

RBA330.K

Frame Fitting Mounting Centre

Independent from a fitting system, for all frame fittings which can use for automatic mounting

Technical data

Window size: minimum clear opening	330 mm x 330 mm
Window size: maximum (theoretical welding measure outside)	3500 mm x 2500 mm
Total connected wattage	Standard plant: 8,5 kW High-speed plant: 13,4 kW
Working pressure	6 bar
Air consumption	Standard plant: 950 l/6 bar High-speed plant: 1100 l/6bar

Possible Models

Standard plant

Typ RBA-LA/SB-1/2-speed.K,
plant for about two-minute-interval*

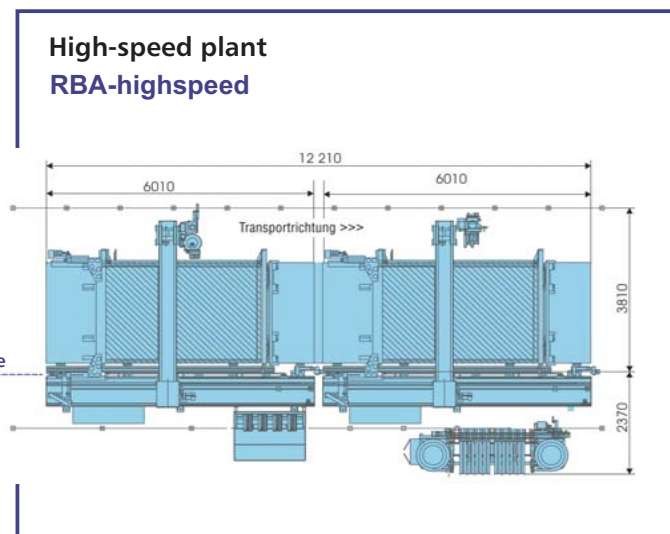
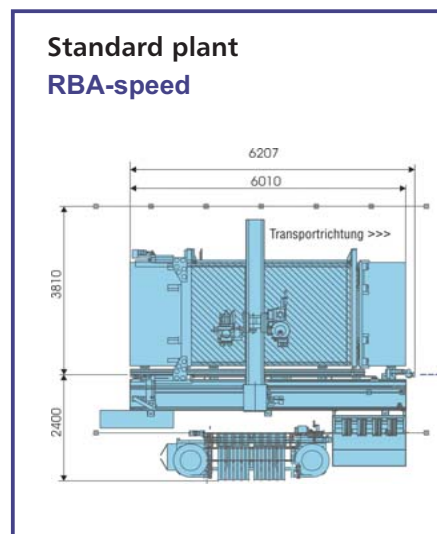
Construction with 1 transverse bar to receive both mounting heads for processing the bearings or keeper, 1 work bench for processing the frame

* the interval refers to the screwing up in plastic

High-speed plant

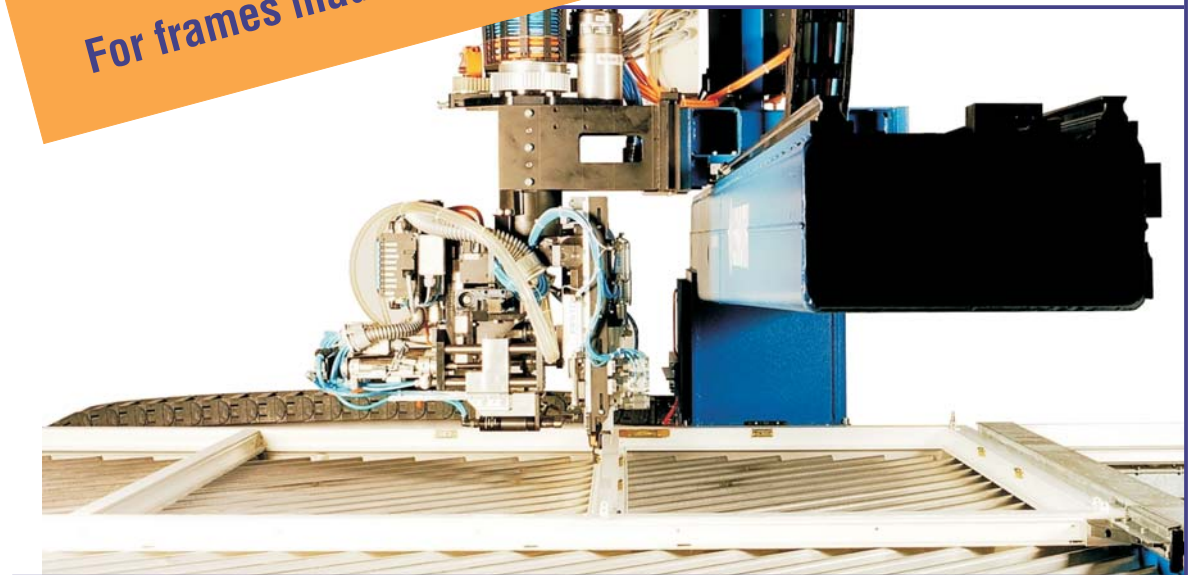
Typ RBA-LA/SB-2/2-highspeed.K,
plant for about one-minute-interval*

