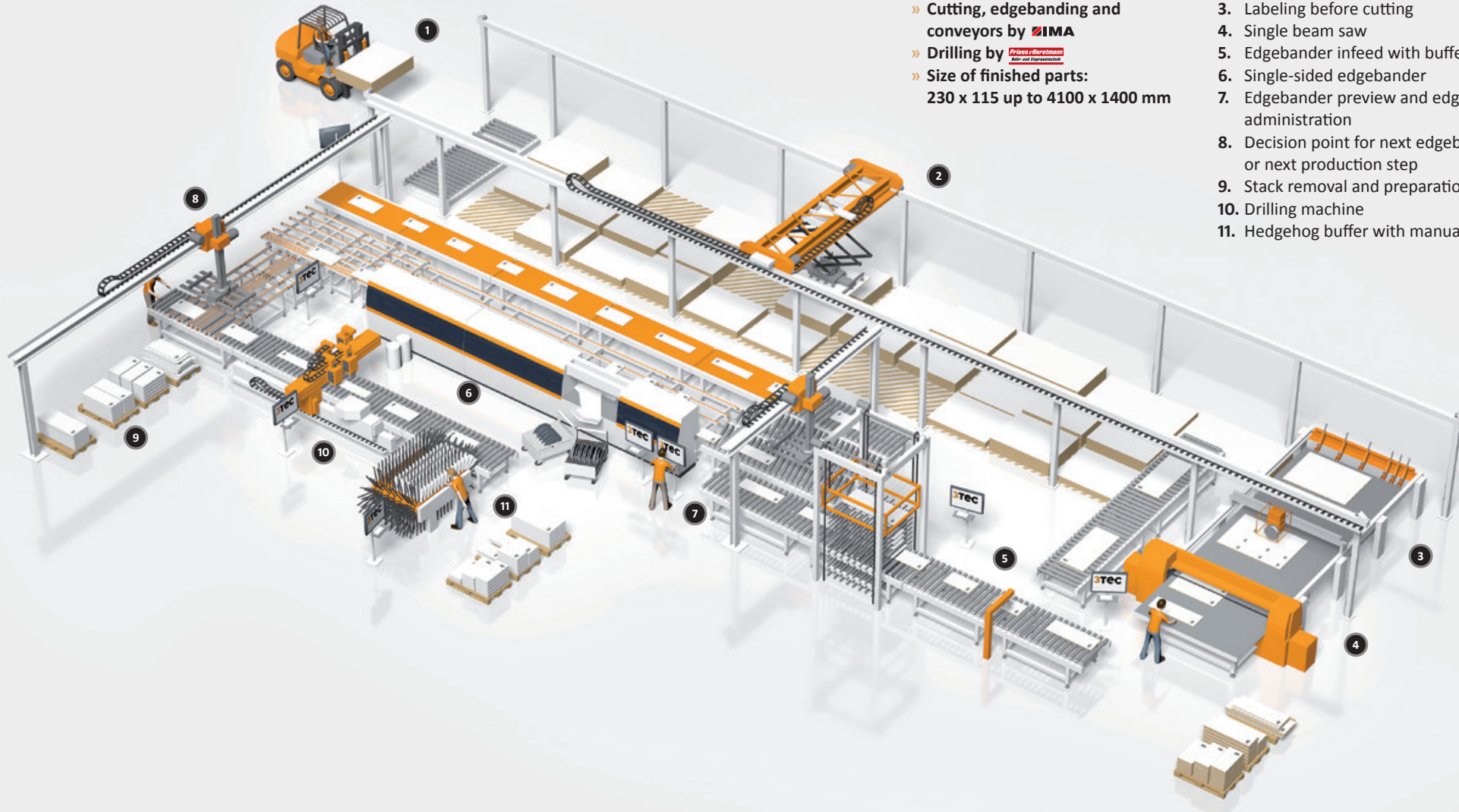# MES – technology with 3TEC

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 conveyors by** IMA
» **Drilling by** Priess & Horstmann Bohr- und Einpresstechnik
» **Size of finished parts:**
  230 x 115 up to 4100 x 1400 mm

1. Preparation of stacks
2. Floor storage for raw and reusable boards
3. Labeling before cutting
4. Single beam saw
5. Edgebander infeed with buffer
6. Single-sided edgebander
7. Edgebander preview and edge material administration
8. Decision point for next edgebander pass or next production step
9. Stack removal and preparation
10. Drilling machine
11. Hedgehog buffer with manual sorting

MES – technology with 3Tec

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

- » Automatic floor storage for raw and reusable boards
- » Labeling 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 and machine visualization

- » Operator guidance
- » Diagnostics and error recovery