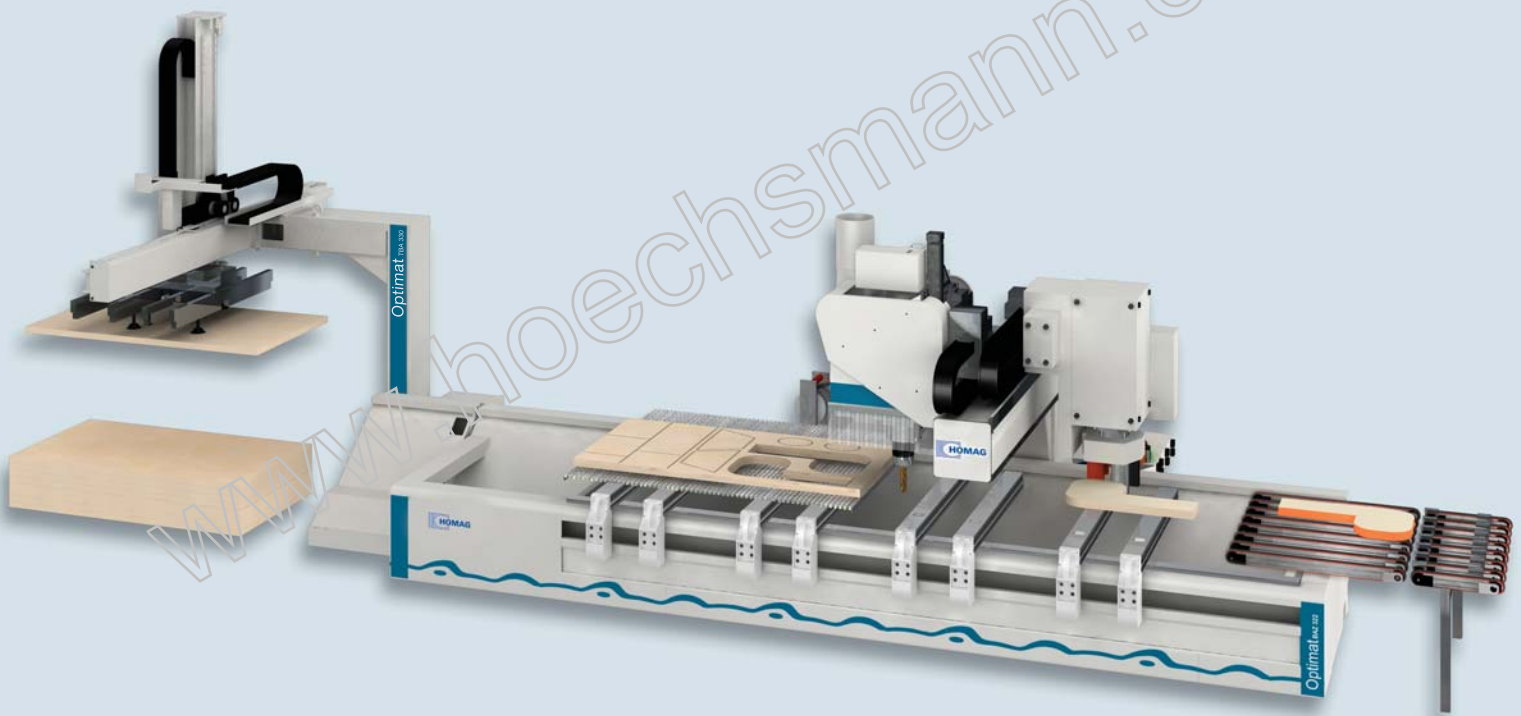


Lean**Factory**



The complete workshop for complete furniture production

Optimat | profi line | power line



Lean**Factory** – a single machine for every production step



The concept: greater productivity with the combo pack
From now on all you need is one machine instead of four to cover all your furniture production requirements: **The LeanFactory**. This innovative combination of processing center and panel saw means profit right from the word go:

- Reduced investment costs through the acquisition of just one machine
- Maximum productivity through complete processing without transport and handling costs
- 30% faster, more economical production through optimized process control
- Minimal space requirement
- Low-manned production, meaning more efficient deployment of staff for other tasks
- Modular system with scope for step-by-step upgrading

The knack:

A single loading operation, complete processing

The LeanFactory automatically runs through the whole work sequence in a single pass:

1. The nesting process takes care of cutting, shaping and vertical processing
2. The complete finish – part separation, horizontal and edge processing including edge banding

The benefits for you:

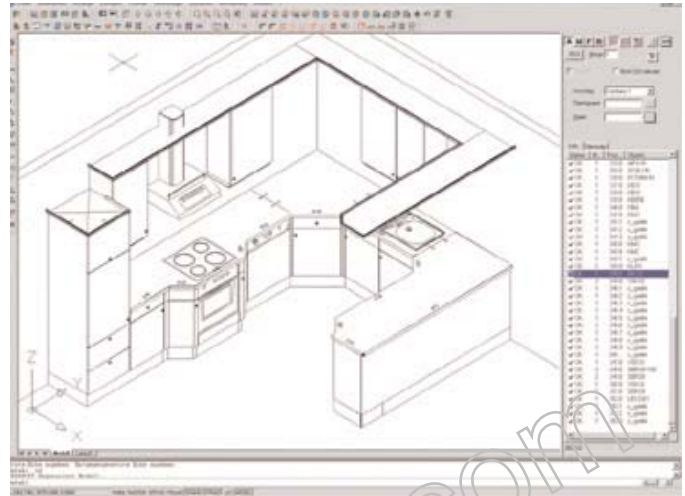
- No panel dividing required – lower costs, less space requirement
- One loading operation, no more restacking – time savings plus increased productivity
- Absolute shaping flexibility for series and particularly single component processing
- More efficient processing center capacity utilization

The ideal solution for every assignment – complete software

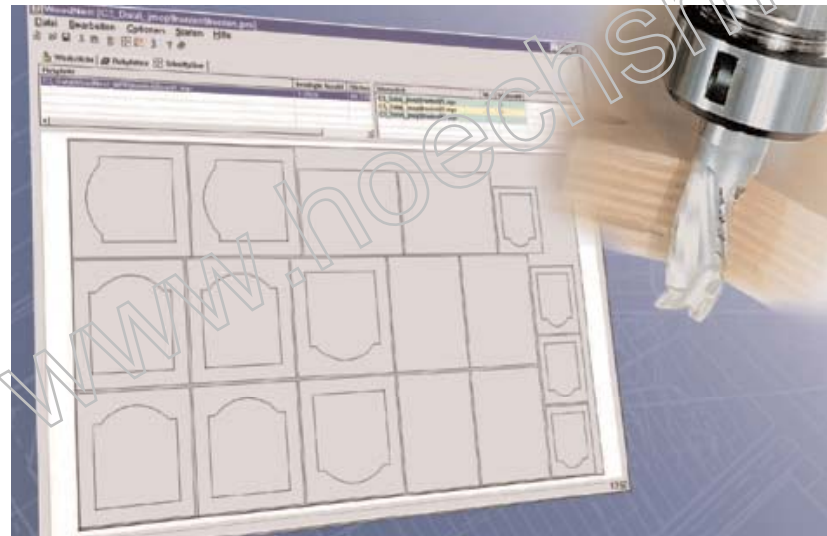
woodProcess – the software package for design and production

provides graphic planning, commercial order processing and comprehensive data preparation for production with the LeanFactory

- Design with product catalogues using CAD
- Compilation of quotations including cost estimation
- Automatic calculation of components such as worktops
- Collation of orders for production optimization
- Compilation of parts lists through to the purchase order stage
- Generation of woodWOP programs for all individual components at the press of a button



Graphics aided kitchen design



woodNest – the software module for optimum cutting

- Material optimization, also for shaped components
- Optimization of cutting paths for reduced production times
- Data preparation for woodWOP

woodWOP – the control software for perfect handling

In conjunction with the power control PC 85 control system

- Individual processing steps including edge banding are automatically generated
- Clamping element positions are precisely determined
- Handling programs are generated for the loader TBA 330 and transport of finished workpieces out of the machine
- Job list control for automatic sequential processing of raw panels
- Part identification by means of bar code



Ingeniously engineered details for top performance

New: Loader TBA 330

- Patented handling solution for extension arm machines
- Positions raw panels on the machine table for dividing using the nesting technique
- Utilizes the processing center's high-performance **power** control PC 85 system without additional programming input

Handling reliability

The intelligently selected optional equipment offers an outstanding degree of process reliability.

