

FBA130/136.K

Sash fittings mounting centre

to mount all corner guides and fixed fittings components

Technical data

Sash min. inner single panel size (W x H)	260 mm x 260 mm
Sash max. outer welded dimensions	1500 mm x 2500 mm

Available models

FBA136-universal

Enhanced configuration for the 2 minute work cycle - speed

Universal automated machine to mount the corner guides, sash hinges and interlocking rods

Equipment:

- 6 corner guide feeders
- 4 sash hinge feeders
- 4 interlocking rod feeders

FBA130-EU

Enhanced configuration for the 1 minute work cycle - high speed

Automated machine to mount the corner guides

Equipment:

- 6 corner guide feeders, upgradeable to 12

FBA136-FL-MV

Enhanced configuration for the 1 minute work cycle - high speed

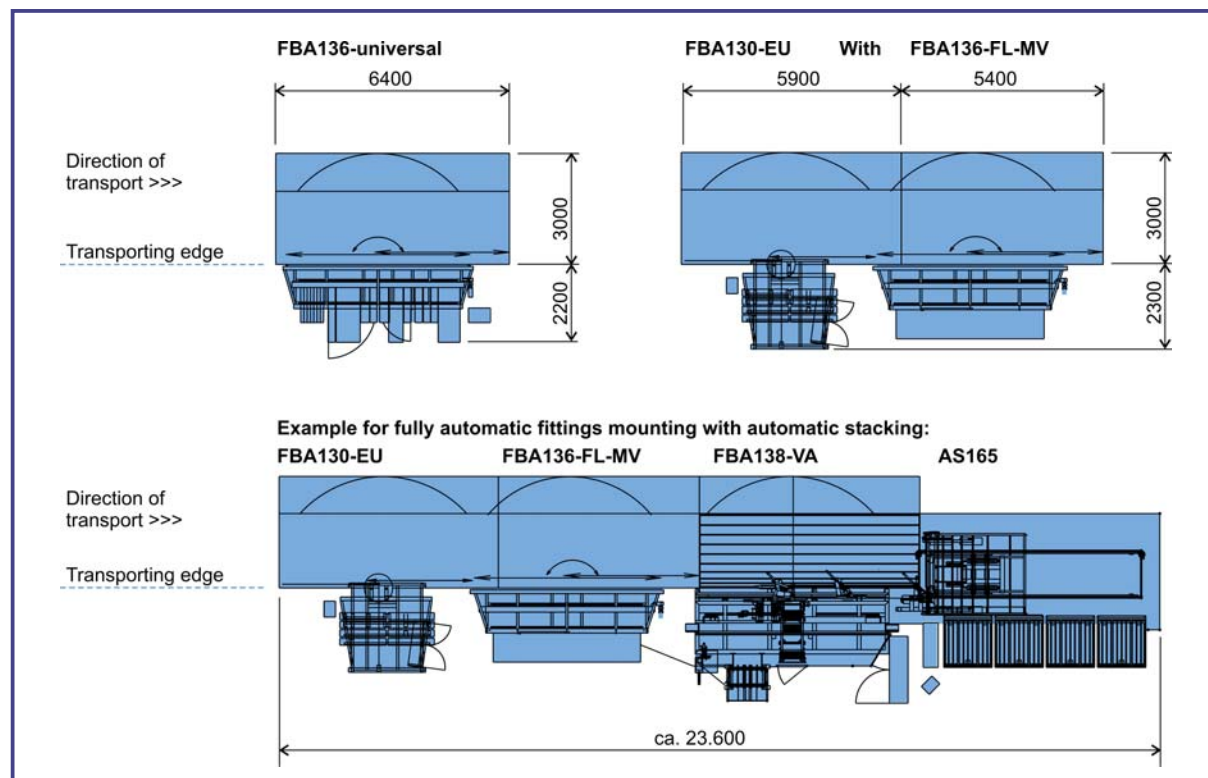
Automated machine to mount the sash hinges and the interlocking rods

Equipment:

