

# GVA115-FF

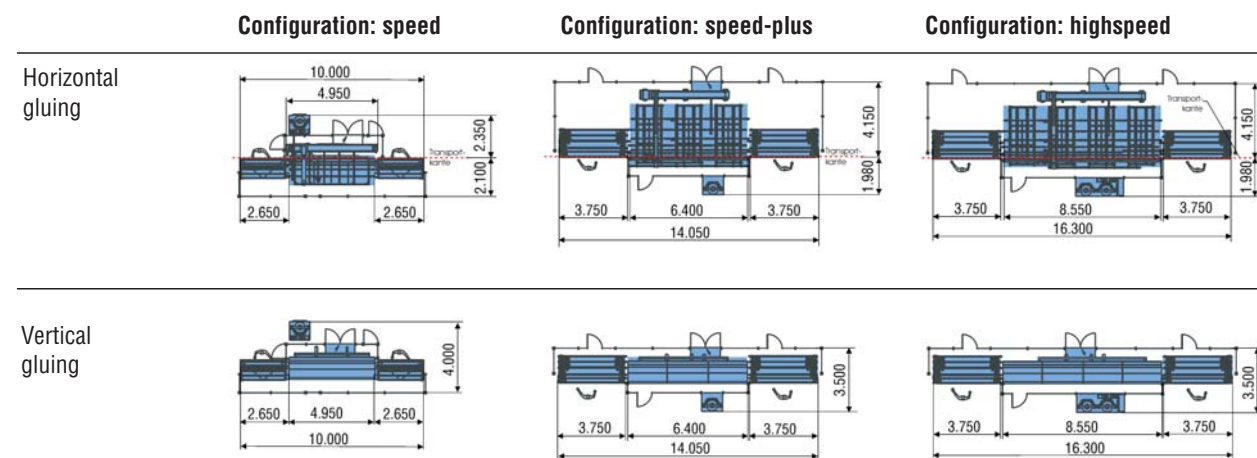
## Glass Pane Gluing Machine

*Gluing into the glazing rebate*

*Inserting pane by hand*

*Gluing glass pane in completely mounted window*

### Possible desings

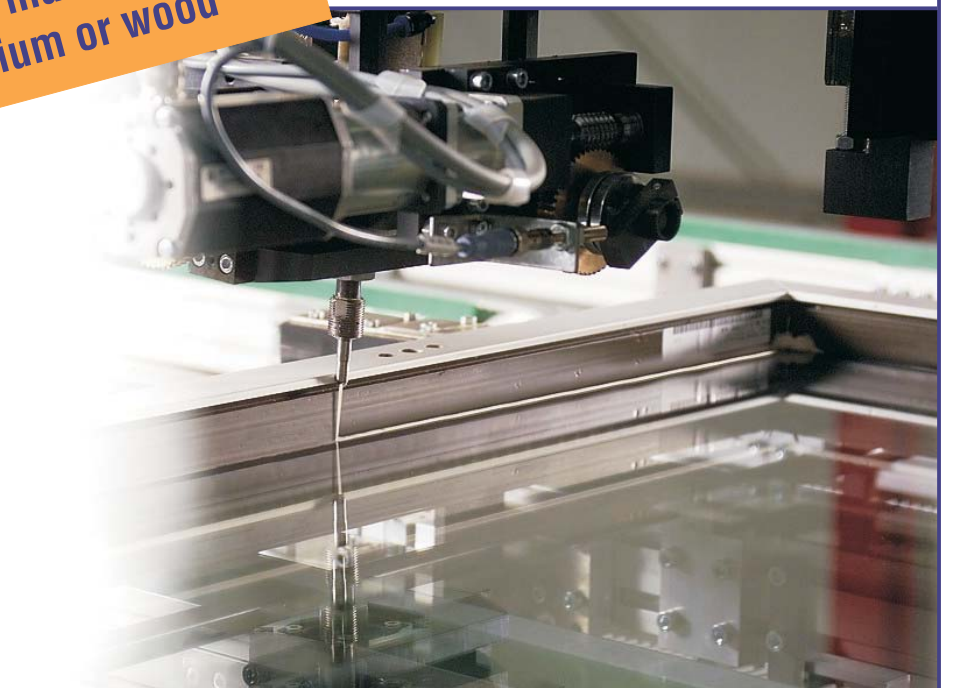


### Technical information

|                          |   |   |   |
|--------------------------|---|---|---|
| Sash preparation         | Pane is mounted in the sash, Sash <b>has not yet been placed</b> in frame | Pane is mounted in the sash, Sash <b>has already been placed</b> in frame | Pane is mounted in the sash, Sash <b>has already been placed</b> in frame |
| Window exterior max.     | 1.500 mm x 2.500 mm   | 2.500 mm x 3.500 mm   | 2.500 mm x 3.500 mm   |
| Window exterior min.     | 400 mm x 400 mm   | 400 mm x 400 mm   | 400 mm x 400 mm   |
| Profile height max.      | 125 mm  | 125 mm  | 125 mm  |
| Time per field 1m x 1.2m | 100 s / per field   | 100 s / per field   | 65 s / per field  |
| Operating voltage        | 230 / 400 V - 50 Hz   | 230 / 400 V - 50 Hz   | 230 / 400 V - 50 Hz   |
| Control voltage          | 24 DC   | 24 DC   | 24 DC   |
| Operating pressure       | 6 bar   | 6 bar   | 6 bar   |