- The optical drop sensor recognizes additionally adhering panels
- Pneumatic pressure tappets prevent the panel slipping on release by the suction cups



The raw panels (up to 2,800/2,100 mm) are positioned on an MDF vacuum spoil board.

Matrix adapter panel

The matrix adapter panel turns the processing center into a "panel dividing center" (retrofitting possible at any time).



Workpiece gripper

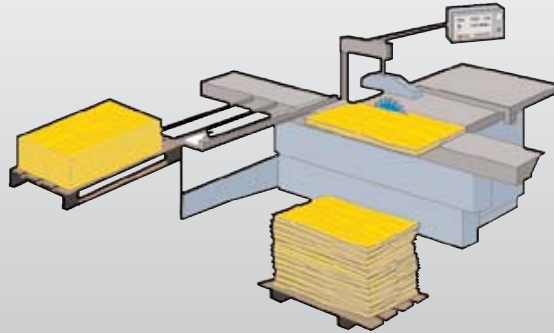
The newly developed workpiece gripper permits the sized parts to be transported individually from the grid table top into the processing area.

LeanFactory – Time savings all the way down the line

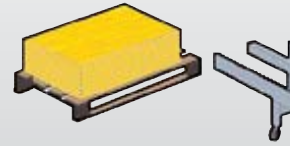
Previously: Four machines – 100% production time



