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为家居智能制造提供系统解决方案
TOTAL SOLUTIONS FOR INTELLIGENT MANUFACTURING

股票代码：002757

股票代码：002757



南兴装备
NANXING MACHINERY

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注: 本公司对产品规格及设计细节不断优化改进, 若有变更, 恕不另行通知。
Note: The company continues to improve the product specifications and design details, the specifications are subject to change without notice.



南兴装备
NANXING MACHINERY

NP

NB

NC

ND

NA



01 东莞厚街基地
Dongguan Houjie Base

公司简介 PROFILE

南兴装备股份有限公司，始创于1996年，2015年在深圳证券交易所主板上市（股票代码：002757）。公司总部位于广东东莞，在全国设有两个研发中心，四大制造基地。

南兴装备是国家高新技术企业和国家级专精特新小巨人企业，拥有强大的技术研发能力和智能制造实力，专注于家居智能制造装备和智能生产线的研发和生产。主要产品包括：数控开料系列产品，智能柔性封边系列产品，数控钻孔系列产品以及智能工作站和整厂智能生产线解决方案。

南兴装备总部及遍布全球的200 + 销售服务中心，为客户提供优越的体验和理想的选择，助力家居产业制造升级，降本增效。以创新技术，优良品质和贴心服务，赢得客户赞誉和市场口碑，成为行业领军企业。

南兴装备，与您同行，共创美好生活。

Nanxing Machinery Co., Ltd., founded in 1996, was listed on the main board of Shenzhen Stock Exchange in 2015 (stock code: 002757). The company is headquartered in Dongguan, Guangdong, and has two R&D centers and four manufacturing bases across the country.

Nanxing Machinery is a national high-tech enterprise and a national-level specialized special new small giant enterprise. Nanxing Machinery has strong technical research and development capabilities and intelligent manufacturing capabilities, focusing on the research and development and production of household intelligent manufacturing equipment and intelligent production lines. The main products include: CNC nesting series products, intelligent flexible edge banding series products, CNC drilling series products, intelligent workstations and intelligent production line solutions for the whole factory.

Nanxing Machinery Headquarters and 200+ sales and service centers around the world provide customers with superior experience and best choices, help the home furnishing industry to upgrade manufacturing, reduce costs and increase efficiency. With innovative technology, excellent quality and considerate service, it has won praise from customers and market reputation, and has become an industry leader.

Nanxing Machinery will create a better life with you together.

02 东莞沙田基地
Dongguan Shatian Base



03 广东韶关基地
Guangdong Shaoguan Base



04 江苏无锡基地
Jiangsu Wuxi Base



企业核心价值观

THE CORE VALUES OF
NANXING MACHINERY



以诚信为本
TRUST PLUS
RELIABILITY



以顾客为核心
SATISFACTION TO
CUSTOMERS



工作即修行
PRACTICE THROUGH
WORKING



细节成就品质
QUALITY WITH DETAILS



品质塑造品牌
BRAND BY QUALITY



管理决定成败
SUCCESS VIA
MANAGEMENT



创新才有未来
INNOVATION
FOR FUTURE

企业荣誉

NANXING HONORS



国家级专精特新“小巨人”企业
NATIONAL-LEVEL SPECIALIZED
“LITTLE GIANT” ENTERPRISE



国家高新技术企业
NATIONAL HIGH-TECH ENTERPRISES



ISO9001:2015质量管理体系认证
ISO9001:2015 QUALITY MANAGEMENT
SYSTEM CERTIFICATION



企业信用评价AAA级信用企业
ENTERPRISE CREDIT EVALUATION
AAA GRADE CREDIT ENTERPRISE



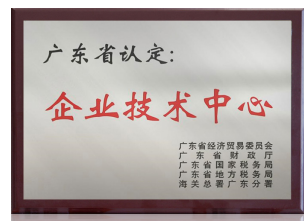
先进制造业集群承担企业
ADVANCED MANUFACTURING CLUSTERS
UNDERTAKE ENTERPRISES



中国机械工业科学技术奖
CHINA MACHINERY INDUSTRY
SCIENCE AND TECHNOLOGY AWARD



广东省知识产权示范企业
GUANGDONG PROVINCE INTELLECTUAL
PROPERTY DEMONSTRATION ENTERPRISE



企业技术中心
GUANGDONG ENTERPRISE
TECHNOLOGY CENTER

合作客户 (部分)

PART OF OUR CUSTOMERS



SOGAL 索菲亚



尚品宅配



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生产制造中心

MANUFACTURING CENTER



装配展示中心

ASSEMBLY DISPLAY CENTER





4 ↑

生产基地
Production base



400 +

专利软著
Patent software



200 +

全球销售服务中心
Global Sales Service Center

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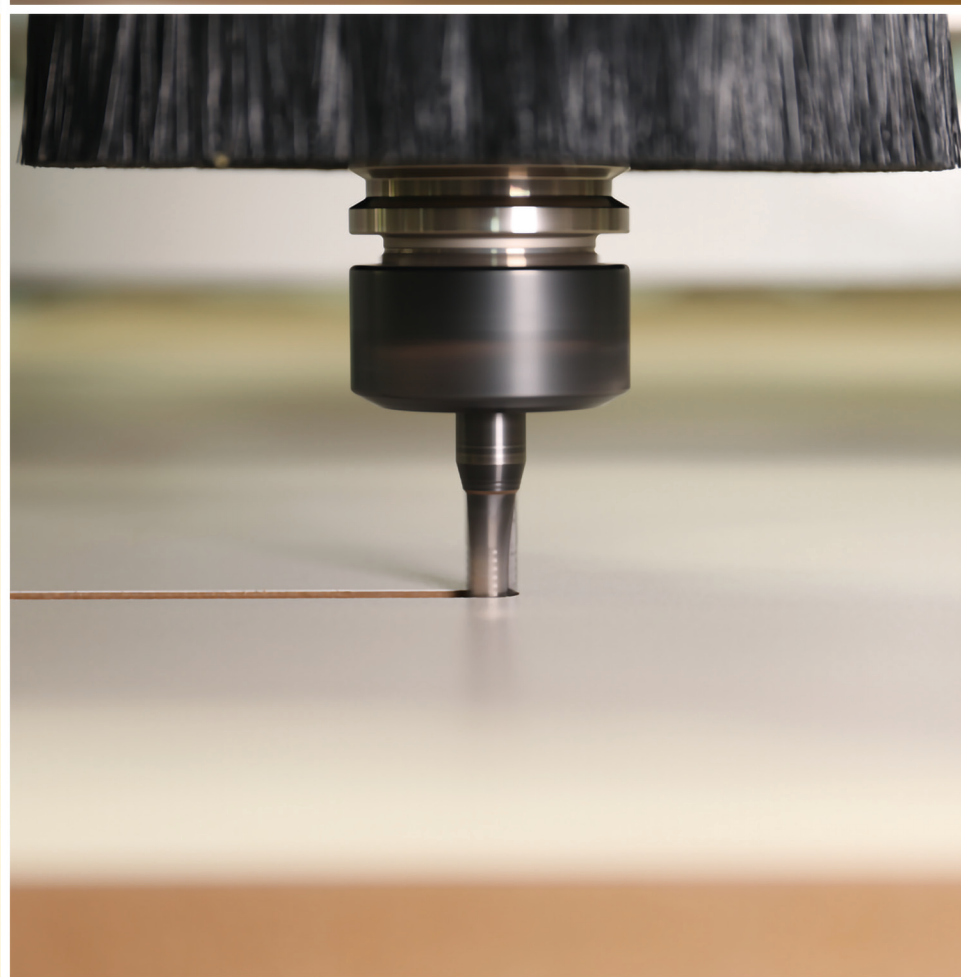
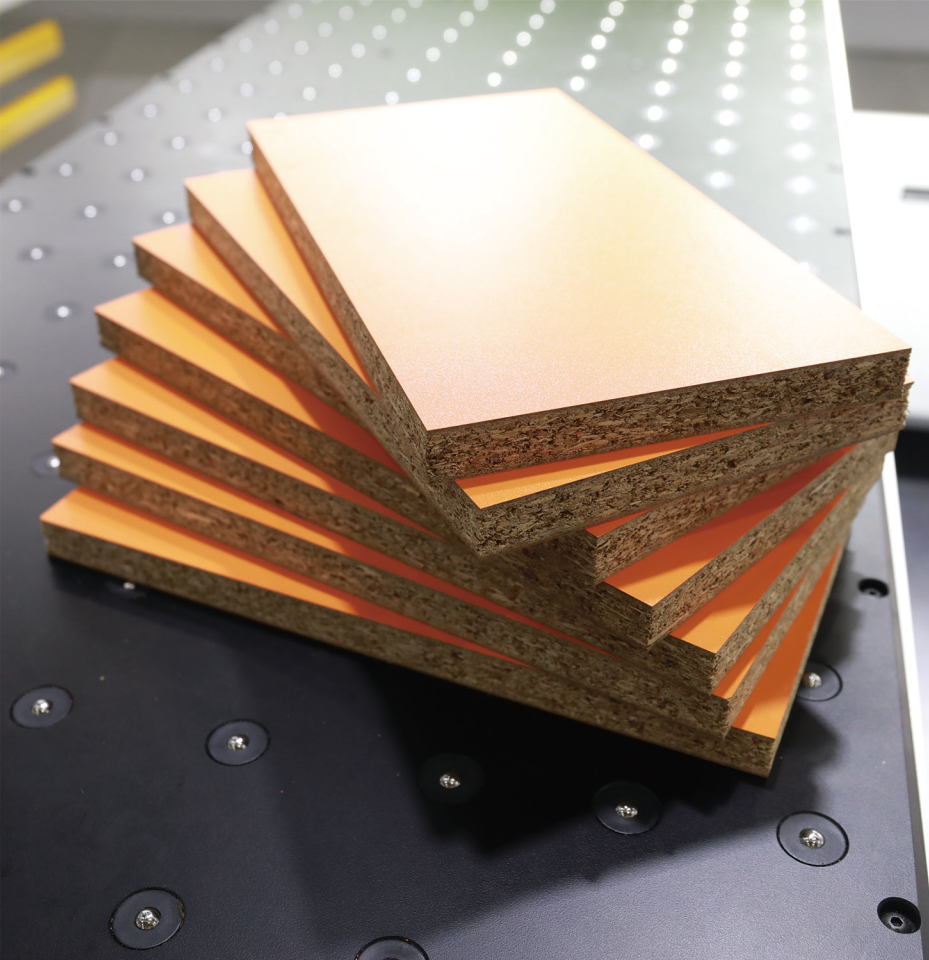
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开料系列

SIZING SERIES

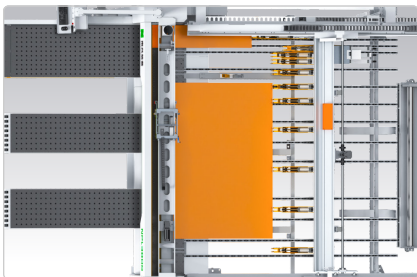
NPL380D

后上料高速电脑裁板锯(双推手)

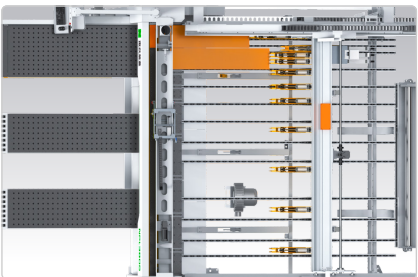
Panel dividing saw with lifting table (Twin program fence & Twin pusher)

可选Option : NPL440D

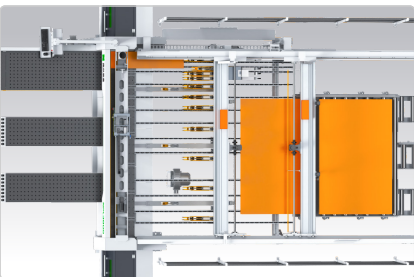
- 重型桥梁式机架
- 重型双横梁双推手
- 锯片引升高度: 120mm
- 标配专业级优化软件
- 可选: 重型液压升降台或四柱式升降台
- Heavy duty bridge frame
- Heavy duty double beam twin pusher
- Saw blade lifting height: 120mm
- Standard professional optimization software
- Optional: heavy duty hydraulic lift table or four-post lift table



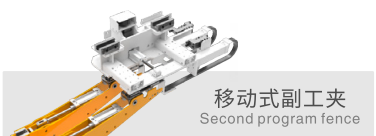
纵向和横向同时锯切
Twin pusher crosscut & ripcut



横向交错锯切
Twin pusher crosscut



重型双横梁
Heavy-duty twin program fence



移动式副工夹
Second program fence



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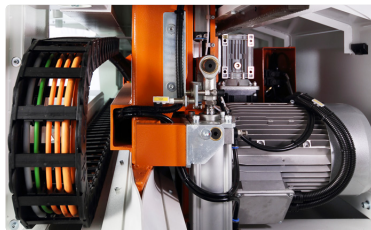
NPL330HG

后上料高速电脑裁板锯

Panel dividing saw with lifting table

可选Option : NPL380HG

- 重型桥梁式机架
 - 锯片引升高度：120mm
 - 可选：重型液压升降台或四柱式升降台
 - 可选：钢制气浮台面
- Heavy duty bridge frame
 - Saw blade lifting height: 120mm
 - Optional: heavy duty hydraulic lift table or four-post lift table
 - Optional: steel air flotation table



高速重型锯座
Fast & heavy-duty saw carriage



配置10个工夹
10 sets of main grippers



重型双横梁
Heavy-duty twin program fence



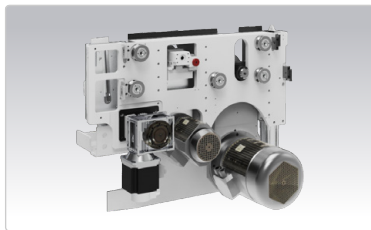
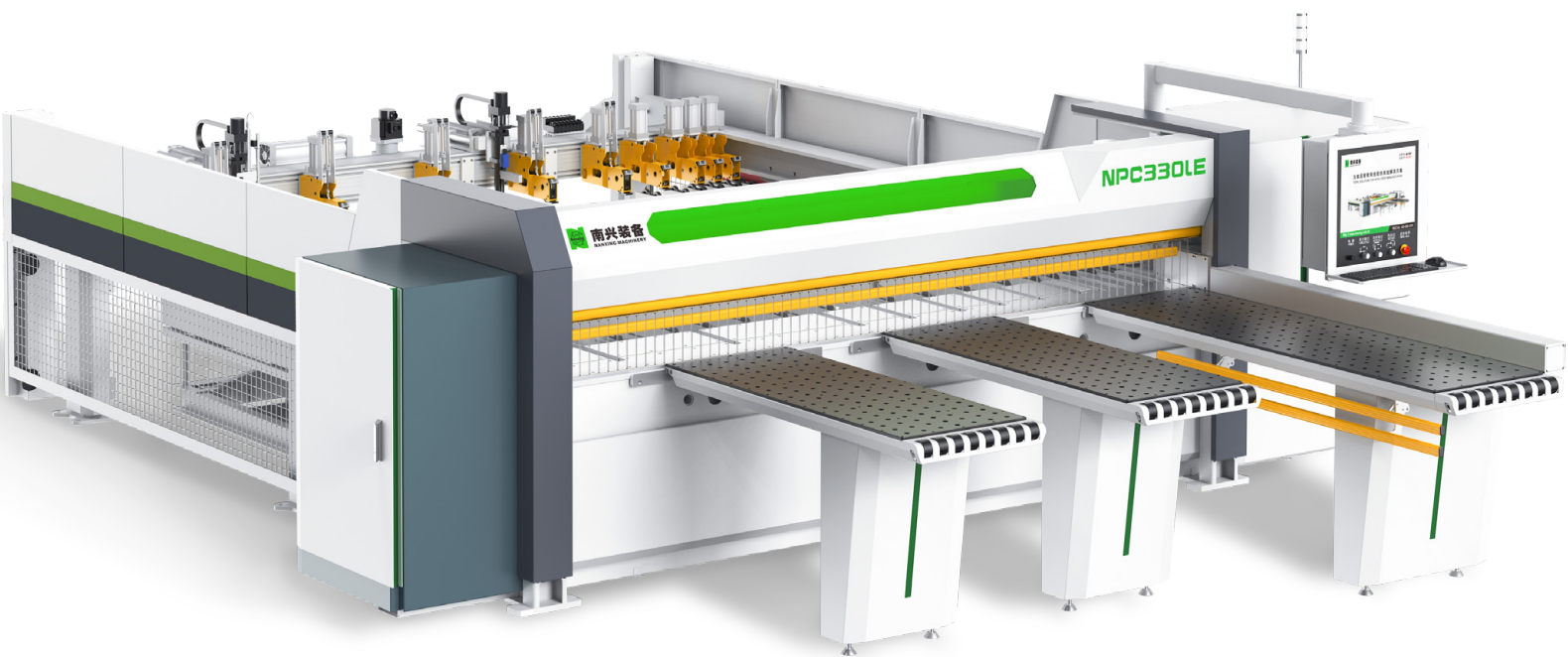
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NPC330LE

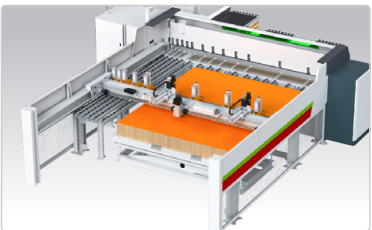
后上料高速电脑裁板锯

Panel dividing saw with lifting table

- 锯片引升高度：90mm(可选120mm)
- Saw blade lift height: 90mm (120mm optional)



整体式锯座
Integrated saw carriage



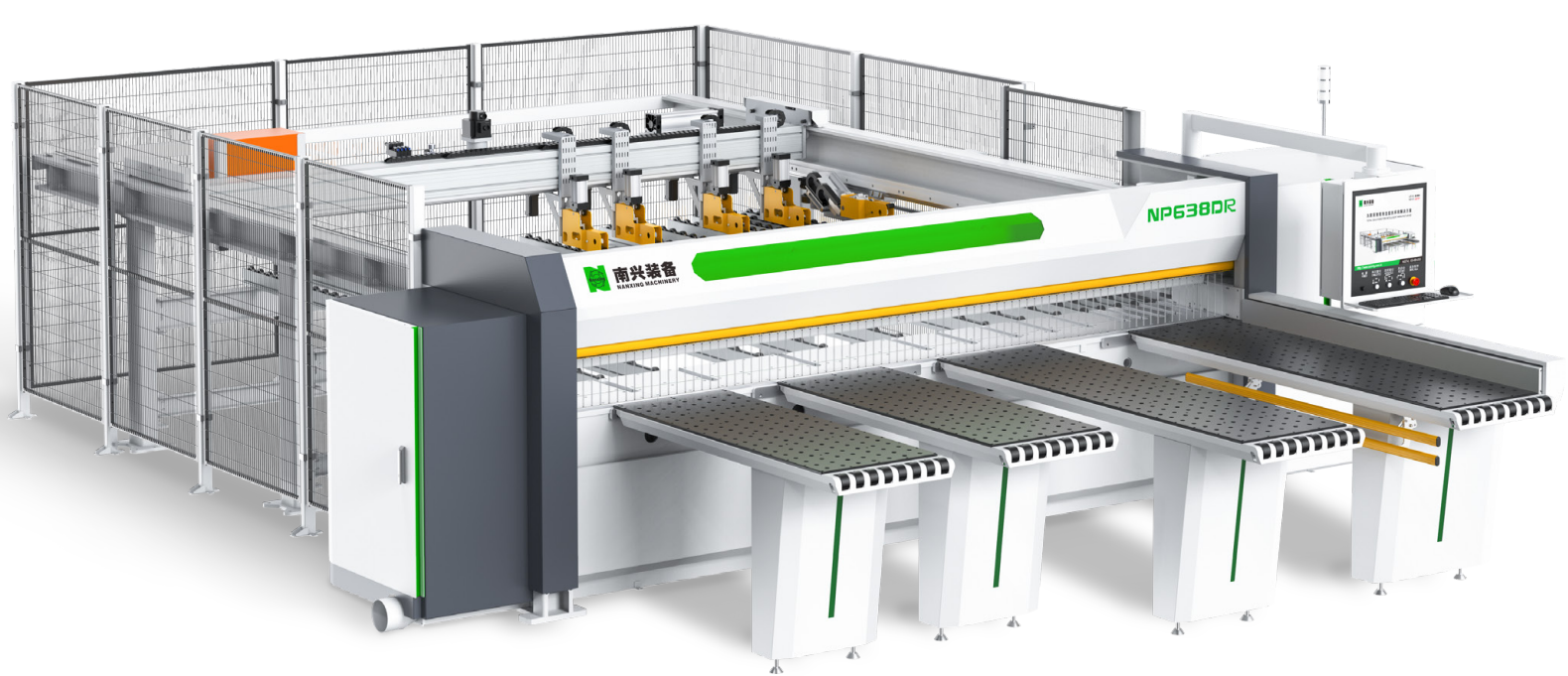
后上料
Rear feeding

NP638DR

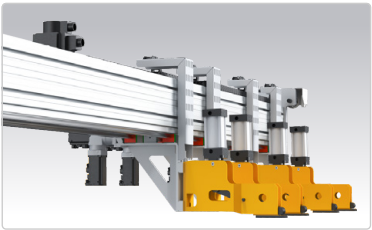
高速电脑裁板锯(双推手)

Panel dividing saw (Twin pusher)

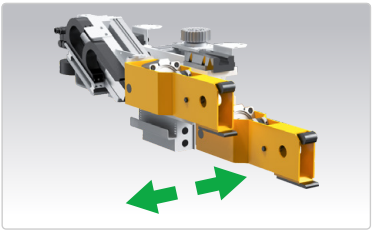
- 前上料双推手
 - 锯片引升高度：90mm
 - 标配专业级优化软件
 - 可选：钢制气浮台面
- Front loading twin pusher
 - Saw blade lifting height: 90mm
 - Standard professional optimization software
 - Optional: steel air flotation table



整体式锯座
Integrated saw carriage



配置4个伺服主工夹
Configure with 4 sets of servo main grippers



移动式副工夹
Second program fence

NPC330

高速电脑裁板锯

Panel dividing saw

- 锯片引升高度：90mm(可选120mm)
- Saw blade lift height: 90mm (120mm optional)

可选Option：NPC280、NPC380、NPC440



重型高刚性框架式机架
Frame-type machine body of high rigidity



配置8个工夹
Configured with 8 sets of grippers

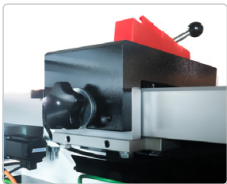
MJK1132F1

数控精密推台锯

Sliding table saw with digital crosscut fence



触摸屏控制
Touch screen control



伺服移动靠档
Digital crosscut fence



MJ1132F

精密推台锯

Sliding table saw



电脑锯开料系列主要技术参数

MAIN TECHNICAL PARAMETERS OF COMPUTER DIVIDING SAW SERIES

型号 Model	最大加工尺寸 Max. machining size	锯座速度 Saw carriage speed	送料速度 Feeding speed	主锯电机 Main saw motor	副锯电机 Scoring saw motor	工夹数量 Gripper QTY	总功率 Total power	净重 Net weight	设备尺寸 Overall dimension
NPL380D	3800mm(长度) 120mm(厚度) 3050×2200mm(最大后上料尺寸)	120m/min(前进) 120m/min(后退)	85m/min(主工夹) 52m/min(副工夹)	18.5(可选22) kw	2.2kw	(2+10) 12个	40kw	12580kg	13384×6700×2020mm(正后上料) 11700×9600×2020mm(右后上料) 11700×9000×2020mm(左后上料)
NPL440D	4400mm(长度) 120mm(厚度) 4200×2200mm(最大后上料尺寸)	100m/min(前进) 120m/min(后退)	85m/min(主工夹) 52m/min(副工夹)	18.5(可选22) kw	2.2kw	(2+11) 13个	41kw	11400kg	10300×9490×2050mm(侧后上料)
NPL330HG	3270mm(长度) 120mm(厚度) 2750×2200mm(最大后上料尺寸)	90m/min(前进) 120m/min(后退)	60m/min(后上料)	18.5(可选22) kw	2.2kw	10个	40kw	12170kg	11226×6170×2020mm(正后上料) 9800×9015×2020mm(左后上料) 9800×9406×2020mm(右后上料)
NPL380HG	3800mm(长度) 120mm(厚度) 3050×2200mm(最大后上料尺寸)	90m/min(前进) 120m/min(后退)	85m/min(后上料)	18.5(可选22) kw	2.2kw	10个	40kw	12500kg	11380×6700×2020mm(正后上料) 9800×9600×2020mm(左后上料) 9800×9900×2020mm(右后上料)
NPC330LE	3270mm(长度) 90mm(厚度) 2440×1220mm(最大后上料尺寸)	90m/min(前进) 120m/min(后退)	85m/min(自动送料)	15kw	2.2kw	9个	29.5kw	6500kg	7100×5400×1820mm
NP638DR	3800mm(长度) 90mm(厚度)	90m/min(前进) 120m/min(后退)	85m/min(主工夹) 55m/min(副工夹)	15kw	2.2kw	(2+4) 6个	26kw	6500kg	7500×6000×1820mm
NPC280	2780mm(长度) 90mm(厚度)	90m/min(前进) 120m/min(后退)	85m/min(自动送料)	15kw	2.2kw	7个	23.5kw	4800kg	4950×1820mm
NPC330	3270(长度) 90/可选120mm(厚度)	90m/min(前进) 120m/min(后退)	85m/min(自动送料)	15(可选18.5) kw	2.2kw	8个	23.5kw	5300kg	6900×5400mm
NPC380	3800mm(长度) 90mm(厚度)	90m/min(前进) 120m/min(后退)	85m/min(自动送料)	15kw	2.2kw	9个	23.5kw	6300kg	7375×6000×1800mm
NPC440	4400mm(长度) 90mm(厚度)	90m/min(前进) 120m/min(后退)	85m/min(自动送料)	15kw	2.2kw	10个	23.5kw	7000kg	8150×6580×1800mm

推台锯系列主要技术参数

MAIN TECHNICAL PARAMETERS OF SLIDING TABLE SAW SERIES

型号 Model	锯切长度 Cutting length	0°最大锯切厚度 0°Max cutting thickness	45°锯切厚度 45°Cutting thickness	主锯电机 Main saw motor	副锯电机 Scoring saw motor	锯片倾斜 Scoring saw blade inclined	总功率 Total power	净重 Net weight	设备尺寸 Overall dimension
MJK1132F1	3100mm	100mm	71mm	5.5kw	1.1kw	0-45°	6.72kw	1000kg	3400×3400×1680mm
MJK1138F1	3700mm	100mm	71mm	5.5kw	1.1kw	0-45°	6.72kw	1050kg	4000×3440×1680mm
MJ1132F	3100mm	100mm	71mm	5.5kw	1.1kw	0-45°	6.6kw	1000kg	3400×3380×1400mm
MJ1138F	3700mm	100mm	71mm	5.5kw	1.1kw	0-45°	6.6kw	1050kg	4000×3380×1400mm