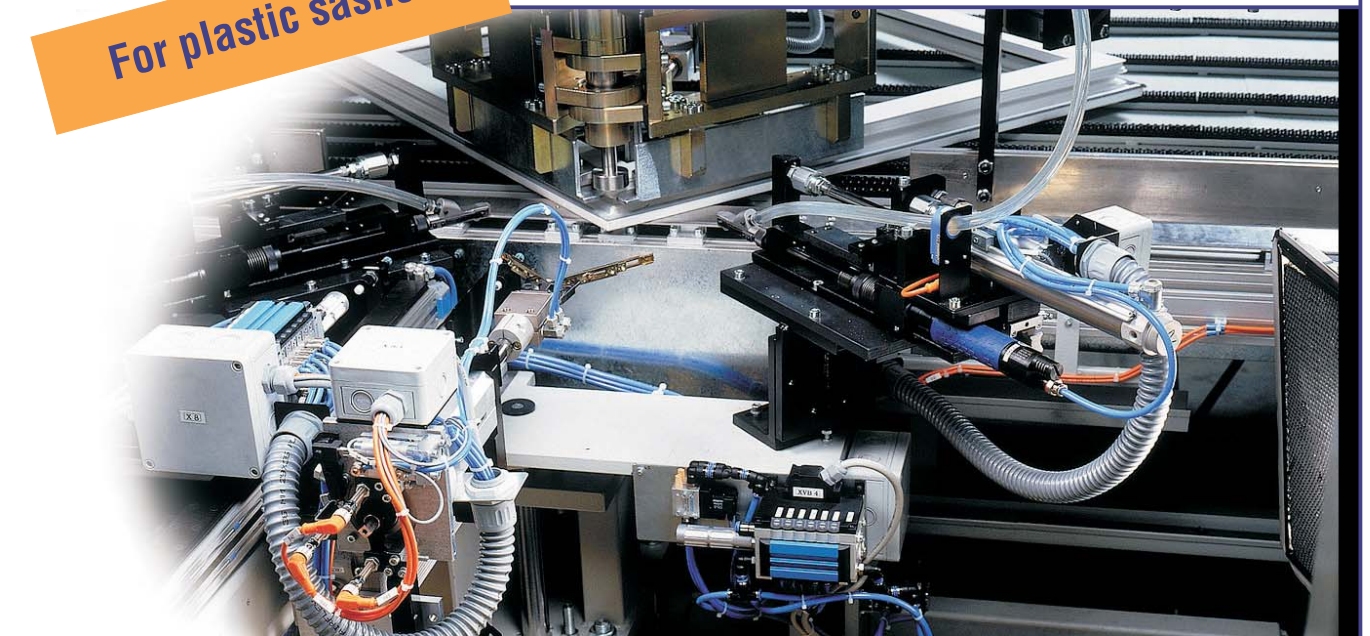
- 4 sash hinge feeders, upgradeable to 7
- 4 interlocking rod feeders, upgradeable to 5

Upgrade options

- Full automation of the sash fittings mounting by adding a FBA138-VA
- Fully automatic stacking of the sashes by adding an AS165 stacking device



For plastic sashes



FBA130/136.K

Sash fittings mounting centre
to mount all corner guides and fixed fittings components

FBA130/136 K

Sash fittings mounting centre

to mount all corner guides and fixed fittings components

Sophisticated mounting concept for fittings suitable for automation

LEMUTH's fittings mounting centres have already since 1995 been successfully in daily operation in many window manufacturing firms in Europe. Thanks to the continuous further development of the machine concept, an optimised spectrum of mounting centres from universal single automated machines to fully automatic mounting production lines is available to the window manufacturer. Thus, two machine concepts, the automated machine series **FBA130** and **FBA136**, are available according to user-preference for a manufacturing procedure with 1 or 2 minute work cycles respectively.

The step to full automation

All LEMUTH automated machines are optimally aligned with one another. As a result the machines **FBA130** and **FBA136** which mount the corner guides, the interlocking rods and the sash hinges are well complemented by a **FBA138-VA** which mounts all fittings components to be cut to length for exam-

ple drive and top rods. If the fittings mounting production line were to be completed by an automatic stacking device, all manual mounting operations in this sector would be omitted.



Large variety of fittings

High speed machines - an upgraded version of the feeder equipment - can be supplied with up to 12 different corner guides, 7 sash hinges and 5 interlocking rods.

Completely non-fitting specific

The new mounting centres are no longer linked to a single fittings system. When changing the fittings the machines can simply be set up and converted to the new system as in a profile change.

