

LIST OF REQUIREMENTS FOR CTS-SAW LINE

Date of change	Type of requirement	REQUIREMENT FR MR D	Notes
		1. GEOMETRY - max master board width 10 ft. - max master board length 18 ft. - master board thickness 2 - 40 mm - stack height of master boards 1200 - 1500 mm - min sheet size 3 x 4 ft., smaller size as an option - max sheet size 10 x 18 ft. - strip handling possibility as an option - group cutting of 3 groups - head cut sawing as an option - max book height at least 200 mm - min book height with thin boards 20 mm - 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 - stacks after the saw: * height 1200 mm * difference (step) of overlapping boards max 1,0 mm * stack bevel max +/- 5 mm/m - waste strip width 10...100 mm - waste strip width less than 10 mm - special attention to industrial design 2. KINEMATICS speeds and accelerations of motions to be chosen so that the required capacity will be achieved without damaging the boards or stacks 3. FORCES - master board weight 15 - 20 ton - board density 400...1200 kg/m³	for one saw size, also other sizes

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		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 - sawing of wood-based, uncoated, sanded or unsanded panels (excluding unedged plywood) - no damages on the surface of the board 6. SIGNAL - control and operation like now - automatic stacking (min sheet size 3 x 4 ft., smaller size as an option) - manual stacking as an option - fully automatic waste handling atleast as an option (waste to chip size) 7. SAFETY AND ERGONOMICS - meets the requirements of CE directives - consideration of ergonomics in service - max equivalent noise level 85 dB(A) 8. MANUFACTURING - manufacturing of products in normal subcontractor workshops - manufacturing possibility also abroad - use of standard or well available components - simple structures	

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