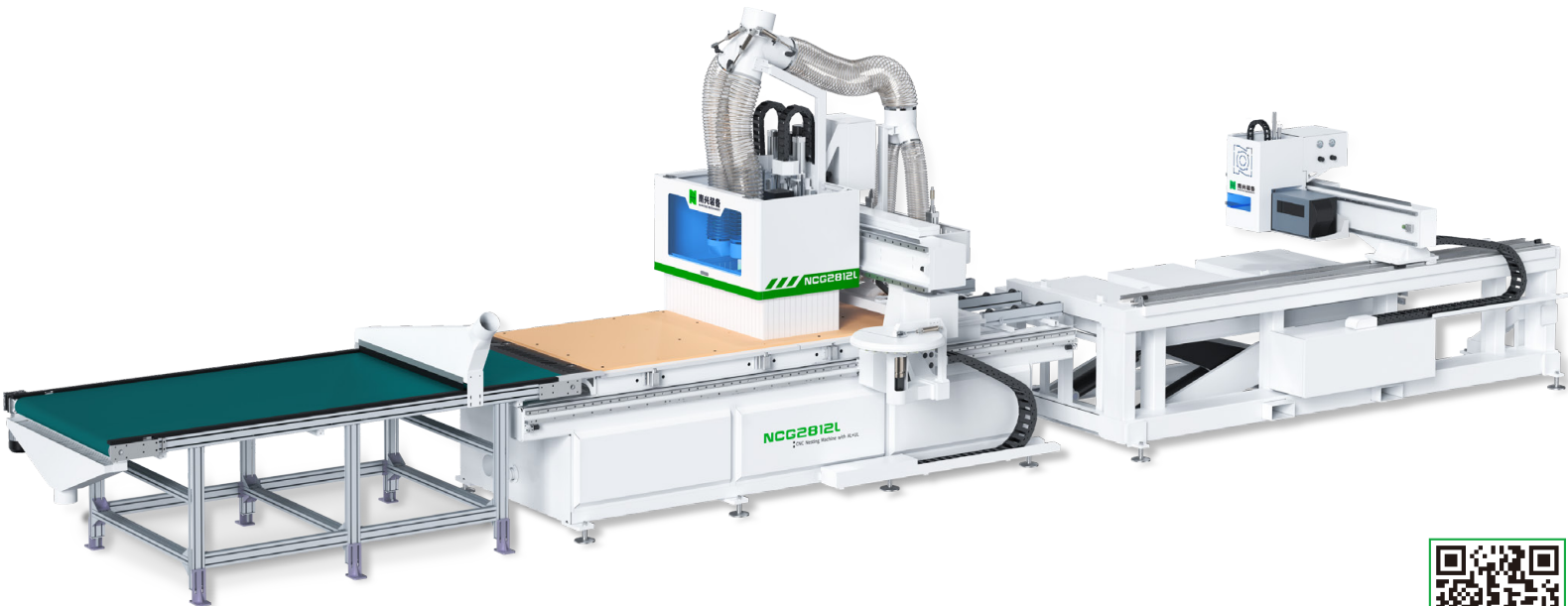
NCG2812L

木工柔性生产线

CNC nesting machine with AL + UL

可选Option : NCG3021L

- 重型床身
 - 主轴最高转速：24000rpm
 - 标配250m³/H风冷真空泵
 - 可选：云优化
 - 可选：压辊
- Heavy duty machine body
 - Spindle max. speed: 24000rpm
 - Standard 250m³/H air-cooled vacuum pump
 - Optional: cloud optimization
 - Optional: pressure roller



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NCG2812LE

木工柔性生产线

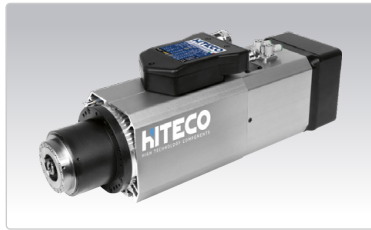
CNC nesting machine with AL + UL

可选Option : NCG3021LE

- 重型床身
 - 标配250m³/H风冷真空泵
 - 可选：自动换刀主轴或4个手动换刀主轴
- Heavy duty machine body
 - Standard 250m³/H air-cooled vacuum pump
 - Optional: automatic tool change spindle or 4 sets of manual tool change spindles



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12kw意大利进口主轴
12kw Italian imported spindle



12刀位伺服换刀刀库
ATC 12 by servo



旋转式贴标
Rotatable labeling device



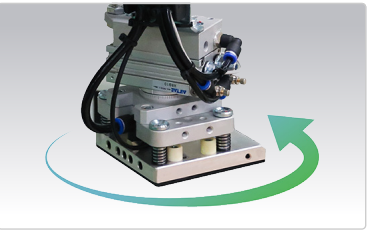
专业软件 (FCC)
Professional software(FCC)



定向吹灰吸尘装置
Directional soot blowing and vacuuming device



12刀位自动换刀刀库
12-slot line tool changer



旋转式贴标
Rotatable labeling device



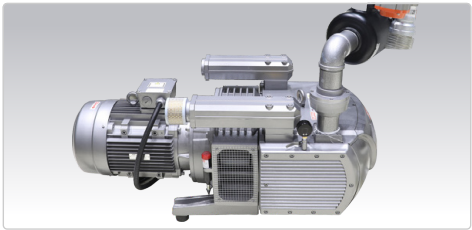
可选：压辊
Optional: pressure roller

NCG2812E

加工中心

CNC nesting machine

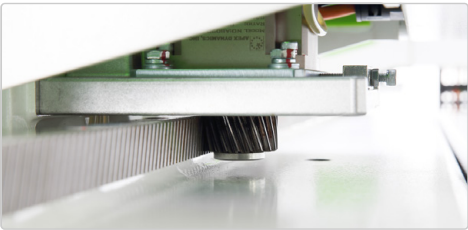
- 可选: 自动换刀主轴或4个手动换刀主轴
 - 可选: 压辊
 - 可选: 吸板上料和推料除尘
 - Optional: automatic tool change spindle or 4 sets of manual tool change spindles
 - Optional: pressure roller
 - Optional: Feed-in vacuum cups and pusher



标配250m³/H风冷真空泵
Standard 250m³/H air-cooled vacuum pump



高品质柔性电缆
High quality flexible cable

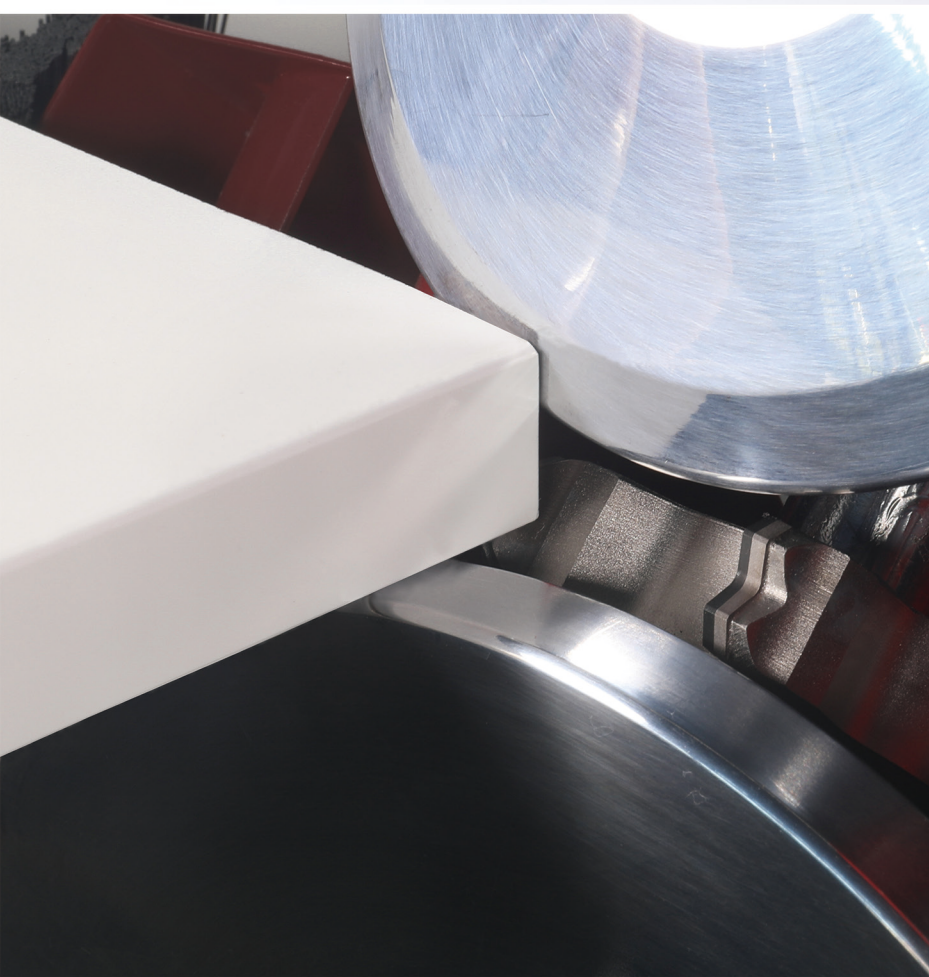
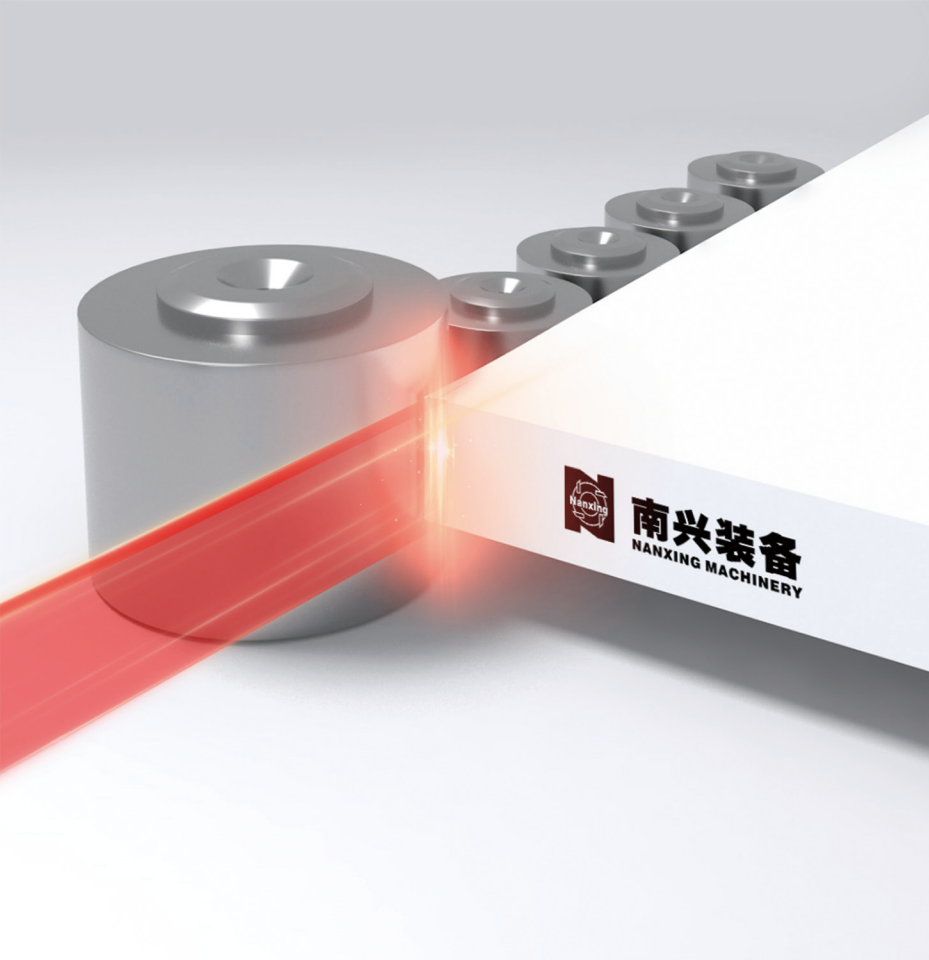


研磨级齿轮齿条传动
Grinding grade rack and pinion drive

数控开料系列主要技术参数

MAIN TECHNICAL PARAMETERS OF CNC NESTING SERIES

型号 Model	台面尺寸 Table size	最高速度 (X/Y/Z) The max. speed (X/Y/Z)	主轴功率 Main spindle power	刀库容量 Tool magazines capacity	垂直钻 Vertical drill	钻包转速 Rotating speed	总功率 Total power	净重 Net weight	设备尺寸 Overall dimension
NCG2812L	2800×1220mm	100/100/20m/min	12kw	12	10	4000rpm	32kw	4500kg	11000×2600×2500mm
NCG3021L	3100×2100mm	70/70/20m/min	12kw	12	10/21	4000rpm	47kw	6000kg	13200×3900×2600mm
NCG3021L-PLUS	3100×2100mm	70/70/20m/min	12kw×2	12×2	21×2	4000rpm	68kw	7200kg	15000×3900×2600mm
NCG2812LE	2800×1220mm	100/100/20m/min	9kw	12	----	----	26kw	4500kg	11000×2460×2500mm
NCG3021LE	3100×2100mm	100/100/20m/min	9kw	12	----	----	34.5kw	5000kg	12300×3200×2500mm
NCG2812E	2800×1220mm	100/100/20m/min	9kw	12	----	----	23kw	2500kg	4020×2270×2500mm



封边系列

EDGE BANDER SERIES

NB10-Smart

智能封边机

Intelligent auto edge banding machine

可选Option：NB9-Smart、NB8-Smart

- NB10-Smart系列可用于二机智能柔性封边连线 (规方)

• NB8-Smart和NB9-Smart系列用于四机智能柔性封边连线 (规方)

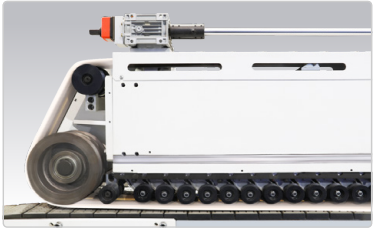
• 能与系统对接实现自动选胶、换带、调刀、开槽等
- NB10-Smart series can be used for two-intelligent single sided edge banding machine line (squaring)

• NB8-Smart and NB9- Smart series can be used for four-intelligent single sided edge banding machine line (squaring)

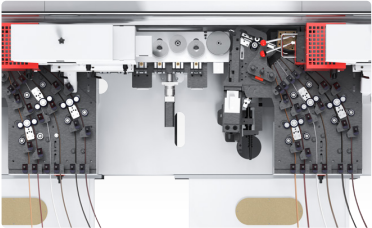
• Can be connected with the system to realize automatic glue selection, tapes change, cutter adjustment and grooving, etc.

整机伺服控制

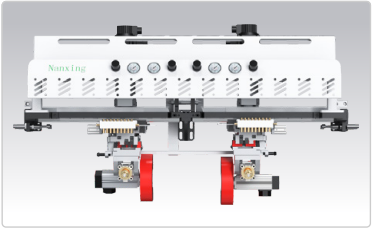
伺服跟踪
32 m/min



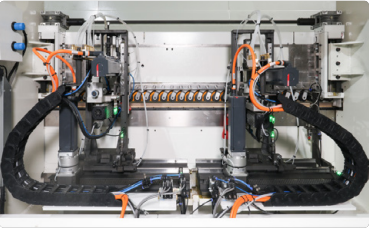
钢制压梁，履带压料
Steel pressure beam, top presser by v-belt



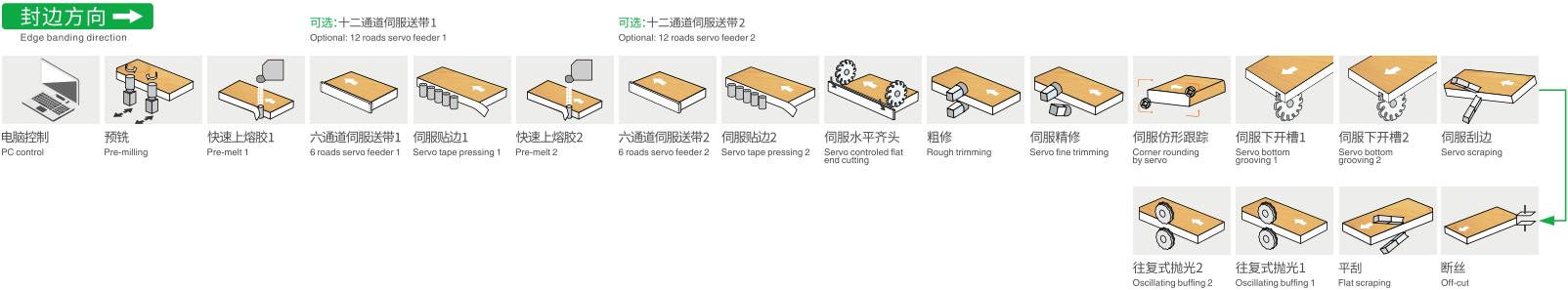
两组6通道伺服送带
Two groups 6 roads servo tape feeder



伺服水平齐头
Servo controlled flat end cutting



伺服仿形跟踪
Corner rounding by servo



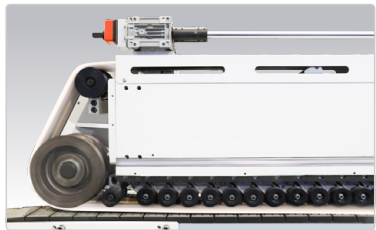
NB-Laser10

激光封边机

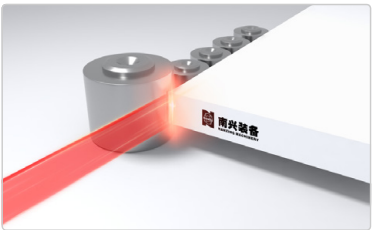
Laser edge banding machine

- 防潮、耐高温、无胶线
 - 自动调节激光高度
 - 采用进口激光光源
 - 可选：PUR涂胶
- Moisture-proof, high temperature resistance, no glue lines
 - Automatic adjustment of laser height
 - Imported laser light source
 - Optional: PUR glue

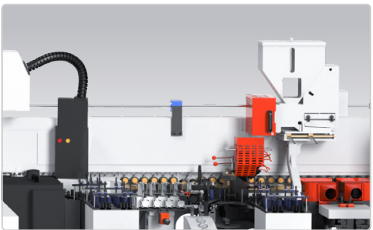
速度 **32m/min**



钢制压梁，履带压料
Steel pressure beam, top presser by v-belt



矩形光斑(可自动调节)
Rectangular spot (can be adjusted automatically)



激光/EVA一键切换
Laser/EVA one-button switching



伺服水平齐头
Servo controlled flat end cutting

封边方向 →
Edge banding direction

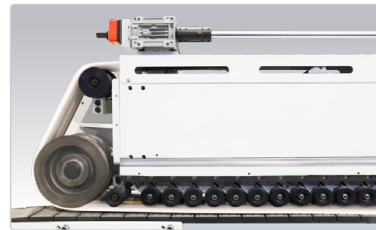


NB-Laser9

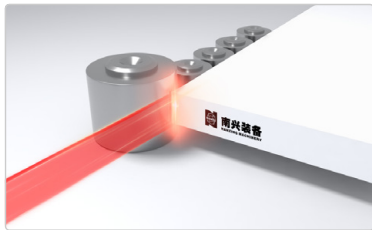
激光封边机

Laser edge banding machine

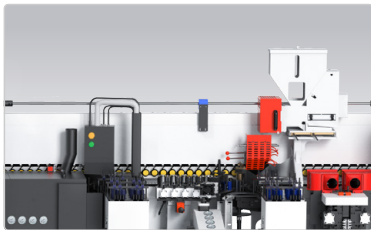
- 防潮、耐高温、无胶线
 - 两组4通道伺服送带
 - 可选：PUR涂胶
- Moisture-proof, high temperature resistance, no glue lines
 - Two groups 4 roads servo tape feeder
 - Optional: PUR glue



钢制压梁，履带压料
Steel pressure beam, top presser by v-belt



矩形光斑
Rectangular spot

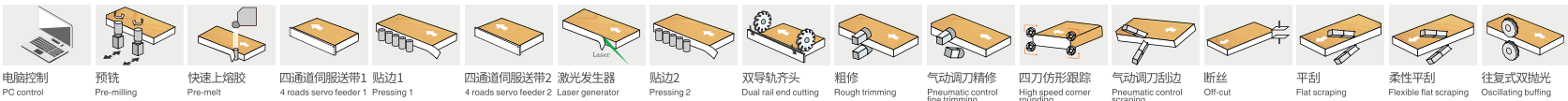


激光/EVA一键切换
Laser/EVA one-button switching



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Find more from here

封边方向 →
Edge banding direction



NB8PCGM-PC

高速自动封边机

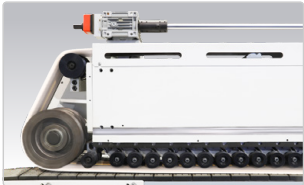
Edge banding machine with V-belt & double gluing units

- 重型整体式床身
- 配置12通道伺服送带 (8+4)
- 配置贴边轮 (1+6)
- 配置金刚石修边刀

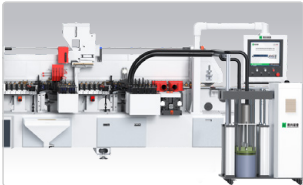
- Heavy-duty integral machine body
- 12 roads servo tape feeder (8+4)
- Press roller (1+6)
- Diamond trimming cutter

仿形跟踪

26m/min



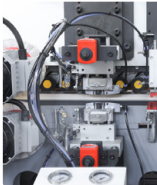
钢制压梁，履带压料
Steel pressure beam, top presser by v-belt



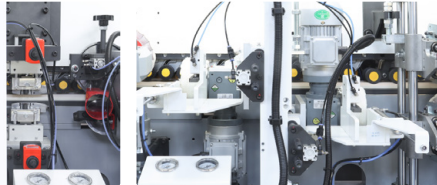
EVA/PUR一键切换
EVA/PUR one button switch



双色免清洗PUR涂胶
Two-color no-clean PUR glue

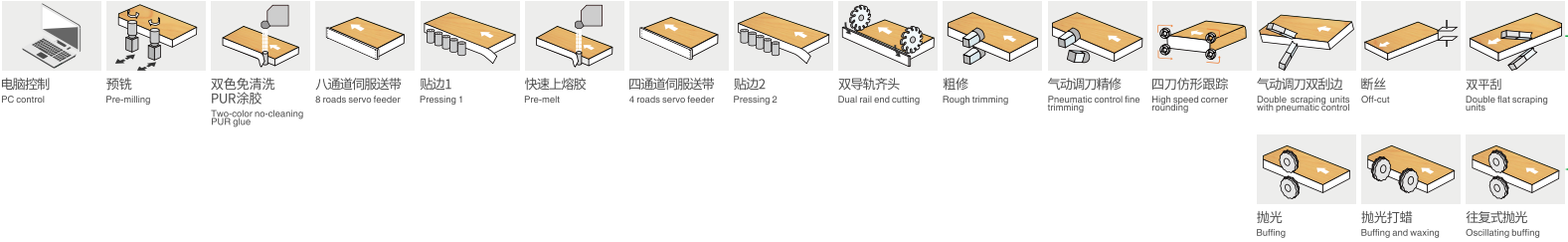


脱膜刮边
Deciduate scraping



抛光打蜡
Buffing and waxing

封边方向 →
Edge banding direction



NB7PCGM-PC

高速自动封边机

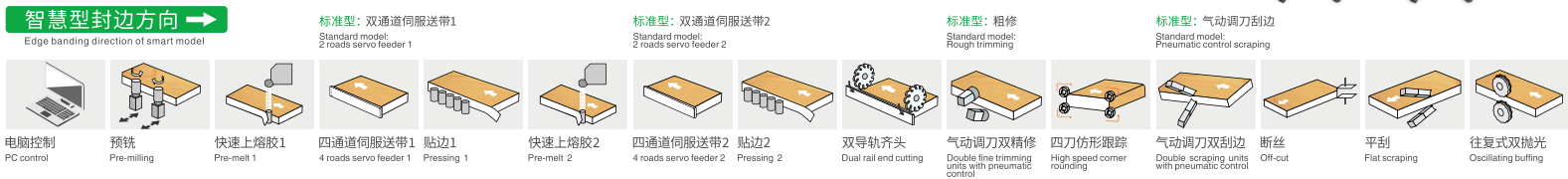
Edge banding machine with V-belt & double gluing units

可选Option：

NB7PCGM (智慧型、标准型)
(Smart model, Standard model)



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Find more from here



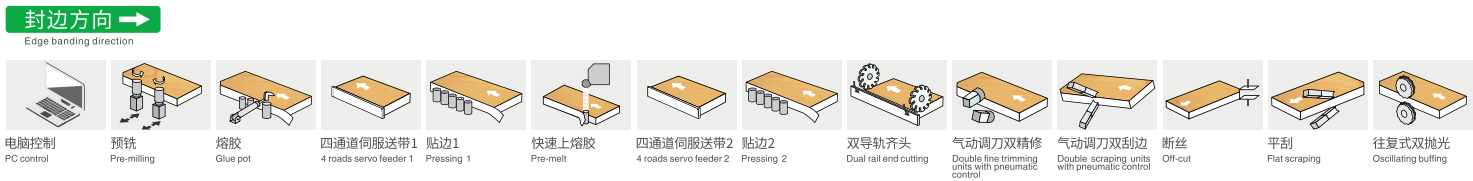
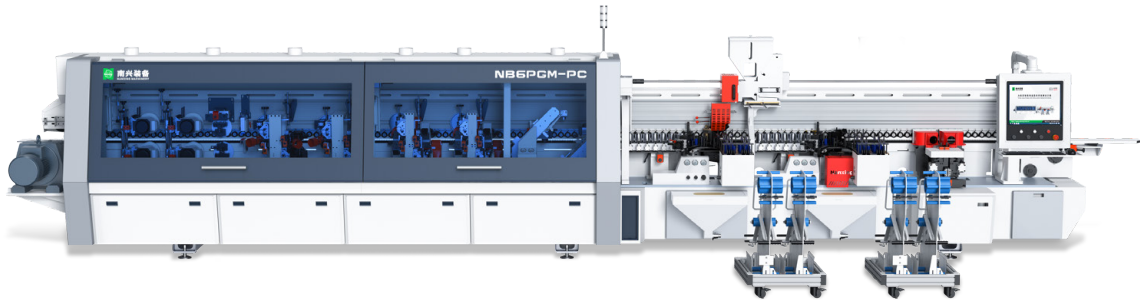
NB6PGM-PC

高速自动封边机

Edge banding machine with V-belt & double gluing units

可选Option：

NB6PGM
NB6PG



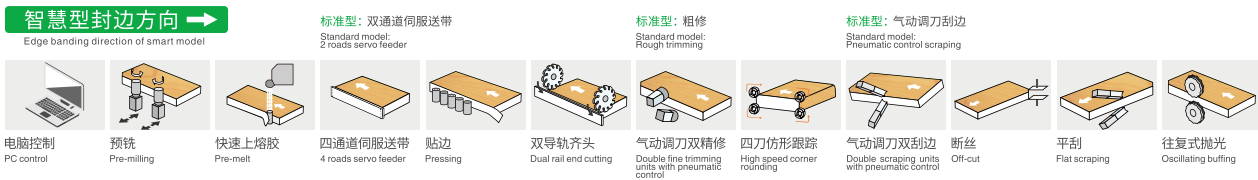
NB7PCG-PC

高速自动封边机

Edge banding machine with V-belt & double gluing units

可选Option：

NB7PCG (智慧型、标准型)
(Smart model, Standard model)



