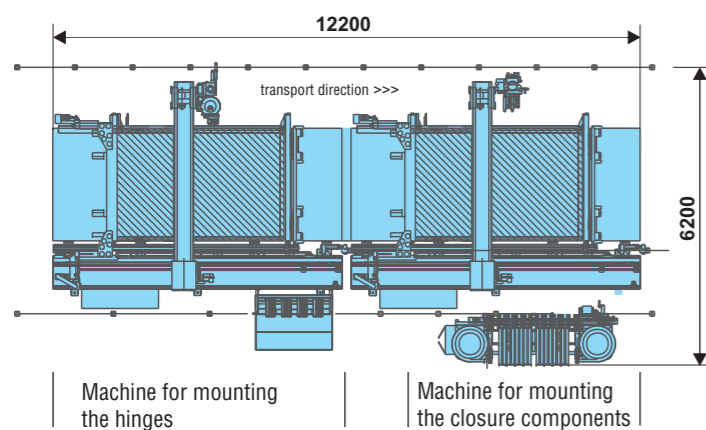


Technical Data

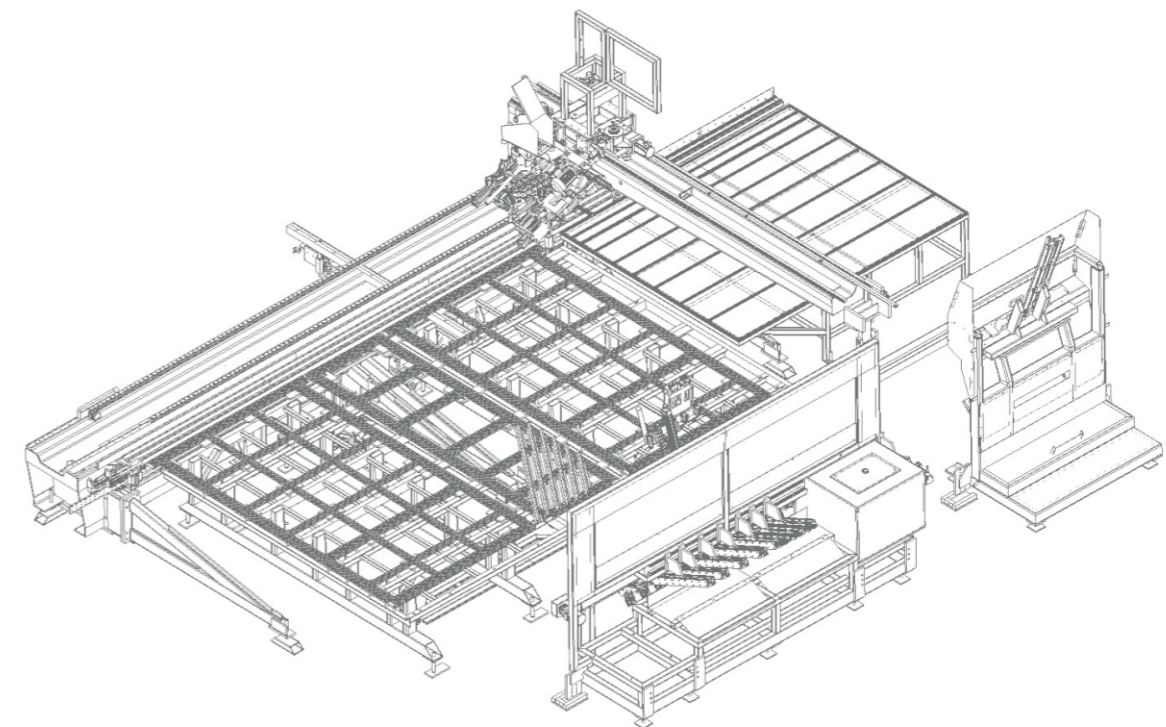
Window size: minimum clear opening	330 mm x 330 mm
Window size: maximum (theoretical welding measure outside)	3500 mm x 2500 mm
Total connected wattage	Standard plant: 8,5 kW High-speed plant: 13,4 kW
Working pressure	6 bar
Air consumption	Standard plant: 950 l / 6 bar High-speed plant: 1100 l / 6 bar

Fully automatic frame fittings mounting on the window element



1-minute cycle High-speed configuration

Model with 2 crossbars, each supporting one mounting head, as well as 2 work tables for simultaneous machining of two supported frames



For frames 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 and harmonised down to the last detail:

