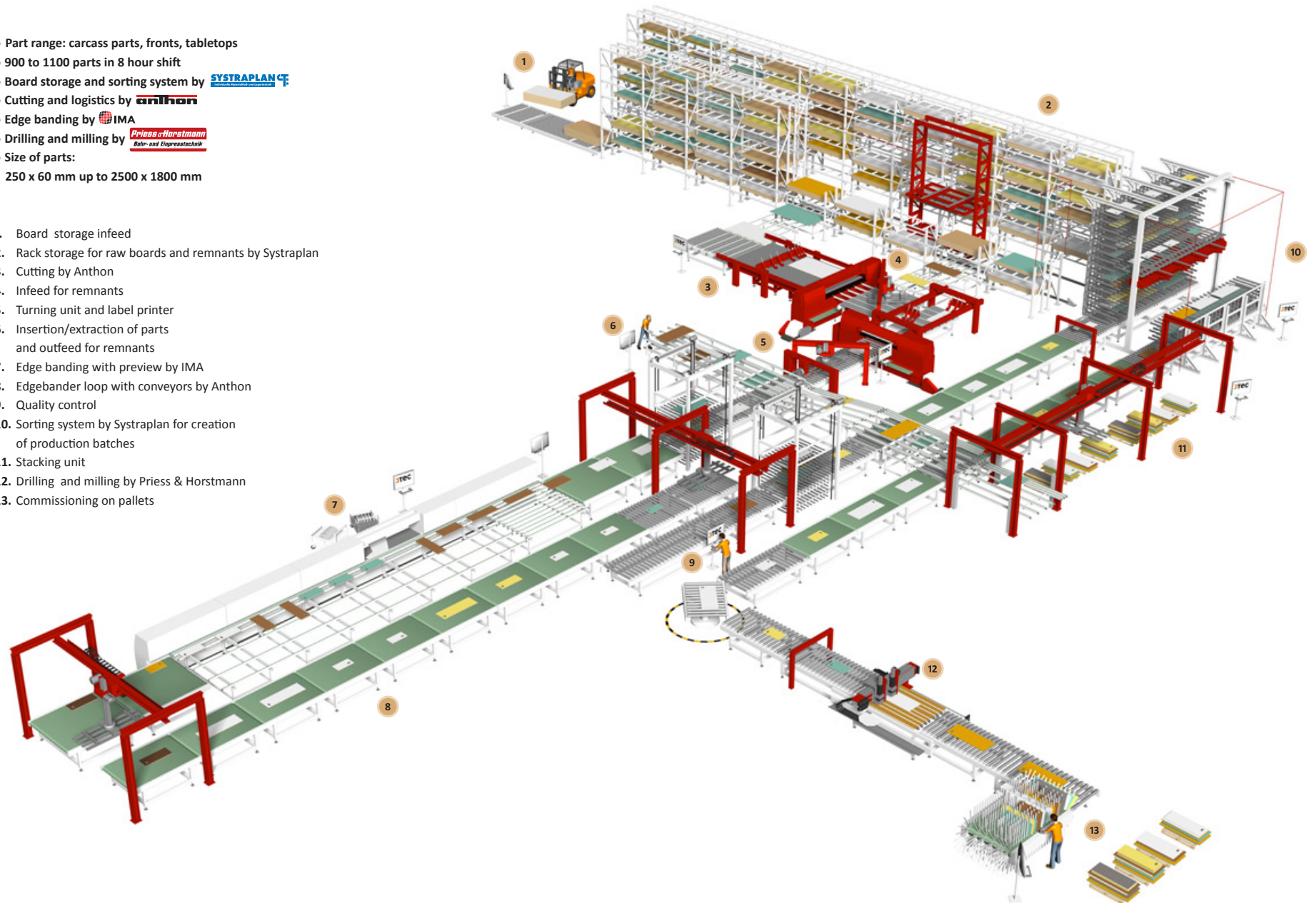# MES technology with 3TEC

Office furniture part production in batch size 1

» **Part range: carcass parts, fronts, tabletops**
» **900 to 1100 parts in 8 hour shift**
» **Board storage and sorting system by** SYSTRAPLAN
» **Cutting and logistics by** anthon
» **Edge banding by** IMA
» **Drilling and milling by** Priess & Horstmann Bohr- und Einpresstechnik
» **Size of parts:**
   250 x 60 mm up to 2500 x 1800 mm

1. Board storage infeed
2. Rack storage for raw boards and remnants by Systraplan
3. Cutting by Anthon
4. Infeed for remnants
5. Turning unit and label printer
6. Insertion/extraction of parts and outfeed for remnants
7. Edge banding with preview by IMA
8. Edgebander loop with conveyors by Anthon
9. Quality control
10. Sorting system by Systraplan for creation of production batches
11. Stacking unit
12. Drilling and milling by Priess & Horstmann
13. Commissioning on pallets

MES technology with 3Tec

Office furniture part production in batch size 1

» Rack storage by Systraplan

» Cutting of raw boards and remnants with an angular saw by Anthon

» Label application

» Buffers before and after edge banding

» Edge banding by IMA

» Automatic edgebander loop with quality control area

» Sorting system for controlling production sequence by Systraplan

» De-stacking of parts on pallets

» Drilling and milling by Priess & Horstmann

» Commissioning of parts on pallets with protective boards

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

» Data preparation for picking from storage, cutting,
  labels, edge banding, drilling 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