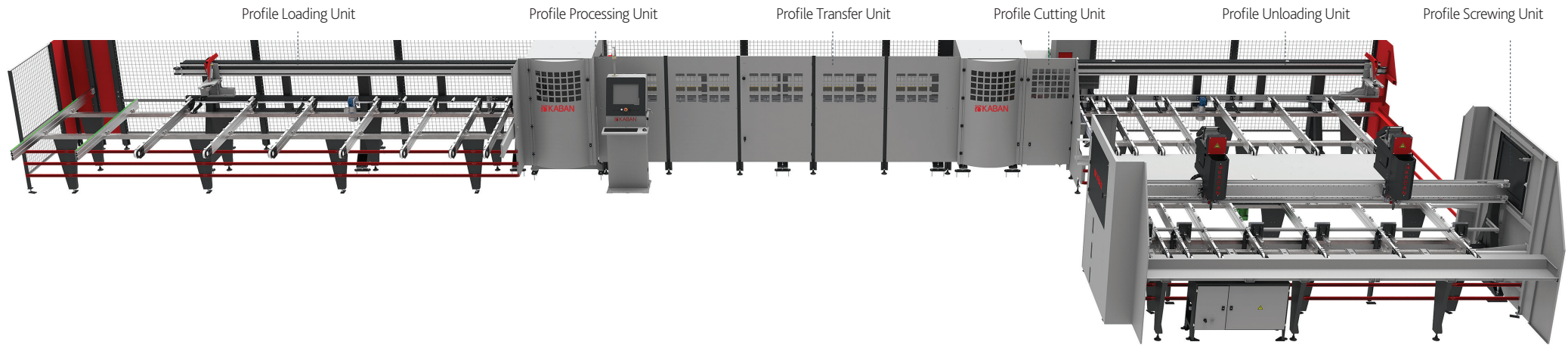


FA 1010

Profile Processing and Cutting Center

FA 1030

Profile Processing, Cutting and Screwing Center



General Features

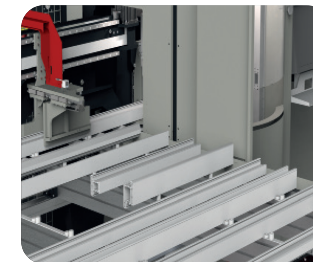
- Robust mechanical design suitable for high speed operations.
- Maximum performance with high quality materials used on production.
- High capacity thanks to independent operation of processing, cutting and screwing units.
- FA 1030 processing, cutting and screwing center has servomotor controlled 14 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



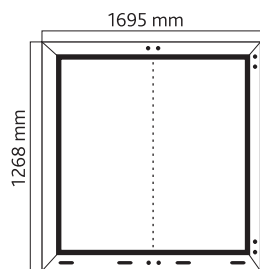
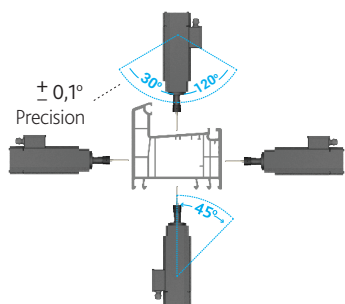
- User-friendly operating system compatible to all joinery and optimization programs.
- Minimum waste, maximum production algorithm.
- The wastes are optimized automatically in cutting list.
- Parameters are set easily.
- Different profiles and hardwares can be configured and optimized.
- Periodical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

Profile Loading Unit



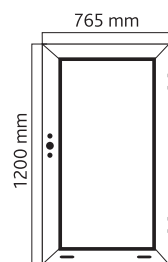
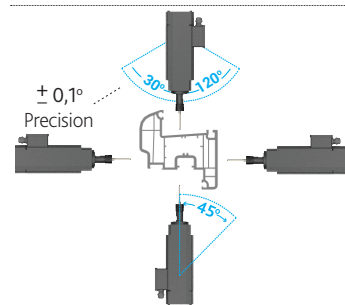
- Profile loading capacity: 9 profiles.
- Loading capacity can be increased optionally.
- Automatic profile recognition feature on profile conveyor and positioner.
- Profile Length: Minimum 800 mm – maximum 6.500 mm. (optionally eternal)
- Warning system to prevent wrong profile loading.

Profile Processing Unit



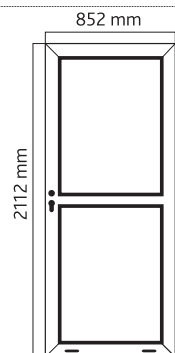
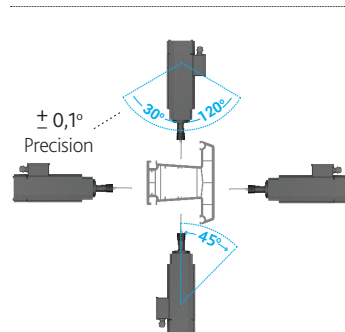
Frame	Processing Time	Profile Length Quan-	Processed Running Meter	Process Symbols	Process Names
1 Frame	50.4 sn.				+/-30°Cutting
10 Frame	8m 24 s	10			Water Slot
571 Frame	8 Hour	571	3426		Striker
					Mullion Connector Hole

Calculated by processing 10 bars of frame profiles.



