FA 1010 Profile Processing and Cutting Center

FA 1030 Profile Processing, Cutting and Screwing Center



General Features

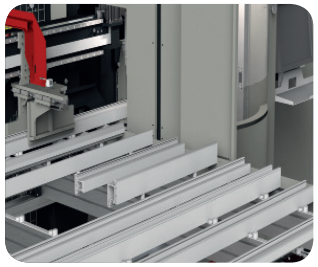
- Robust mechanical design suitable for high speed operations.
- Maximum performance with high quality materials used on production.
- High capacity thanks to independent operation of processing, cutting and screwing units.
- FA 1030 processing, cutting and screwing center has servomotor controlled 14 axis, FA 1010 processing and cutting center has servomotor controlled 12 axis.
- Precise measuring thanks to linear measurement system.
- Reverse cutting to prevent wastes while frame is made from mullion profile.
- Screwing unit can be integrated to FA 1010 later on.
- Automatic gresasing system.

Control Panel

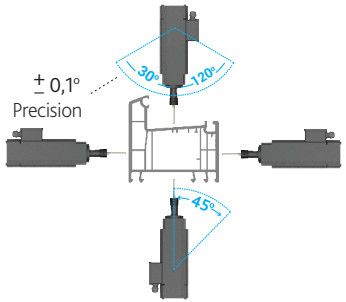


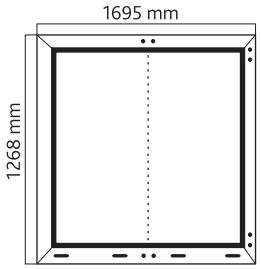
- User-friendly operating system compatible to all joinery and optimization programs.
- Minimum waste, maximum production algorithm.
- The wastes are optimized automatically in cutting list.
- Parameters are set easily.
- Different profiles and hardwares can be configured and optimized.
- Periodical maintenance reminder function.
- 17" LCD Screen.
- Usb input.

Profile Loading Unit



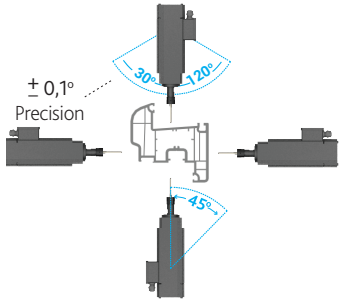
- Profile loading capacity: 9 profiles.
- Loading capacity can be increased optionally.
- Automatic profile recognition feature on profile conveyor and positioner.
- Profile Length: Minimum 800 mm – maximum 6.500 mm. (optionally eternal)
- Warning system to prevent wrong profile loading.

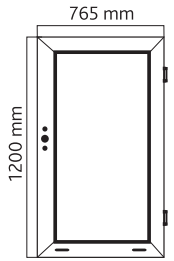




Frame	Processing Time	Profile Length Quantity	Processed Running Meter	Process Symbols	Process Names
1 Frame	50.4 sn.				+/-30°Cutting
10 Frame	8m 24 s	10			Water Slot
571 Frame	8 Hour	571	3426		Striker
					Mullion Connector Hole

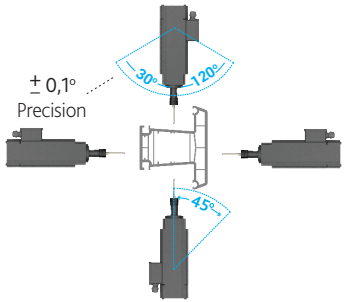
Calculated by processing 10 bars of frame profiles.

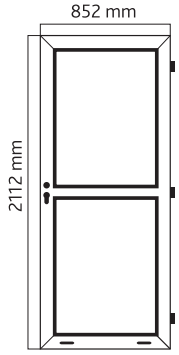




Sash	Processing Time	Profile Length Quantity	Processed Running Meter	Process Symbols	Process Names
1 Frame	45,5 s				+/-30°Cutting
10 Frame	7m 35 s	6,66			Water Slot
633 Frame	8 Hour	422	2532		Striker
					Window Handle Holes

Calculated by processing 10 bars of sash profiles.

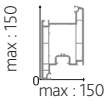




Door	Processing Time	Profile Length Quantity	Processed Running Meter	Process Symbols	Process Names
1 Frame	57,3 s				+/-30°Cutting
10 Frame	9m 33 s	10			Water Slot
502 Frame	8 Hour	502	3012		Striker
					Cylinder Hole Espagnolette Can
					Mullion Connector Hole

Calculated by processing 10 bars of door profiles.

