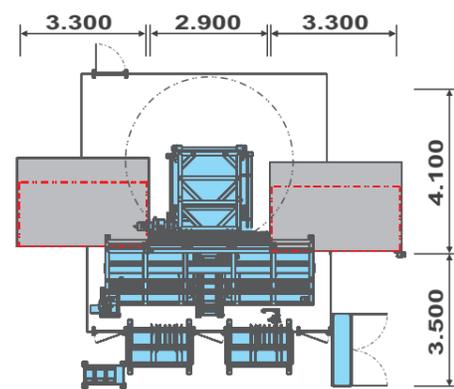


Technical Data

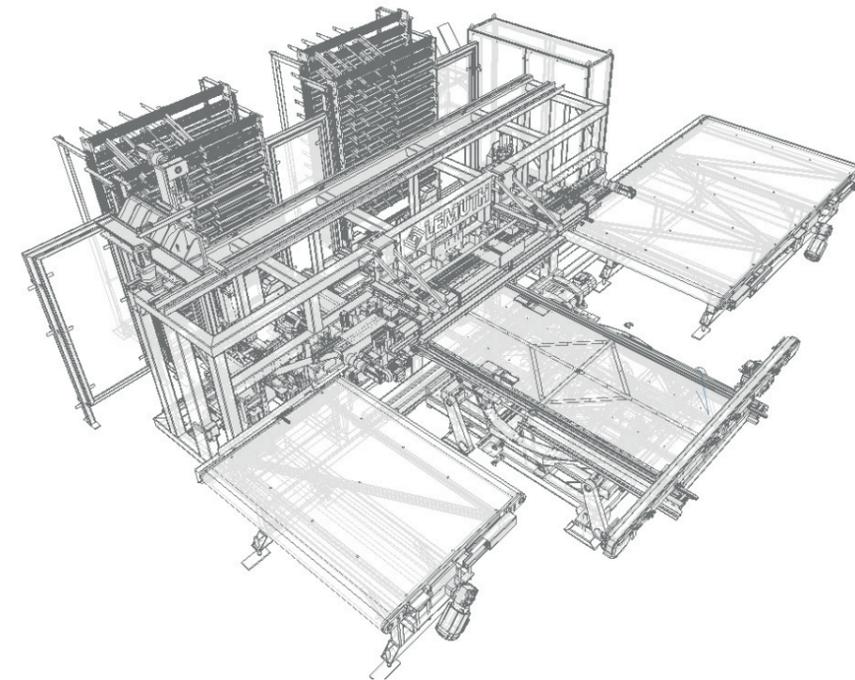
Size of sash, minimum inner single panel size (W x H)	260 mm x 260 mm
Size of sash, minimum rebate dimensions (W x H)	340 mm x 340 mm
Size of sash, maximum outer welded dimensions (W x H)	1500 mm x 2500 mm
Supply voltage	230 / 400 V 50 Hz
Control voltage	24 VDC
Operational voltage	6 bar
Air consumption	1150 l/min
Pneumatic connection type	Quick connection coupling 1/2"



Stand-Alone-unit

Typ: FBA138

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



For elements made of:

✓ PVC

✓ Wood

✓ Aluminum

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



998_361 Prospekt FBA138_2014_englisch - Technical modification reserved



FBA138

Sash fittings mounting centre

Fully automatic fittings mounting process

The fittings mounting centre FBA-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.

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 prepositioned on to 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 subassembly 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 subassembly 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.

Special models for the machining of PVC elements

The machining table has a brush-type surface. In order to turn the sash, a rotator is used.



Special models for the machining of wooden/aluminium elements

Wooden materials call for particularly careful machining. Consequently, in this configuration, the machining table is equipped with driven conveyor belts. These ensure that the elements are conveyed without risk of damage. During the turning process, the element lies rigid on the driven conveyor belts and the whole machining table turns to the new position.