Sash	Processing Time	Profile Length Quan-	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

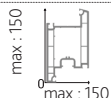
Calculated by processing 10 bars of sash profiles.



Door	Processing Time	Profile Length Quan-	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.

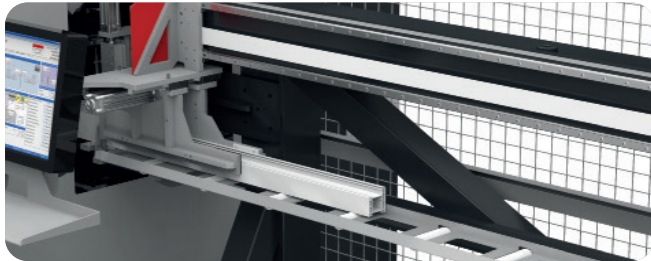
Processed profile dimensions:



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

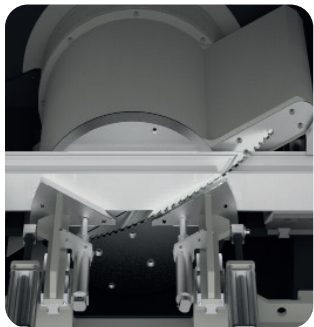
* When the hardwares are changed or added, process times may vary.

Profile Transfer Unit



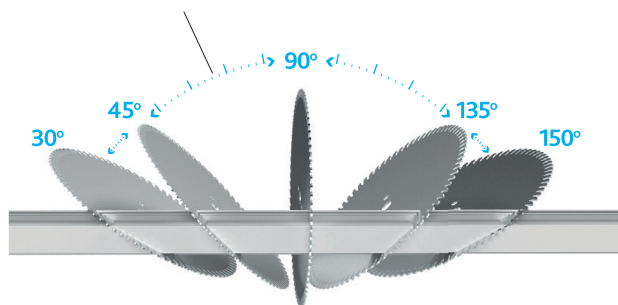
- Conveys the processed profiles to cutting unit.

Profile Cutting Unit

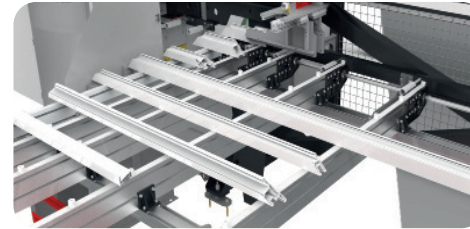


- Servo controlled cutting unit. Progress speed and distance can be adjusted for each profile separately.
- Long lasting saw thanks to special working system.

± 0.01° Precision



Profile Unloading Unit

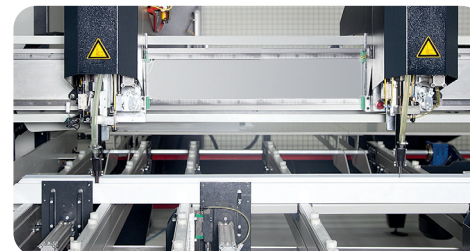


- Output robot conveys the cut profiles on conveyor automatically.



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

Profile Screwing Unit

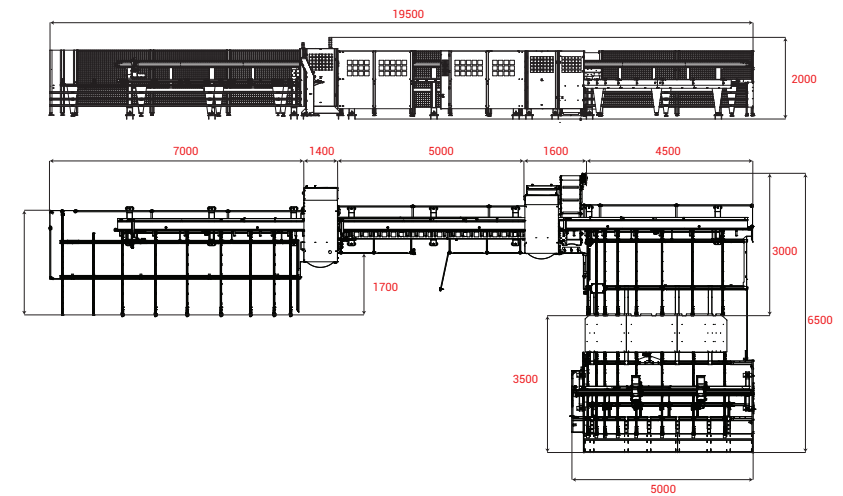
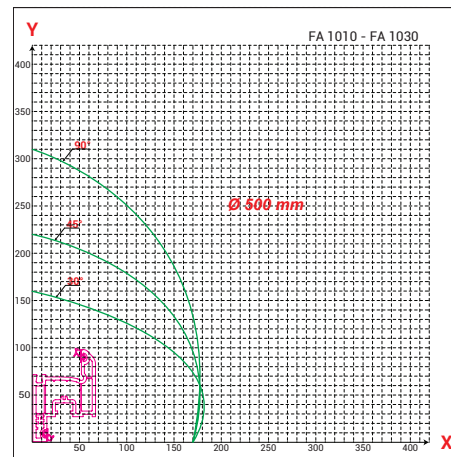