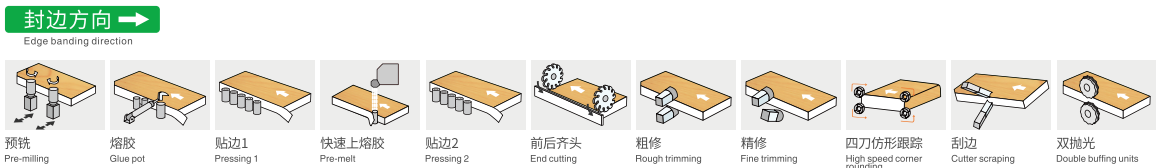
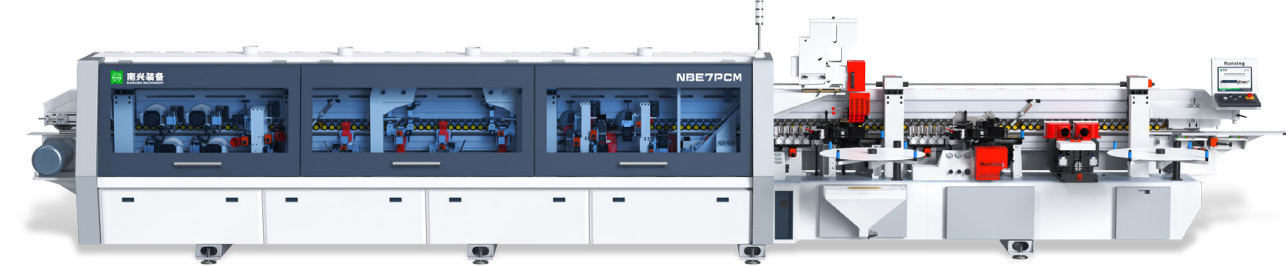
NBE7PCM

高速自动封边机

Edge banding machine with V-belt



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Find more from here



NB577D

自动封边机

Edge banding machine

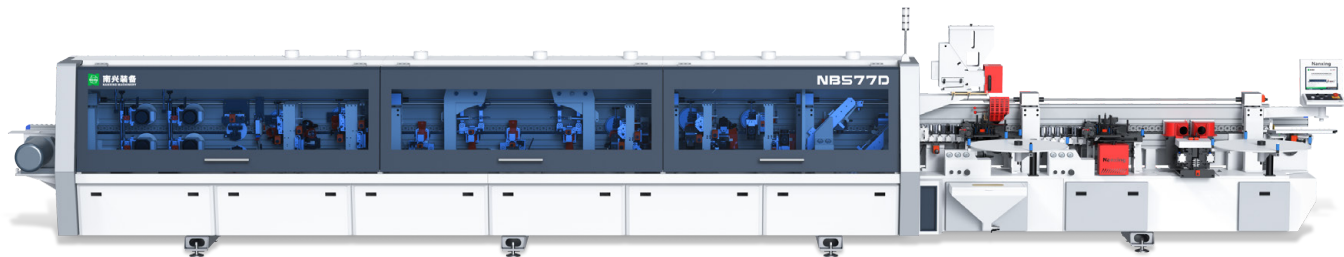
可选Option：

NB577D (标准型)
(Standard model)

- 双导轨齐头
- 四刀仿形跟踪
- 可选：电脑控制
- Dual rail end cutting
- High speed corner rounding by 4motors
- Option: PC control

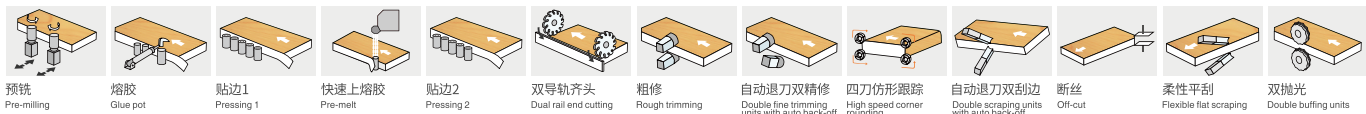


扫码了解更多
Find more from here



智慧型封边方向 →

Edge banding direction of smart model



NB7CJM

自动封边机

Edge banding machine

可选Option：

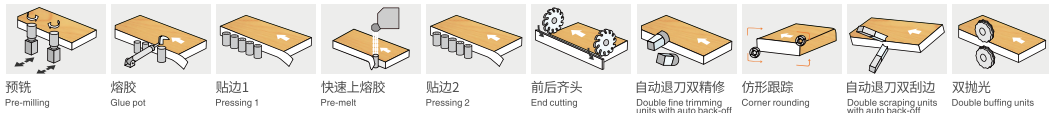
NB7CJM (标准型)
(Standard model)
NB6CJM

- 自动供胶装置
- 可选：双色免清洗PUR涂胶
- 可选：电脑控制
- Automatic glue supply device
- Optional: two-color no-cleaning PUR glue
- Option: PC control



智慧型封边方向 →

Edge banding direction of smart model



NB6JM

自动封边机

Edge banding machine

封边方向 →

Edge banding direction



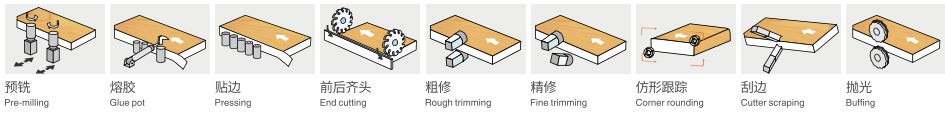
NB7CJ

自动封边机

Edge banding machine

封边方向 →

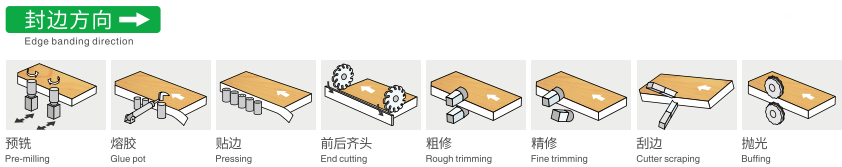
Edge banding direction



NB6J

自动封边机

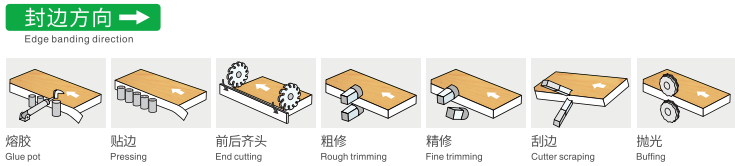
Edge banding machine



NB5J

自动封边机

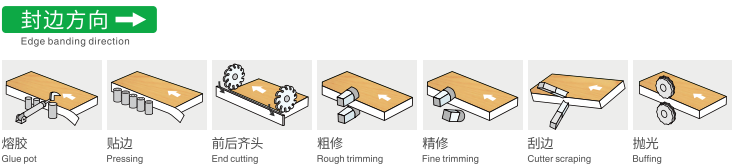
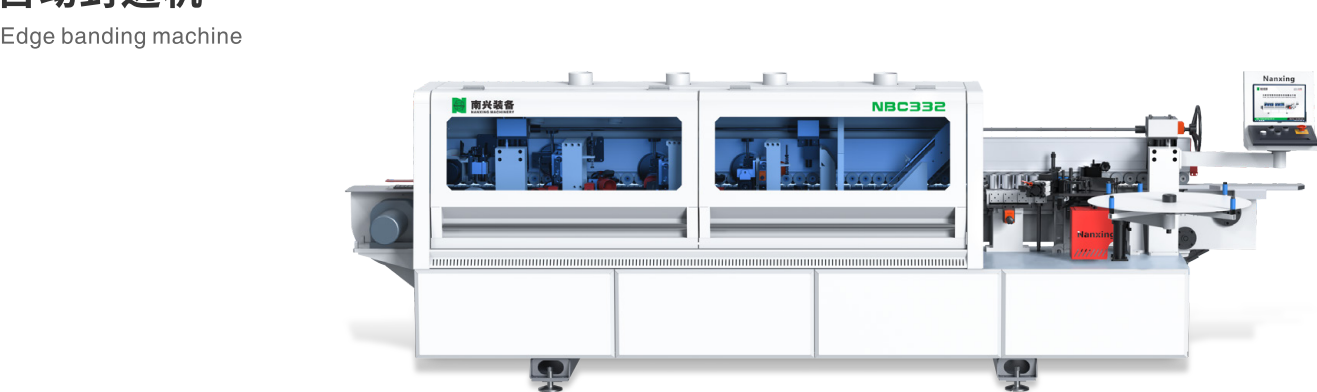
Edge banding machine



NBC332

自动封边机

Edge banding machine



MF80S

手动封边机

Manual edge banding machine

可选Option :
MF50S



NB577DN

窄板自动封边机

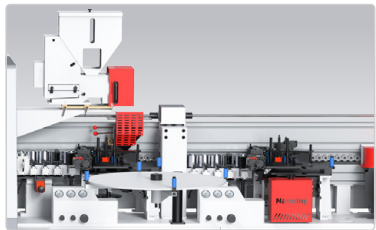
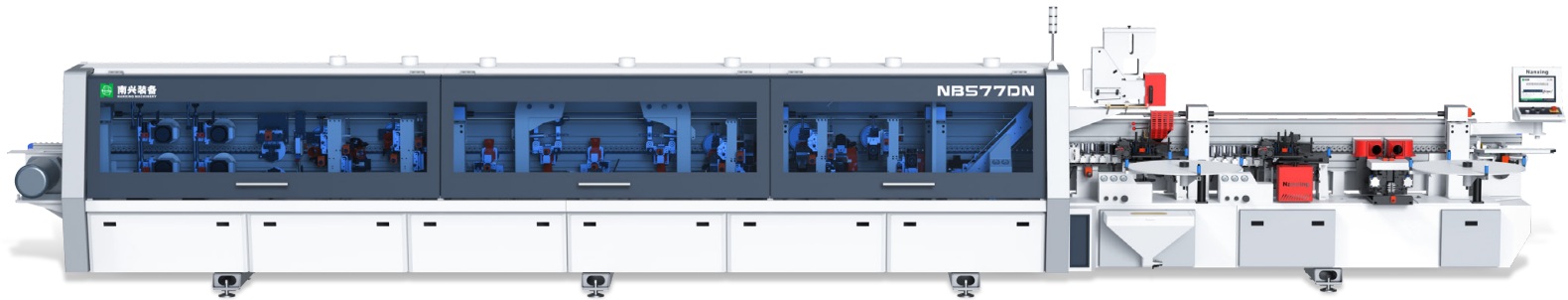
Edge banding machine for narrow parts

可选Option :

NB577DN(标准型)
(Standard model)

- 最小封边宽度40mm
- 四刀仿形跟踪
- 可选: 电脑控制
- 可选: 双通道送带

- Min. workpiece width 40mm
- High speed corner rounding by 4motors
- Option: PC control
- Optional: 2 roads tape feeder



双胶缸一键切换
Double gluing units One button switch



可选: 双色免清洗PUR涂胶
Optional: two-color no-cleaning PUR glue

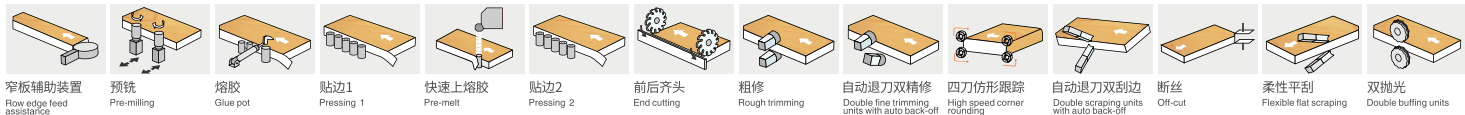


四刀仿形跟踪
High speed corner rounding by 4motors



扫码了解更多
Find more from here

智慧型封边方向 →
Edge banding direction of smart model



NB7CJMN

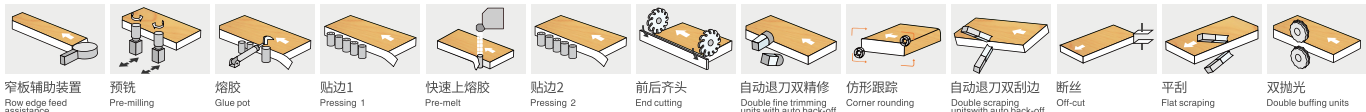
窄板自动封边机

Edge banding machine with double gluing units for narrow parts

- 最小封边宽度40mm
- 可选: 双色免清洗PUR涂胶
- Min. workpiece width 40mm
- Optional: two-color no-cleaning PUR glue



封边方向 →
Edge banding direction



扫码了解更多
Find more from here

NB6JMN

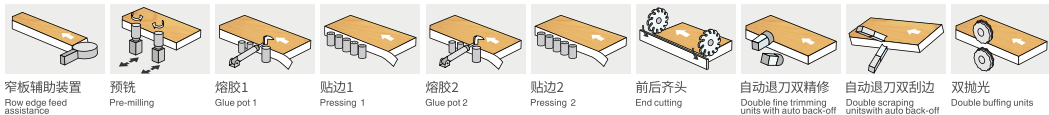
窄板自动封边机

Edge banding machine for narrow parts

- 最小封边宽度30mm
- Min. workpiece width 30mm



封边方向 →
Edge banding direction



NB875

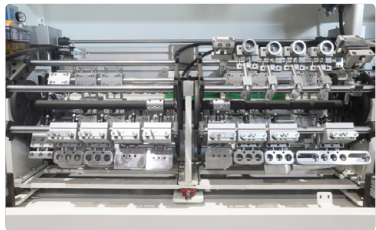
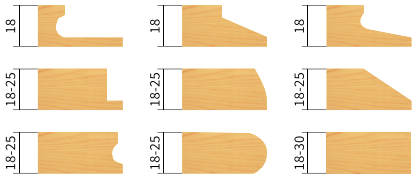
软成型自动封边机

Soft forming auto edge banding machine

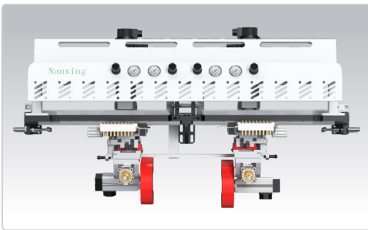
- 三组独立的成型铣刀
- 三组贴边轮可快速切换

- Three sets of independent form milling cutters
- Three sets of press rollers quick switch

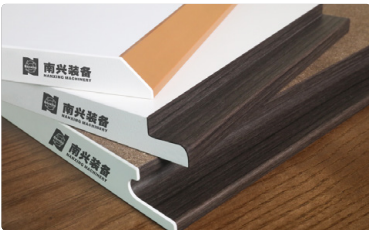
可选任意三组加工工艺
Can choose any three groups of process diagram



异型贴边轮
Soft forming press roller



伺服水平齐头
Servo controlled flat end cutting

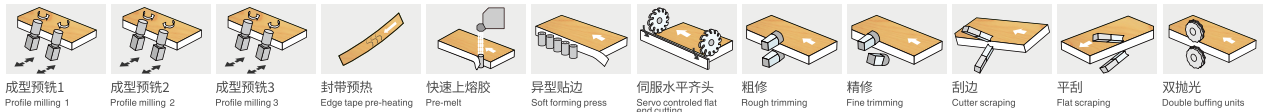


加工样板
Processing sample model



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Find more from here

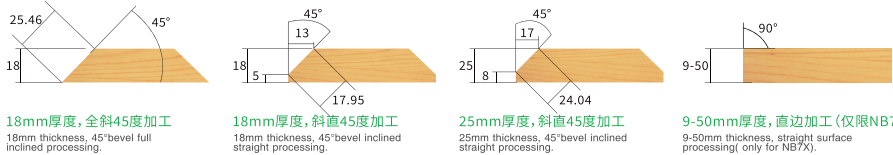
封边方向 →
Edge banding direction



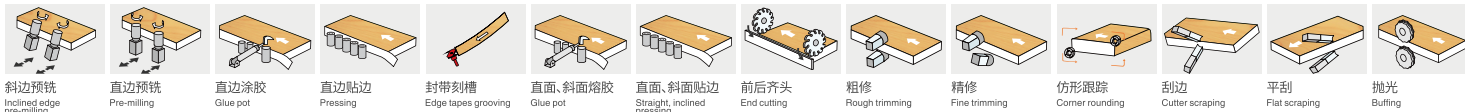
NB7X

斜边自动封边机

Edge banding machine for inclined edge



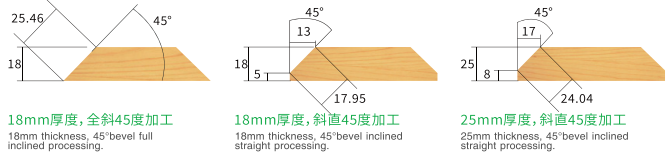
封边方向 →
Edge banding direction



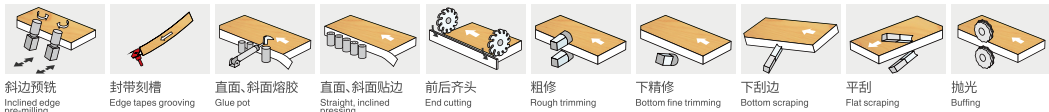
NB5X

斜边自动封边机

Edge banding machine for inclined edge



封边方向 →
Edge banding direction



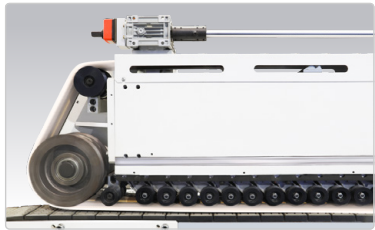
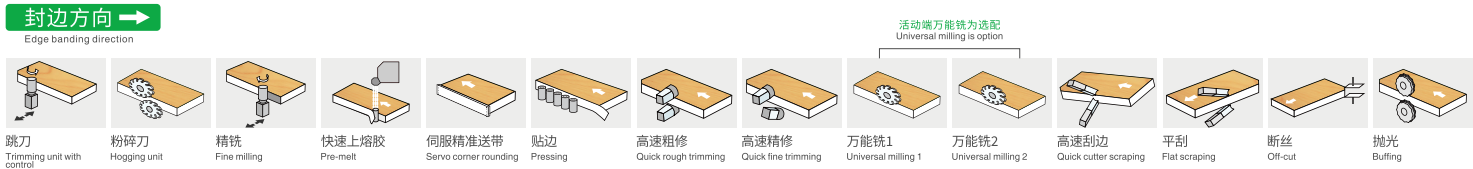
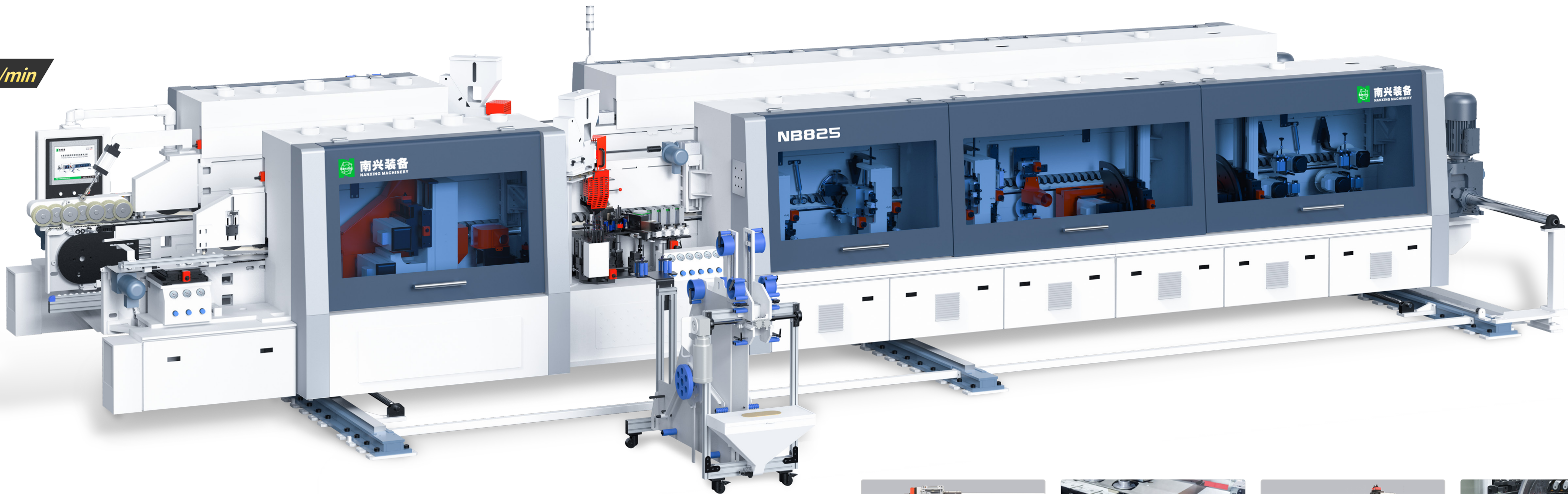
NB825

重型高速双端封边机

High speed double sided edge banding machine

- 超重型框架式机身
- 大功率伺服开合装置
- 双通道动力送带架
- 电脑控制
- Ultra-heavy frame-type machine body
- High-power servo opening and closing device
- 2 roads powered tape feeder
- PC control

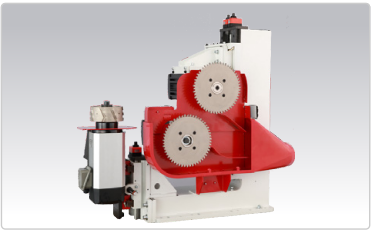
速度 **50m/min**



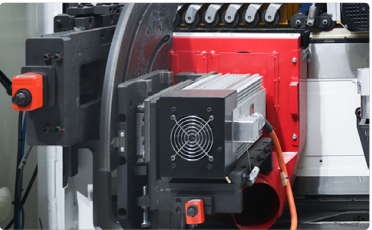
钢制压梁，履带压料
Steel pressure beam, top presser by v-belt



重型坦克链
Heavy-duty tank chain



粉碎刀
Hogging unit



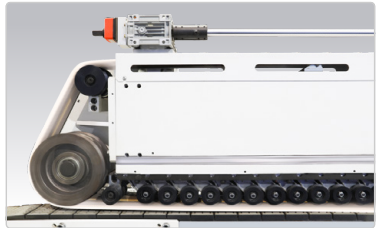
万能铣
Universal milling

NB826

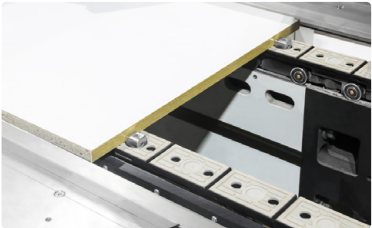
重型高速双端封边机

High speed double sided edge banding machine

- 超重型框架式机身
 - 大功率伺服开合装置
 - 双通道动力送带架
 - 电脑控制
- Ultra-heavy frame-type machine body
 - High-power servo opening and closing device
 - 2 roads powered tape feeder
 - PC control



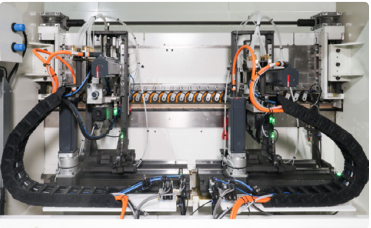
钢制压梁, 履带压料
Steel pressure beam, top presser by v-belt



重型坦克链定位规方装置
Heavy-duty tank chain stop cams device

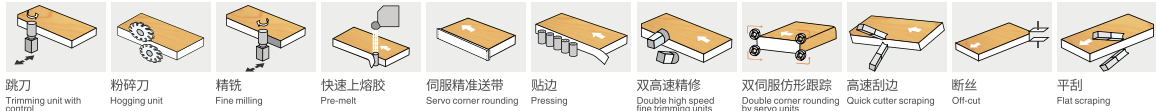


贴边轮
Press roller



伺服仿形跟踪
corner rounding by servo

封边方向 →
Edge banding direction



NB6S2IIP

双端自动封边机

Double sided edge banding machine with V-belt

可选Option :

NB7HS2P
NB7CS2IIP

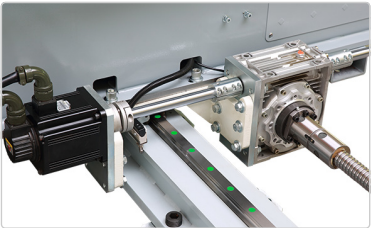
- 重型整体式机架
 - 可选: 窄板进料辅助装置
- Heavy-duty integrated machine body
 - Optional: narrow plate feed assistance



履带压料
Top presser by v-belt



重型坦克链定位规方装置
Heavy-duty tank chain stop cams device

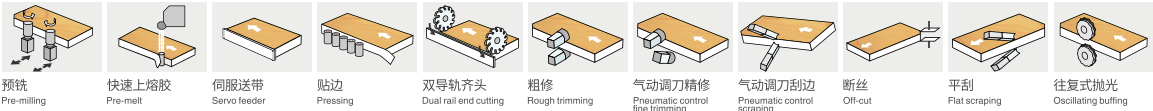


大功率伺服开合装置
High-power servo opening and closing device



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封边方向 →
Edge banding direction