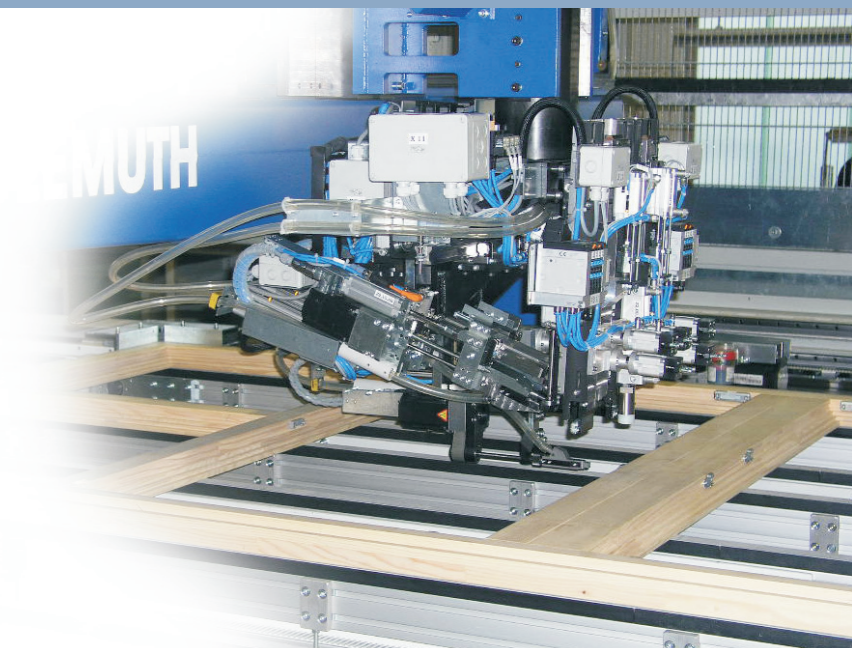
- Project management
- System planning
- Factory planning
- construction
- Electrical project management
- Component production
- Installation
- Start-up
- Staff training
- Documentation

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_281 Prospekt RBA330_2014_englisch - Technical modification reserved



RBA330

Frame Fitting Mounting Centre

Adjustable for any type of fitting, for all frame fittings suitable for use in automatic systems

RBA330 series frame fittings mounting machines fully automatically mount and bolt all hinge and closure components on frame elements made of pvc, wood or aluminum. The closure components are supplied by means of oscillating conveyors and the gravity chute magazine for the hinges is filled manually.

Comfortable equipment

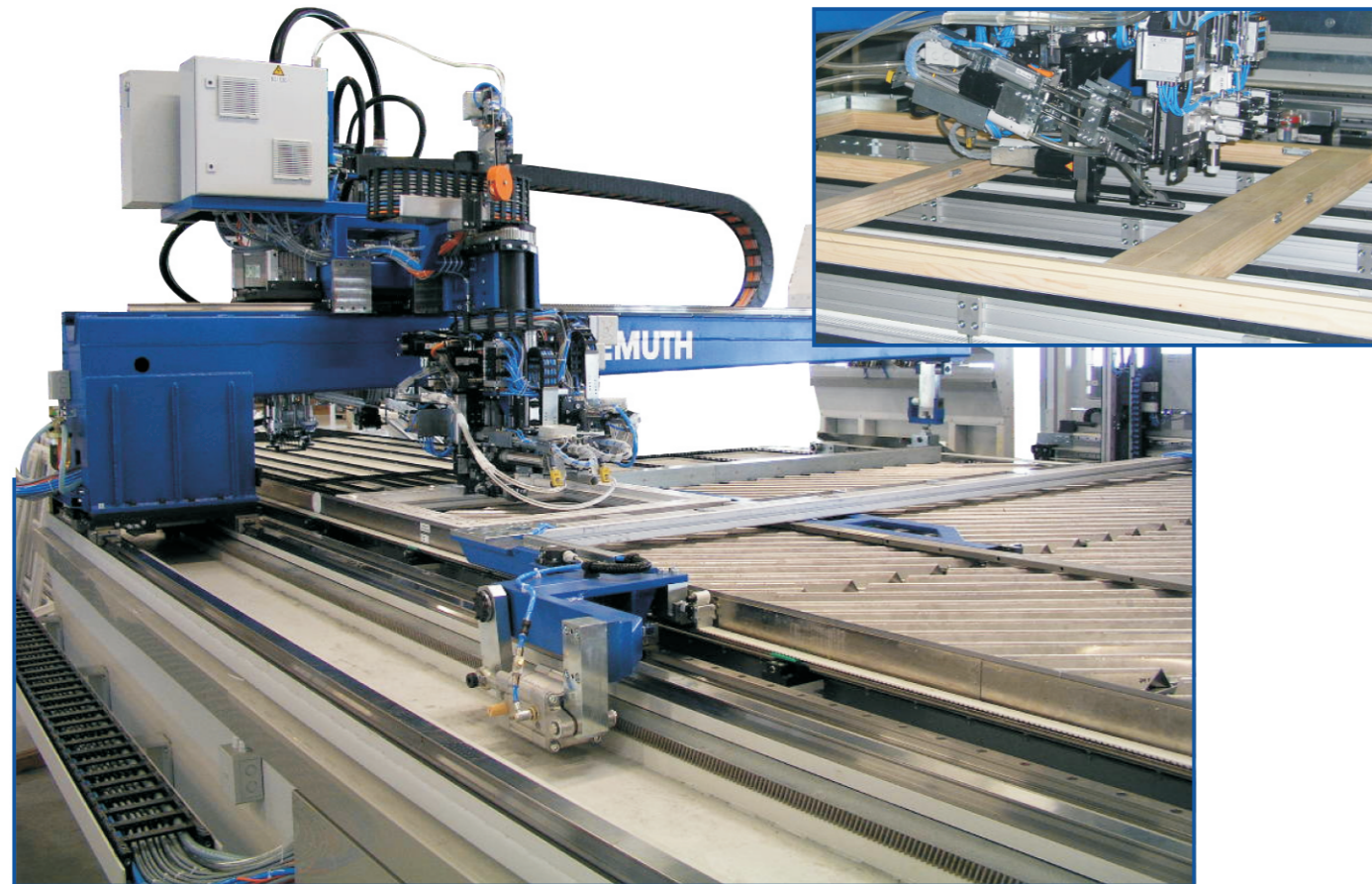
The plant has separate mounting heads for mounting the keeper and mounting the bearings for sash hinges. These mounting heads are equipped with several drilling and screwing units which work independently.