- Used on FA 1030.
- Screwing conveyor conveys the profile to screwing unit.
- Servo controlled double head screwing unit screws according to profile length and operations made on profile.
- Profile Length to be screwed: Minimum: 340mm maximum 4360mm.



FA 1010					
Motor Specifications	Power (kW)	Motor Speed (rpm)	Angular Speed (°/dk)	Axis Speed (m/dk)	Reducer
Loading Servo Motor	1,50	2000	-	320	
Loading Conveyor Motor	0,75		-		
Router X1 Axis Servo	0,75		-	30 - 60	
Router X2 Axis Servo	0,75		-	30 - 60	
Router Y1 Axis Servo	0,40		-	30 - 60	
Router Y2 Axis Servo	0,40		-	30 - 60	
Router Z1 Axis Servo	0,75		-	30 - 60	
Router Z2 Axis Servo	0,75		-	30 - 60	
Router B Axis Servo	0,40		60	-	
Spindle Motor 1	0,75	18000		-	
Spindle Motor 2	0,75	18000		-	
Spindle Motor 3	0,75	18000		-	
Spindle Motor 4	0,75	18000		-	
Transfer Unit Servo Motor	1,50	2000		320	
Cutting Motor Y Axis Servo	0,40		-	30 - 60	
Cutting Motor B Axis Servo	0,40		60	-	
Cutting Unit Saw	1,50	2800			
Unloading Unit Servo Motor	1,00		-	320	
Unloading Conveyor	0,75		-		

FA 1030					
Motor Specifications	Power (kW)	Motor Speed (rpm)	Angular Speed (°/dk)	Axis Speed (m/dk)	Reducer
Loading Servo Motor	1,50	2000	-	320	
Loading Conveyor Motor	0,75		-		
Router X1 Axis Servo	0,75		-	30 - 60	
Router X2 Axis Servo	0,75		-	30 - 60	
Router Y1 Axis Servo	0,40		-	30 - 60	
Router Y2 Axis Servo	0,40		-	30 - 60	
Router Z1 Axis Servo	0,75		-	30 - 60	
Router Z2 Axis Servo	0,75		-	30 - 60	
Router B Axis Servo	0,40		60	-	
Spindle Motor 1	0,75	18000		-	
Spindle Motor 2	0,75	18000		-	
Spindle Motor 3	0,75	18000		-	
Spindle Motor 4	0,75	18000		-	
Transfer Unit Servo Motor	1,50	2000		320	
Cutting Motor Y Axis Servo	0,40		-	30 - 60	
Cutting Motor B Axis Servo	0,40		60	-	
Cutting Unit Saw	1,50	2800			
Unloading Unit Servo Motor	1,00		-	320	
Unloading Conveyor	0,75		-		
Screwing X Axis S. Motor 1	0,40			30	
Screwing X Axis S. Motor 2	0,40			30	
Screwing Conveyor Motor	0,75				



FA 1010

400 V (50-60 Hz) (kW)	6-8 bar (t/dk)	kg	W x L x H (mm)	L (min.) x L (max.) (mm)	a x h (mm) (min.)	a x h (mm) (max.)	ØD x Ød x b (mm)
15	150	4779	19500 x 3000 x 2000	400 x 6500	40 x 40 20 x 20	150 x 150 160 x 160	500 x 30 x 4,0

FA 1030

400 V (50-60 Hz) (kW)	6-8 bar (t/dk)	kg	W x L x H (mm)	L (min.) x L (max.) (mm)	a x h (mm) (min.)	a x h (mm) (max.)	ØD x Ød x b (mm)
16,55	420	6159	19500 x 6500 x 2000	8500 x 400 x 6500	40 x 40 20 x 20	150 x 150 160 x 160	500 x 30 x 4,0

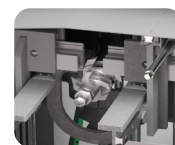
Optional Equipments



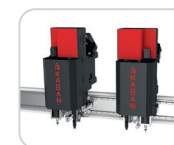
- PTR 200 Shelved Profile Trolley It is designed to stock properly and carry the cut profiles easily.



- 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.