单端封边机主要技术参数

MAIN TECHNICAL PARAMETERS OF SINGLE SIDE EDGE BANDING MACHINE

型号 Model	工件长度 Workpiece length	工件宽度 Workpiece width	最小工件尺寸 Min. Workpiece size	工件厚度 Workpiece thickness	封带厚度 Edge tape thickness	进给速度 Feeding speed	总功率 Total power	净重 Net weight	设备尺寸 Overall dimension
NB10-Smart	≥120mm	≥80mm	120×120mm (西边) 200×80mm (长边)	9-60mm	0.8-3mm	20/26/32/40m/min 32m/min (开跟踪)	----	----	12800×900×1900mm
NB9-Smart	≥120mm	≥80mm	120×120mm (西边) 200×80mm (长边)	9-60mm	0.8-3mm	20/26/32/40m/min 32m/min (开跟踪)	----	----	11500×900×1900mm
NB8-Smart	≥120mm	≥80mm	120×120mm (西边) 200×80mm (长边)	9-60mm	0.4-3mm	19/25/30m/min 32m/min (开跟踪)	----	----	11200×1050×1850mm
NB-Laser10	≥120mm ≥200mm (开跟踪)	≥80mm	120×120mm (西边) 200×80mm (长边)	9-60mm 9-35mm (激光)	0.4-3mm 0.8-3mm (激光)	19/25/32m/min 25m/min (开跟踪)	45kw	----	11650×1050×2100mm
NB-Laser9	≥120mm ≥200mm (开跟踪)	≥80mm	120×120mm (西边) 200×80mm (长边)	9-60mm 9-35mm (激光)	0.4-3mm 0.8-3mm (激光)	18/22/26m/min 22m/min (开跟踪)	42kw	6200kg	11200×1050×1850mm
NB8PCGM-PC	≥120mm ≥200mm (开跟踪)	≥80mm	120×120mm (西边) 200×80mm (长边)	9-60mm	0.4-3mm	18/22/26m/min	35.5kw	6800kg	11650×1050×1850mm (单机) 11350×1050×1850mm (连线)
NB7PCGM-PC	≥120mm ≥200mm (开跟踪)	≥80mm	120×120mm (西边) 200×80mm (长边)	9-60mm	0.4-3mm	18/22/26m/min	42kw	6110kg	11200×1050×1850mm (单机) 10900×1050×1850mm (连线)
NB7PCGM (智慧型)	≥120mm ≥200mm (开跟踪)	≥80mm	120×120mm (西边) 200×80mm (长边)	9-60mm	0.4-3mm	18/22/26m/min	37kw	6110kg	11200×1050×1850mm (单机) 10900×1050×1850mm (连线)
NB7PCGM (标准型)	≥120mm ≥200mm (开跟踪)	≥80mm	120×120mm (西边) 200×80mm (长边)	9-60mm	0.4-3mm	18/22/26m/min	37kw	6110kg	11200×1050×1850mm (单机) 10900×1050×1850mm (连线)
NB6PGM-PC	≥120mm	≥80mm	120×120mm (西边) 200×80mm (长边)	9-60mm	0.4-3mm	18/22/26m/min	39kw	4750kg	9650×1050×1850mm (单机) 9350×1050×1850mm (连线)
NB6PGM	≥120mm	≥80mm	120×120mm (西边) 200×80mm (长边)	9-60mm	0.4-3mm	18/22/26m/min	36kw	4750kg	9650×1050×1850mm (单机) 9350×1050×1850mm (连线)
NB6PG	≥120mm	≥80mm	120×120mm (西边) 200×80mm (长边)	9-60mm	0.4-3mm	18/22/26m/min	28kw	4340kg	8600×1050×1850mm
NB7PCG-PC	≥120mm ≥200mm (开跟踪)	≥80mm	120×120mm (西边) 200×80mm (长边)	9-60mm	0.4-3mm	18/22/26m/min	30kw	4750kg	9650×1050×1850mm (单机) 9350×1050×1850mm (连线)
NB7PCG (智慧型)	≥120mm ≥200mm (开跟踪)	≥80mm	120×120mm (西边) 200×80mm (长边)	9-60mm	0.4-3mm	18/22/26m/min	30kw	4750kg	9650×1050×1850mm (单机) 9350×1050×1850mm (连线)
NB7PCG (标准型)	≥120mm ≥200mm (开跟踪)	≥80mm	120×120mm (西边) 200×80mm (长边)	9-60mm	0.4-3mm	18/22/26m/min	30kw	4750kg	9650×1050×1850mm (单机) 9350×1050×1850mm (连线)
NBE7PCM	≥120mm ≥200mm (开跟踪)	≥80mm	120×120mm (西边) 200×80mm (长边)	9-60mm	0.4-3mm	16/20/24m/min	35kw	3850kg	9800×1050×1650mm
NB577D (智慧型)	≥120mm ≥200mm (开跟踪)	≥60mm	120×120mm (西边) 200×60mm (长边)	9-60mm	0.4-3mm	18/22/26m/min	36.2kw	4350kg	11200×1050×1850mm
NB577D (标准型)	≥120mm ≥200mm (开跟踪)	≥60mm	120×120mm (西边) 200×60mm (长边)	9-60mm	0.4-3mm	18/22/26m/min	35.2kw	4030kg	10400×1050×1850mm
NB7CJM (智慧型)	≥120mm ≥200mm (开跟踪)	≥60mm	120×120mm (西边) 120×60mm (长边)	9-60mm	0.4-3mm	16/20/24m/min	33.7kw	3670kg	9800×1050×1850mm (单机) 9610×1050×1850mm (连线)
NB7CJM (标准型)	≥120mm ≥200mm (开跟踪)	≥60mm	120×120mm (西边) 120×60mm (长边)	9-60mm	0.4-3mm	16/20/24m/min	33.7kw	3670kg	9800×1050×1850mm (单机) 9610×1050×1850mm (连线)
NB6CJM	≥120mm ≥200mm (开跟踪)	≥60mm	120×120mm (西边) 120×60mm (长边)	9-60mm	0.4-3mm	16/20/24m/min	22.6kw	3670kg	9800×1050×1650mm
NB6JM	≥120mm	≥40mm	120×120mm (西边) 120×40mm (长边)	9-60mm	0.4-3mm	16/20/24m/min	29.3kw	3200kg	8750×1050×1650mm
NB7CJ	≥120mm ≥200mm (开跟踪)	≥60mm	120×120mm (西边) 120×60mm (长边)	9-60mm	0.4-3mm	16/20/24m/min	24kw	2800kg	7700×1050×1650mm

型号 Model	工件长度 Workpiece length	工件宽度 Workpiece width	最小工件尺寸 Min. Workpiece size	工件厚度 Workpiece thickness	封带厚度 Edge tape thickness	进给速度 Feeding speed	总功率 Total power	净重 Net weight	设备尺寸 Overall dimension
NB6J	≥120mm	≥40mm	120×120mm (西边) 120×40mm (长边)	9-60mm	0.4-3mm	16/20/24m/min	23kw	2400kg	6600×1050×1650mm
NB5J	≥120mm	≥40mm	120×120mm (西边) 120×40mm (长边)	9-60mm	0.4-3mm	16/20/24m/min	14.4kw	1880kg	5500×1050×1650mm
NBC332	≥120mm	≥60mm	120×120mm (西边) 120×60mm (长边)	9-60mm	0.4-3mm	16/20/24m/min	12.2kw	1620kg	5040×1050×1440mm
MF80S MF50S	----	----	----	----	10-80mm (厚度) 10-80mm (0.3-3)	1-18m/min	2.2kw	310kg	1800×1120×1150mm
NB577DN (智慧型)	≥120mm ≥200mm (开跟踪)	≥40mm	120×120mm (西边) 200×40mm (长边) 200×40mm (短边)	9-60mm	0.4-3mm	18/22/26m/min	36.8kw	4350kg	11200×1050×1850mm
NB577DN (标准型)	≥120mm ≥200mm (开跟踪)	≥40mm	120×120mm (西边) 200×40mm (长边) 200×40mm (短边)	9-60mm	0.4-3mm	18/22/26m/min	35.8kw	4030kg	10400×1050×1850mm
NB7CJMN	≥120mm	≥40mm	120×120mm (西边) 200×40mm (长边) 200×40mm (短边)	9-60mm	0.4-3mm	16/20/24m/min	33.7kw	3670kg	9800×1050×1850mm (单机) 9610×1050×1850mm (连线)
NB6JMN	≥120mm	≥30mm	120×120mm (西边) 200×30mm (长边) 200×30mm (短边)	9-60mm	0.4-3mm	16/20/24m/min	29.3kw	3200kg	8750×1050×1650mm

软成型/斜边封边机主要技术参数

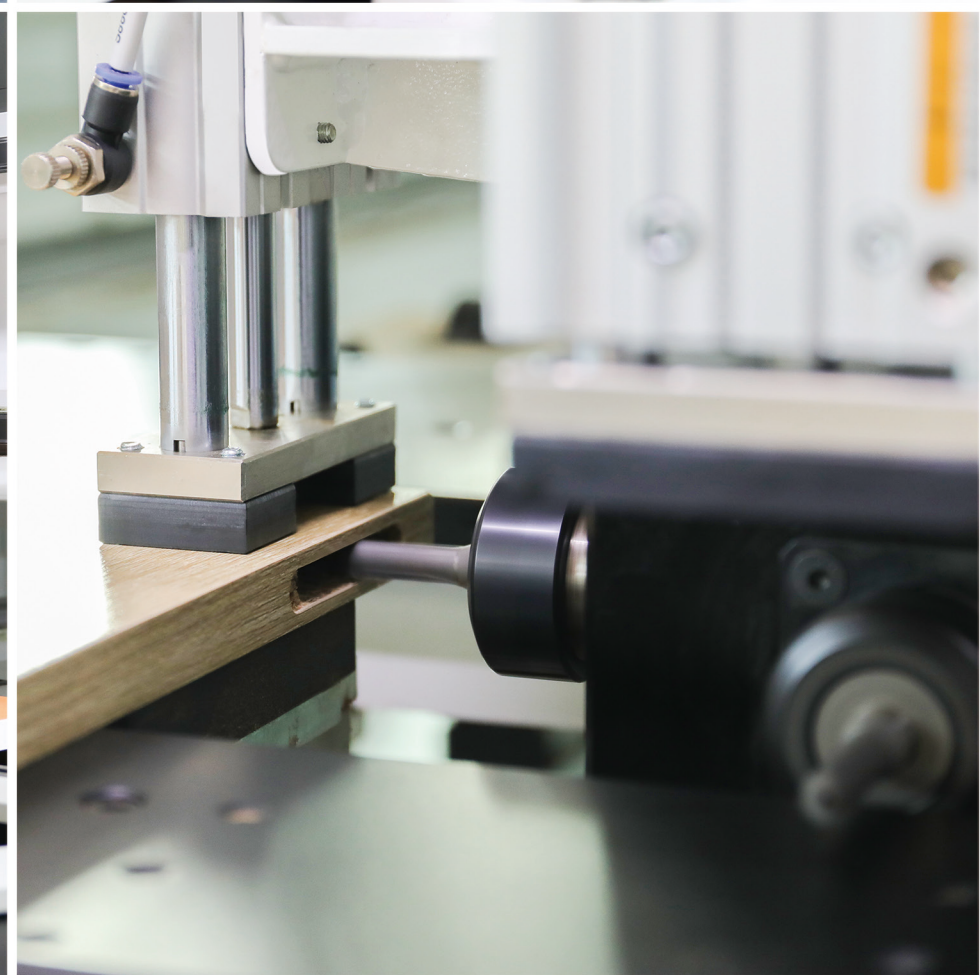
MAIN TECHNICAL PARAMETERS OF SOFT FORMING EDGE BANDING MACHINE

型号 Model	最小工件尺寸 Min. Workpiece size	工件厚度 Workpiece thickness	封带厚度 Edge tape thickness	封直边工件厚度 Straight surface banding thickness	封直斜边工件厚度 Inclined and straight surface edge banding thickness	封全斜边工件厚度 Full inclined surface edge banding thickness	进给速度 Feeding speed	总功率 Total power	净重 Net weight	设备尺寸 Overall dimension
NB875	250×150mm	≥18-60mm (封直边) ≥18-25mm (软成型)	≥0.4-0.6mm (异形边) ≥0.6-2.0mm (直边) ≥0.6-2.0mm (直斜边)	----	----	----	12-16m/min	42kw	4800kg	11600×1050×1900mm
NB7X	150×120mm	----	0.6-2mm	9-50mm	15-25mm	15-25mm	14m/min 24m/min (封直边)	42kw	3900kg	9800×1050×1650mm
NB5X	150×120mm	15-25mm	0.6-2mm	----	15-25mm	15-25mm	14/16m/min	33kw	3000kg	7700×1050×1650mm

双端封边机主要技术参数

MAIN TECHNICAL PARAMETERS OF DOUBLE SIDES EDGE BANDING MACHINE

型号 Model	最大工件尺寸 Max. workpiece size	最小工件尺寸 Min. Workpiece size	工件厚度 Workpiece thickness	封带厚度 Edge tape thickness	进给速度 Feeding speed	总功率 Total power	净重 Net weight	设备尺寸 Overall dimension
NB825	1220×2440mm	200×250mm	9-60mm	0.4-3mm	20-50m/min	114kw	20000kg	10630×3460×1950mm
NB826	1220×2440mm	200×250mm	9-60mm	0.4-3mm	20-35m/min	140kw	26000kg	13265×4960×1950mm
NB6S2IIP	1220×2440mm	285×285mm	9-60mm	0.4-3mm	16-20m/min	51kw	11550kg	9500×4400×1950mm
NB7HS2P	1220×2440mm	285×285mm	9-60mm	0.4-3mm	16-20m/min	56kw	11600kg	9500×4400×1950mm
NB7CS2IIP	1220×2440mm	285×285mm	9-60mm	0.4-3mm	16-20m/min	53.4kw	12980kg	11000×4400×1950mm



钻孔系列

DRILL SERIES

NCB612DPL

双工位六面数控钻孔中心

CNC 6-Sided Drilling Machine with Double Work Station

可选Option : NCB612DPTL

钻孔效率
7.5 pcs/min

- 双独立控制系统
- 最小加工宽度为50mm
- 6钻包4主轴
- 台面规格：650+650mm, 可选：800+800mm、1200+650mm
- 可选：2组8刀位自动换刀

- Double independent control system
- Min. processing width : 50mm
- 6 drilling blocks, 4 spindles
- Specification of table: 650+650mm,Optional: 800+800、1200+650mm
- Optional: 2 groups of 8 tool positions automatic tool changer

NCB612DXL

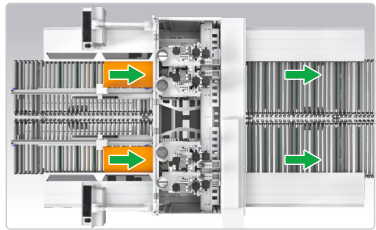
六面数控钻孔中心

CNC 6-sided drilling machine

可选Option : NCB612DXTL



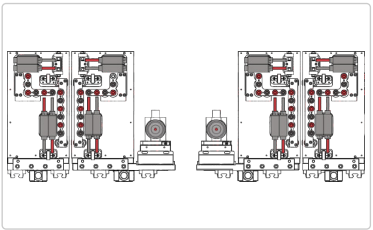
扫码了解更多
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自动进出料
Auto feed in and out



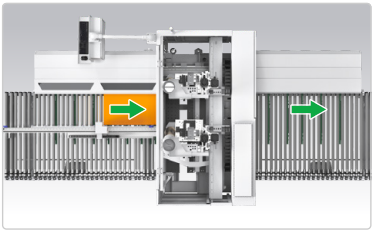
宽度自动检测及补偿
Automatic width detection and compensation



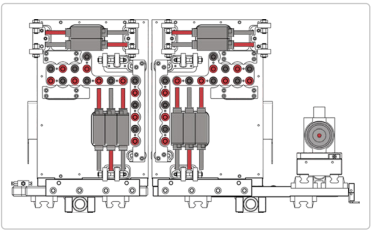
NCB612DPL上加工单元结构图
Structural diagram of the upper processing unit of NCB612DPL



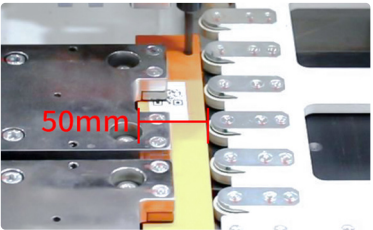
NCB612DPTL配置2组8刀位自动换刀刀库
2 sets 8-slot tool magazine of NCB612DPTL



自动进出料
Auto feed in and out



NCB612DXL上加工单元结构图
Structural diagram of the upper processing unit of NCB612DXL



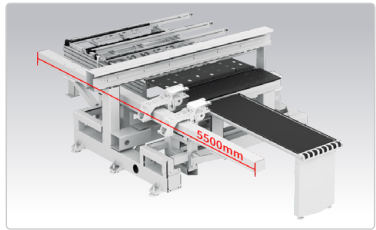
最小加工尺寸:50mm
Min. processing dimension: 50mm

NCB612DX

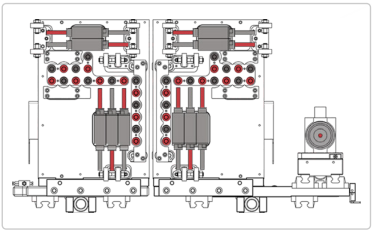
六面数控钻孔中心

CNC 6-sided drilling machine

- 单机最小加工宽度为30mm
- 上加工单元配置对称双钻包
- The min. processing width of a single machine is 30mm
- The upper processing unit is equipped with symmetrical double drilling blocks



重型整体式机架
Heavy-duty integrated machine body



NCB612DX上加工单元结构图
Structural diagram of the upper processing unit of NCB612DX



可选: 四夹手
Optional: four grippers



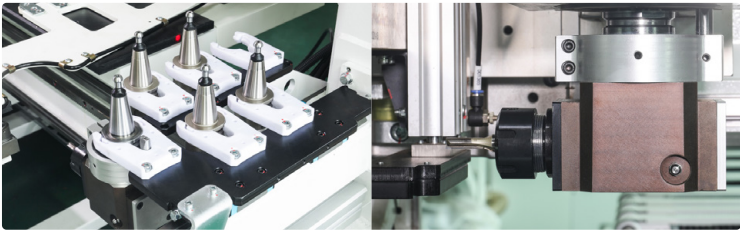
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NCB612DXT

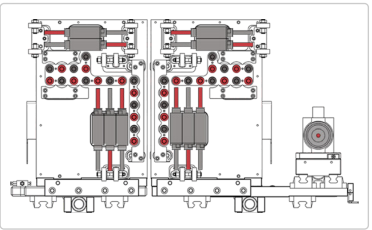
六面数控钻孔中心

CNC 6-sided drilling machine

- 单机最小加工宽度为30mm
- 上加工单元配置对称双钻包
- 配置自动换刀主轴和刀库
- 可选: 四夹手
- The min. processing width of a single machine is 30mm
- The upper processing unit is equipped with symmetrical double drilling blocks
- Auto tool changing spindle and magazine
- Optional: four grippers



可选: 六刀位自动换刀刀库和铣型角度头
Optional: ATC 6 by servo and single aggregate



NCB612DXT上加工单元结构图
Structural diagram of the upper processing unit of NCB612DXT



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NCB612T

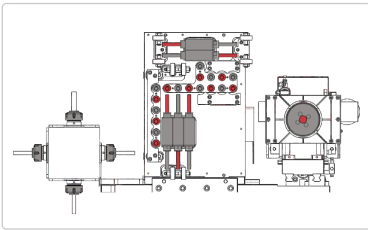
六面数控钻孔中心

CNC 6-sided drilling machine

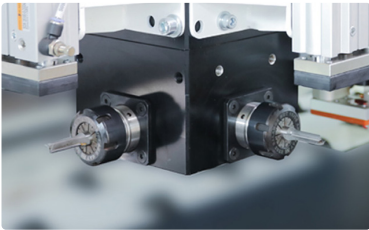
- 配置自动换刀主轴和刀库
- 可选：下加工单元增加主轴
- Auto tool changing spindle and magazine
- Option: Extra spindle on bottom processing unit



六刀位自动换刀刀库
ATC 6 by servo



NCB612T上加工单元结构图
Structural diagram of the upper processing unit
of NCB612T



十字主轴
Cross spindle



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Find more from here

NCB612FT

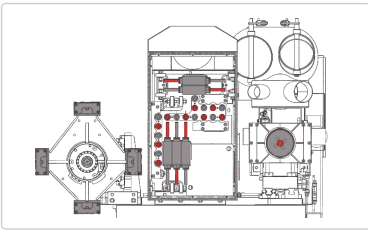
六面数控钻孔中心

CNC 6-sided drilling machine

- 配置自动换刀主轴和刀库
- 可选：下加工单元增加主轴
- Auto tool changing spindle and magazine
- Option: Extra spindle on bottom processing unit



八刀位自动换刀刀库
ATC 8 by servo



NCB612FT上加工单元结构图
Structural diagram of the upper processing unit
of NCB612FT



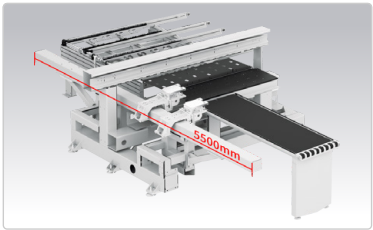
旋转角度头
Rotatable aggregate

NCB612

六面数控钻孔中心

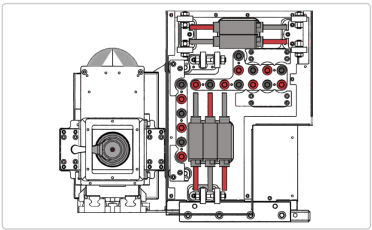
CNC 6-sided drilling machine

- 可选: X方向增加锯片NCB612S
- Optional: extra saw blade in X direction NCB612S



重型整体式机架

Heavy-duty integrated machine body



NCB612上加工单元结构图

Structural diagram of the upper processing unit of NCB612



双夹手

Twin grippers



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数控钻孔系列主要技术参数

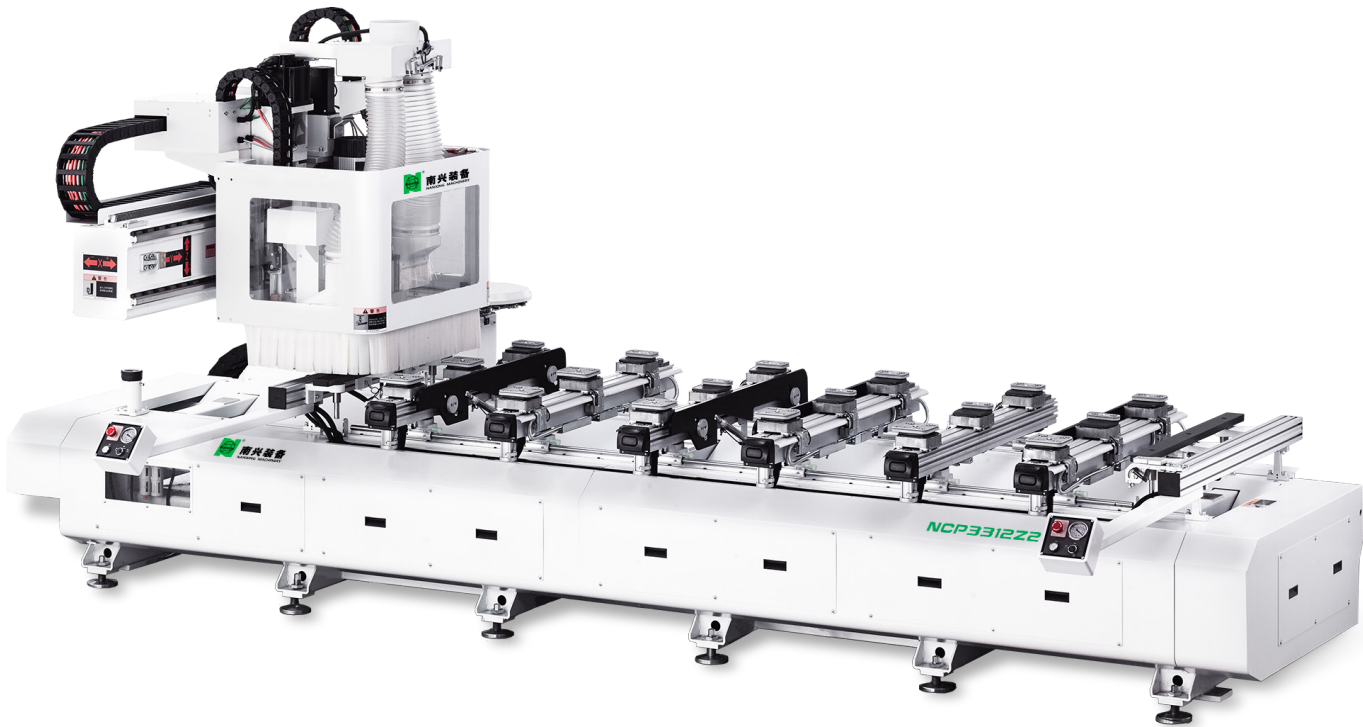
THE MAIN TECHNICAL PARAMETERS OF CNC DRILLING SERIES

型号 Model	板材长宽 Panel length	板材厚度 Panel thickness	最高速度(X/U/Y/Z) Max. speed (X/U/Y/Z)	主轴功率 Spindle power	钻包 Drill	总功率 Total power	净重 Net weight	设备尺寸 Overall dimension
NCB612	200-3000mm(长度) 30-1200mm(宽度)	10-60mm	135/135/75/ 30m/min	3.5kw(上主轴) 3.5kw(下主轴)	18(上垂直钻) X:6 Y:4(上水平钻) 9(下垂直钻)	18.03kw	3200kg	6150×2273×2325mm
NCB612S	200-3000mm(长度) 30-1200mm(宽度)	10-60mm	135/135/75/ 30m/min	3.5kw(上主轴)+1.7kw(锯片电机) 3.5kw(下主轴)	18(上垂直钻) X:6 Y:4(上水平钻) 9(下垂直钻)	19.73kw	3250kg	6150×2273×2325mm
NCB612DX	200-3000mm(长度) 30-1200mm(宽度)	10-60mm	135/135/75/ 30m/min	3.5kw(上主轴) 3.5kw(下主轴)	18×2(上垂直钻) X:6×2 Y:4×2(上水平钻) 9(下垂直钻)	21.93kw	3750kg	6150×2806×2325mm
NCB612DXS	200-3000mm(长度) 30-1200mm(宽度)	10-60mm	135/135/75/ 30m/min	3.5kw(上主轴)+1.7kw(锯片电机) 3.5kw(下主轴)	18×2(上垂直钻) X:6×2 Y:4×2(上水平钻) 9(下垂直钻)	23.63kw	3800kg	6150×2806×2325mm
NCB612DXT	200-3000mm(长度) 30-1200mm(宽度)	10-60mm	135/135/75/ 30m/min	5.5kw(上主轴) 3.5kw(下主轴)	18×2(上垂直钻) X:6×2 Y:4×2(上水平钻) 9(下垂直钻)	23.93kw	3850kg	6150×2806×2325mm
NCB612T	200-3000mm(长度) 30-1200mm(宽度) (十字主轴加工最大宽度800mm)	10-60mm	135/135/75/ 30m/min	5.5kw(上主轴)+4kw(十字主轴) 3.5kw(下主轴)	18(上垂直钻) X:6 Y:4(上水平钻) 9(下垂直钻)	24.48kw	3200kg	6150×2806×2325mm
NCB612FT	200-2800mm(长度) 30-1200mm(宽度) (角度头加工最大宽度800mm)	10-60mm	135/135/75/ 30m/min	5.5kw(上主轴)+5.5kw(旋转角度头) 3.5kw(下主轴)	18(上垂直钻) X:6 Y:4(上水平钻) 9(下垂直钻)	26.58kw	3350kg	6150×3006×2325mm
NCB612DPL	250-2800mm(长度) 左工位:50-650mm;右工位:50-650mm(宽度) 可选(左工位:50-800mm,右工位:50-800mm) 可选(左工位:50-1200mm,右工位:50-650mm)	10-60mm	135/135/75/ 30m/min	3.5kw×2(上主轴) 3.5kw×2(下主轴)	12×4(上垂直钻) X:4×4 Y:2×4(上水平钻) 9×2(下垂直钻)	48.36kw	8000 8250kg(选配)	7390×3530×2325mm 7390×4080×2325mm
NCB612DXL	250-2800mm(长度) 50-1200mm(宽度)	10-60mm	135/135/75/ 30m/min	3.5kw(上主轴) 3.5kw(下主轴)	18×2(上垂直钻) X:6×2 Y:4×2(上水平钻) 9(下垂直钻)	24.18kw	4710kg	7390×2806×2325mm
NCB612DXTL	250-2800mm(长度) 50-1200mm(宽度)	10-60mm	135/135/75/ 30m/min	5.5kw(上主轴) 3.5kw(下主轴)	18×2(上垂直钻) X:6×2 Y:4×2(上水平钻) 9(下垂直钻)	26.18kw	4810kg	7390×2806×2325mm

