

LIST OF REQUIREMENTS FOR CTS-SAW LINE

Date of change	Type of requirement	REQUIREMENT FR MR D	Notes
		1. GEOMETRY	
	FR	- max master board width 10 ft.	for one saw size, also other sizes
	FR	- max master board length 18 ft.	
	FR	- master board thickness 2 - 40 mm	
	FR	- stack height of master boards 1200 - 1500 mm	
	MR	- min sheet size 3 x 4 ft., smaller size as an option	
	FR	- max sheet size 10 x 18 ft.	
	D	- strip handling possibility as an option	
	FR	- group cutting of 3 groups	
	D	- head cut sawing as an option	
	MR	- max book height at least 200 mm	
	MR	- min book height with thin boards 20 mm	
	MR	- min book height with single boards 6 mm	
		- tolerance requirements (of the machine):	
		* dimensions +/- 0,2 mm	
		* straightness +/- 0,1 mm / 3 m	
		* angularity +/- 0,2 mm/m	
	FR	- stacks after the saw:	
		* height 1200 mm	
		* difference (step) of overlapping boards max 1,0 mm	
		* stack bevel max +/- 5 mm/m	
	FR	- waste strip width 10...100 mm	
Opposite for line above		- waste strip width less than 10 mm	
	FR	- special attention to industrial design	
		2. KINEMATICS	
	MR	speeds and accelerations of motions to be chosen so that the required capacity will be achieved without damaging the boards or stacks	
		3. FORCES	
	FR	- master board weight 15 - 20 ton	
	FR	- board density 400...1200 kg/m ³	

Date of change	Type of requirement	REQUIREMENT	Notes
	MR	4. CAPACITY - guaranteed capacity 1500 m³/d: - master board 10 x 18 ft. - sheet size 5 x 9 ft. - board thickness 12 mm 22 h/d 5. MATERIAL FR - sawing of wood-based, uncoated, sanded or unsanded panels (excluding unedged plywood) FR - no damages on the surface of the board 6. SIGNAL FR - control and operation like now FR - automatic stacking (min sheet size 3 x 4 ft., smaller size as an option) D - manual stacking as an option D - fully automatic waste handling atleast as an option (waste to chip size) 7. SAFETY AND ERGONOMICS FR - meets the requirements of CE directives D - consideration of ergonomics in service MR - max equivalent noise level 85 dB(A) 8. MANUFACTURING FR - manufacturing of products in normal subcontractor workshops D - manufacturing possibility also abroad FR/D - use of standard or well available components D - simple structures	

Date of change	Type of requirement	REQUIREMENT	Notes
		9. CHECKING	
	FR	- inspection of delivery and possible testing of products according to appropriate inspection records	
	FR	- new products to be tested before delivery	
		10. INSTALLATION	
	D	- foundation work to be minimized	
	D	- distributed I/O	
	D	- installation work to be reduced	
		11. TRANSPORT	
	FR	- requirements of overseas transport must be met (packing and protection)	
		12. OPERATION	
	FR	- markets and operation all over the world	
		13. MAINTENANCE	
	D	- minor need for service	
	FR	- easy to service	
	FR	- well-designed dust exhauge	
		14. COSTS	
	MR	- cost reduce 25 % compared with Dominance-project	
		15. SCHEDULE	
	MR/FR	- development work ready 31.12.1996	