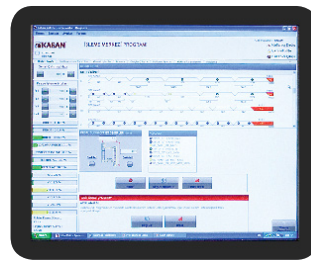


General Features

- 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



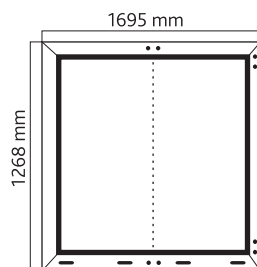
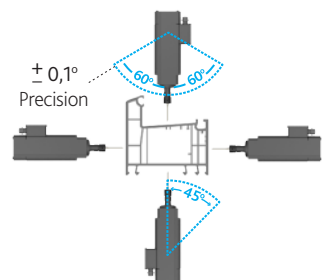
- User-friendly operating system compatible to all joinery and optimization programs.
- Minimum waste, maximum production algorithm.
- The wastes are optimized automatically in cutting list.
- Parameters are set easily.
- Different profiles and hardware can be configured and optimized.
- Periodical maintenance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

Profile Loading Unit



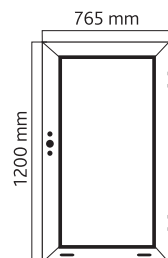
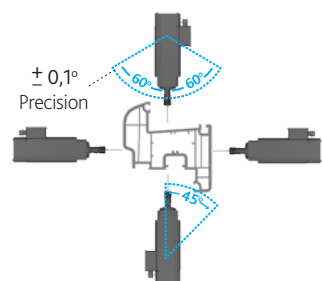
- Profile loading capacity: 9 profiles.
- Loading capacity can be increased optionally.
- Automatic profile recognition feature on profile conveyor and positioner.
- Profile Length: Minimum 850 mm – maximum 6.500 mm. (optionally eternal)
- Warning system to prevent wrong profile loading.

Profile Processing Unit



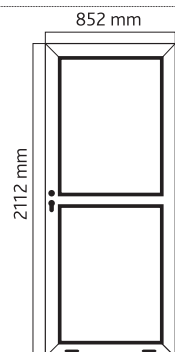
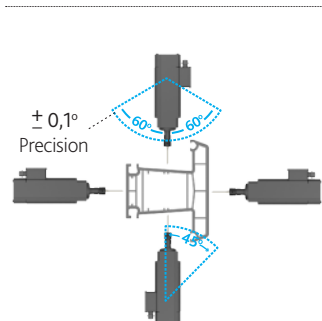
FRAME	Processing Time	Profile Length Quantity	Processed Running Meter	Process Symbols	Process Names
1 Frame	50.4 sn				+/-30° Cutting
10 Frame	8m 24s	10			Water Slot
571 Frame	8 Hour	571	3426		Striker
					Mullion Connector Hole

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 35s.	6,66			Water Slot
633 Frame	8 Hour	422	2532		Striker
					Window Handle Holes

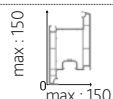
Calculated by processing 10 bars of sash profiles.



DOOR	Processing Time	Profile Length Quantity	Processed Running Meter	Process Symbols	Process Names
1 Frame	57.3 s				+/-30° Cutting
10 Frame	9mn 33s	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.

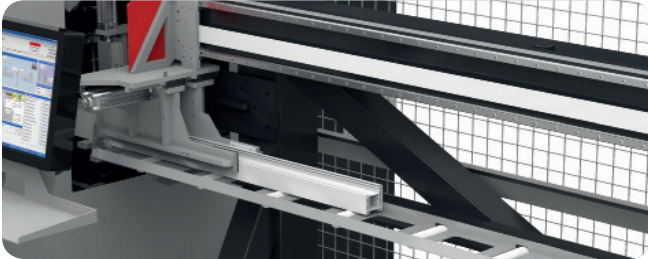
Processed profile dimensions:



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

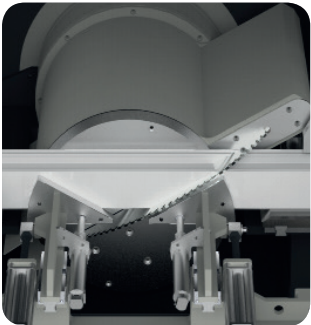
* When the hardwares are changed or added, process times may vary.

