

FBA138-VA.K

Sash fittings mounting centre

Full automation

Available models

Typ FBA138-VA

Automated machine to mount all fittings components to be cut to length on to the sash

Options

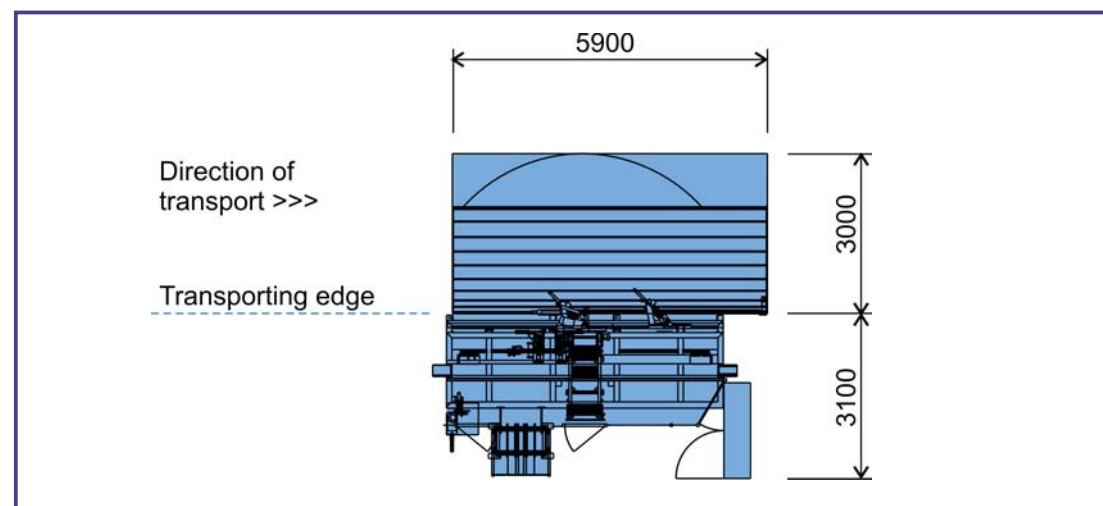
- fully automatic measuring system to calculate the actual length of the glazing bead
- additional bolt sorting devices with program switch and distribution system for the use of further bolt lengths
- automatically adjustable machine edges to machine overlapping casements and special profile sections
- connection of an automatic stacking device

Special equipment

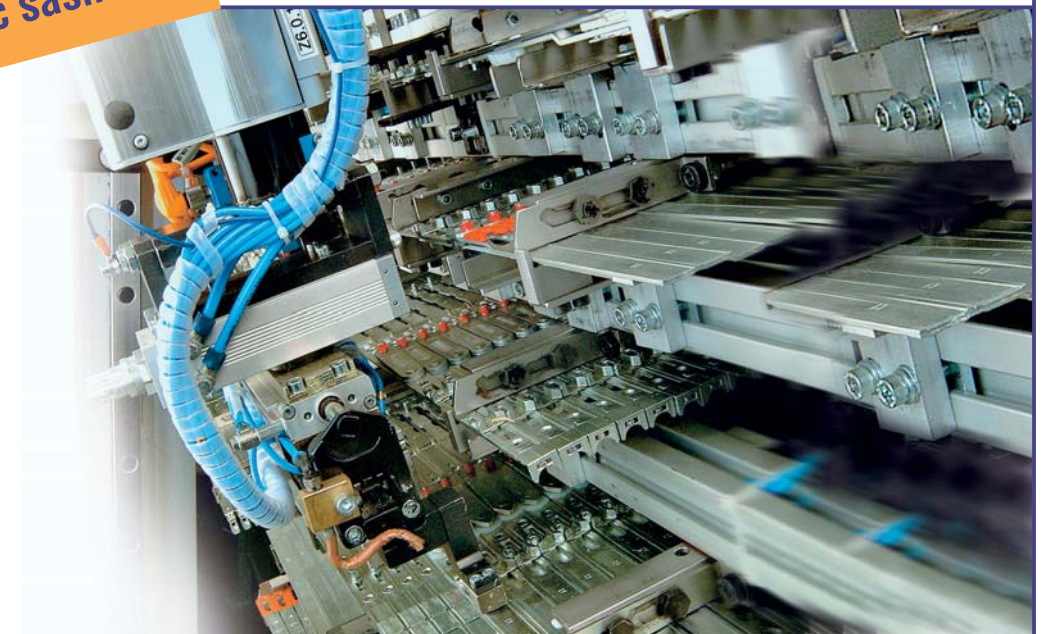
- two-headed drilling device for balcony door handle drill hole
- key handle drilling sub-assembly