Complex manufacturing technology with patented frame fitting and hopper logistics

Hoppers (insert or feed hoppers) or oscillating conveyors are used to place the mounting frames. The hoppers are tipped according to the parts and outside the safety stop. So the operator's work is simplified very much. During the processing of the current frame the control system takes over the part data from the offset plant for the following frame which has to be processed. Thus the gathering of information and the supply of all lock furniture for the next frame processing is done in one cycle before the actual mounting.

High flexibility in production

The automatic can feed frames of different sizes professionally on horizontal and vertical legs with lock furniture. The processing of door frames and crosses goes without saying. The theoretically maximum number of panels is 99 panels.



Equipment of mounting head for keepers

- two independent drilling units for first drilling of screw holes for single and double drilling
- two independent screwing units for single and double screwing
- two storage hoppers for narrow and wide keepers
- one servo controlled depth advance for mounting the keepers
- one servo controlled depth advance for positioning the drilling and screwing units

Equipment of mounting head for hinge bearings

- two storage hoppers to receive all corner and shearing bearings which have to be processed on the following part
- sixfold drilling head with 90° swivelling unit
- quadruple screwdriver with 90° swivelling unit
- measurement equipment to find out deviations from the theoretical nominal sizes, which arise from profile tolerances or mounting faults in the frame production. With these values an automatic calculation of the correction values for the following exact mounting of the corner and shearing bearings on frames, door frames and crosses.

Variable arrangement of hoppers

The hoppers can alternatively be arranged before or behind the machine. As standard the plant can process maximally 4 different bearings and 12 different keepers.

Wide variety of keepers

The plant sets all the necessary lock furniture on the frame, e.g. keepers, leading supports, balcony door latch bolts, automatic lock, corner bearings, shearing bearings.

Precise, high-exact frame processing

High-exact NC placing facilities ensure the exact delivery of all processing points at the frame. After delivering the positions of the grooves the parts are mounted and all necessary processes such as first drilling, setting and screwing up the mounting frames. The delivery of different screwing appliances to the mounting places is done by servo control.

RBZ332

Mounting of fittings frame *on the detached bar*



Mounting of closure components on the detached bar

This fittings mounting centre mounts and bolts all closure components on the detached bar. The machine is best positioned immediately after the bar cutting. The system can thus be easily integrated into a LEMUTH unicut 200 cutting and machining centre. This configuration can also be used as a standalone system. The user-friendly provisioning of the closure components is carried out via feed magazines and oscillating conveyors.