



„STELLA” machine for assembling bed frames

STELLA can produce 72 different standardized variants of hotel / bedroom bed frames.

Bed frame lengths: 1900, 2000, 2100 mm (17, 18 or 19 pieces of lateral)

Bed frame side heights: 95, 130, 190 mm.

Bed frame widths: 700, 800, 900, 1000 mm

The above parameters are clearly marked by slots and pins, which allow for a quick change between bed frame sizes. However, the width of the frames can be adjusted by any increment between the width range of 700 and 1000 mm.



Fasteners and Fastening tools:

- Jumbo coil nails BDC, length: 90 mm
- 4 nailers with Jumbo magazines
- staples type 14, length: 40 mm
- 2 BeA Autotec staplers

Output:

the average assembly time of one frame is about 50 seconds,

Hence, we can assume that the hourly output is around 62 finished frames.

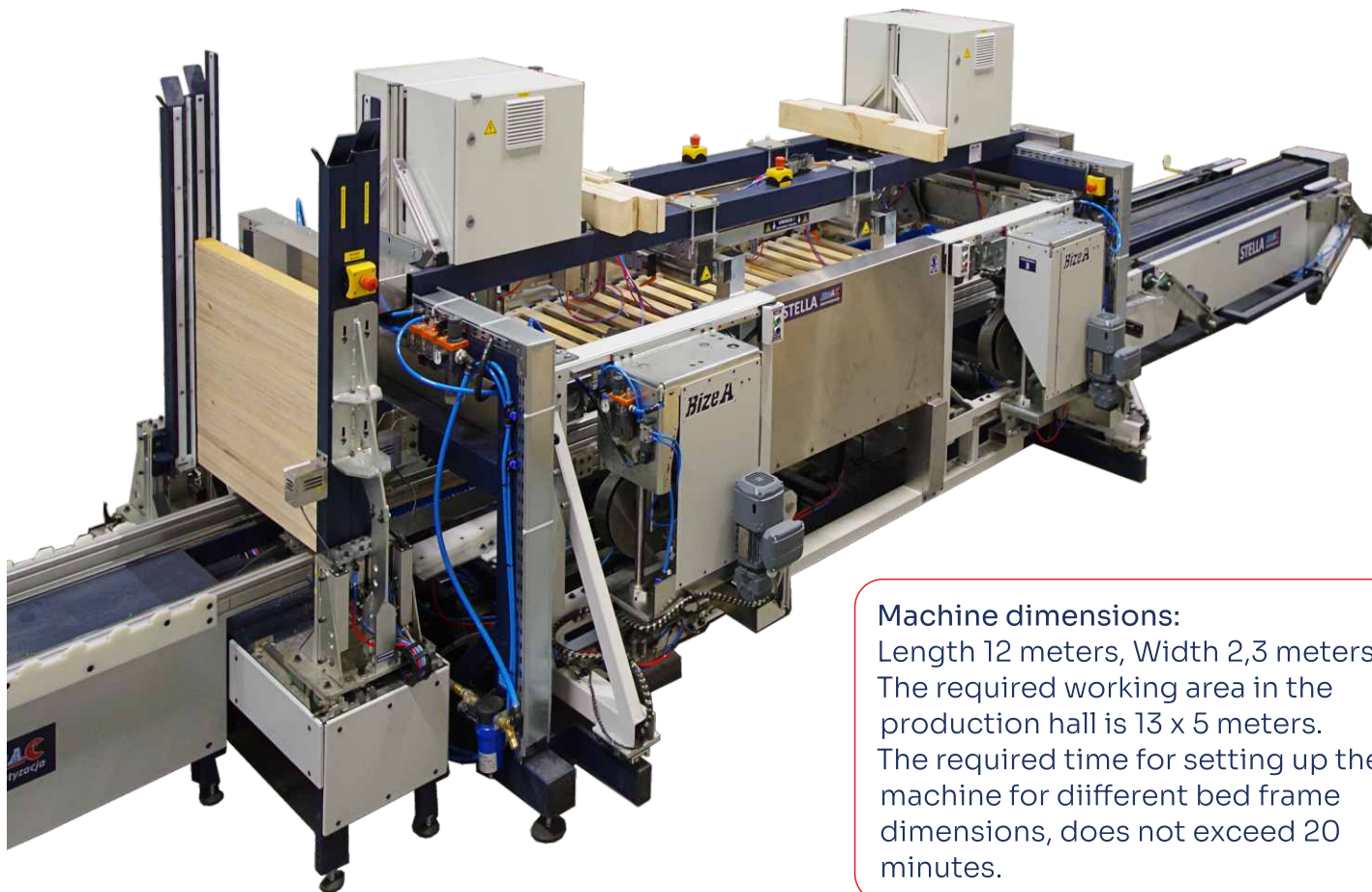
When using staples instead of nails for connecting the corners of the frame, the assembly time will be several seconds shorter.

Two people are required to insert the side and head boards and initiate the fastening cycle. A third person is responsible for the collection of the finished frames and the supply of the frame elements required for the machine's operation.

The reloading frequency of the bed frame elements:

- nails every 150 minutes,
- staples every 50 minutes,
- slat magazines every 6 beds.

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Machine dimensions:
Length 12 meters, Width 2,3 meters
The required working area in the production hall is 13 x 5 meters.
The required time for setting up the machine for different bed frame dimensions, does not exceed 20 minutes.

Frame corners are connected by collated nails inserted by four nailers with Jumbo magazines. Bottom slats are automatically fed from a vertical magazine and positioned on a movable template. Next they are attached at the base to the frame by four staples. The connection is carried out by two BeA Autotec K14 staplers from the 242 series with a high capacity magazine. The magazine for slats can be loaded while the machine is working.



The collection of the finished frame depends on the customer's required production flow. A conveyor belt system can be used or done manual the receiving table.

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