NCP3312Z2

加工中心
CNC machining center

可选Option : NCP5312Z2



梁式台面
Beam table



十二刀位伺服换刀刀库
ATC 12 by servo



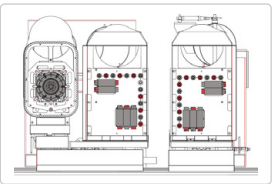
可选:C轴/角度头
Optional: C-axis/ aggregate

NCG3312DA

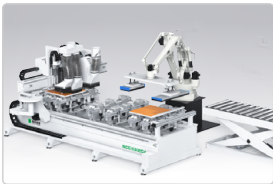
加工中心
CNC machining center



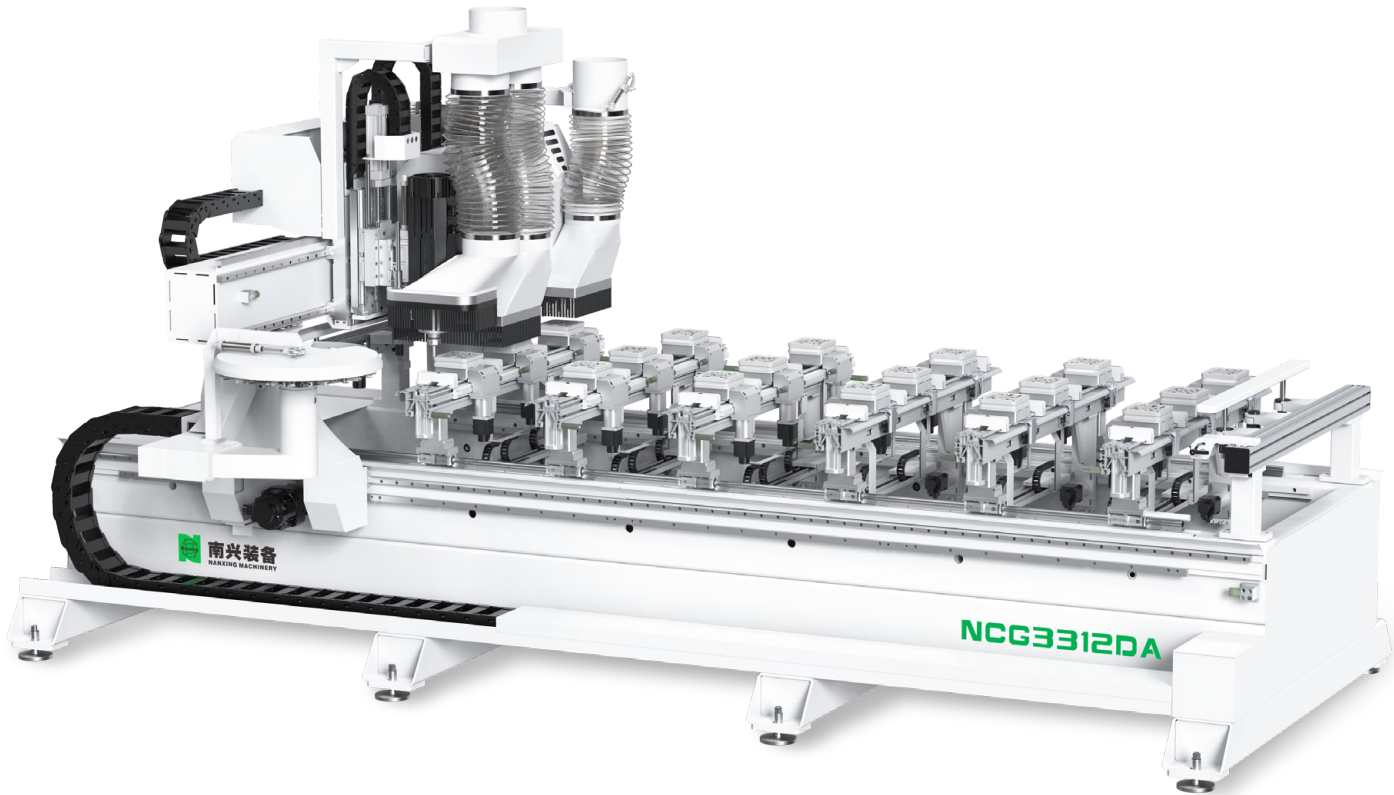
伺服控制梁式台面
Beam Table by servo control



NCG3312DA上加工单元机构图
Structural diagram of the upper processing unit
of NCG3312DA



机器人上下料
Loading and unloading by robot



加工中心主要技术参数

THE MAIN TECHNICAL PARAMETERS OF CNC MACHINE SERIES

型号 Model	台面尺寸 Work table dimension	最高速度(X/Y/Z) Max. speed (X/Y/Z)	主轴功率 Spindle power	钻包 Drill	刀库容量 Tool magazine capacity	锯片数量 Quantity of saw blades	真空泵功率 Vacuum pump power	总功率 Total power	净重 Net weight	设备尺寸 Overall dimension
NCP3312Z2	3300×1250mm	80/80/30m/min	12kw	14(垂直钻) x:2×2;y:2×2(水平钻)	12	1	5.5kw	29kw	4800kg	5220×2600×2620mm
NCP5312Z2	3300×1250mm	80/80/30m/min	12kw	14(垂直钻) x:2×2;y:2×2(水平钻)	12	1	5.5kw×2	35kw	7000kg	7220×2600×2620mm
NCG3312DA	3300×1250mm	70/70/30m/min	12kw	14×2(垂直钻) x:(3+3)×2;y:(2+2)×2(水平钻)	12	1	5.5kw	33kw	4500kg	5500×2500×2300mm

NDC662A

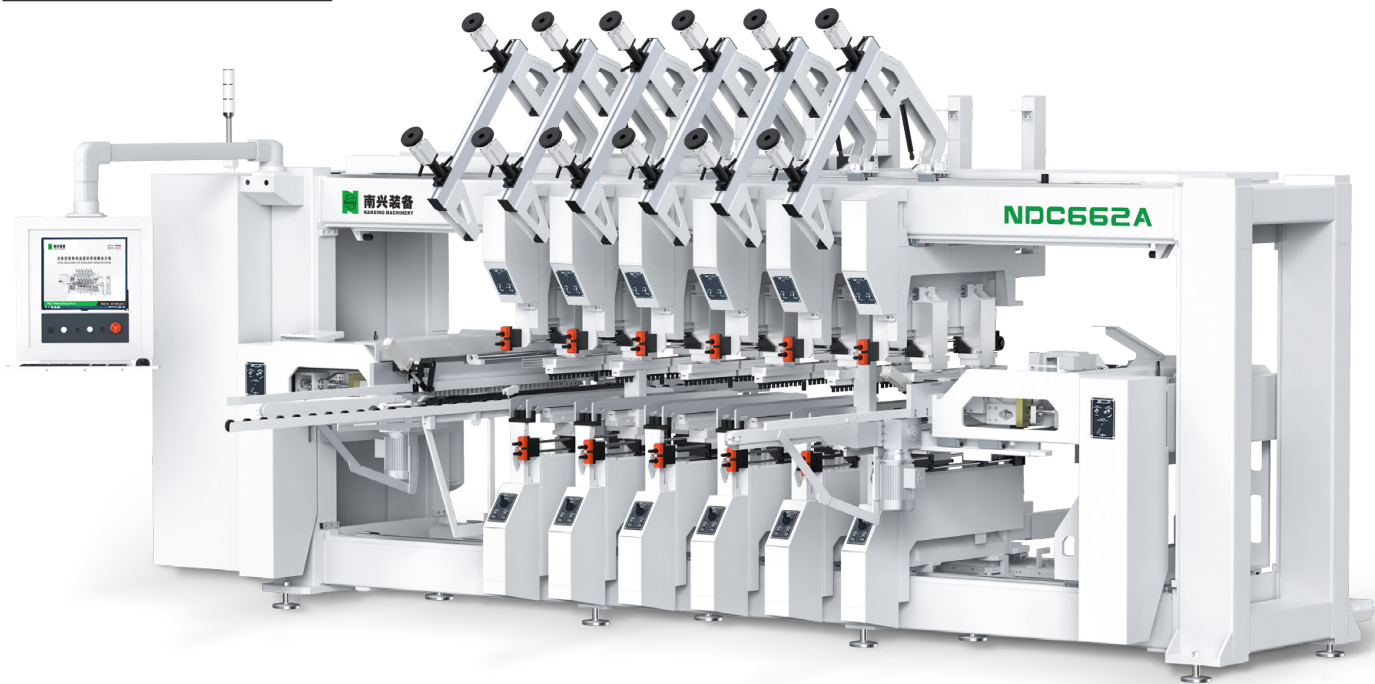
数控排钻

Throughfeed drilling machine with servo driven

可选Option : NDC532A、NDC642A

- 垂直孔最小间距128mm
- Min. vertical hole spacing 128mm

最高效率
24 pcs/min



NDC402

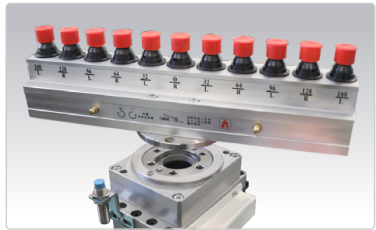
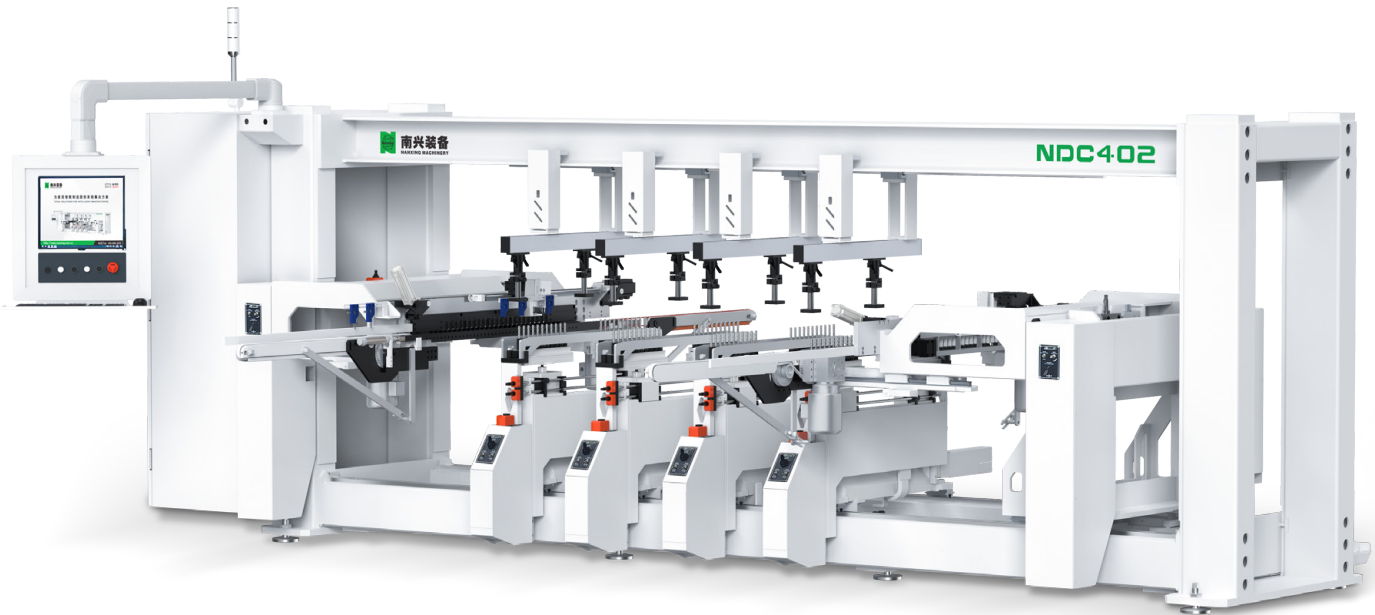
数控排钻

Throughfeed drilling machine with servo driven

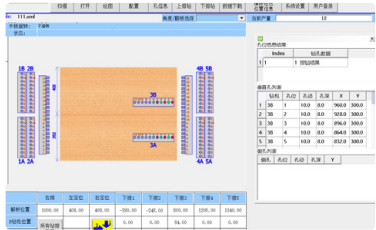
可选Option : NDC532、NDC642

- 垂直钻排采用伺服驱动
- 垂直孔最小间距128mm

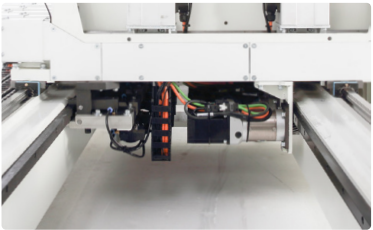
- Vertical drilling row drive by servo
- Min. vertical hole spacing 128mm



快换式钻包(可定做特殊钻包)
Quick change drilling block (can customize)



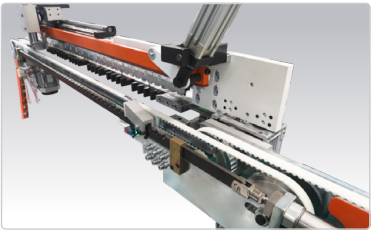
专业钻孔优化软件
Professional drilling optimizing software



钻排水平、垂直方向采用伺服驱动
(可选:升降伺服驱动)
The horizontal and vertical directions
of the drill rows are driven by servo
(optional: lifting servo drive)



电脑控制
PC control

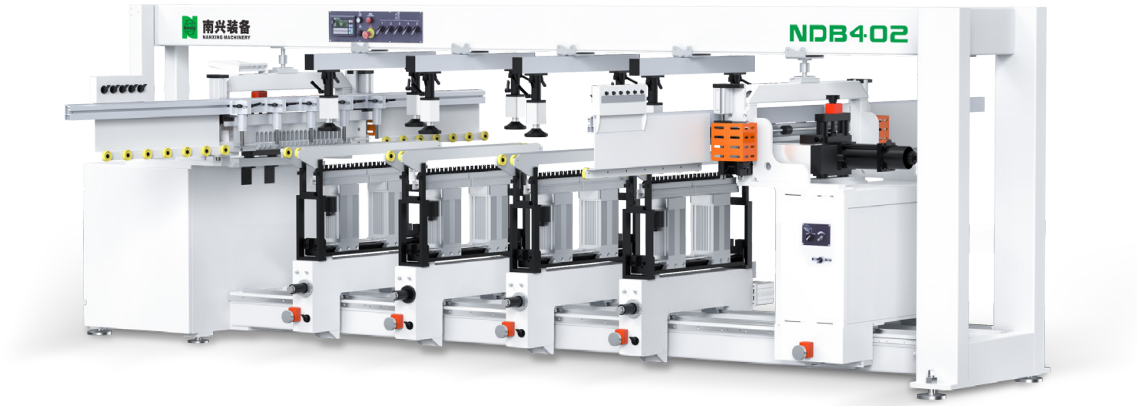


三段式送料装置
Three-stage feeding device

NDB402

多排多轴钻

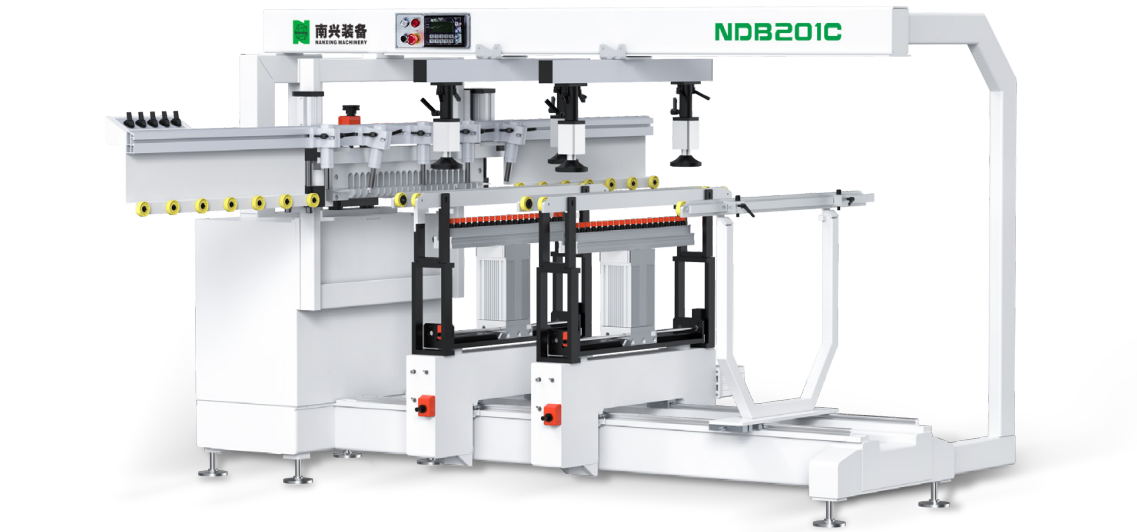
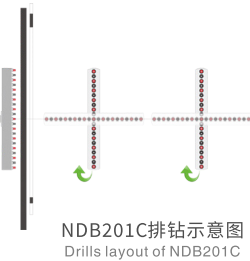
Drilling machine



NDB201C

多排多轴钻

Drilling machine



数控排钻系列主要技术参数

THE MAIN TECHNICAL PARAMETERS OF DRILLING MACHINE WITH SERVO DRIVED

型号 Model	板材最大宽度 Max. panel width	板材最小宽度 Min. panel width	板材最大厚度 Max. panel thickness	钻轴中心距 Spacing of drills	垂直钻最大钻孔深度 Max. drilling depth of vertical drills	水平钻最大钻孔深度 Max. drilling depth of horizontal drills	总功率 Total power	净重 Net weight	设备尺寸 Overall dimension
NDC662A	2550mm	250mm	60mm	32mm	45mm	40mm	62kw	7600kg	5540×3660×2350mm
NDC532A	2550mm	250mm	60mm	32mm	45mm	40mm	48.5kw	6700kg	5540×3660×2200mm
NDC642A	2550mm	250mm	60mm	32mm	45mm	40mm	57kw	7100kg	5540×3660×2200mm
NDC742A	2550mm	250mm	50mm	32mm	50mm	40mm	58.1kw	7400kg	5540×3660×2200mm
NDC402	2550mm	250mm	60mm	32mm	45mm	40mm	25kw	5200kg	5540×3660×1950mm
NDC532	2550mm	250mm	60mm	32mm	45mm	40mm	40kw	6700kg	5540×3660×2200mm
NDC642	2550mm	250mm	60mm	32mm	45mm	40mm	47kw	7100kg	5540×3660×2200mm

多排多轴钻系列主要技术参数

THE MAIN TECHNICAL PARAMETERS OF DRILLING MACHINE

型号 Model	板材最大宽度 Max. panel width	板材最小宽度 Min. panel width	板材最大厚度 Max. panel thickness	钻轴中心距 Spacing of drills	垂直钻最大钻孔深度 Max. drilling depth of vertical drills	水平钻最大钻孔深度 Max. drilling depth of horizontal drills	总功率 Total power	净重 Net weight	设备尺寸 Overall dimension
NDA402	2650mm	250mm	70mm	32mm	70mm	40mm	15kw	2400kg	4790×2635×1670mm
NDB402	2850mm	220mm	70mm	32mm	70mm	40mm	13.4kw	2200kg	4800×2835×1670mm
NDB301	2500mm	----	70mm	32mm	70mm	40mm	9.3kw	1470kg	3460×2835×1670mm
NDB201	2500mm	----	70mm	32mm	70mm	40mm	6.7kw	1300kg	3460×2835×1670mm
NDB201C	1700mm	----	70mm	32mm	70mm	40mm	4.1kw	1100kg	2550×2835×1510mm
NDA232	210mm	15mm	25mm	32mm 可定制钻包 (标配)	25mm	----	11.5kw	2800kg	3150×1520×1820mm
NDA022	260mm	15mm	25mm	32mm 可定制钻包 (标配)	25mm	----	6.5kw	1700kg	3150×1660×1820mm



智能工作站及整体解决方案

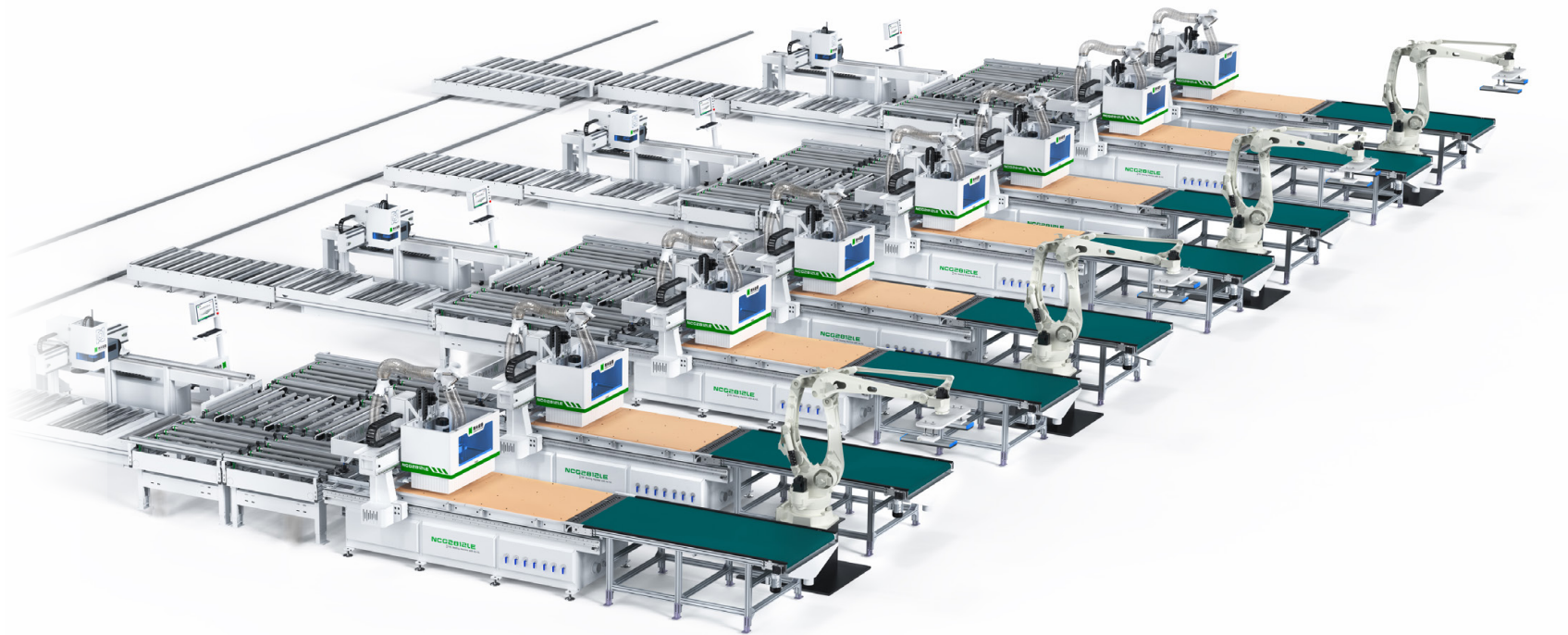
INTELLIGENT WORK STATION
AND TOTAL SOLUTION



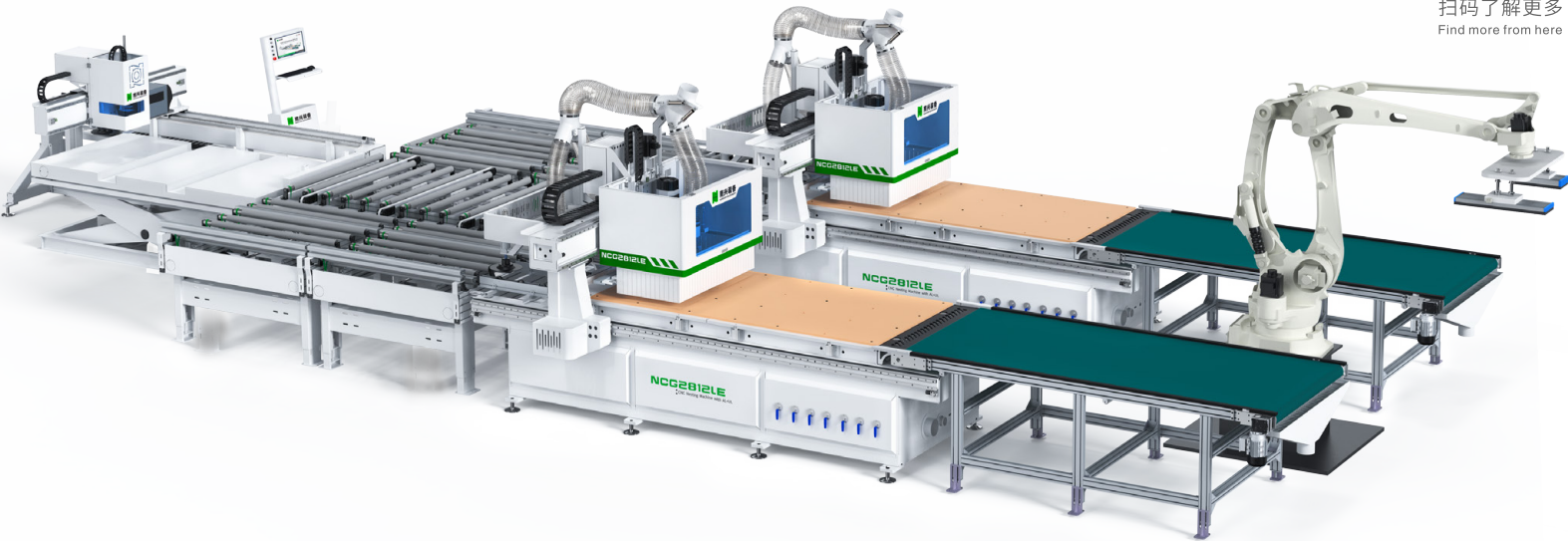
南兴装备
NANXING MACHINERY

智能开料工作站

Intelligent nesting work station



型号Model：1T2-NCG2812LE-A



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简介

本智能开料工作站以多组一拖二开料工作站进行组合,形成更大的开料工作阵列,有着更为强大的产能输出。另外可以根据实际需求扩展或缩减工作站数量,并进行前后端的自动化连接,为客户提供更多样化的开料解决方案。

亮点

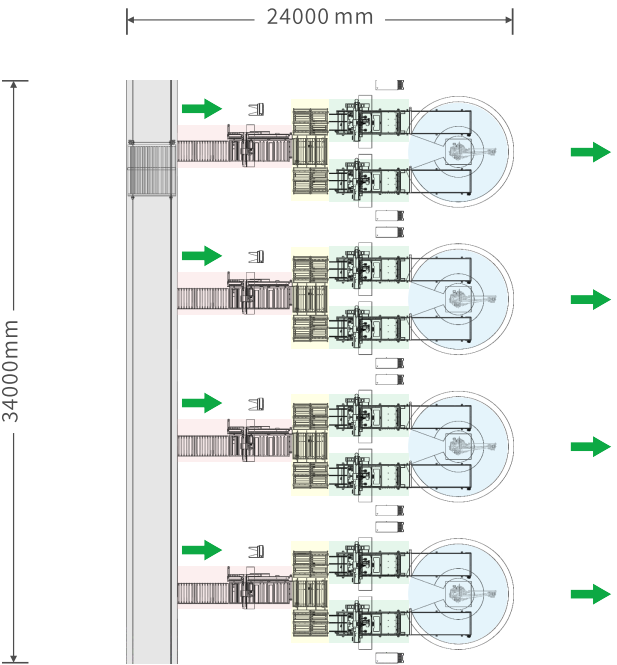
- 1、柔性不间断生产模式,大大减少人工成本；
- 2、生产效率高,单组两机连线可完成2800+PCS (约300-350张48/49尺大板)；
- 3、采用CCD视觉辅助定位系统,智能机器人抓板下料定位精准,最小抓取工件宽度50mm并可合理码放工件；
- 4、开料采用铣刀加工,开料方式更灵活,利用率可达到90%-92% (以100个订单优化)；
- 5、可单独使用,也可通过辅助滚筒或RGV小车等系统与后工序相连,为实现工业4.0夯实基础。

Overview

This intelligent nesting work station is combined with multiple groups of one-to-two nesting work stations to form a larger nesting work layout and have a more powerful production capacity output. In addition, the number of work stations can be expanded or reduced according to actual demand, and the front-end and back-end can be connected automatically. Provide customers with more diversified nesting solutions.