Processed profile dimensions:

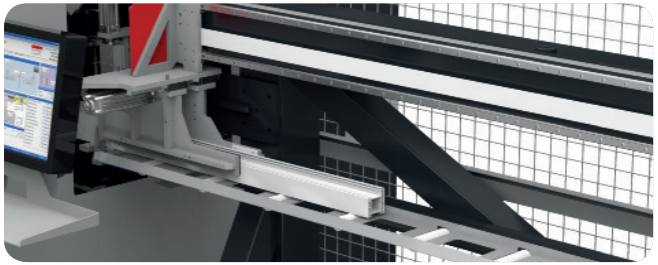


- Processing unit has 7 servomotor controlled axis.
- Handle, cylinder holes and water slot canals are performed double sided at the same time.

* When the hardwares are changed or added, process times may vary.

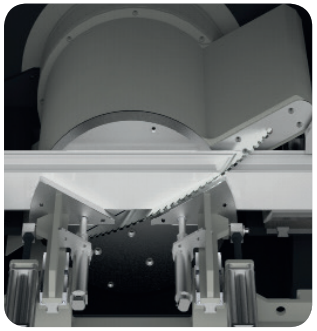
FA 1010 Profile Processing and Cutting Center

Profile Transfer Unit



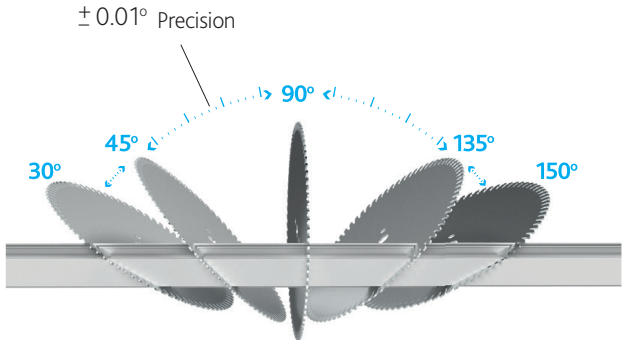
- Conveys the processed profiles to cutting unit.

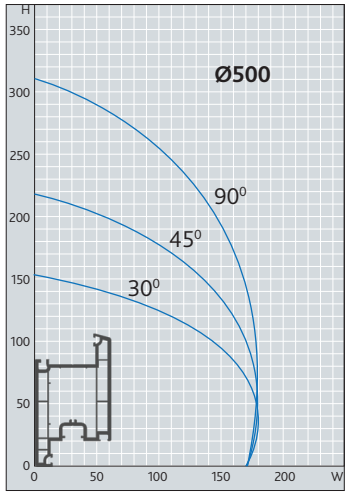
Profile Cutting Unit





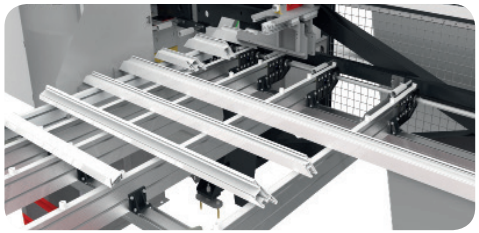
- Servo controlled cutting unit. Progress speed and distance can be adjusted for each profile separately.
- Long lasting saw thanks to special working system.





FA 1030 Profile Processing, Cutting and Screwing Center

Profile Unloading Unit

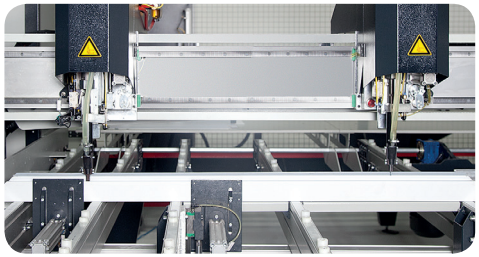


- Output robot conveys the cut profiles on conveyor automatically.



- The operator sticks the barcode on cut pieces to prepare for next operation.