Profile Transfer Unit



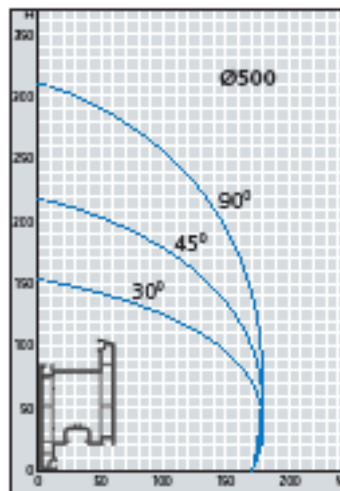
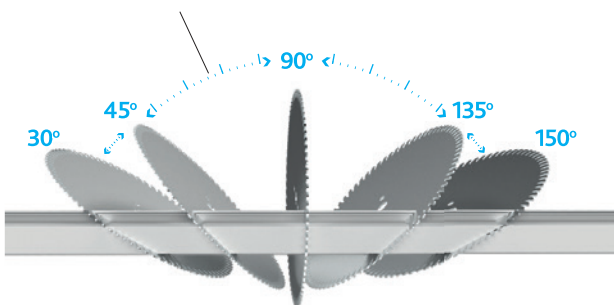
- Conveys the processed profiles to cutting unit.

Profile Cutting Unit

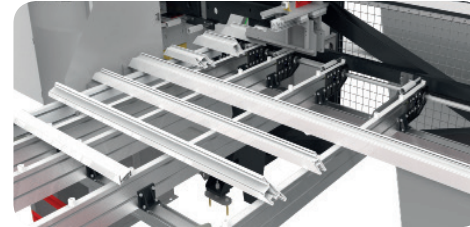


- Servo controlled cutting unit. Progress speed and distance can be adjusted for each profile separately.
- Long lasting saw thanks to special working system.

± 0.01° Precision



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



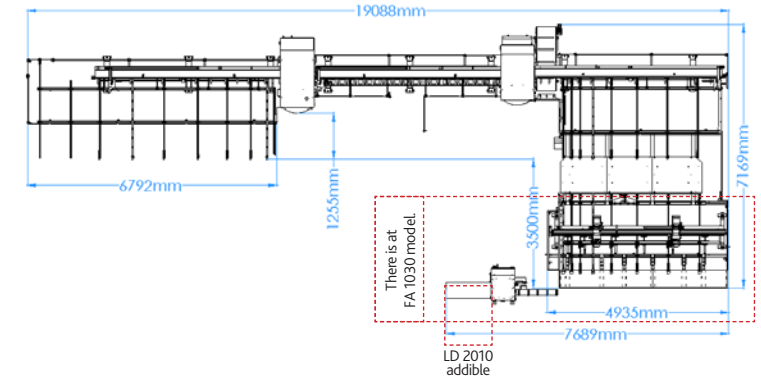
- Used on FA 1030.
- Screwing conveyor conveys the profile to screwing unit.
- Servo controlled double head screwing unit screws according to profile length and operations made on profile.
- Profile Length to be screwed: Minimum: 340mm maximum 4360mm.



Technical Features

	FA 1010	FA 1030
Profile Loading Unit		
Servo Motor	1x1,5 kW	1x1,5 kW
Rapid Speed	320m/min	320m/min
Loading Conveyor	1x0,75 kW	1x0,75 kW
Profile Processing Unit		
X Axis Servo Motor	2x 0,75 kW	2x 0,75 kW
Y Axis Servo Motor	2x 0,40 kW	2x 0,40 kW
Z Axis Servo Motor	2x 0,75 kW	2x 0,75 kW
B Axis Servo Motor	1x 0,40 kW	1x 0,40 kW
Spindle Motors	4x0,75 kW 18000 d/d	4x0,75 kW 18000 d/d
X - Y - Z Axis Rapid Speeds	30 / 60 m/min	30 / 60 m/min
B Axis Angle	-60° +60° 0,1 accuracy	-60° +60° 0,1 accuracy
Profile Transfer Unit		
Servo Motor	1x1,5 kW	1x1,5 kW
Rapid Speed	320 m/min	320 m/min
Profil Kesim Ünitesi		
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	-30° +150° 0,1 hass.	-30° +150° 0,1 hass.
Y Axis Rapid Speed	30 / 60 m/dak	30 / 60 m/dak
Saw Motor	1x / 1,5 kW 2800 d/d	1x / 1,5 kW 2800 d/d
Profile Unloading Unit		
Servo Motor	1x1 kW	1x1 kW
Rapid Speed	320m/dak	320m/dak
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 Hz		30 m/dak
Loading Conveyor		1 x 0,75 kW
Makina Ölçüleri		
Height	2230 mm	2230 mm
Width	4250 mm	7445 mm
Lenght	19070 mm	19070 mm
Weight	5500 kg	7500 kg
Air		
Pressure	6-8 bar	6-8 bar
Consumption	270 l/dak	450 l/dak
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.



- BR 200 Barcode Reader
Transfers profile information to screwing unit.



- OK 100 End Milling Unit
End milling of 2 profiles at the same time after the cutting unit.



- L 100 Gasket Cutting
Cuts the welding chips under the gaskets.