Production engineering



Sawing + transport



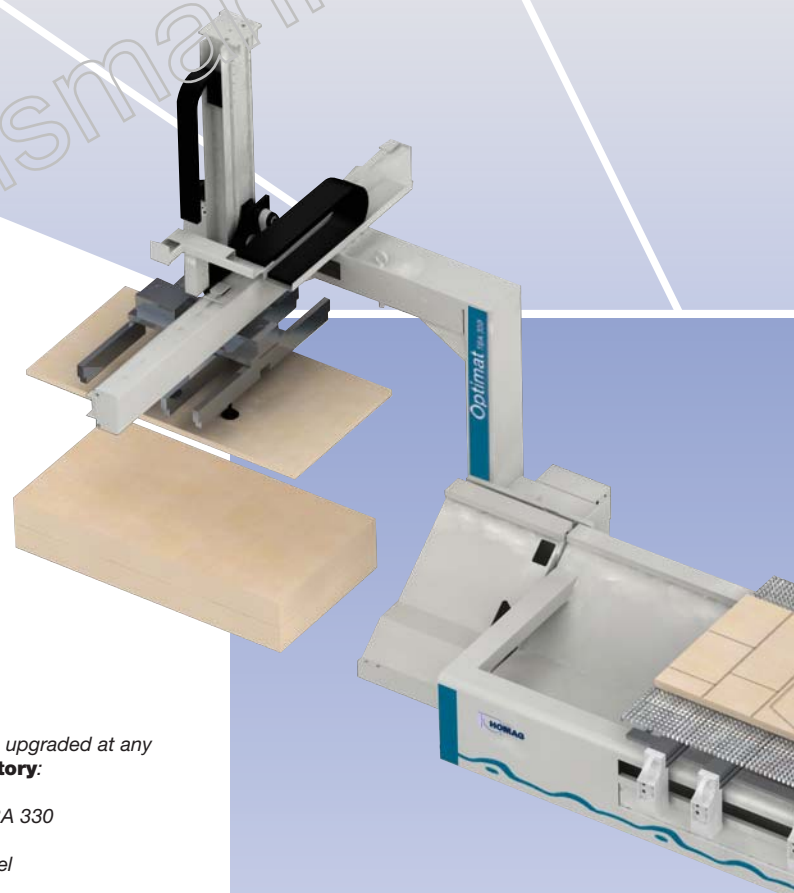
Edge

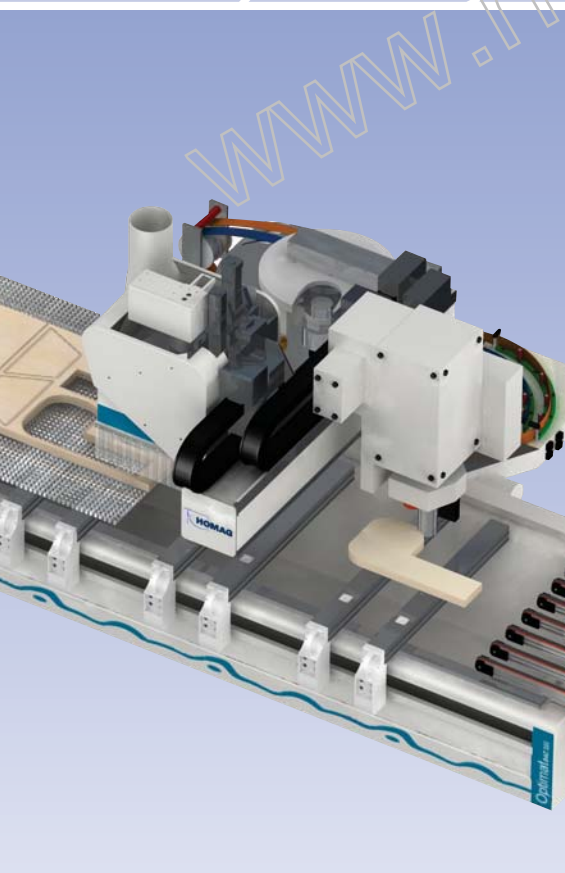
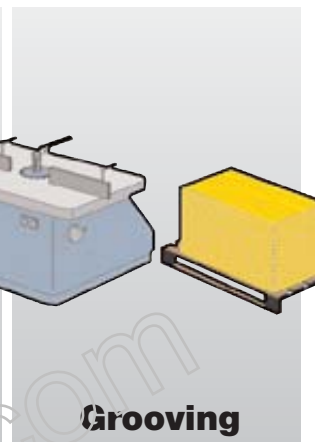
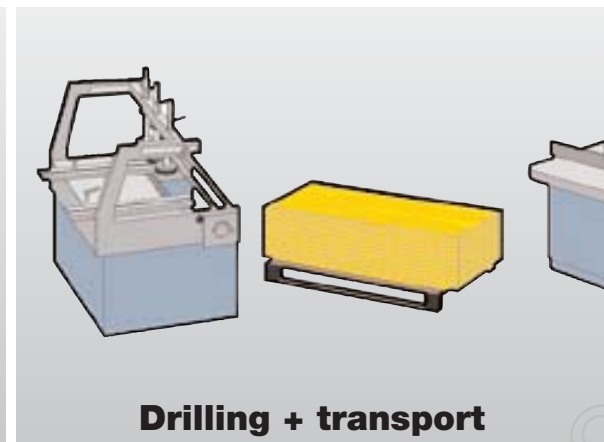
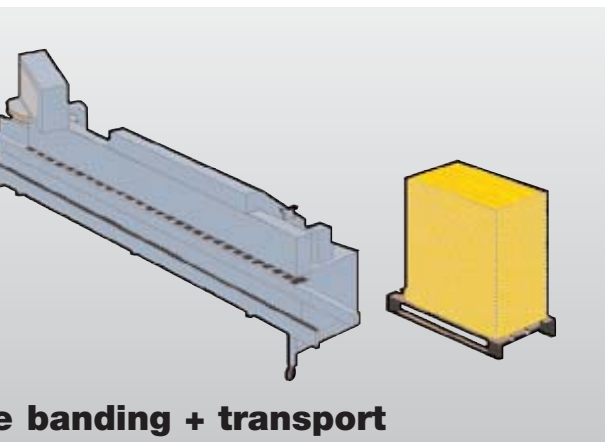
Faster, more flexible, more effective

The LeanFactory cuts out time-consuming restacking and transportation from one machine to the next. Which in conventional machines accounts for around 30% of the overall processing time. Another bonus: Your operating personnel can be more effectively deployed elsewhere. Which means faster, more cost-effective production.