Construction with 2 transverse bars to receive one mounting head each, 2 work benches for simultaneous processing the frame



998_257 Prospekt RBA330_englisch - Technical modifications reserved

For frames made of PVC



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The Frame Fitting Mounting Centre points the way to the fully automatic final assembly of windows. Beside a high flexibility in manufacturing this plant offers highest precision and optimal time management at the same time. All works which are necessary for mounting the frame hardware - e.g. first drilling, setting and screwing - are done at the finished frame fully automatically and with highest precision. Expensive manual mounting on unwieldy frames, as well as mounting faults become unnecessary.

Comfortable equipment

The plant has separate mounting heads for mounting the keeper and mounting the bearings for sash hinges. These mounting heads are equipped with several drilling and screwing units which work independently.

Equipment of mounting head for keepers

- two independent drilling units for first drilling of screw holes for single and double drilling
- two independent screwing units for single and double screwing
- two storage hoppers for narrow and wide keepers
- one servo controlled depth advance for mounting the keepers
- one servo controlled depth advance for positioning the drilling and screwing units

Equipment of mounting head for hinge bearings

- two storage hoppers to receive all corner and shearing bearings which have to be processed on the following part
- sixfold drilling head with 90° swivelling unit
- quadruple screwdriver with 90° swivelling unit
- measurement equipment to find out deviations from the theoretical nominal sizes, which arise from profile tolerances or mounting faults in the frame production. With these values an automatic calculation of the correction values for the following each mounting of the corner and shearing bearings on frames, door frames and crosses.

Complex manufacturing technology with patented frame fitting and hopper logistics

Hoppers (insert or feed hoppers) or oscillating conveyors are used to place the mounting frames. The hoppers are tipped according to the parts and outside the safety stop. So the operator's work is simplified very much. During the processing of the current frame the control system takes over the part data from the offset plant for the following frame which has to be processed. Thus the gathering of information and the supply of all lock furniture for the next frame processing is done in one cycle before the actual mounting.

High flexibility in production

The automat can feed frames of different sizes

professionally on horizontal and vertical legs with lock furniture. The processing of door frames and crosses goes without saying. The theoretically maximum number of panels is 99 panels.

Variable arrangement of hoppers

The hoppers can alternatively be arranged before or behind the machine. As standard the plant can process maximally 4 different bearings and 12 different keepers.

corner bearings, shearing bearings ...



Precise, high-exact frame processing

High-exact NC placing facilities ensure the exact delivery of all processing points at the frame. After delivering the positions of the grooves the parts are mounted and all necessary processes such as first drilling, setting



Wide variety of keepers

The plant sets all the necessary lock furniture on the frame, e.g. keepers, leading supports, balcony door latch bolts, automatic lock,

and screwing up the mounting frames. The delivery of different screwing appliances to the mounting places is done by servo control.

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*

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 *FB5136 / 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*

Gluing the pane in the element, semi-automatic
Semi-automatic glass pane gluing machine *Serie GVH112 range*

Gluing the pane in the element, fully automatic
Glass pane gluing machine *Serie GVA115 range*

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