Technical data

Size of sash, minimum inner single panel size (W x H)	260 mm x 260 mm
Size of sash, minimum rebate dimensions (W x H)	340 mm x 340 mm
Size of sash, maximum outer welded dimensions (W x H)	1500 mm x 2500 mm
Supply voltage	230 / 400 V 50 Hz
Control voltage	24 VDC
Total connected load	6,5 kW
Electrical connection type	CCE
Operational voltage	6 bar
Air consumption	1150 l/min
Pneumatic connection type	Quick connection coupling ½"



For plastic sashes



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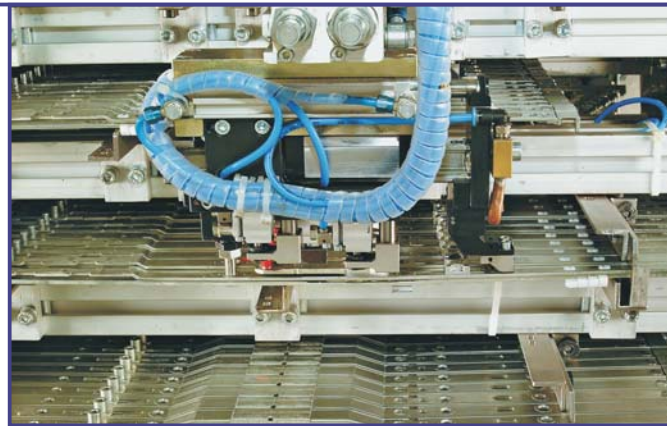
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Enhanced configuration for fully automatic fittings mounting on to the sash

Fully automatic fittings mounting process

The fittings mounting centre FBA138-VA cuts, punches and mounts all fittings components to be cut to length, such as drive and top rods, stay guides and interlocking rods, including all connection plates on to the sash. By adding the automated machine on to the rear of a mounting complex for corner guides, interlocking rods and sash hinges, it is possible to fully automatically mount the fittings! Manual mounting errors are eliminated. A stacking device completes the fully automatic sash fittings mounting process.

Setting and connecting of the cut to length fittings

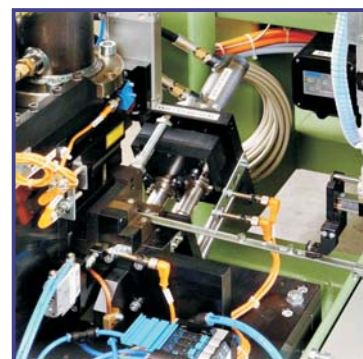


Flexible and non-fittings-specific

All fittings systems suitable for automation can be processed by the machine. Two feeder towers with 15 feeder chutes each store a total of up to 30 different fittings types. The adjustable feeders can be installed in every system and converted if required.

Automatic fittings punching mechanism

If elongated fittings were up until now manually shortened, the working process now takes place fully automatically in the mounting centre. The grabbing mechanical attachment picks up the fittings component to be cut to length out of the feeder chute and feeds this into the punching mechanism without having to spread them apart beforehand. High-precision



numerically controlled axes set up the fittings in the tool to the precise cutting measurement transmitted by the control system. The fittings component is accurately cut to length and embossed.

Efficient mounting technology

The high efficiency of the mounting centre is due to the skilful interaction of working operations which prepare and process. Already whilst the



automated machine is mounting the elongated fittings on to the current sash, all fittings components for the subsequent window are

cut to length, embossed and pre-positioned onto the loading conveyor belt. Therefore, after the subsequent window has been loaded on, the mounting can commence straight away.

Top equipment for precision mounting

The high standards in modern window manufacture are suited to the fittings mounting centre because of its innovative technology. All important transporting of the sub-assembly units are carried out on accurate, fast-acting numerically controlled axes. As a result both bolting devices as well as the mounting operating device can be simultaneously positioned on to the sash using the same sub-assembly carrier. Servo-axes with special features are also used to prepare the fittings. In general, it is possible

to set the fittings components on to four different groove position levels. An automatic scanning device is integrated to control the correct bolting-in depth.

Modern control system

The Windows programmed industrial computer with colour screen is set up for data inputting. A network card is integrated for connection to a Novell or Windows network. The remote maintenance of the machine is naturally designed to provide a direct and practical service. Optionally a fixed network or radio connection can be established through an analog modem or ISDN card. The convenient programming of the machine control system is carried out according to IEC 1133.



Mounting centre FBA138-VA with fully automatic stacking device

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-FFIGVA115-FÜ range*

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