At the entry level:
Our BAZ 322 can be upgraded at any
time into a LeanFactory:

- Loading system TBA 330
- Matrix adapter panel
- Workpiece gripper and roller table as
stock for several workpieces





**One machine does all:
The LeanFactory
30% more profitability**

An investment which pays dividends

Patented AutoClamp console table

permits automatic table set-up. The benefits for you:

- Reduced downtimes due to resetting during workpiece changeover
- High output even for batch size 1 production
- Versatile vacuum clamp available for different workpiece geometries
- Scope for flexible upgrading up to a production cell

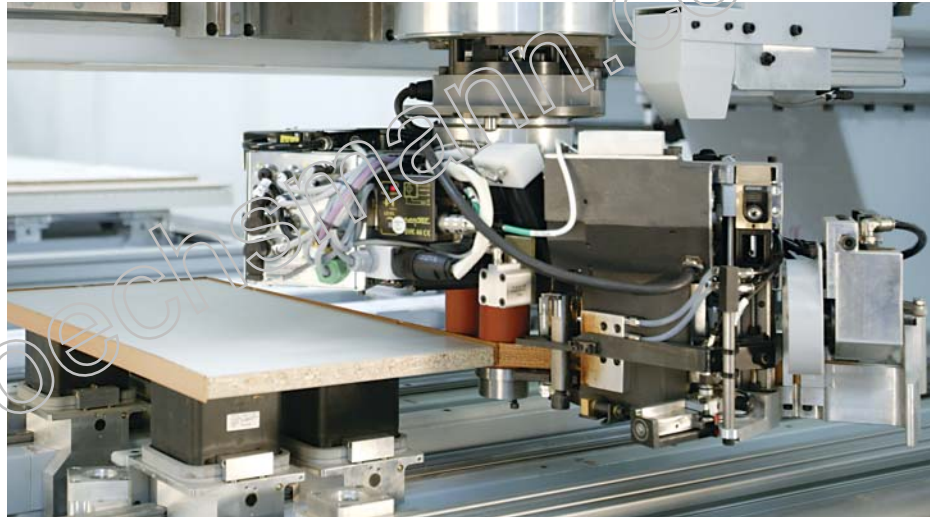


Modular drilling technology

Different drilling heads with variable speed of up to 7,500 rpm and a spindle locking mechanism for extremely high loads, such as with HPL processing. The wide range of add-on units available permits drilling heads to be upgraded in line with your specific needs. A supplementary routing spindle permits the deployment of tools such as a special router bit without the need for a working spindle tool change.

Gluing technology

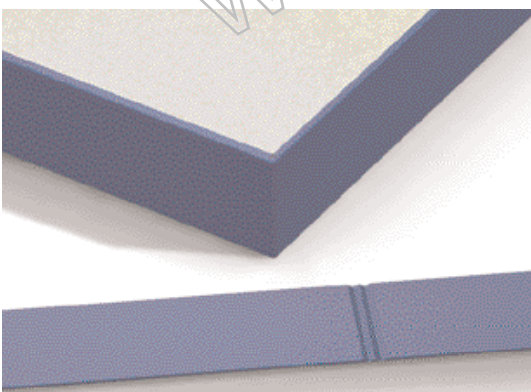
The gluing unit turns the processing center into an edge banding machine for workpieces in any shape and with any type of edging.



Edge folding

This revolutionary new technique ensures:

- edging of rectangular workpieces in a single operation
- perfect workpiece appearance
- up to 35% time savings