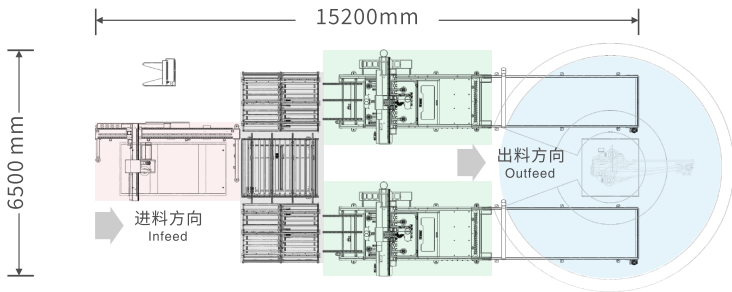
Highlights

- 1.Flexible and non-stop production reduces labor cost;
- 2.High production efficiency, 2800+PCS (about 300-350 pcs 48/49 feet large panels) can be completed by two machines connection in a single group;
- 3.Using the CCD vision-assisted positioning system, the intelligent robot grabs the workpieces and unloads accurately, and the minimum width of the workpiece is 50mm and can be reasonably stacked;
- 4.Nesting by milling cutter is more flexible, utilization reaches 90%-92% ;
- 5.Possible to use individually or connect to following process through conveyor RGV to build Industrial 4.0 automation line.



- RGV
RGV
- 自动贴标
Gantry Feeder
- 输送单元
Delivery unit
- 木工柔性生产线
CNC nesting machine with AL+UL
- 机器人下料
Robot stacker

型号Model：1T2-NCG2812LE

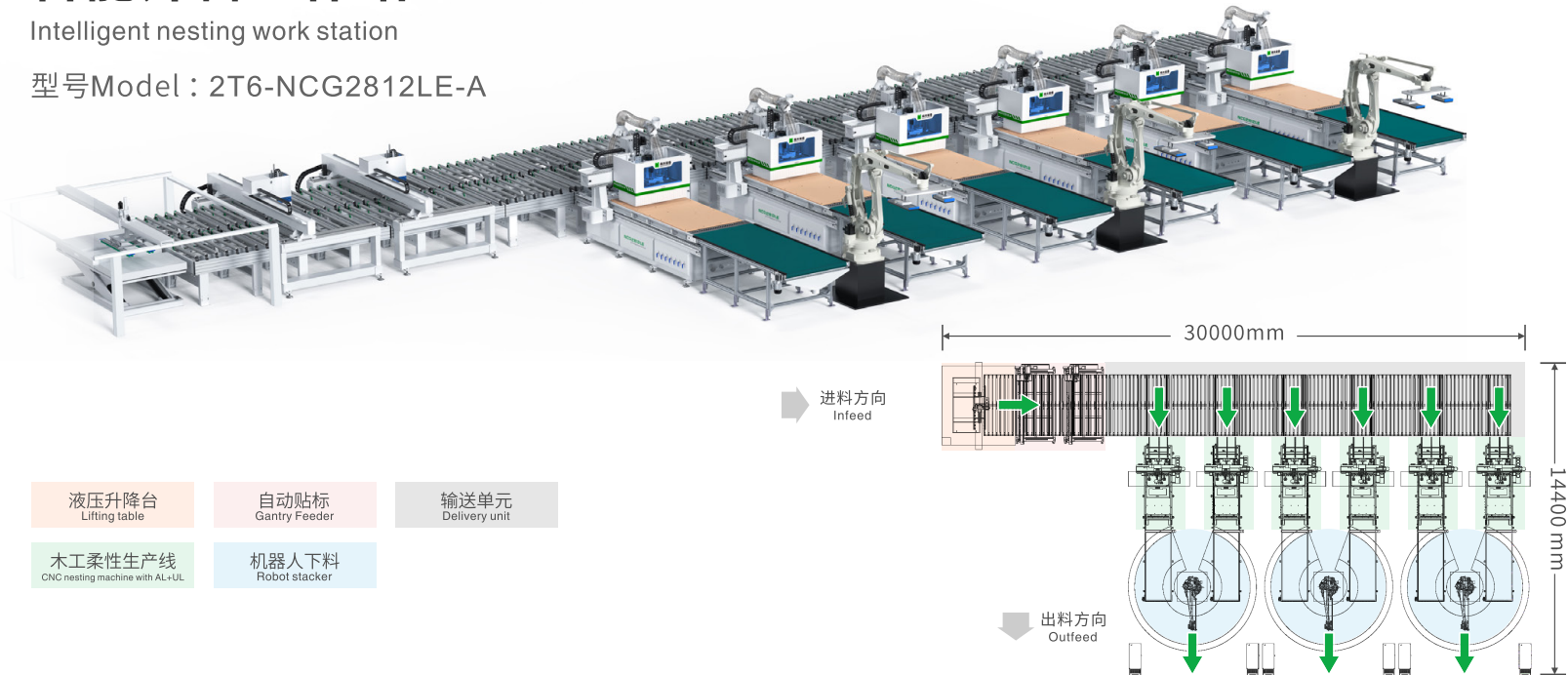


- 自动贴标
Gantry Feeder
- 输送单元
Delivery unit
- 木工柔性生产线
CNC nesting machine with AL+UL
- 机器人下料
Robot stacker

智能开料工作站

Intelligent nesting work station

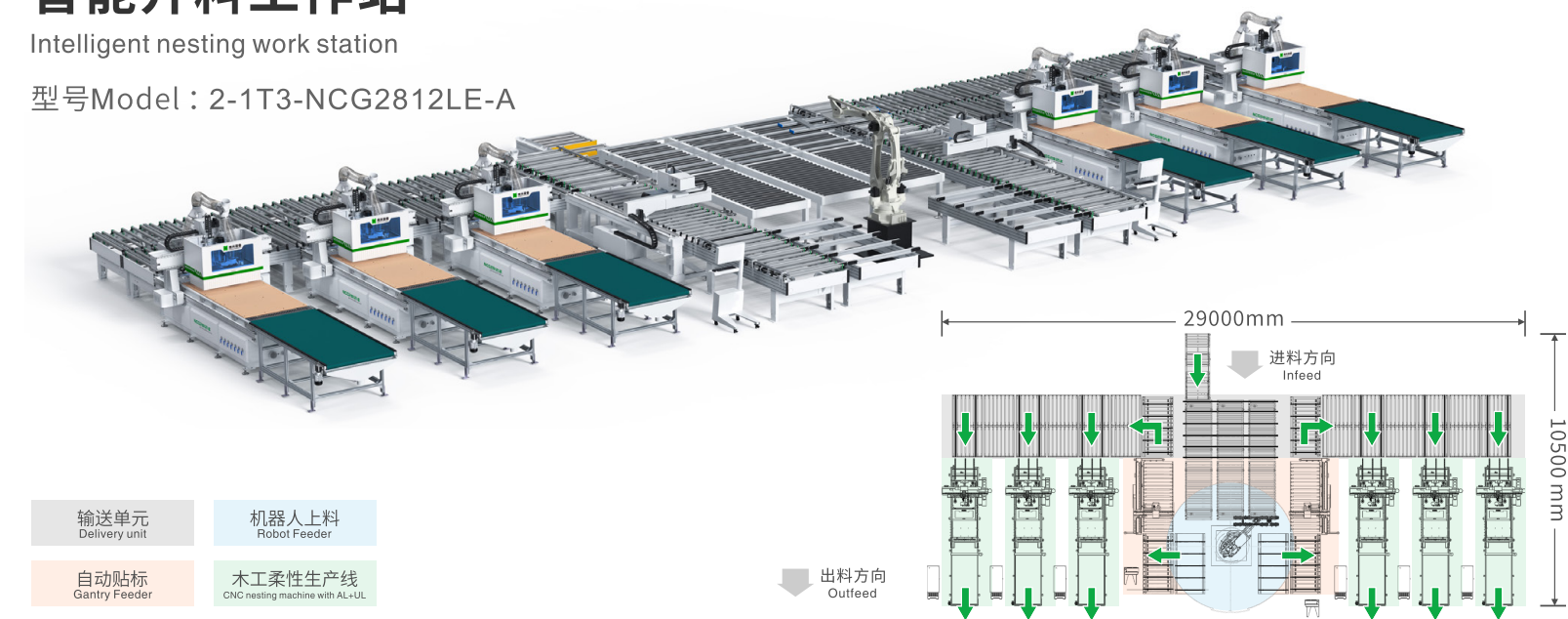
型号Model：2T6-NCG2812LE-A



智能开料工作站

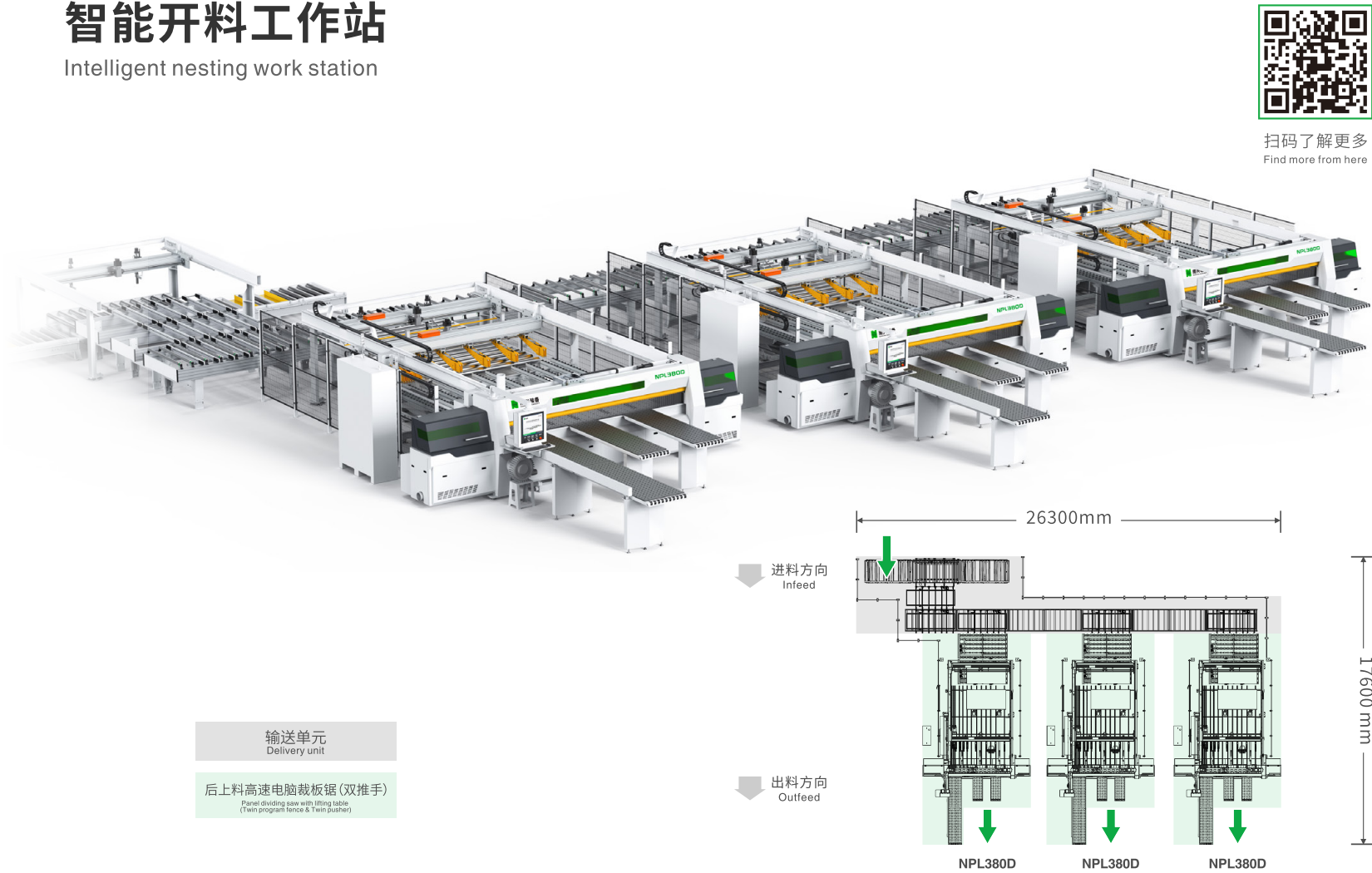
Intelligent nesting work station

型号Model：2-1T3-NCG2812LE-A



智能开料工作站

Intelligent nesting work station



简介

智能开料工作站采用三台或多台后上料高速电脑裁板锯，以及输送台、分板设备等自动化装置进行重组，并通过总控系统，实现集中上料、自动分板、灵活开料。

亮点

- 1、集中上料，可根据生产需求，提前混垛上料，减少原材料周转频率，提升效率；
- 2、总控系统自动完成数据导入、解析，并根据实际工作状态智能分配、发送数据；
- 3、可以单板或叠板开料加工，最大锯切厚度120mm，充分兼容定制化和批量化生产模式；
- 4、可根据需求增减设备并联数量，满足不同的产能需求；
- 5、可选择人工下料码垛或对接自动输送线送板，与前后工序组成自动化生产线；
- 6、开放数据库，可与MES系统进行数据对接，记录并反馈工作站的工作状态，便于车间管理。

Overview

The intelligent nesting work station adopts three or more rear-loading high-speed panel dividing saws, as well as automatic devices such as conveyor tables and separating equipment to reorganize, and through the main control system, realizing centralized feeding, automatic separating, and flexible cutting.

Highlights

1. Centralized feeding can be mixed in advance according to production needs, reducing the turnover frequency of raw materials and improving efficiency;
2. The master control system automatically completes data import and analysis, and intelligently allocates and sends data according to the actual working status;
3. It can be processed by single board or stacked boards, with a maximum sawing thickness of 120mm, fully compatible with customized and mass production modes;
4. The quantity of equipment in parallel can be increased or decreased according to demand to meet different capacity demands;
5. Can choose manual unloading and stacking or docking automatic conveyor line to feed boards, and form an automated production line with the front and rear processes;
6. The open database can be connected with the MES system to record and feedback the working status of the workstation, which is convenient for workshop management.

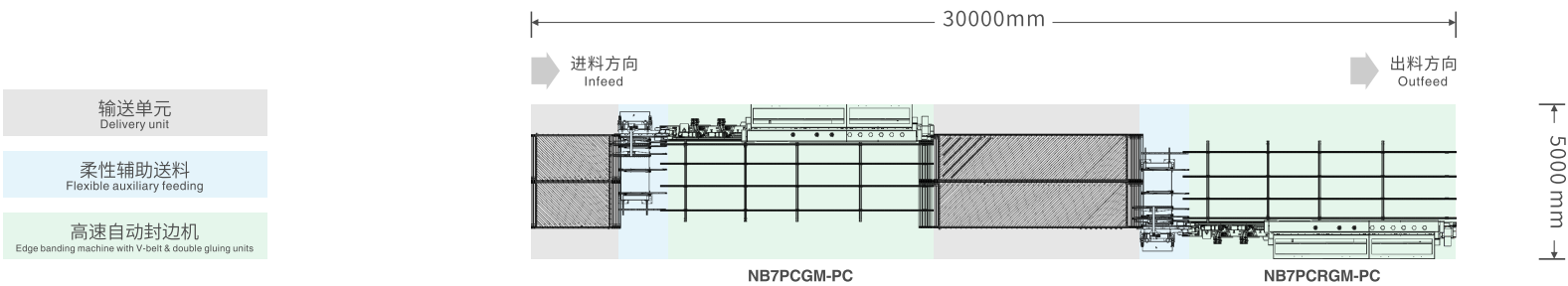


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柔性封边连线

Single sided edge banding machine line (L+R)

可选Option：柔性辅助送料装置



简介

左右柔性封边连线是“一次操作，左右自动封边”，由两台左右高速自动封边机，中间用高速输送台连接，让板件自动完成左右封边，是大规模全屋定制家居企业的首选。

亮点

- 1、节省50%人工，减少搬运时间，提升人均产能；
- 2、板件尺寸适应性强，板件长宽比最大10:1 (根据板材而定)；
- 3、最小封边尺寸200*200mm，最大封边尺寸可选2400*1200mm或2800*1200mm；
- 4、输送台速度灵活，变频调速，保证整线运行平稳。

Overview

Single sided edge banding machine line (L+R) advantages in large scale batch size one production by combining 2 sets opposite single sided edge banding machines with conveyor connected in between to finish left and right sides edge banding in one process. It is the first choice for large-scale whole house furniture custom enterprises.

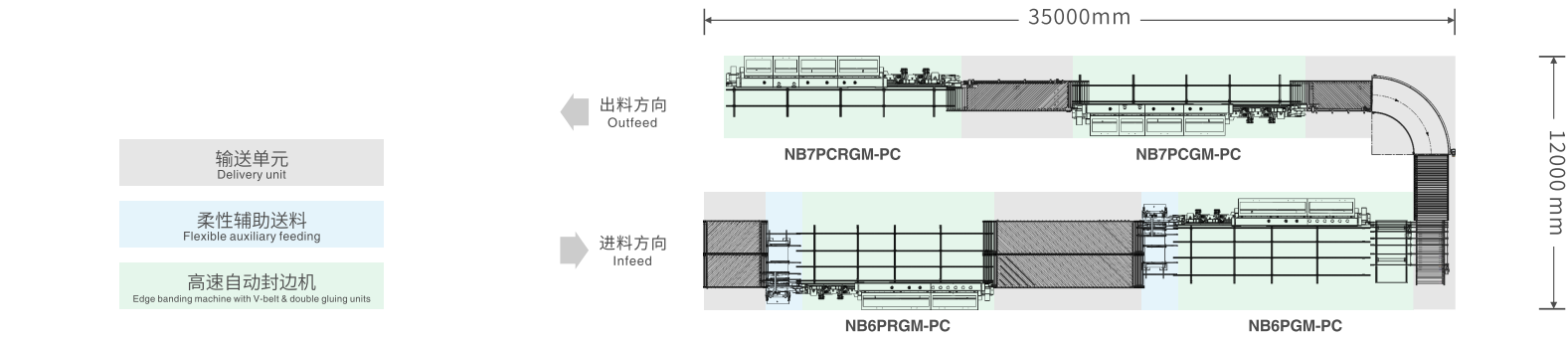
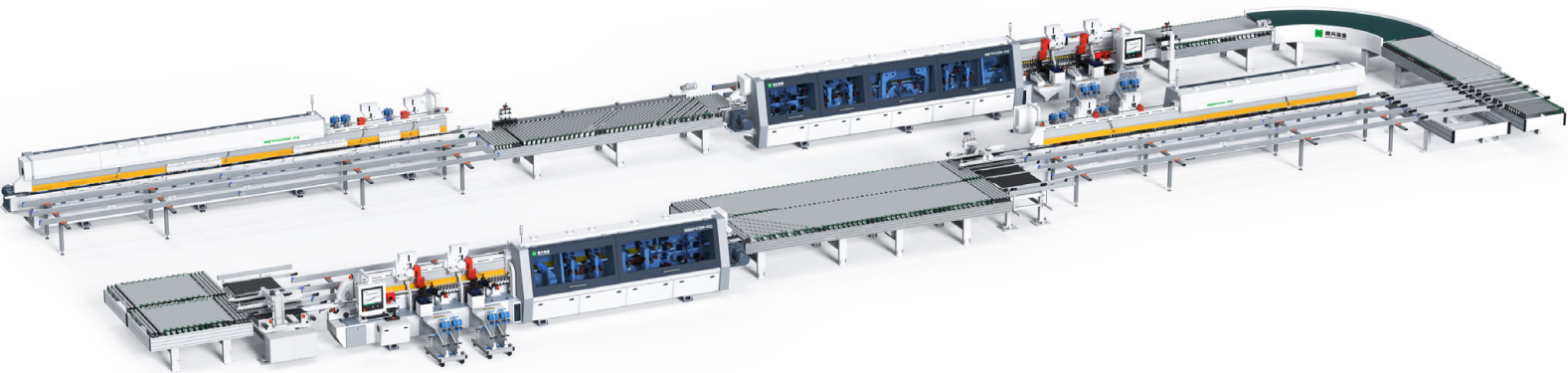
Highlights

- 1.Save 50% labour, reduce transport time, improve per capita capacity;
- 2.Excellent boards size adaptability, maximum aspect ratio of the board is 10:1 (depending on the different board);
- 3.Minimum processable board size 200*200mm, maximum is optional 2400*1200mm or 2800*1200mm;
- 4.The speed of the conveying table is flexible, and the frequency conversion speed regulation ensures the smooth operation of the whole line.

柔性封边连线(先短后长)

Single sided edge banding machine line (short side first then long side)

可选Option：柔性辅助送料装置



简介

四机柔性封边连线是“一次操作，四边自动封边”，配置四台高速自动封边机，中间采用高速输送台连接，让板件自动完成四边封边，前后可接开料工作站或钻孔工作站 (封边工艺采用先封短边后封长边)。

亮点

- 1、可排布U字形，一字型连线方案 (根据客户现场情况)；
- 2、节省人工，无需搬运板件，减少占地面积，提升生产效率；
- 3、板件尺寸适应性强，板件长宽比最大10:1 (根据板材而定)；
- 4、最小封边尺寸200*200mm，最大封边尺寸可选2400*1200mm或2800*1200mm。

Overview

4 sided edge banding machine line is possible to finish 4 sides edge banding at one time by configuring 4 sets left/right sided edge banding machines with high speed conveyors connected in between, likable to nesting working cell or drilling work cell (short side first then long side).

Highlights

- 1.Flexible to select U shape line or linear line according to factory space;
- 2.Save 50% labour, reduce transport time, improve per capita capacity;
- 3.Excellent boards size adaptability, maximum aspect ratio of the board is 10:1 (depending on boards);
- 4.Minimum processable board size 200*200mm, maximum is optional 2400*1200mm or 2800*1200mm.

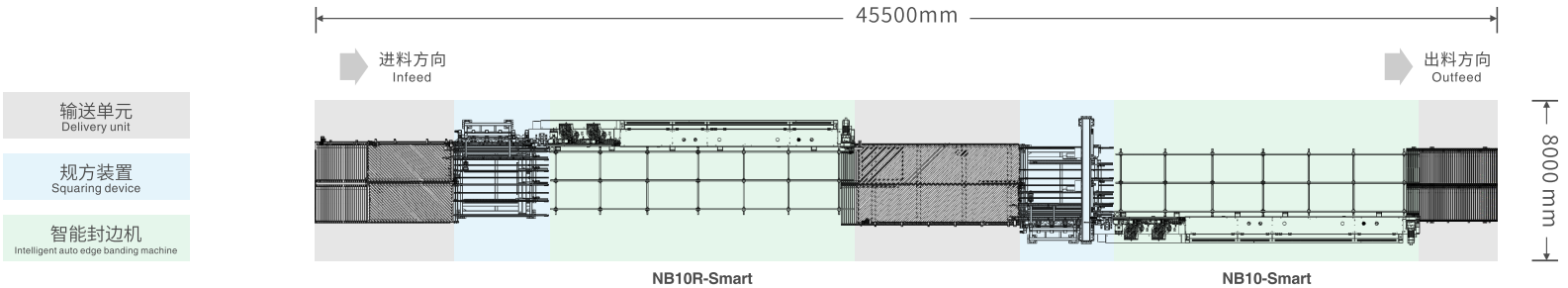
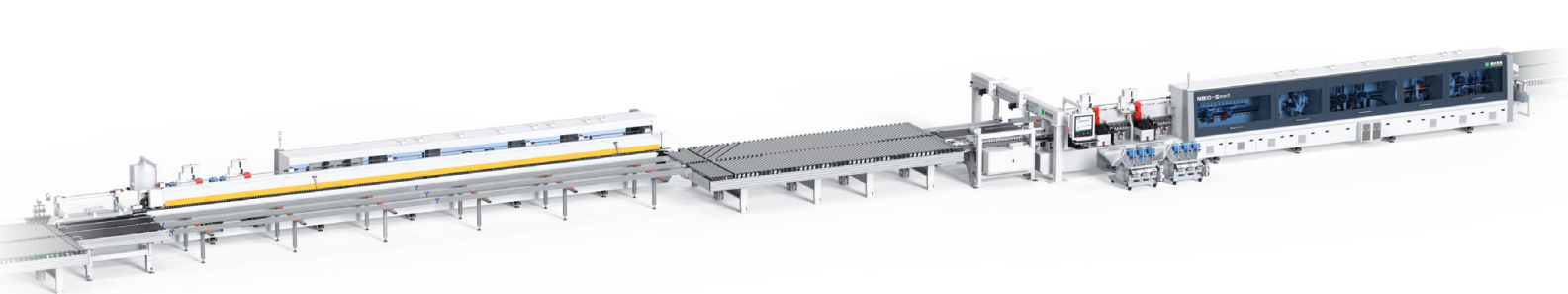


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智能柔性封边连线

Intelligent single sided edge banding machine line

可选Option：规方装置



简介

智能柔性封边连线有两台高速智能封边机、规方系统和输送台组成，智能封边机采用全伺服控制，一次通过可完成左右两边的封边，是高定家居柔性封边的首选。

亮点

- 1、采用全伺服配置机型，整线速度可达32m/min，高效智能；
- 2、配置进料规方机构，保证高的长宽比以及工件精度；
- 3、每台设备配置12通道伺服送带，可满足多样性的封边花色要求；
- 4、最小封边尺寸120*250mm，最大封边尺寸可达2800*1200mm。

Overview

The intelligent flexible edge banding line connection is composed of two high-speed intelligent edge banding machines, square system and conveyor tables. The intelligent edge banding machine adopts full servo control, and can complete the left and right edge banding in one time. It is a good choice for customized flexible edge banding.

