

CNC Drill-saw machine MPS2600

Starting point: max material width: 80 mm

Exchange parts must be easily exchangeable.

Inkjet coder is not replaced.

Supply:

-The push-on gripper must be adjustable in the Y-direction with the handwheel, adjustment range 50 mm is sufficient.



-Pusher grip narrower at the back due to the blade.

- Adjust the bottom of the gripper plate, approx. 3 mm thick because of the blade

Adjust the feed magazine so that the width between the cams becomes 80 mm. Existing cams are transferred to new tires and additional cams are added.



This makes it possible to insert profiles in about 10 warehouse positions against 6 pieces in an existing set-up. 4 new tires with partly new cams. The 4 minitek 90x90 support profiles must be extended approximately 10 to 20 cm.

Roller conveyor rollers replaced by narrower rollers with a roll width of approx. 90 mm. The roller supports should also be replaced. A total of about 16 pieces.

Vertical rollers of the feed conveyor need to be higher, new supports and new rollers. Total about 10 pieces.

- 4 orientation cylinders equipped with a quick-change system for the div profiles to orient profiles with respect to the push-up gripper.

Sawing machine:

- extension with horizontal drill from the rear. New DP 10 A, height adjustable with existing dovetail table. Can be mounted on the side of the saw on minitec 90x180

- various interchangeable blocks on horizontal saw clamps

- vertical clamp on discharge side replaced by clamp with longer stroke and side guide.

- provision on saw bed to screw on exchangeable parts.

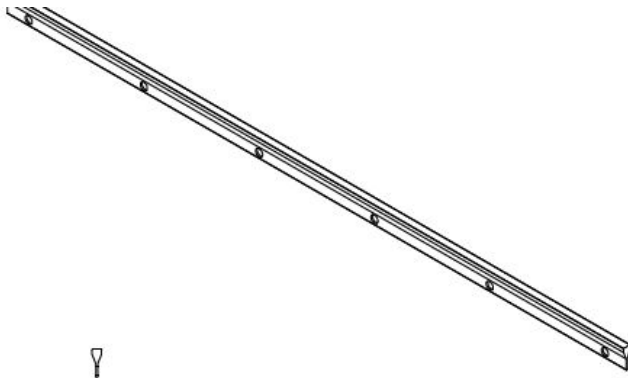
- check machine.

Drain:

- stripping cylinder provided between the first roll of the discharge conveyor and the 1st discharge conveyor to ensure that profiles that lean on the rear block of the discharge grab are stripped when the discharge grab moves towards the saw.

- waste grab equipped with a quick-change system for quick placement of product-specific blocks, e.g. by means of a dovetail.

Adjustment for blade punching:



- vertical pneumatic punch unit for hole 6.55 ??? Positioning accuracy becomes very important here! In the current situation, all blades are punched on a punching machine, so that mutual inaccuracy is less important, the pitch compared to the other blades is exactly the same.

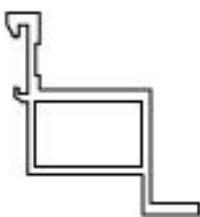
- punch unit must stand on lin guide, 2 positions: front / rear. stroke approx. 100 mm. the unit is pulled forward

Adjust gripper to grab this profile.

Orientation blocks on supply track

Interchangeable strips on sawbed, 2 x length approx. 0.5 m

For outer frame floor grille:



Horizontal drilling unit from the front or rather from the rear for holes 4 mm.

Optional: keep existing drilling unit from above for drilling 3.5 mm holes

Orientation blocks on supply track

Interchangeable strips on sawbed, 2 x length approx. 0.5 m

Interchangeable blocks on discharge grab

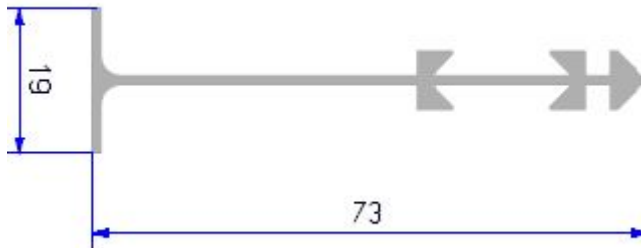
For outer frame wall grille:

Orientation blocks on supply track

Interchangeable strips on sawbed, 2 x length approx. 0.5 m

Interchangeable blocks on discharge grab

For Middle pillar 73x19:



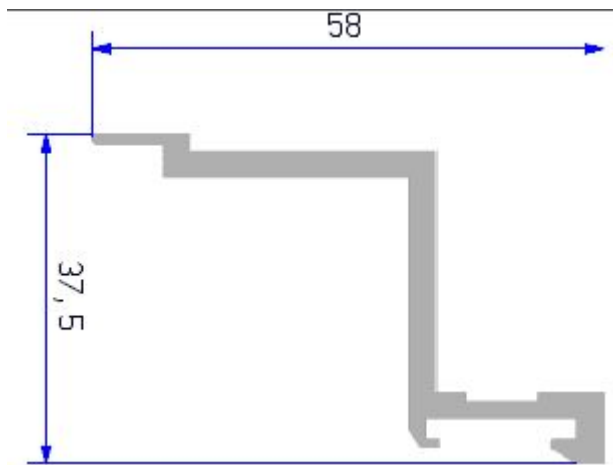
Straight cut (optional miter)

Orientation blocks on supply track (looks the same as with outer frame wall grille)

Interchangeable strips on sawbed, 2 x length approx. 0.5 m

Interchangeable blocks on drain grab (looks the same as with outer frame wall grille)

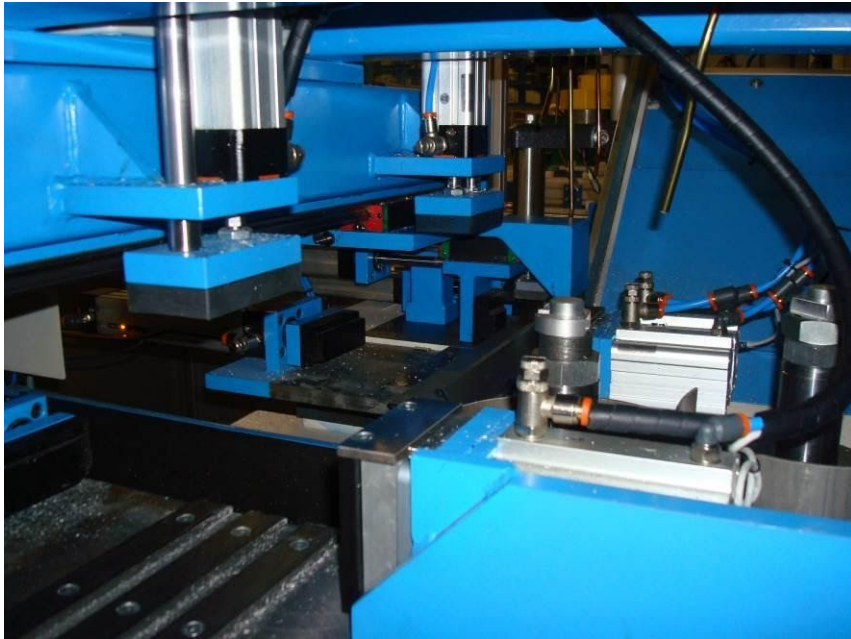
For frame 58x37.5:



Orientation blocks on supply track

Interchangeable strips on sawbed, 2 x length approx. 0.5 m

Interchangeable blocks on discharge grab



Control:

- PLC replaced by S-Dias in combination with PC 21 "touchscreen with MPS control.

- Post processor MPS Control
 - The progress can be followed in the program, including which products have already been made and how far the machine has progressed with the current product (ie). Manually operating the machine is also done in this program instead of on the PLC. '
 - Production orders can be automatically imported as a CSV file from the ERP system.

The control of the push-up system remains controlled via the PLC



-Safety:

point of further consultation with customers. The advice is to make the current door switches and hood switches redundant and to place a light screen at the front in front of the supply magazine. (now a walk-in photocell is provided).

Depending on the arrangement, fences must be expanded.

Milling units:

The milling units remain intact, and are not further adjusted.