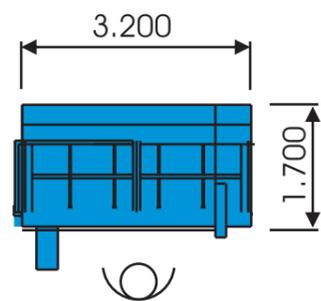


Technical information

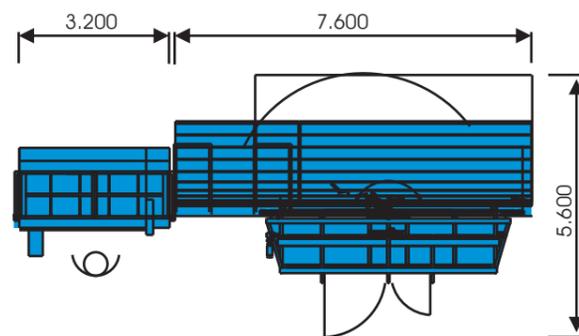


Sash Fitting mounting station FBM135

consisting of the following optional components:

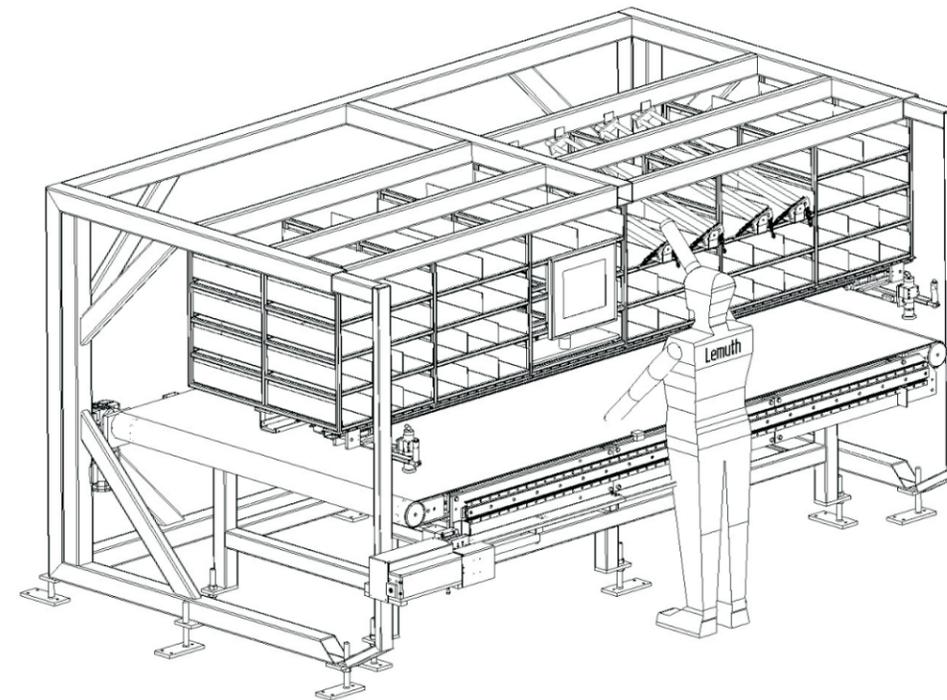
- Fittings assembly table
- Fittings rack
- Cutting-to-length tool
- Numerically controlled dog
- Bolting unit
- Industrial PC

Possible extension:



Manual sash clamping station with subsequent bolting by a LEMUTH Automatic Sash Fittings Bolting Machine FBS135

In this configuration the fittings components are clamped by the fitter in the fittings groove and the elongated fittings are cut to the required dimension. Then the follow-on automatic bolting machine bolts all fittings fully automatically.



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 an 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_330 Prospekt FBM135_2014_englisch - Technical modification reserved



FBM135

Sash Fitting mounting station

The Fittings Mounting Station **FBM 135** has been developed for the manual mounting of fittings components. The machinery of the fittings mounting station can be assembled in stages and can therefore be optimally aligned to the requirements of the production line.

Production sequence:

The fitter places the sash on the assembly table and scans it. The image of the sash is shown on the monitor, and the fittings components to be mounted on the sash are graphically represented around the sash. The exact designation of the fittings, the correct storage compartment and the sequence of mounting the fittings are also displayed. Then the fitter mounts all fittings in the specified order and cuts the elongated fittings to their correct length. To do this, the NC dog automatically travels to the exact position where the fittings components - after they have been inserted into the punch - are cut to length and the connection holes are embossed.

A fittings mounting station consists of the following individual components:

Fittings mounting table

As an option, the contact faces can be fitted with **brush strips**, **plastic strips** or a **wide continuous belt**.



Configuration of the fittings mounting station for wood sashes with glass panes

An air cushion lifting the wood sash is generated under the glass pane by means of air pressure so that the sash can be turned on the table without any problems. The required air is blown under the glass pane through openings in the conveyor belt. The machining position and the size of the sash to be mounted with fittings are variable as the conveyor belt has several vent holes.



Configuration of the fittings mounting station for PVC sashes and elements without glass panes

The fittings assembly table comes with PVC or brush strips that are used as the bearing area. Tilting bolts, which are additionally mounted on the table, are used as stops for mounting the fittings.

NC cutting-to-length shaft



It is possible to use a cutting-to-length tool in order to punch and cut all fittings components to be cut to length for mounting on to the drive and top sides of the sash. The elongated fittings are cut-to-length and at the same time embossed with a new connection hole.

The numerically controlled dog on the tool sets the cutting gauge to the next dimension specified by the control system each time. The precise and correct cutting-to-length of the elongated fittings is thus ensured.

Bolting device



The bolting unit consists of an automatic bolting device complete with a bolt sorting and singularising device for one type of bolts. The automatic bolting device is mounted on an easy-glide guide for convenient positioning.

Monitoring station

The industrial PC has been designed as a monitoring station including a colour monitor and input devices. It uses the latest Windows operating system and has a fittings resolution capability for automation compatible fittings systems that can be connected.

Fittings rack

The fittings rack arranged over the table provides clearly laid out storage for the elongated fittings to be mounted.

RFID reader

