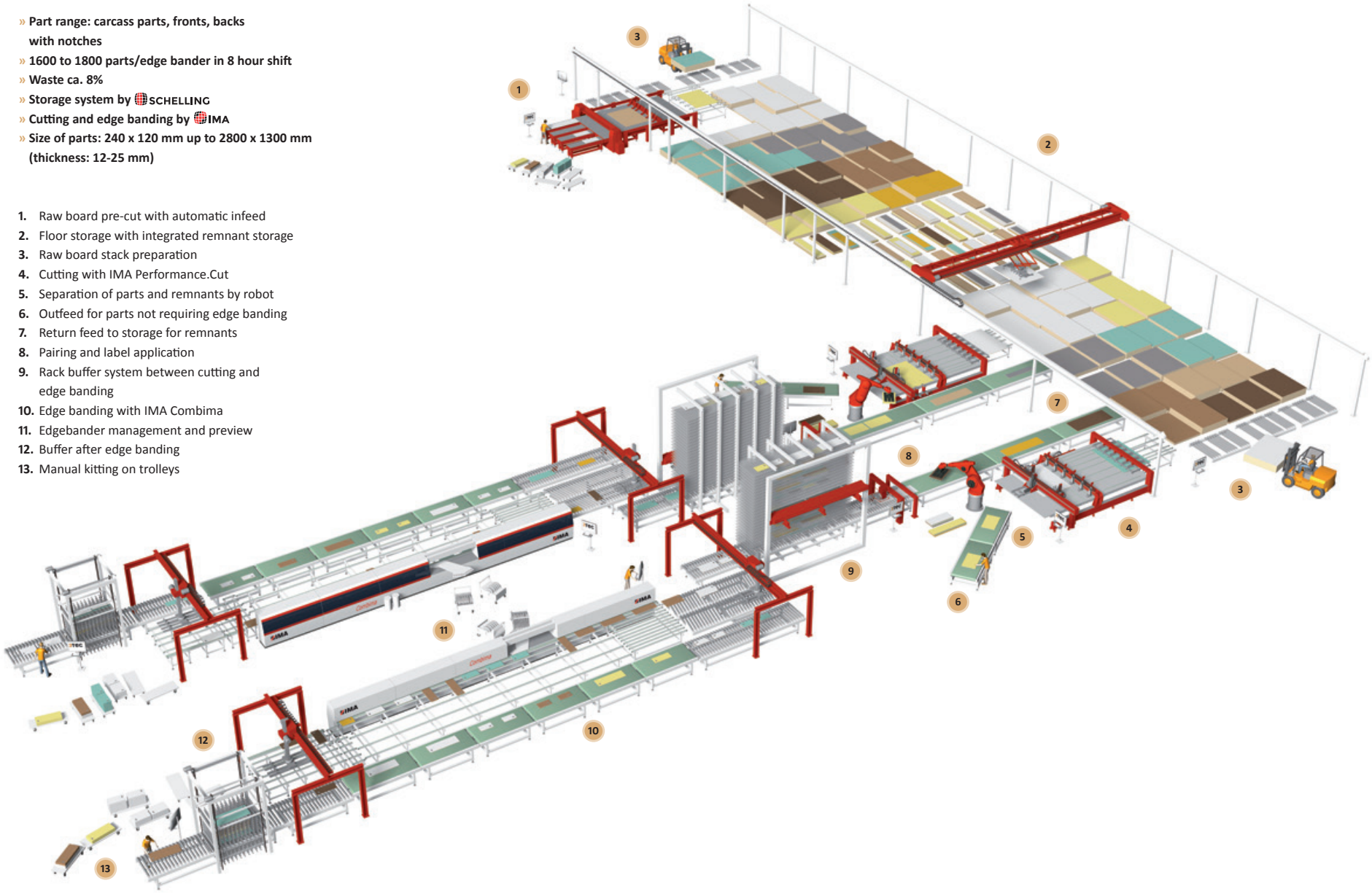
MES technology with 3Tec

High-performance kitchen furniture part production in batch size 1

- **Part range: carcass parts, fronts, backs with notches**
- **1600 to 1800 parts/edge bander in 8 hour shift**
- **Waste ca. 8%**
- **Storage system by SCHELLING**
- **Cutting and edge banding by IMA**
- **Size of parts: 240 x 120 mm up to 2800 x 1300 mm (thickness: 12-25 mm)**

1. Raw board pre-cut with automatic infeed
2. Floor storage with integrated remnant storage
3. Raw board stack preparation
4. Cutting with IMA Performance.Cut
5. Separation of parts and remnants by robot
6. Outfeed for parts not requiring edge banding
7. Return feed to storage for remnants
8. Pairing and label application
9. Rack buffer system between cutting and edge banding
10. Edge banding with IMA Combima
11. Edgebander management and preview
12. Buffer after edge banding
13. Manual kitting on trolleys



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High-performance kitchen furniture part production in batch size 1

- Floor storage by Schelling
- Cutting of raw boards and remnants with 1 Performance.Cut and 1 saw
- Removal and separation of parts and remnants by robot
- Label application
- Outfeed for backs immediately after cutting
- Buffer for edge banding
- Automatic edgebander loop
- Buffer for kitting
- Pre-planned kitting on varnishing trolleys

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 picking from storage, cutting, labels, edge banding and kitting
- Edgebander management and preview
- Handling of reproductions and quick shots

Control system

- Material flow control
- Tracking of individual parts
- 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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