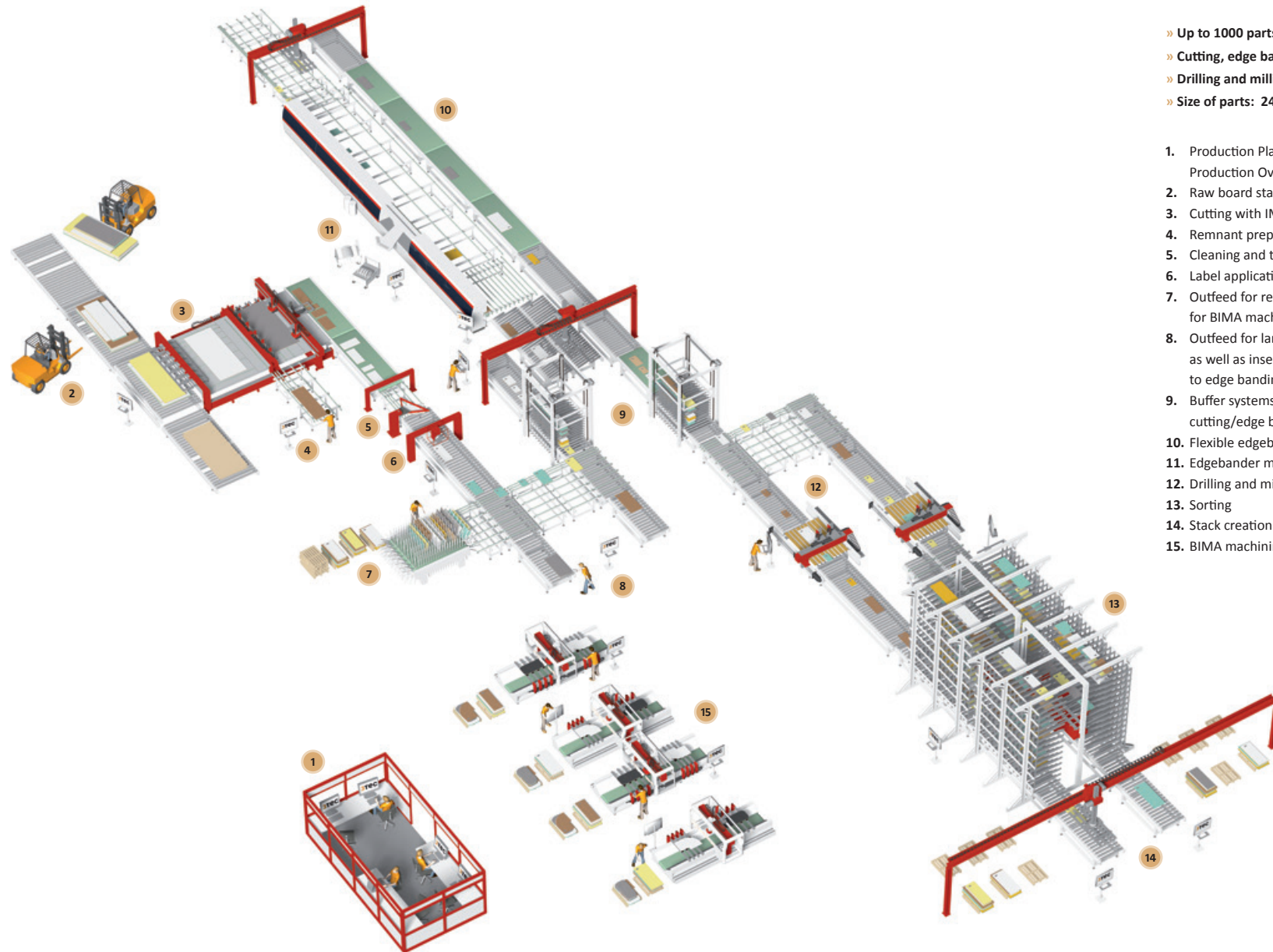# MES technology with 3TEC

Intelligent and extremely flexible office tabletop production

» **Up to 1000 parts per shift**
» **Cutting, edge banding and logistics by** IMA
» **Drilling and milling by** Priess+Horstmann Bohr- und Einpresstechnik
» **Size of parts: 240 x 120 mm up to 3050 x 1300 mm**

1. Production Planning/Optimization/ Production Overview
2. Raw board stack building
3. Cutting with IMA Performance.Cut
4. Remnant preparation
5. Cleaning and turning unit
6. Label application
7. Outfeed for remnants and boards for BIMA machining centers
8. Outfeed for large remnants and boards as well as insertion and direct feed to edge banding
9. Buffer systems between cutting/edge banding and edge banding/drilling
10. Flexible edgebander loop
11. Edgebander management and preview
12. Drilling and milling machines
13. Sorting
14. Stack creation and direct outfeed
15. BIMA machining centers

MES technology with 3tec

Intelligent and extremely flexible office tabletop production

» Creation of pre-commissioned raw board stacks
» Cutting of raw boards and remnants with a Performance.Cut
» Label application
» Outfeed for remnants and boards for CNC/BAZ
» Buffer for edge banding
» Automatic edgebander loop
» Buffer for drilling
» Automatic drilling
» Sorting system for packing and subsequent production steps
» Stacking system

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, drilling, CNC processing,
   sorting and stacking system
» Edgebander management and preview
» Handling of reproductions and quick shots

Control 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