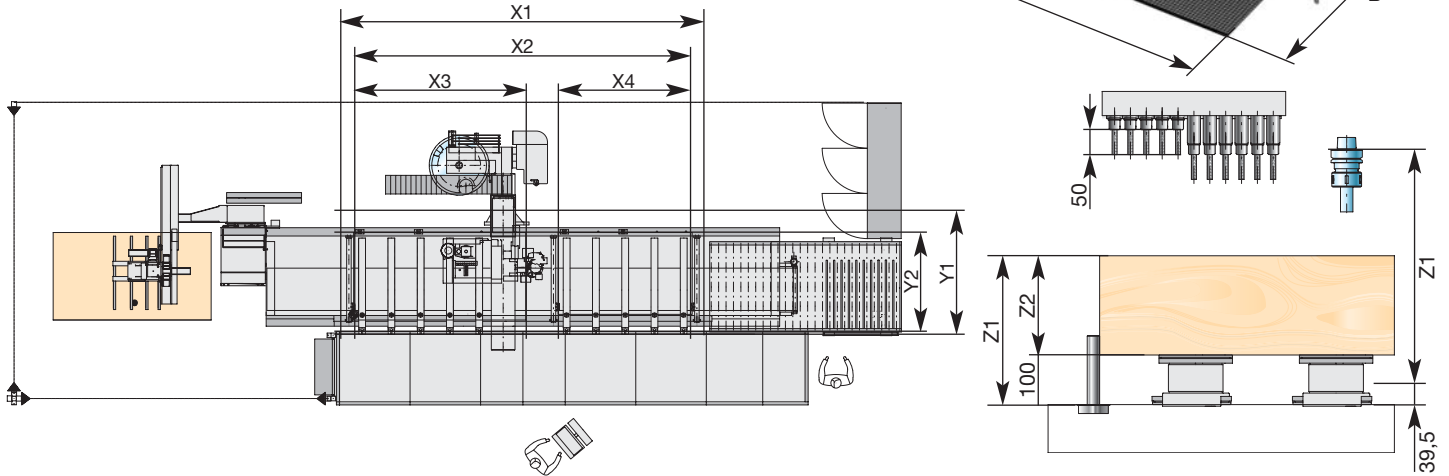
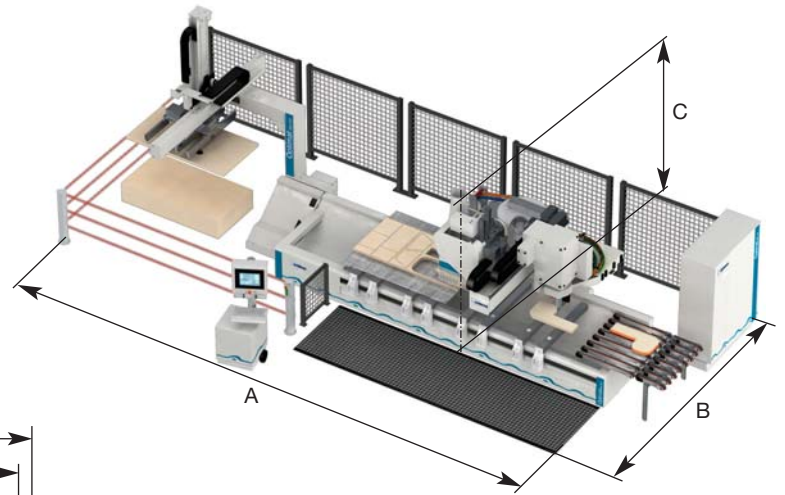
Fast and reliable: Edge banding around corners

Fully automatic, streamlined, upgradeable

The LeanFactory is far more than just another machine:

Now is the time to get on board - and reap the benefit of an ultra-modern, modular overall system. For added success.

Specifications



Certain details of the specifications and photos may differ from those stated.
We reserve the right to make changes in the interests of further development.

		BAZ 322/60/KC	BAZ 322/60/KC (Option Y=2100)
Traversing paths			
X axis	X1 [mm]	6400 (252,0")	6400 (252,0")
Y axis	Y1 [mm]	2180 (85,8")	2550 (100,4")
Processing dimensions with tool diameter 25 mm			
Working spindle	X2 [mm]	6000 (236,2")	6000 (236,2")
Drilling head	X2 [mm]	6000 (236,2")	6000 (236,2")
Auxiliary spindle (option)	X2 [mm]	6000 (236,2")	6000 (236,2")
Dual processing (nesting)	X3 [mm]	2800 (110,2")	2800 (110,2")
Auxiliary spindle	X4 [mm]	2550 (100,4")	2550 (100,4")
Working spindle	Y2 [mm]	1730 (68,1")	2100 (82,7")
Drilling head	[mm]	1940 (76,4")	2310 (90,9")
Auxiliary spindle	[mm]	2100 (82,7")	2470 (97,2")
Traversing path			
Z axis working spindle	Z1 [mm]	535 (21,1")	535 (21,1")
Processing dimensions *			
Upper edge of standard suction cup	Z2 [mm]	200 (7,9")	200 (7,9")
incl. clamping element	Z3 [mm]	300 (11,8")	300 (11,8")
*using the relevant unit and tool lengths			
Set-up dimensions			
Set-up dimensions X direction	A [mm]	14500 (570,9")	14500 (570,9")
Set-up dimensions Y direction	B [mm]	5250 (206,7")	5750 (226,4")
Set-up dimensions Z direction	C [mm]	3800 (149,6")	3800 (149,6")

A member of the HOMAG Group



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