The machine meets the uniform requirements pursuant to the Machinery Directive 98 / 37 / EC

For windows made of plastic, aluminium or wood



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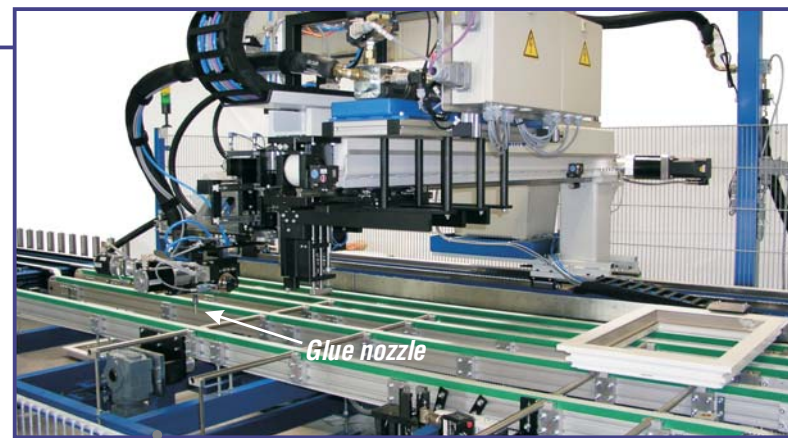
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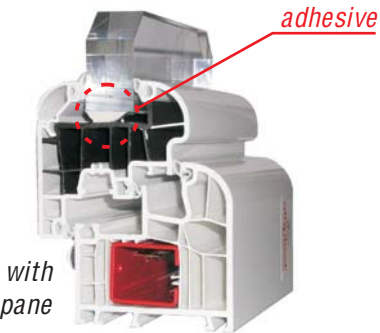
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*Gluing into the glazing rebate  
Inserting pane by hand  
Gluing glass pane in completely mounted window*



Profile cross section with glued-in glass pane



### Precision gluing of panes into sashes

LEMUTH's glass gluing machine guarantees the accurate and neat gluing of panes into the sashes. The machine needs 60 to 100 seconds to apply the glue to a standard surface area of 1 m x 1.2 m, depending on the configuration.

The composition of the profile to be processed must be adapted accordingly, meaning, the slot between the glass pane and the rebate base of the sash will be reduced to 3 - 4 mm to minimise the amount of glue required. A reduction of the slot is possible since this gluing method does not require using wedges for the glass pane.

### Fully Automated Machining

After the operator has placed the pane in the sashes of the already mounted window on the upstream tilting table, the machine accepts the window for processing. The entire process is fully automated, from loading to the application of glue and finally discharge. Conveyer belts are used for the careful loading of parts onto the tilting table and gluing machine.

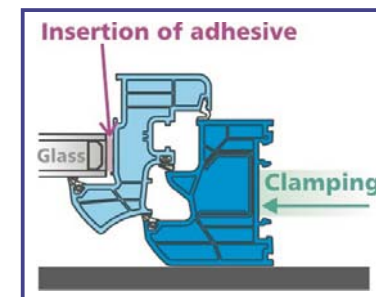
### Gluing of numerous user-defined panels

The machine can process windows with any number of sashes. After the parts have been recognised using a barcode reader the control system processes all the necessary information from the data record for the machining of the parts.

### Hi-tech down to the very last detail

Via an automatic plausibility check the machine controls the

exact thickness of the glass. A special device to align the glue stream is also built into the machine. This ensures that the glue nozzle always moves at an ideal angle along the profile. The glue nozzle, when not in use, is heated to prevent the glue from drying.



### Gluing into the glazing rebate

After the loading into the machining position, specially designed corners and rotating clamps ensure that the sash is positioned exactly for the application of glue. The glue is placed along the periphery between the glass seal and the glazing rebate. As soon as the glue has been completely applied, it is possible to gently off-load the sash.

### Vertical or horizontal gluing

It is possible to glue in either a vertical or horizontal position.

### Windows-PC and fast remote-access

A convenient industry PC with windows OS is available for data input. For fast remote-access there is an integrated modem.

### Advantages of the new gluing technology

Economic advantages are attained as a result of savings on steel and auxiliary materials such as wedge

bridges or screws. Activities such as steel reinforcements on the cutting and machining centre or time-consuming wedging are no longer necessary and reduce labour costs.

### Gluing affords greater stability

Gluing technology delivers a much higher level of stability. The number of subsidences or deformations is noticeably reduced. The gluing of PVC sashes in glazing rebates of up to 2 m also dispenses with the need for steel reinforcements. It is also possible

narrow the profile of the sash itself resulting in an additional savings on materials. The sash is lighter. The greater rigidity of the unit facilitates the production of larger sashes.

### Outstanding heat insulation

The glued sashes are absolutely windproof. Elements with standard glazing improve the insulation value by 20%. Windows with such good characteristics are optimal for use in passive and low-energy houses.



### 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*

**Gasket insertion, 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*

**Partially automatic assembly of fittings**  
Clip station and leaf fitting connection machine  
*FBS136 / FBK135 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, fully automatic**  
Glass pane bonding machine  
*Serie GVA115 range*

More information on the internet at [www.LEMUTH.com](http://www.LEMUTH.com) or by telephone +49 3693 9412-0