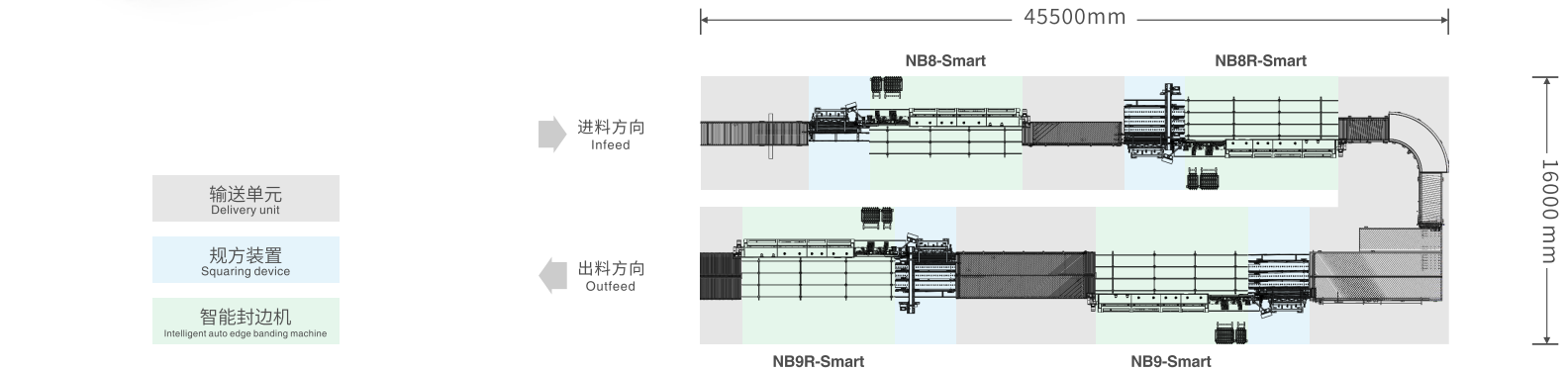
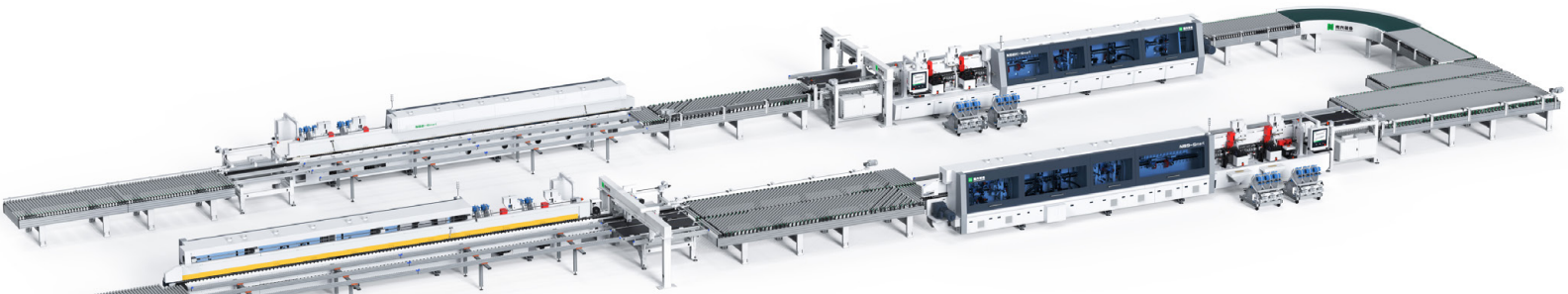
Highlights

- 1.Adopt full servo configuration model, the speed of whole line can reach 32m/min, efficient and intelligent;
- 2.Equipped with a feeding squaring mechanism to ensure high aspect ratio and workpiece accuracy;
- 3.Each device is equipped with 12 roads servo taps feeding, which can meet the requirements of various colors when edge banding;
- 4.The min. edge banding size is 120*250mm, and the max. edge banding size can reach 2800*1200mm.

智能柔性封边连线

Intelligent single sided edge banding machine line

可选Option：规方装置



简介

智能柔性封边连线，配置四台高速智能封边机、规方系统、输送台、转向输送台等组合成完整封边，可实现一次上料，四边封边。（工序先封长边后封短边）

亮点

- 1、采用全伺服配置机型，整线速度可达32m/min，高效智能；
- 2、配置进料规方机构，保证高的长宽比以及工件精度；
- 3、每台设备配置12通道伺服送带，可满足多样性的封边花色要求；
- 4、最小封边尺寸120*250mm，最大封边尺寸可达2800*1200mm；
- 5、可采用人工或自动化（机器人）上下料，也可与前后工段连线，实现整线自动化。

Overview

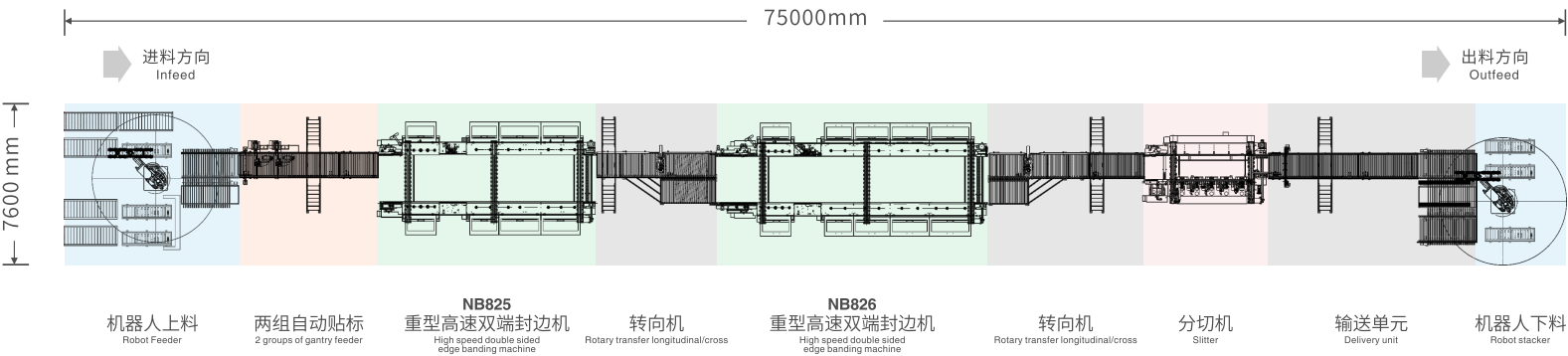
Intelligent flexible edge banding line, equipped with four high-speed intelligent edge banding machines, square system, conveyor tables, turning conveyor table, etc. to form a complete edge banding, which can realize one-time feeding and four-side edge banding. (long side first and then the short side)

Highlights

- 1.Adopt full servo configuration model, the speed of whole line can reach 32m/min, efficient and intelligent;
- 2.Equipped with a feeding squaring mechanism to ensure high aspect ratio and workpiece accuracy;
- 3.Each device is equipped with 12 roads servo taps feeding, which can meet the requirements of various colors when edge banding;
- 4.The min. edge banding size is 120*250mm, and the max. edge banding size can reach 2800*1200mm;
- 5.Can choose manual or automatic (robot) loading and unloading, and it can also be connected with the front and rear sections to realize the automation of the whole line.

高速四端封边连线

High-speed double sided edge banding machine line



简介

高速四端封边+分切机连线, 适用于大批量规模化板件生产场合。主要配置包括两台重型高速双端封边机, 高速分切机、上下料机器人、高速输送台、转向机等。

亮点

- 1、整线速度最快可达50m/min (开跟踪35m/min) , 满足批量化快速封边需求;
- 2、机器人上下料, 无需人工作业, 减少操作人工;
- 3、特制烧结金属链条, 配置规方定位装置, 可确保工件精度和质量;
- 4、高速分切机, 根据工件工艺方式, 一键开启或关闭, 大大提升产线灵活性和适应性;
- 5、总控系统装置, 可实时下发和反馈数据, 监控设备状态, 便于车间生产管理。

Overview

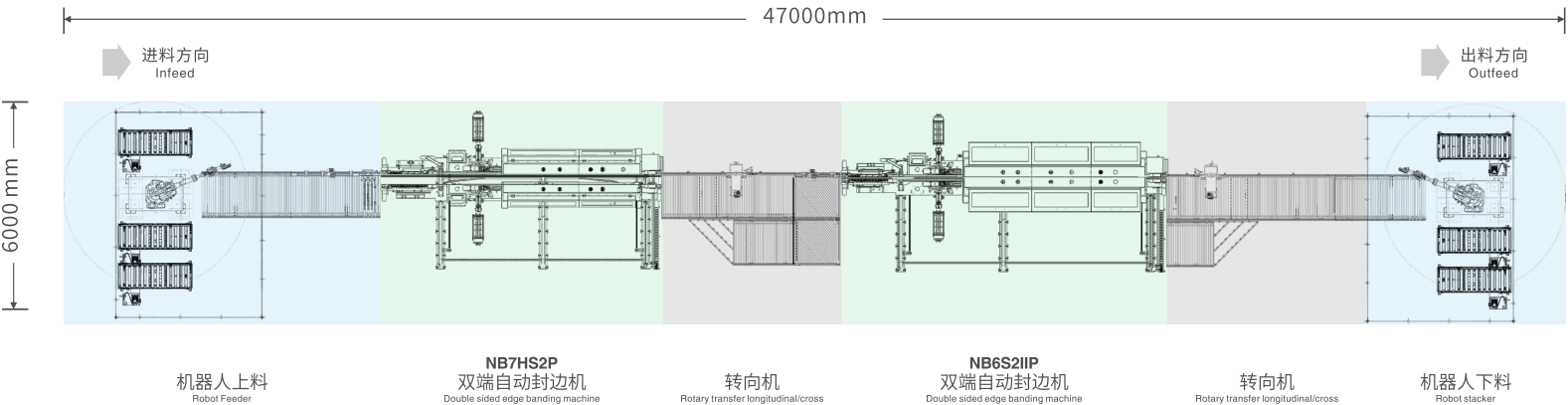
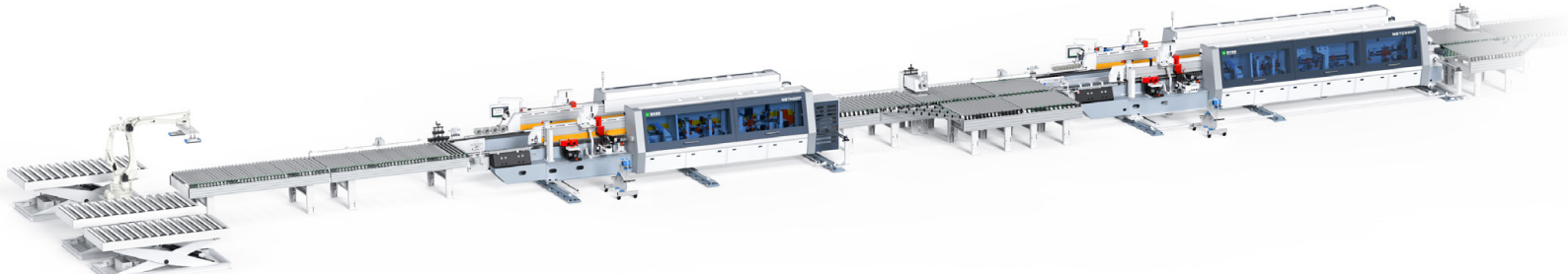
High-speed four sides edge banding + slitting machine connection, suitable for large-scale panel production situation. The main configuration includes two heavy-duty high-speed double sided edge banding machines, high-speed slitting machines, auto loading and unloading robots, high-speed conveyor tables, turning machines, etc.

Highlights

- 1.The speed of the whole line can reach up to 50m/min (Corner rounding speed: 35m/min) , which meets the demand of batch quick edge banding;
- 2.Robot loading and unloading, no need for manual work, reducing operating labor;
- 3.Special sintered metal chain, equipped with square stop cam device, can ensure the accuracy and quality of the workpiece;
- 4.The high-speed slitting machine can be turned on or off with one button according to the workpiece process method, which greatly improves the flexibility and adaptability of the production line;
- 5.The main control system device can send and feed back data in real time, monitor equipment status, and facilitate workshop production management.

四端封边连线

Double Sided Edge Banding Machine Line



简介

四端封边连线, 适用于贴面刨花板、密度板、蜂窝板等批量化封边场合。主要配置包括两台重型高速双端封边机, 上下料机器人、高速输送台、转向机等。

亮点

- 1、机器人上下料, 无需人工作业, 减少人工;
- 2、特制烧结金属链条, 配置钩头规方装置, 确保工件精度;
- 3、总控系统装置, 可实时下发和反馈数据, 监控设备状态, 便于车间生产管理。

Overview

Double sided edge banding machines line, suitable for batch edge banding occasions such as veneer particle board, MDF, honeycomb board and so on. The main configuration includes two heavy-duty high-speed double sided edge banding machines, loading and unloading robots, high-speed conveyor tables, turning machines, etc.

Highlights

- 1.Robot loading and unloading, no need for manual work, reducing labor;
- 2.Special sintered metal chain, equipped with square stop cam device, can ensure the accuracy of the workpiece;
- 3.The main control system device can send and feed back data in real time, monitor equipment status, and facilitate workshop production management.

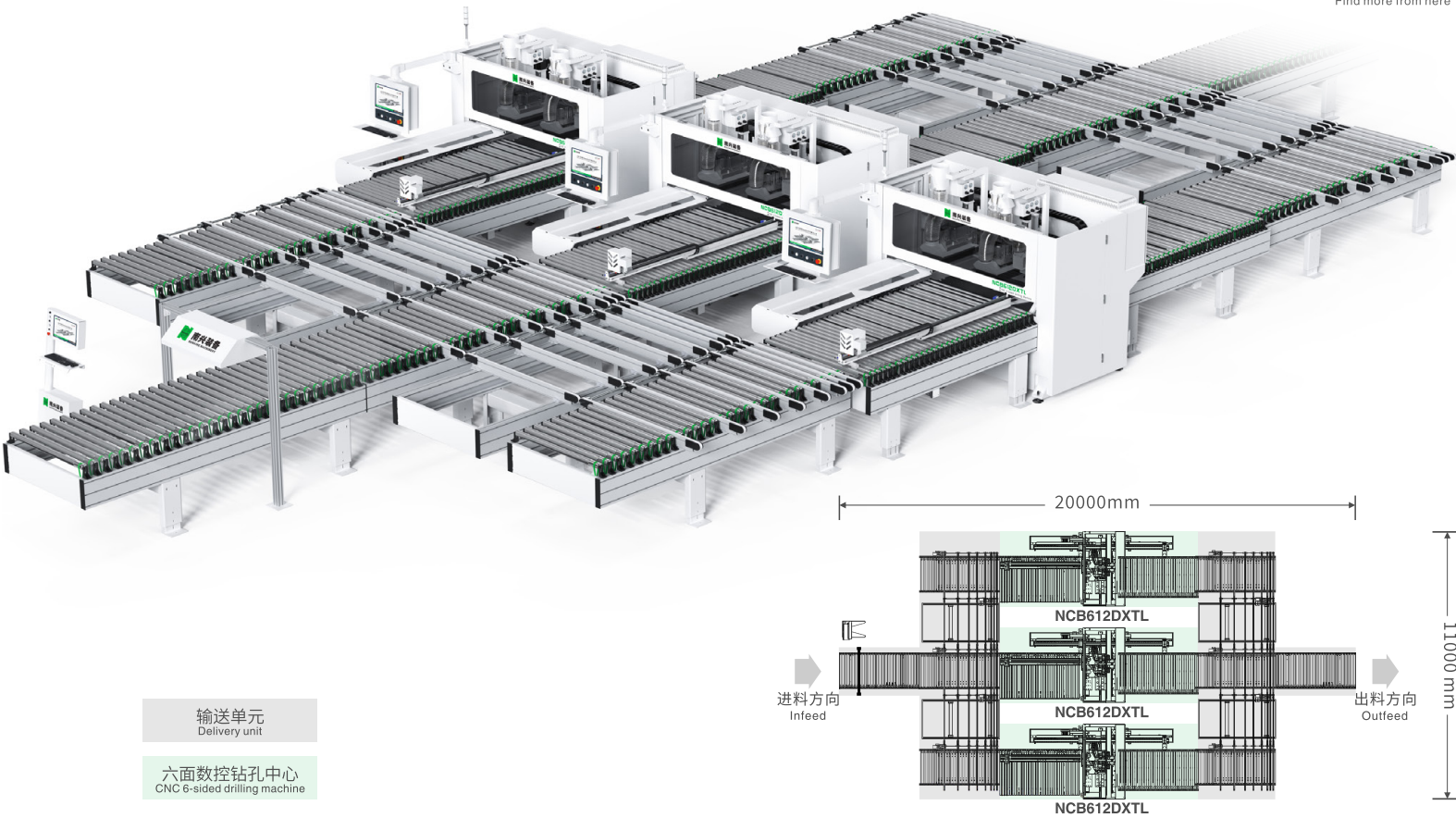
智能钻孔工作站

Intelligent drilling work station

型号Model : 3-NCB612DXTL



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简介

智能钻孔工作站是为中小型定制家居钻孔环节自动化升级的钻孔单元。它不仅可以独立使用,同时可以根据场地的不同进行适当的增减,也可以多组进行组合适合更大批量的生产。此工作站由多台六面数控钻孔中心组成,“即来即加工”工作方式,灵活搭配,无需专门定制工艺线路。

亮点

- 1、集中式控制系统,可视化各个工件加工状态;
- 2、可双面开槽、铣型、六面钻孔等加工;
- 3、“即来即加工”工作模式,自动分配给对应机台;
- 4、可灵活搭配,多台进行组合;
- 5、总控系统可自动记录工件、加工、设备等各类信息,也可对接MES系统(选配)。

Overview

CNC 6-sided drilling work station the upgraded drilling solution for drilling job of small and medium-sized customized furniture is not only capable of using individually to add or reduce machines according to factory space but also combining multiple machines to meet larger production capacity requirement. This work station consists of N+1 sets CNC 6-sided drilling machines, "Just-in-time processing" working mode, flexible combination.

Highlights

1. Centralized control system to visualize the machining status of each board;
2. 6 sides drilling, top and bottom grooving and routing in one process;
3. Boards are transported to suitable machines according to real-time working status automatically;
4. Flexibly combine 1+N sets of machines;
5. Automatically record various information such as boards, processing, equipment, etc, and can also be connected to the MES system (option).

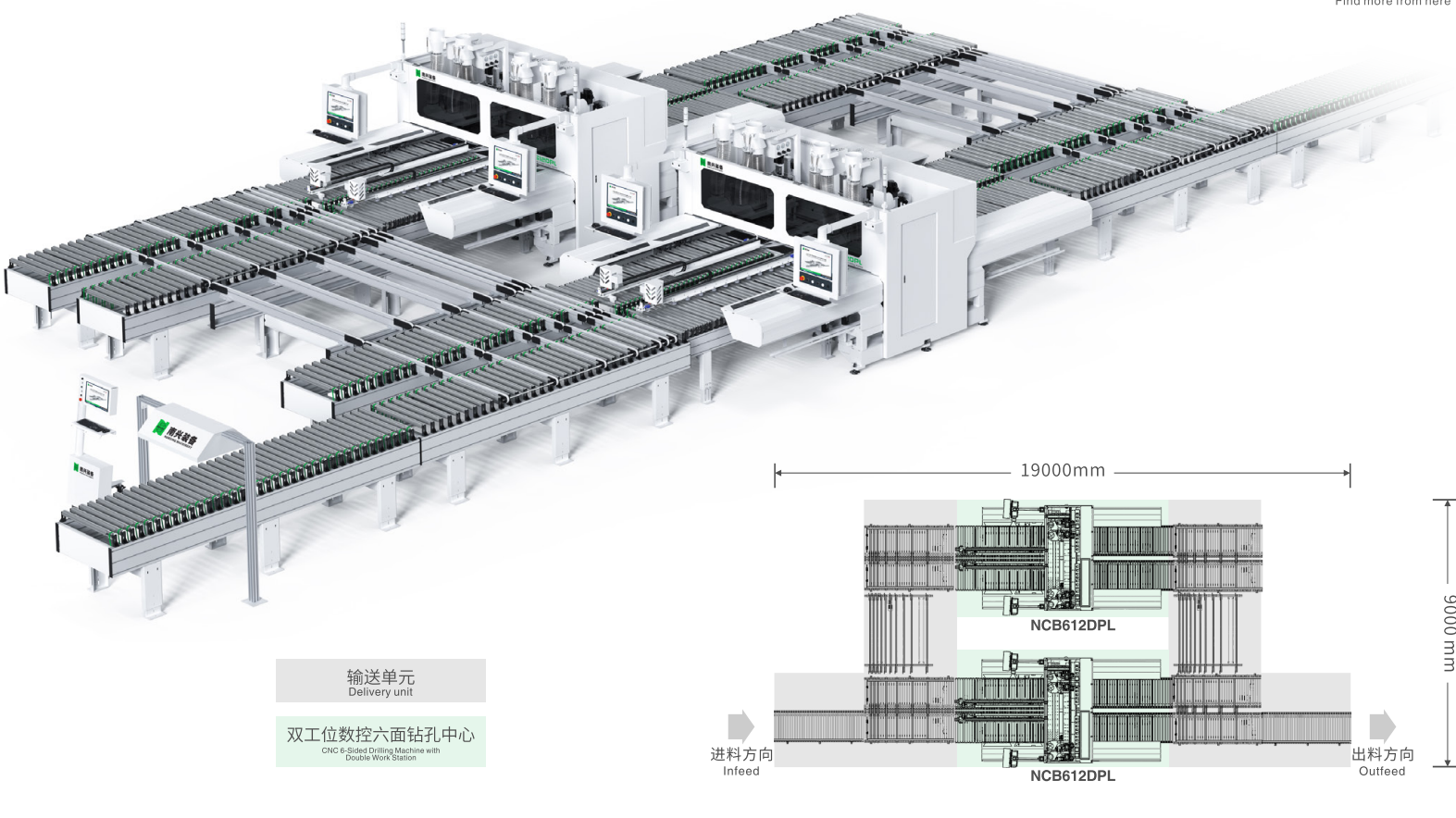
智能钻孔工作站

Intelligent drilling work station

型号Model : 2-NCB612DPL



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简介

智能钻孔工作站是专为大规模全屋定制生产厂家自动化改造升级量身定做的工业级钻孔单元,它不仅仅可以独立使用,同时可以根据场地的不同进行适当的调整,也可以多台进行组合适合更大批量的生产。此工作站由两台或两台以上的双通道六面数控钻孔中心、扫描系统以及辅助设备组成。智能钻孔工作站无需人员干预,由系统对工件自动分配最适合的工艺路线,是实现智能生产工厂的最佳选择。

亮点

- 1、自动扫描系统,可将工件自动分配至最佳适合机台;
- 2、工作站式钻孔方式效率高,单班钻孔效率900pcs/h;
- 3、集中式总控系统,可视化各个工件加工状态;
- 4、各机台可连线或单机,便于管理或维修;
- 5、可与分拣系统或前段封边工序单元连接,为实现工业4.0夯实基础。

Overview

Intelligent Drilling Work station, specially designed for automation transformation and upgrading of whose-house customized furniture factories of large production capacity demand is not only individually used but also adjustable for combination with several more machines based on space conditions to satisfy higher production requirements. The work call integrates two or more sets CNC 6-sided drilling machines with double work station, label scanning system and other automation equipment. It's intelligent supervisor is able to allocate boards to proper processing path automatically without need of any extra manual work, no doubt the optimal solution for intelligent drilling production.

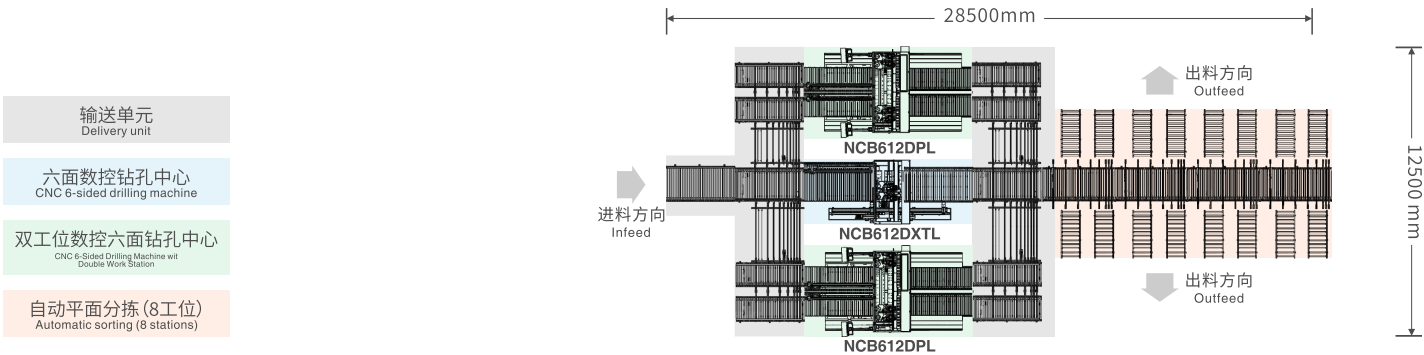
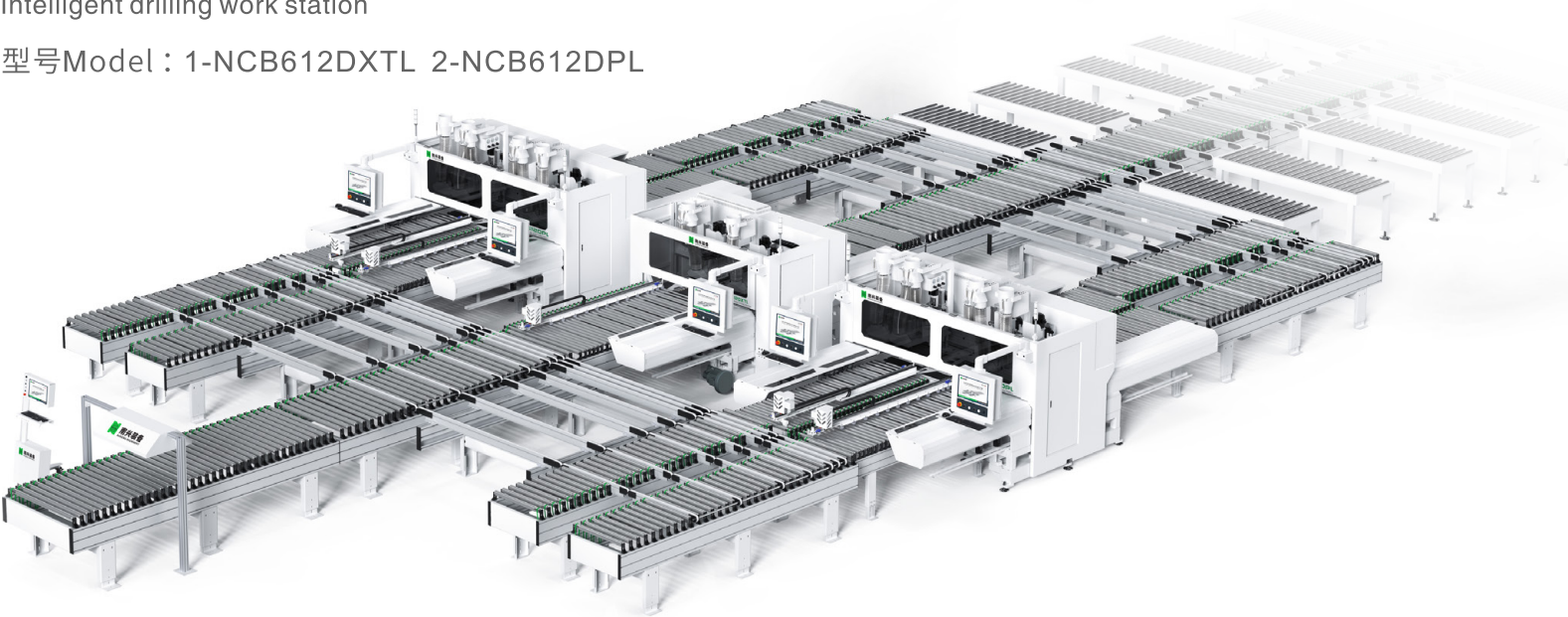
Highlights

1. Through the processing info read by auto label scanning system, boards can be allocated to proper working station automatically;
2. Higher efficiency, 900pcs/h for each shift;
3. Integrated control system makes all boards' processing status available at a glance;
4. Each machine can be used in line or individually, simplify the machines' management or maintenance;
5. Modular design of such work cell is easy to link to sorting system or edge banding work station to build Industrial 4.0 production line.

