



**The investment has paid off:** Peter Haas, Josef Haubenhofer, Manfred Schafner and Bernd Prem (from the left)

Bildquelle: Nöster



**The operator puts the raw lengths (max. 6,3 m)** onto the table from where they are automatically introduced by catch series

## SCHAFLER TIMBER INDUSTRIES

# Cutting from lot size 1 on

## Efficient optimizing for special pallets

Schafner Timber Industries produces about 700.000 pallets per year. Half of them are pallets with special sizes. Increasing demand and tight delivery schedules induced Schafner to invest in a new cutting line.

Schafner in Hirsdorf is very proud of its new plant and the building infrastructure around it: The optimizing cross-cut saw from Dimter in Illertissen/Germany, a company of the Weinig Group, dominates the production hall that has been refurbished with cross laminated timber walls incorporating glazed areas. The hall is situated nearby the office building. "This reduces walking distances. The glass walls help the fork lift drivers to recognize goods ready for transportation or to foresee the need for new sawn timber", explains Bernd Prem, project manager at Schafner Timber Industries. Previously, the cut to size requirements for special pallets were made with two under table cross-cut saws. Now, a modern optimizing cross-cut saw OptiCut S 90 XL from Dimter has been installed in the new hall.

### One for all

Since October 2012, the entire cutting for the low volume production of special pallets can be done by one operator in a most efficient way – even at lot size 1. The infeed and outfeed mechanization allows for easy handling. Josef Haubenhofer, the operator of the machine, puts the required packets or individual workpieces onto the cross con-

veyor which is equipped with catch series to have a buffer function. When the OptiCut has finished cutting, the operator takes off the workpieces and puts them into stacks.

"Once, the cutting process used to be the bottleneck. The workers at the pallet station often had to wait until the required pieces arrived. Now, this belongs to the past", says Prem. He is very happy about the smooth workflow. The nailing station for the special pallets is also placed in the new hall. This helps to reduce walking distances once more.

### Packaging software even at small lot sizes

Another highlight of the installation is the packaging software "OptiPal" from Dimter. Beginning at the data input of the order, all steps are managed by this software: pre-optimizing of the raw material and display of the order-related workpiece on the outfeed monitor. "OptiPal is very convenient

even at small lot sizes", Werner Blum, the Dimter Sales Manager confirms. "A significant advantage of the software is the fact that several orders can be summed up and optimized at the same time. This increases timber yield", Prem adds.

"The OptiCut S 90 XL is equipped with the OptiCom Direct control and is online with the office PC", says Peter Haas, the Weinig sales representative. The production manager enters the corresponding cutting lists and transmits the data on to the OptiCut S 90 XL. "As the orders often arrive with very short lead times, they can be entered directly on the saw monitor", explains Prem.

### Two options in one machine

At Schafner Timber Industries, the OptiCut S 90 XL optimizes two times: Cutting is carried out either only length-optimized or the machine is used for cutting out defects.

At the first option, the operator treats the raw material in packets. At the second option, he marks the timber defects with fluorescent chalk. At the infeed table, the pusher travels above the timber, recognizing the overall length and the chalk markings before optimizing the cut to size by means of the registered cutting lists. The line is also appropriate for pallet blocks. For this application, a branding iron device has been installed which applies the proper IPPC logo as well as the Schafner order number. Reinforced packet ejectors are able to handle even big dimensions of 180 x 240 mm which are cut at the OptiCut S 90 XL.

"The OptiCut S 90 XL represents the current state of the art technology with regard to efficiency and working safety. Thanks to the separation of the cutting process from the remaining panel production, we have been able to reduce idle times in the manufacturing process significantly", says Prem. He is satisfied with the workflow and confirms that the good price-performance ratio influenced their decision for Dimter.



**On the outfeed monitor,** the operator can watch the dimensions related to the corresponding order



**The IPPC logo** can be branded onto the pallet blocks thanks to the branding iron (in the background)



**The OptiCut S 90 XL** from Dimter has been installed at Schafner Timber Industries in October 2012