- ▶ 900 front and cabinet parts per shift
- ▶ Cutting, edgebanding by **IMA** Klessmann
- ▶ Storage, logistics by **IMA** Meinert
- ▶ Size of finished parts: 230 x 120 up to 3050 x 1300 mm

MES technology with 3Tec

Bathroom furniture C items production, processing and sorting in batch size 1
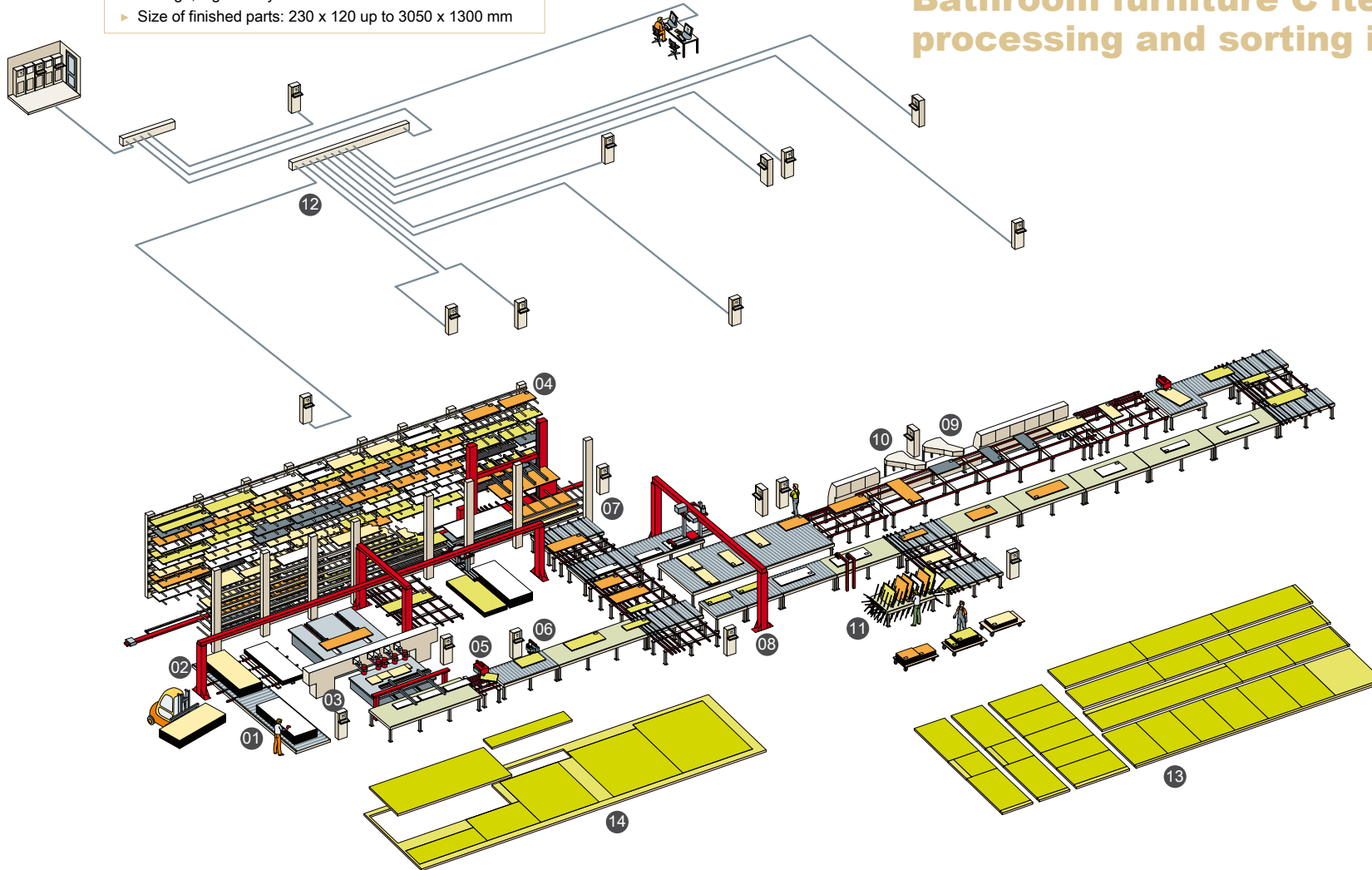
- 01 Areas for preparing commissioned stacks
- 02 Cutting center infeed and outfeed
- 03 Cutting center
- 04 Direct access reusable board storage
- 05 Turning station
- 06 Label printer
- 07 Re-storage of reusable boards
- 08 Turning unit for single and pairwise edgebanding
- 09 Single-sided edgebander
- 10 Edgebander preview and edge material administration
- 11 Hedgehog buffer
- 12 Network including separate subnet for production machines
- 13 Typical cutting plan
- 14 Special cutting plan with stripes

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MES technology with 3Tec

Bathroom furniture C items production, processing and sorting in batch size 1

- **Production of C items (fronts, sides and transverse) from half format and reusable boards in batch size 1**
- **Cutting Center for raw board processing**
- **Labelling of component parts**
- **Edgebanding**
- **Manual sorting with variable destinations**

Production data import and preparation

- All data relevant to production is imported from the ERP system
- Production data stored in MS-SQL database
- Cutting plan optimization
- Creation of cutting plans for the cutting center
- Data preparation for edgebanding
- Edgebander preview and edge material administration
- Handling of re-productions and quick shots

Control system

Warehouse management and control

- Automatic storage of reusable boards
- Manual pre-storage

Material flow control

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

System-wide display elements

- Operator guidance
- Diagnostics and error recovery

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