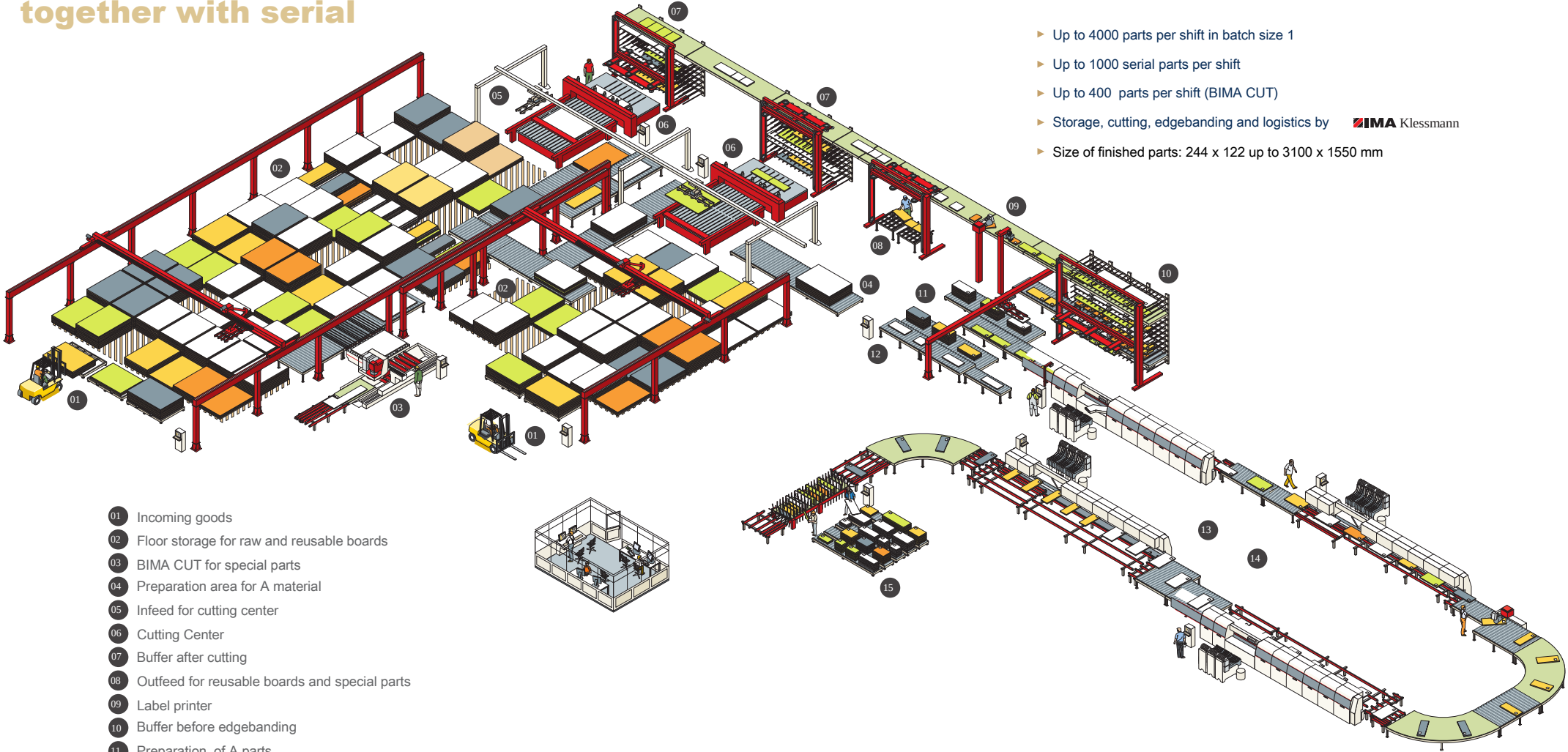# MES technology with 3Tec

Furniture parts production in batch size 1 together with serial

- ▶ Up to 4000 parts per shift in batch size 1
- ▶ Up to 1000 serial parts per shift
- ▶ Up to 400 parts per shift (BIMA CUT)
- ▶ Storage, cutting, edgebanding and logistics by **IMA** Klessmann
- ▶ Size of finished parts: 244 x 122 up to 3100 x 1550 mm

01 Incoming goods
02 Floor storage for raw and reusable boards
03 BIMA CUT for special parts
04 Preparation area for A material
05 Infeed for cutting center
06 Cutting Center
07 Buffer after cutting
08 Outfeed for reusable boards and special parts
09 Label printer
10 Buffer before edgebanding
11 Preparation of A parts
12 Area for quick shots
13 4 single-sided edgebanders
14 Edegbander preview and edge material administration
15 Hedgehog buffer with manual sorting

MES technology with 3Tec

Furniture parts production in batch size 1 together with serial

- **Automatic floor storage for raw and reusable boards**
- **2 Cutting Centers and 1 BMA CUT**
- **Labelling of component parts**
- **Planning and optimization of production orders**
- **Buffer for edgebanding**
- **Feed for A parts**
- **4 single-sided edgebanders**
- **Manual sorting and stack building according to diverse criteria**

Production data import and preparation

- All data relevant to production is imported from the ERP system
- Production data stored in MS-SQL database
- Planning and cutting plan optimization (except BIMA CUT)
- Data preparation for edgebanding
- Edgebander preview and edge material administration
- Handling of re-productions and quick shots

Control system

Warehouse management and control of automatic floor storage system

Preparation of A material

Material flow control

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

Inter-process feedback

Production status display for all production steps

System-wide display elements

- Operator guidance
- Diagnostics and error recovery