智能钻孔工作站

Intelligent drilling work station

型号Model：1-NCB612DXTL 2-NCB612DPL



简介

智能钻孔工作站, 适合中小型全屋定制家居企业钻孔工段的自动化升级, 主要由两台双工位六面数控钻孔中心 (NCB612DPL) 和一台单通道六面数控钻孔中心 (NCB612DXTL) 以及自动平面分拣组成。具有占地面积小, 效率高, 人工少, 自动化程度高等特点。

亮点

- 1、进料自动扫码识别, 自动根据板材工艺和设备状态分配钻孔路径, 效率高;
- 2、集中式总控系统, 钻孔和分拣集成管理, 监控每个工位运行状态、工件的加工进度和状态;
- 3、自动平面分拣, 无需单独控制, 加工完成可自动完成分拣, 节省场地, 降低人工成本;
- 4、可以人工或机器人上料, 也可与前端工序做自动化连接, 组成完整自动化生产线。

Overview

The intelligent drilling workstation is suitable for the automatic upgrade of the drilling section of the small and medium-sized whole house customized home furnishing enterprises. It mainly consists of two dual-channel six-sided CNC drilling machines (NCB612DPL) and one single-channel six-sided CNC drilling machine (NCB612DXTL) and automatic sorting composition. It has the characteristics of small foot area, high efficiency, less labor and high degree of automation.

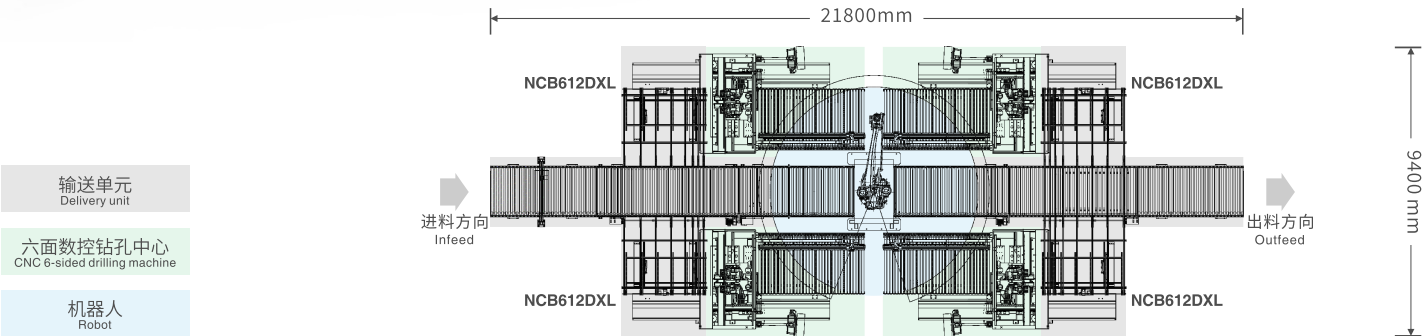
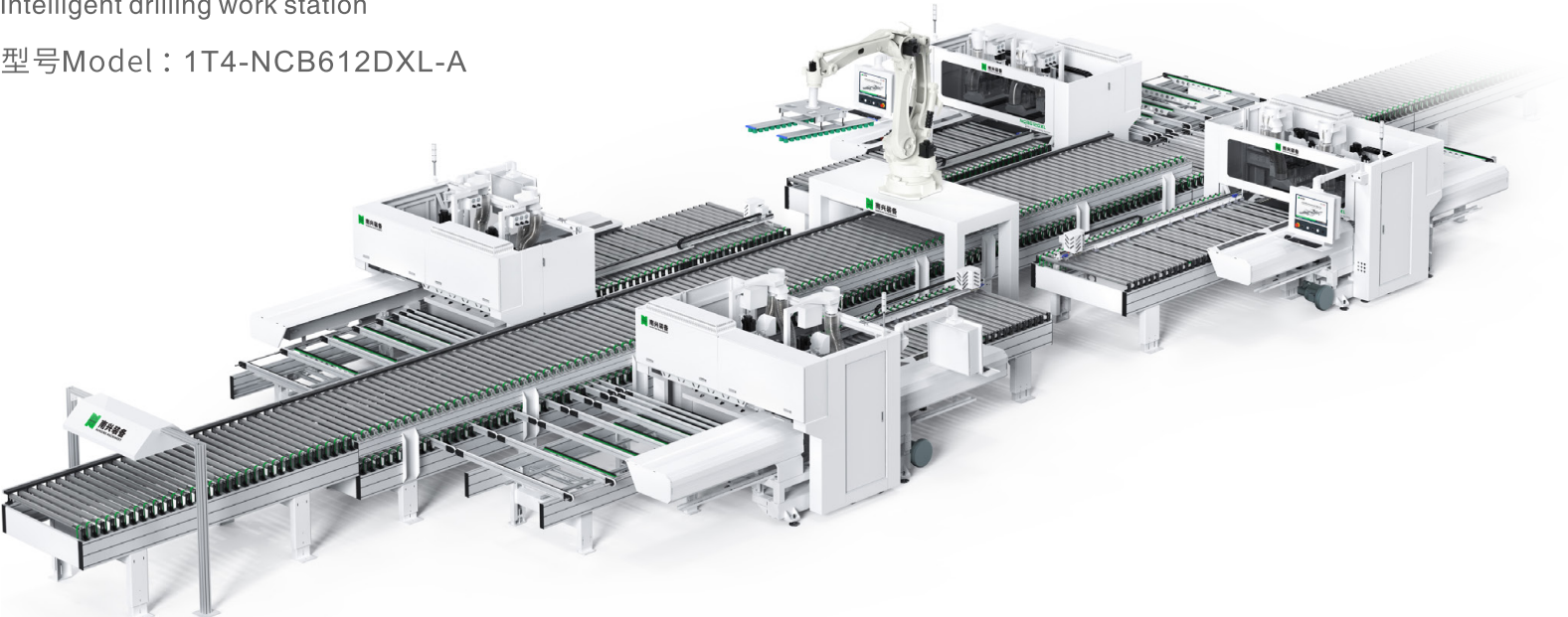
Highlights

1. Automatic scanning of feeding, automatic allocation of drilling paths according to workpiece process and equipment status, high efficiency;
2. Centralized main control system, integrated management of drilling and sorting, monitoring the running status of each station, the processing progress and status of workpieces;
3. Automatic sorting, without separate control, sorting can be completed automatically after processing, saving space and reducing labor costs;
4. It can be loaded manually or by robot, and can also be automatically connected with the front-end process to form a complete automated production line.

智能钻孔工作站

Intelligent drilling work station

型号Model：1T4-NCB612DXL-A



简介

智能钻孔工作站, 适合中小型全屋定制家居企业钻孔工段的自动化升级, 主要由四台单工位六面数控钻孔中心, 双层输送台和分配工件机器人组成, 具有自动化程度高、占地面积小等特点, 能有效助力家居智能工厂。

亮点

- 1、自动扫码进料, 机器人根据设备工作状态分配加工机台, 减少人工成本;
- 2、集中式总控系统, 对设备进行集成管理, 监控每个工位运行状态、工件的加工进度;
- 3、工件进出料实现分流, 互不干涉, 有效提升整体工作效率;
- 4、可采用人工或自动化 (机器人) 上下料, 也可与前后工段做连线, 实现整线自动化。

Overview

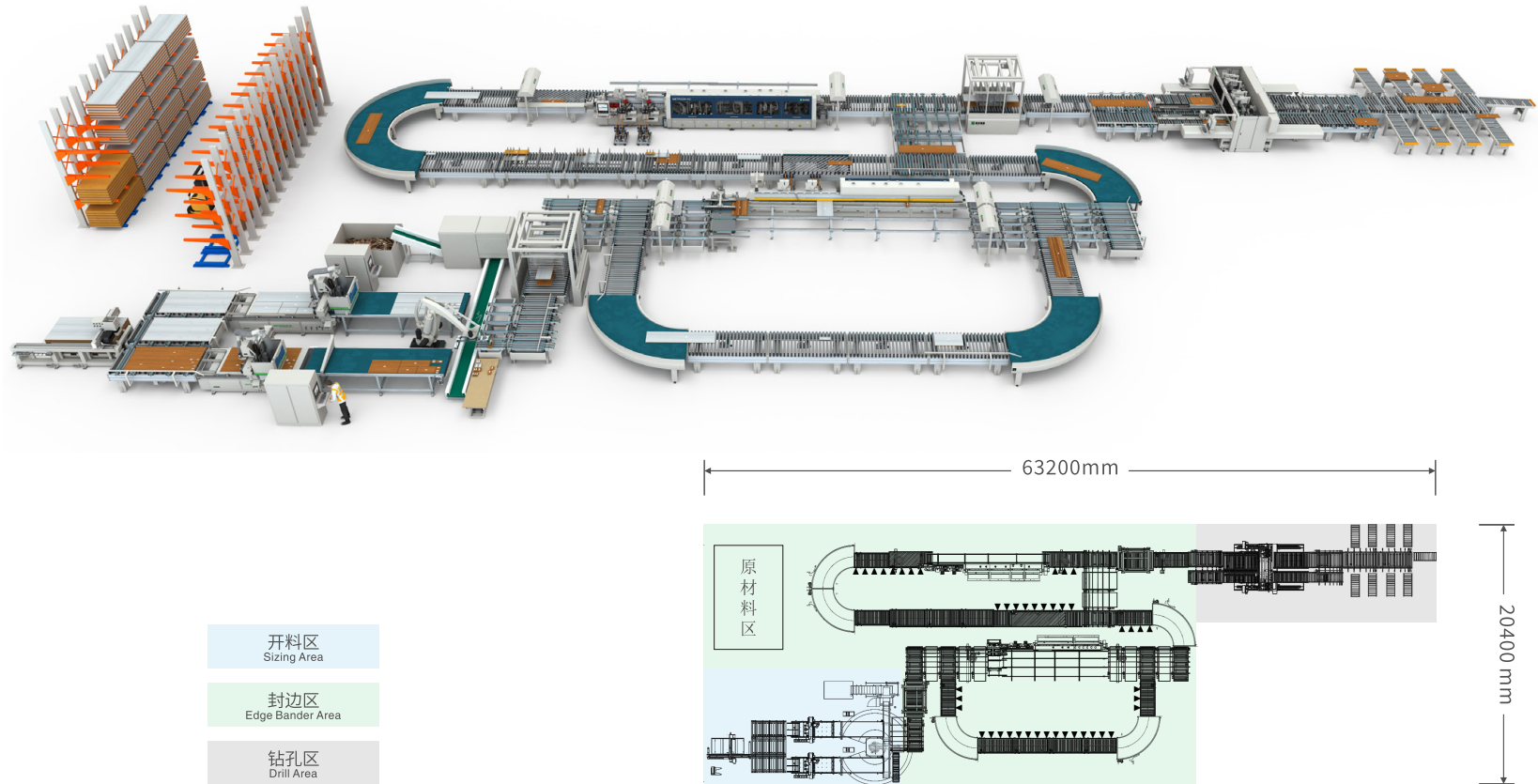
The intelligent drilling workstation is suitable for the automation upgrade of the drilling section of small and medium-sized whole-house customized home furnishing enterprises. It is mainly composed of four single-station six-sided CNC drilling machines, double-layer conveyor table and a sorting robot. It has the characteristics of high degree of automation and small foot area, and can effectively help furniture factories.

Highlights

1. Automatic scanning of feeding, robots assign processing machines according to the working status of the equipment, reducing labor costs;
2. Centralized control system, integrated management of equipment, monitoring the operation status of each station and the processing progress of workpieces;
3. Feeding and feeding out in order, non-interference, effectively improve the overall work efficiency;
4. It can be loaded manually or by robot, and can also be automatically connected with the front-end and back-end process to form a complete automated production line.

家居智能生产线(一)

Furniture intelligent production line



简介

家居智能生产线,适用于中小型全屋定制家居工厂,主要由一组一拖二智能开料工作站、两组封边自动回转线 and 一台双工位六面数控钻孔中心组成。根据厂房面积可调整布线方式,具有占地面积小,自动化程度高,操作人工少等特点。

亮点

- 1、完整的开料、封边、钻孔连接,实现加工工段的全线自动化;
- 2、各工段留有上下料NG口,可实现工件在各工段环节进行上线下线交互;
- 3、根据厂房面积,可灵活调整布线方式和紧凑的布局,提升自动化水平和坪效比;
- 4、产能可达300pcs/h,最小工件宽度可达100mm,整线全屋定制板件上线率可达85%以上。

Overview

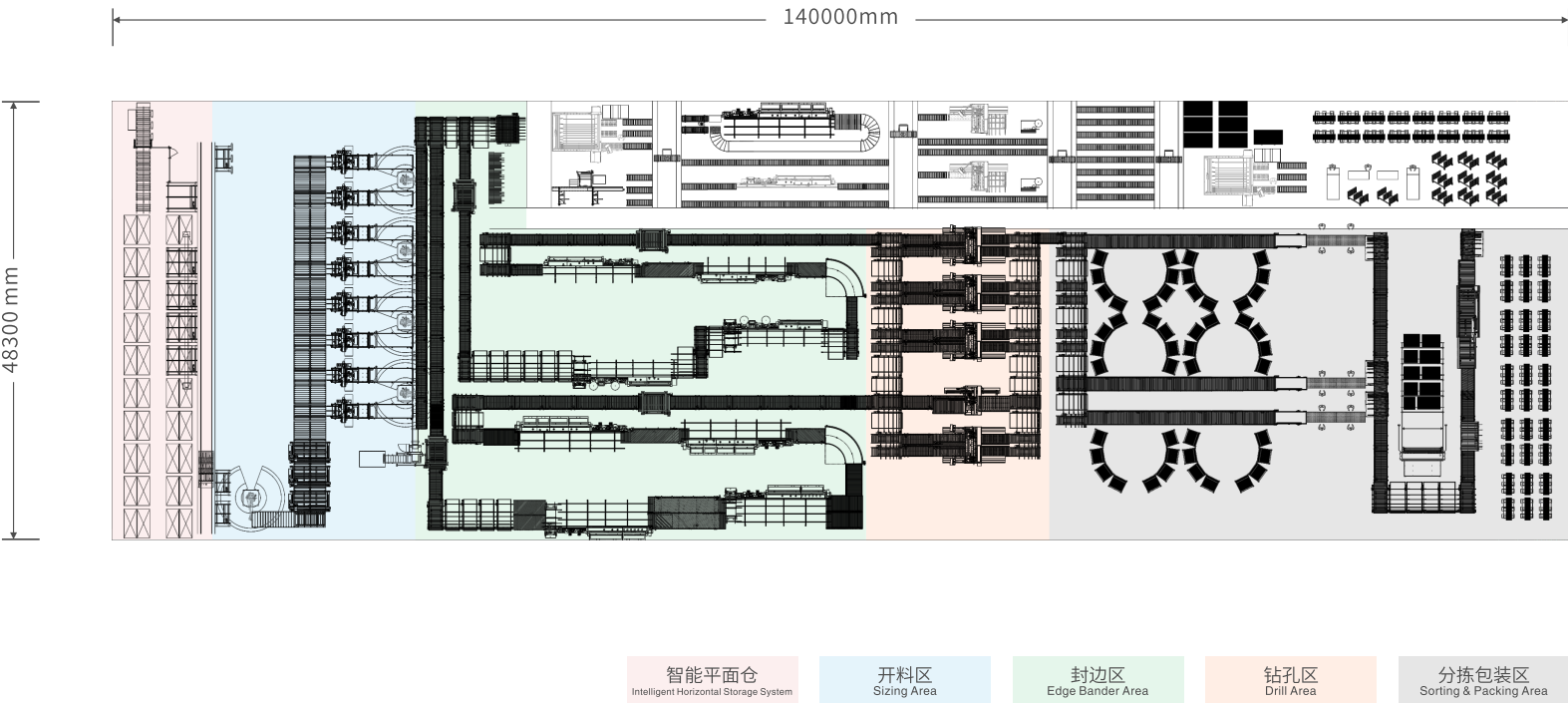
Furniture intelligent production line is suitable for small and medium-sized whole-house customized home furnishing factories. It mainly consists of a group of one-to-two intelligent nesting workstations, two sets of rotary automatic edge banding lines and one two-channel six-sided CNC drilling machine. The layout can be adjusted according to the area of the factory building, and it has the characteristics of small foot area, high degree of automation, and less operator labor.

Highlights

- 1.Complete cutting, edge banding, drilling connection, realize the full-line automation of the processing section;
- 2.There are NG signal for loading and unloading in each section, which can realize the on-line and off-line interaction of workpieces in each section;
- 3.According to the factory area, the layout can be flexibly adjusted to improve the automation level and floor area efficiency ratio;
- 4.The production capacity can reach 300pcs/h, the minimum workpiece width can reach 100mm, and the on-line rate of the whole house customized in whole line can reach more than 85%.

家居智能生产线(二)

Furniture intelligent production line



简介

家居智能生产线,适用于中大型全屋定制智能生产线,主要由原材料立库、上料配板系统、智能开料工作站、柔性封边连线(窄板连线和常规板件连线)、智能钻孔工作站、智能分拣工作站和自动裁纸包装等设备组成,实现全工段智能生产线。具有自动化、柔性化、少人化等特点。

亮点

- 1、实现从原材料-加工-入库,全线板不落地,实现全工段自动化;
- 2、通过自动配板、材料优化、板件标示、分配工件等功能,具有更高生产柔性化和更高效的物流周转;
- 3、各工段留有上下料NG口,可实现工件在各工段环节进行上线下线交互;
- 4、该智能产线产能可达1200pcs/h,全屋定制板件上线率可达95%以上。

Overview

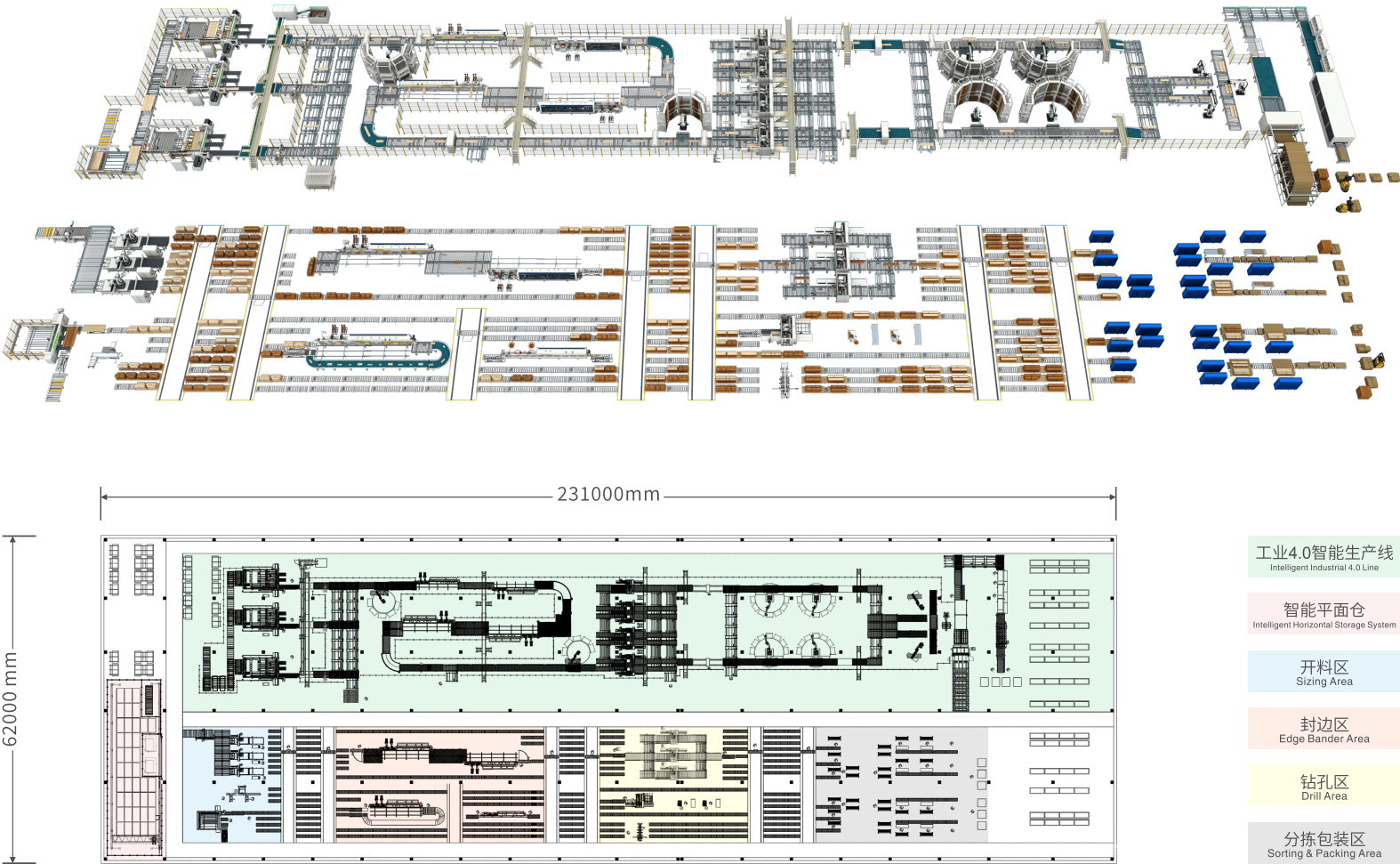
Furniture intelligent production line, suitable for medium and large-scale whole house customized intelligent production line, mainly consists of raw material storage, material loading and matching board system, intelligent nesting workstation, flexible edge banding connection (narrow edge banding connection and conventional board connection), intelligent drilling work station, intelligent sorting work station and automatic paper cutting and packaging equipment to realize the intelligent production line of the whole process section. It has the characteristics of automation, flexibility, and fewer people.

Highlights

- 1.From raw materials-processing-warehousing, the boards in whole line never suspend, realized the automation of the whole process section;
- 2.Through functions such as automatic board matching, material optimization, board labeling, and workpiece distribution, it has higher production flexibility and more efficient delivery;
- 3.There are NG signal for loading and unloading in each section, which can realize the on-line and off-line interaction of workpieces in each section;
- 4.The production capacity of this intelligent production line can reach 1200pcs/h, and the on-line rate of the whole house customized in whole line can reach more than 95%.

家居智能工厂(一)

Furniture intelligent factory



简介

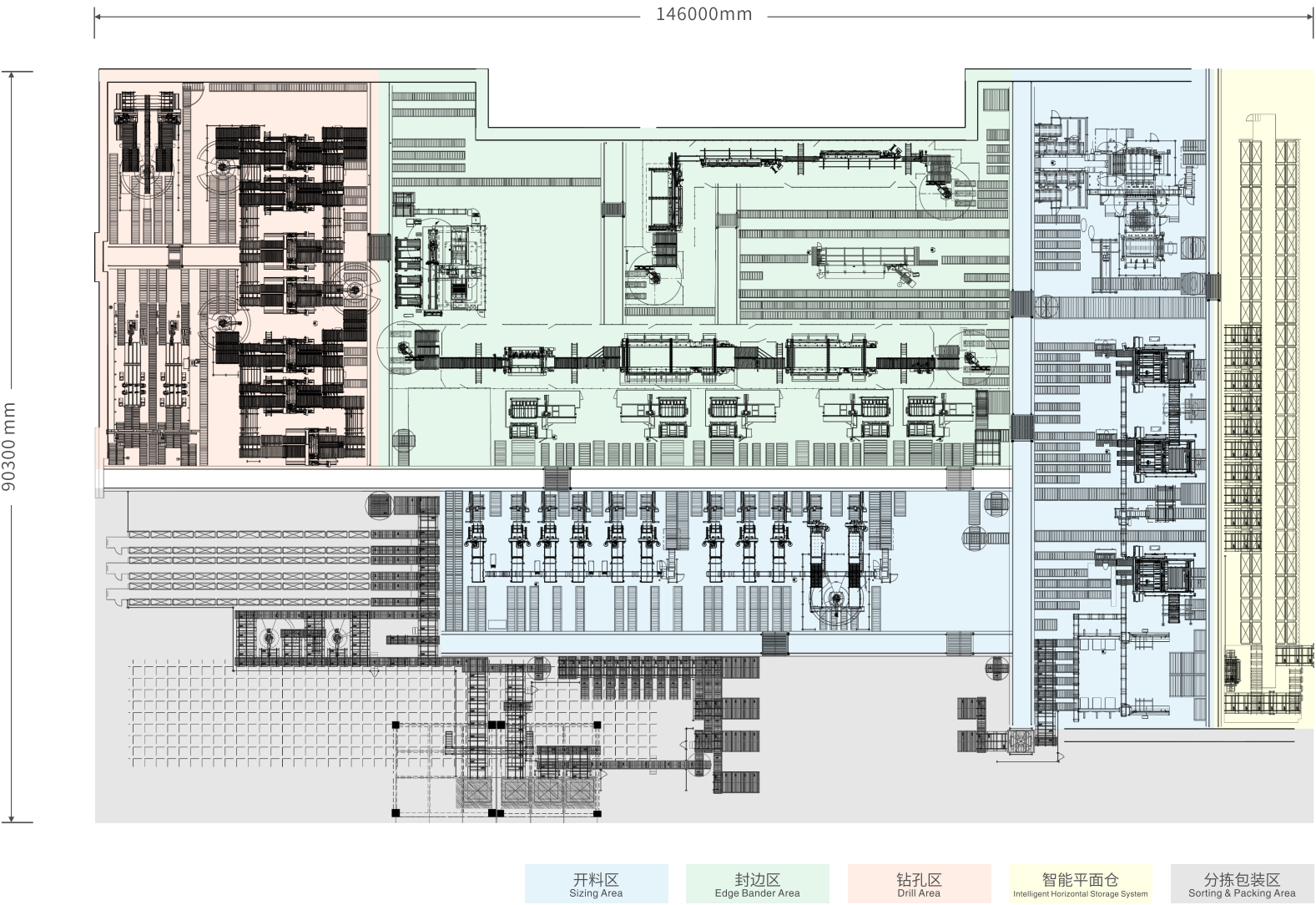
家居工业4.0智能工厂适用于大规模柔性全屋定制家居生产,如衣柜、橱柜、鞋柜、酒柜、卫浴、阳台柜等门墙柜一体化各类板式家居。此方案由智能生产线、工段自动化或手动生产线三部分组成,智能工厂需配备人工65人,厂房面积大约10000平方,整厂年产值大约2亿元。

Overview

The above-mentioned smart home factory is suitable for large-scale flexible whole-house custom home production, such as wardrobes, cabinets, shoe cabinets, wine cabinets, bathroom cabinets, balcony cabinets and other door-to-wall cabinets integrated into various types of panel home furnishing. This solution consists of three parts: intelligent production line, section automation or manual production line. The intelligent factory only needs to be equipped with no more than 65 people. The plant area is about 10,000 square meters, with an annual output value of about RMB 200 million.

家居智能工厂(二)

Furniture intelligent factory



简介

该家居智能工厂主要应用于板式套床智能化工厂项目布局,将原材料立库、开料、封边、钻孔、分拣、缓存、成品立库、物流等集成式规划,具有精益化、自动化、信息化、智能化等特点。工厂占地面积只需13000平方米,产能能达到2000套床架和1400个床头柜,仅需39人操作。

Overview

The furniture intelligent factory is mainly aimed at the project layout of the panel intelligent factory project, and integrates the planning of raw material storage, cutting, edge banding, drilling, sorting, caching, finished product storage, delivery, etc., with lean, automated, informatization, intelligence and other characteristics. The factory covers an area of only 13,000 square meters, the production capacity can reach 2,000 sets of bed frames and 1,400 bedside cabinets, and all of this only need 39 people to operate.