Profile Screwing Unit



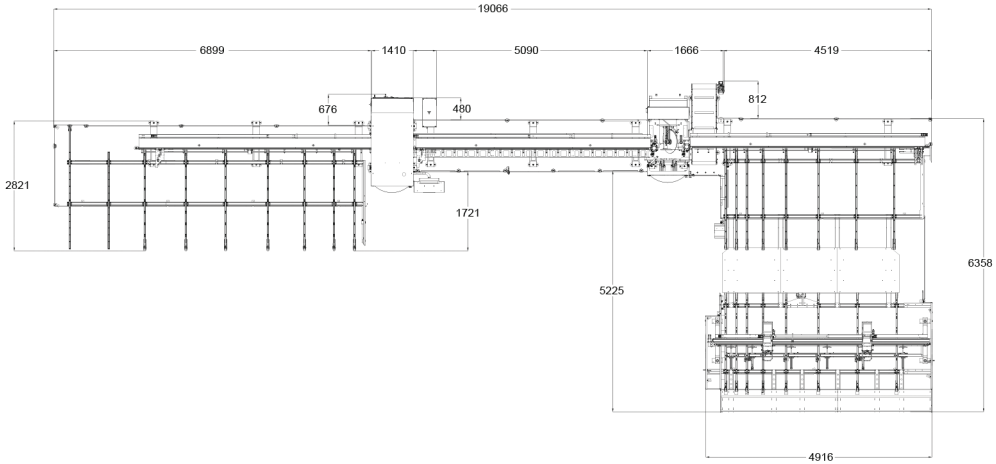


- Used on FA 1030.
- Screwing conveyor conveys the profile to screwing unit.
- Servo controlled double head screwing unit screws according to profile length and operations made on profile.
- Profile Length to be screwed: Minimum: 340mm maximum 4360mm.

Technical Features

		FA 1010	FA 1030
Profile Loading Unit			
	Servo Motor	1 x 1,5 kW	1 x 1,5 kW
	Rapid Speed	320 m/min	320 m/min
	Loading Conveyor	1 x 0,75 kW	1 x 0,75 kW
Profile Processing Unit			
	X Axis Servo Motor	2 x 0,75 kW	2 x 0,75 kW
	Y Axis Servo Motor	2 x 0,40 kW	2 x 0,40 kW
	Z Axis Servo Motor	2 x 0,75 kW	2 x 0,75 kW
	B Axis Servo Motor	1 x 0,40 kW	1 x 0,4 kW
	Spindle Motors	4 x 0,75 kW 18000 d/d	4 x 0,75 kW 18000 d/d
	X-Y-Z Axis Rapid Speeds	30 / 60 m/min	30 / 60 m/min
	B Axis Angle	-60° +30° 0,1 accuracy	-60° +30° 0,1 accuracy
Profile Transfer Unit			
	Servo Motor	1 x 1,5 kW	1 x 1,5 kW
	Rapid Speed	320 m/min	320 m/min
Profile Cutting Unit			
	Y Axis Servo Motor	1 x 0,40 kW	1 x 0,40 kW
	B Axis Servo Motor	1 x 0,40 kW	1 x 0,40 kW
	B Axis Angle	-60° +60° 0,1 prec.	-60° +60° 0,1 prec.
	Y Axis Rapid Speed	30 / 60 m/min	30 / 60 m/min
	Saw Motor	1x / 1,5 kW 2800 d/d	1x / 1,5 kW 2800 d/d
Profile Unloading Unit			
	Servo Motor	1 x 1 kW	1 x 1 kW
	Rapid Speed	320 m/min	320 m/min
	Unloading Conveyor	1 x 0,75 kW	1 x 0,75 kW
Screwing Unit			
	X Axis Servo Motor		2 x 0,40 kW
	X Axis Rapid Speed		30 m/min
	Loading Conveyor		1 x 0,75 kW
Machine Dimensions			
	Height	2230 mm	2230 mm
	Width	4250 mm	7200 mm
	Lenght	19070 mm	19070 mm
	Weight	5500 kg	7500 kg
Air			
	Pressure	6 - 8 bar	6 - 8 bar
	Consumption	150 l / cycle	250 l / cycle
Screen			
		lcd 17"	lcd 17"
Communication			
		Ethernet	Ethernet
		Usb	Usb
Software			
		KabanCad	KabanCad
		Windows 7	Windows 7
Electricity			
	Voltage	400V (L1-L2-L3-N-PE) 50/60 Hz	400V (L1-L2-L3-N-PE) 50/60 Hz
	Power	15 kW	16,55 kW

Machine Layout

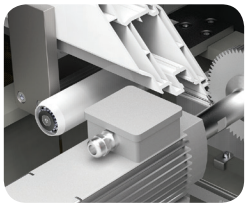


Optional Equipments



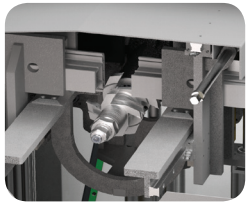
- PTR 200 Shelved Profile Trolley

  It is designed to stock properly and carry the cut profiles easily.



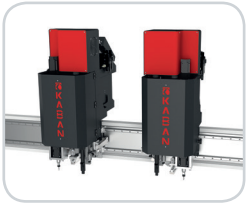
- L 100 Gasket Cutting

  Cuts the welding chips under the gaskets.



- OK 100 End Milling Unit

  End milling of 2 profiles at the same time after the cutting unit.



- H 500 Screwing and drilling unit.

* Ok 100 and L 100 options can not be installed to the same machine.