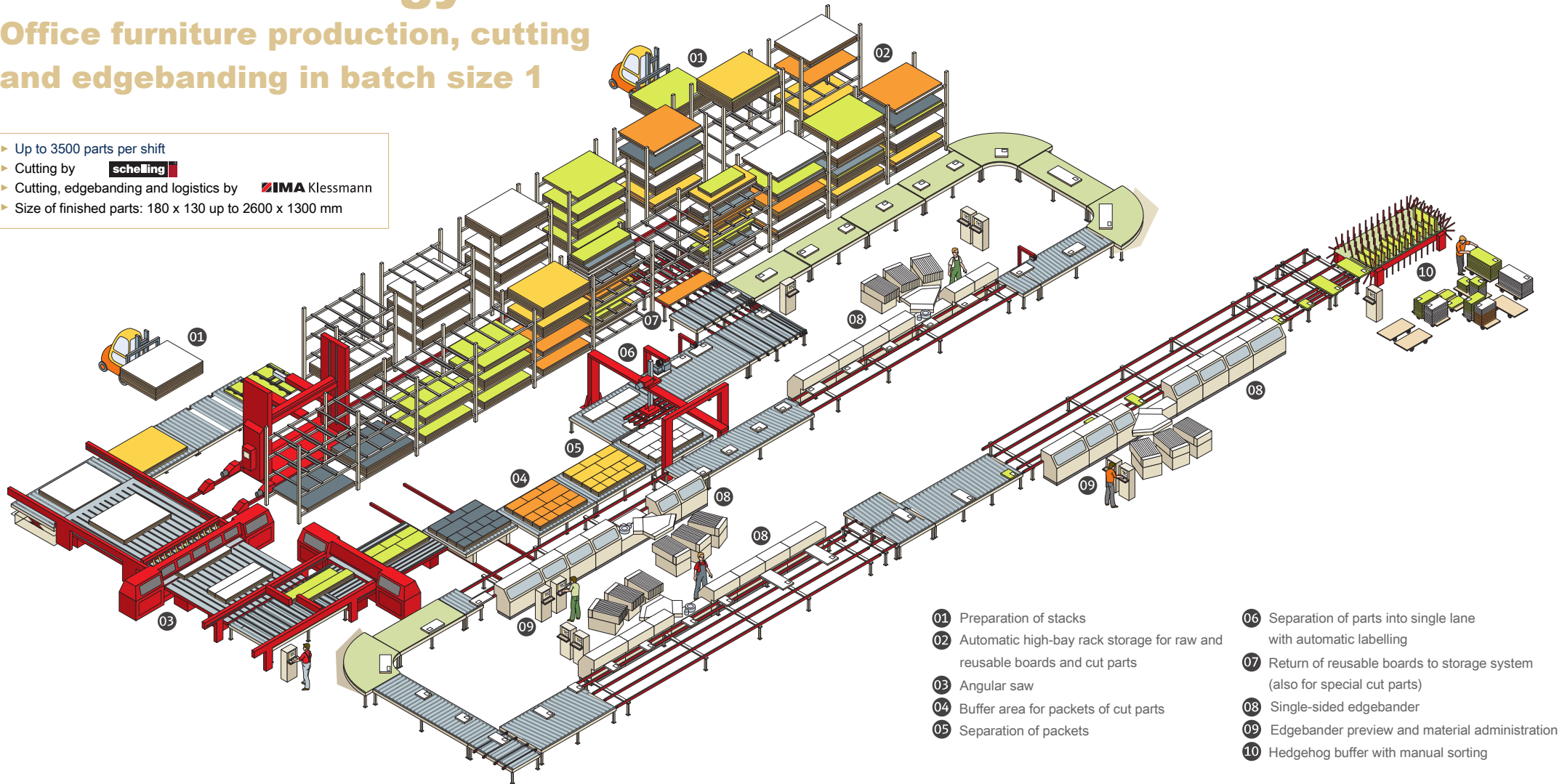# MES technology with 3Tec

Office furniture production, cutting and edgebanding in batch size 1

- Up to 3500 parts per shift
- Cutting by **schelling**
- Cutting, edgebanding and logistics by **IMA** Klessmann
- Size of finished parts: 180 x 130 up to 2600 x 1300 mm

01	Preparation of stacks	06	Separation of parts into single lane with automatic labelling
02	Automatic high-bay rack storage for raw and reusable boards and cut parts	07	Return of reusable boards to storage system (also for special cut parts)
03	Angular saw	08	Single-sided edgebander
04	Buffer area for packets of cut parts	09	Edgebander preview and material administration
05	Separation of packets	10	Hedgehog buffer with manual sorting

Automation | Information | Transparency

3Tec

MES technology with 3Tec

Office furniture production, cutting and edgebanding in batch size 1

- **Automatic high-bay rack storage for raw and reusable boards and special cut parts**
- **Cutting with angular saw**
- **Buffering of packets of cut parts**
- **Labelling of component parts**
- **Edgebanding with 4 single-sided edgebanders**
- **Hedgehog buffer with manual sorting**

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 and control of the cutting plan optimizer
- Edgebander preview and edge material administration
- Handling of re-productions and quick shots

Control system

Warehouse management and control of high-bay rack storage system

- Tracking of individual parts
- Connections to production machines
- Labelling
- Monitoring via barcode scanning

Inter-process communicaton and feedback

Production status display for all production steps

Stacking unit control system

- Stock movements from pre-storage to automatic storage
- Preparation of A material

System-wide display elements

- Operator guidance
- Diagnostics and error recovery

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