Precision machining

High-tech components from the quick numerically controlled positioning device to sophisticated operation technology ensure the highest quality for automatic component machining. Optimal operation is ensured through the concise and easily accessible arrangement of the feeders as well as the simple operator routines on the industrial computer.

Automatic mounting

The machines from the FBA130 and FBA136 series mount all corner guides, sash hinges and interlocking rods on to the sash. All transporting, handling and mounting processes take place automatically. Already in the standard model four different groove position levels can be operated. It is possible to adjust extremely variable profile types with the use of an adjustable machine edge.

Mounting of the corner guide

- suitable for all corner components such as corner guides, top hinge elbows, corner stay guides, sash stay guides etc.

The corner components are supplied by six vibratory feeders. Depending on the model, each feeding device can store approximately 50 to 70 fittings components. According to the mounting concepts for the 1 and 2 minute respective work cycles the gripping mechanical attachment accurately sets the fittings to an angle of 90° or 45° on the sash corner for them to be automatically bolted on.



Mounting of the sash hinge

- suitable for sash hinges, interlocking rods, corner hinges, ramp parts etc.

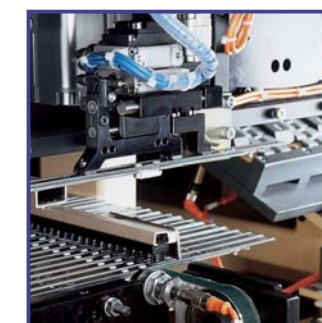
The mounting operation takes the sash hinge from the hop feeder. Every one of the four slanting feeder chutes can store approximately 40 fittings. To set the sash hinge, the mounting holes are accurately drilled by a two-headed drilling device. Quick pneumatic bolting devices position the sash hinge on to the window.

Mounting the interlocking rods

- suitable for interlocking rods, centre locks

Special chain conveyors are used to feed the interlocking rods. On every one of the four feeders up to 80 elongated fittings can be stored. For the mounting process, the double-pivoting machine picks up the fittings out of the feeder and sets up through numerical control the exact setting position. Up to three inter-

locking rods, each a maximum of 500mm long, can be linked and bolted together.



User-friendly and optimal service

The machining data is accessible online through the central network, on disk or manually. More flexibility as a result of minimised wiring requirements brings the optimal network communication via radio communication. Data inputted by the operator appears on the industrial computer with concise operator guidance. The remote maintenance of the automated machine through the integrated modem is a matter of course. You will experience competent assistance whether on the telephone hotline or on site with our friendly customer service team.



FBA130-FL-MV and FBA130-EU high speed enhanced configuration for the 1 minute work cycle

The all-round service from LEMUTH

guarantees security for your investment

You will receive the following services from a single source and harmonised down to the last detail

- Project management
- System planning
- Factory planning
- Construction
- Electrical project management
- Component production
- Installation
- Start-up
- Staff training
- Documentation

And included in the software field:

- PLC programming of the system control
- Programming of the industrial PC interfaces
- Network connection to the company network
- Networking the window construction system

Further LEMUTH Systems for your Window Manufacture:

Cutting and processing for PVC or aluminium
Cutting and processing centre *unicut200 range*

Cutting for steel
Steel cutting machine *ZS180 range*

Vertical four-headed welder
Four-headed welding machine *VKS140 range*

Vertical corner cleaner
Corner cleaning machine *EPA120 range*

Glazing bar saw
Automatic glazing bar saw *ZFW300 range*

Gasket insertion
Partially automatic in rods
Gasket insertion machine for straight processing *DAGL110 range*

Fully automatic
Gasket insertion machine for all-round processing on the frame and leaf *DAW100 range*

Manual assembly of fittings
Leaf fitting assembly station *FBM135 range*

Fully automatic assembly of fittings
Leaf fitting assembly centre *FBA130/136/138 range*
Frame fitting assembly centre *RBA330 range*

Stacking
Fully automatic stacking device *AS165 range*

Bonding the pane in the element
Semi automatic
Semi-automatic glass pane gluing machine *Serie GVH112 range*

Fully automatic, in the glazing rebate or casement overlap
Glass pane gluing machine *Serie GVA115-FF/GVA115-FÜ range*

More information on the internet at www.LEMUTH.com or by telephone +49 3693 9412-0