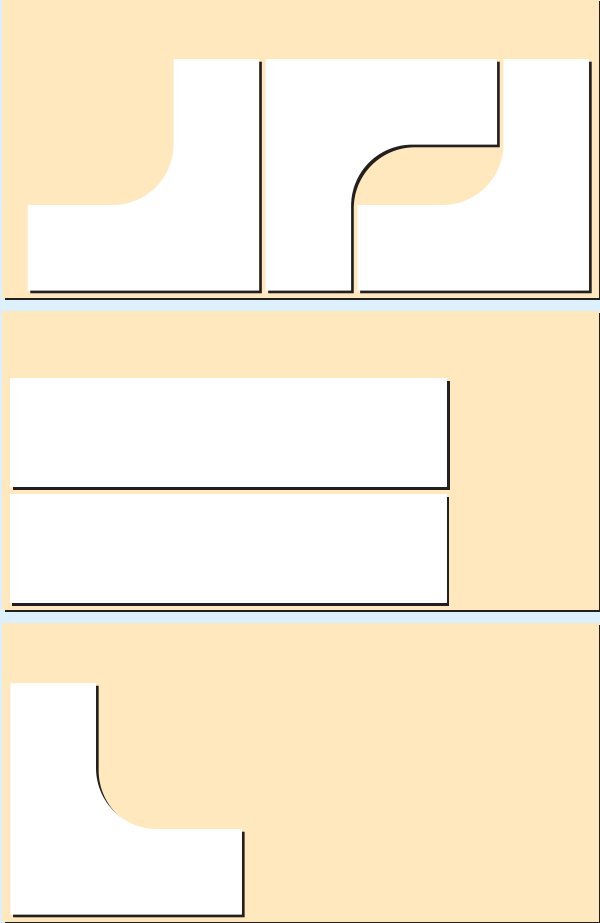


# Every Eighth Kitchen Free

*You've made the decision to join the NBM revolution and to buy a CNC router, but now you are wondering what size machine is right for you.*

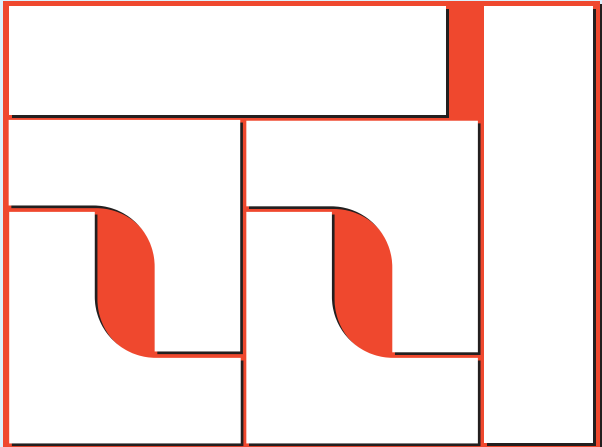
To answer this question you must first decide what sheet size is going to offer the greatest benefits. As a general rule, the larger the sheet size you can process, the more efficient your NBM operation will be. As an example, if the average kitchen takes 70 square metres of material, using a 1220x2440 sheet you will nest 24 sheets as compared to 16 sheets when using 1830x2440 sheets. With an average sheet change of 5 minutes, including spoil-board cleaning, the savings is 40 minutes of machine time per kitchen. Allowing 4 hours of cutting time per kitchen, excluding sheet changing, you can process 8 kitchens using the 1830x 2440 sheets in the same machine time as it takes



**As a general rule, the larger the sheet size you can process, the more efficient your NBM operation will be**

*Left:* This example shows nesting of six components on three 1220x2440mm sheets.

*Below:* The same six components nested on one 1830x2440mm sheet.



to process 7 kitchens using the 1220x2440 sheets. The machining of the eighth kitchen is effectively free. Add to this the savings from better yield that the larger sheet will give you and the savings in labour, and you will realise an increase in production and a saving in associated costs.

Using a larger sheet size also enhances the other major benefit of NBM, free labour. As larger sheets have a longer process time the operator can make better use of the between sheet change time, allowing them to edgeband and assemble with less interruptions. If the process time is too short, the operator may not feel obliged to perform secondary tasks.

There are two main types of NBM machines available in the market, P2P styled machines and gantry type NBM machines. However,

if you want to process 1830mm wide sheets the P2P styled machines are not an option as they are generally limited to a 1220mm wide sheet, due to their design. This leaves you with a limited number of choices in the gantry type NBM machines. Of the machines available the locally built iCAM Advantage is an obvious choice. Anyone who has had to fly out a technician for an imported machine will agree that strong local support is a must. With a process size of 1830x3660 and under \$120k, the iCAM Advantage 4072 ATC offers excellent value especially when you consider how much the processing of larger sheets can save you.

For those of you who would choose to use only 1220x2440 sheets because, "they can be lifted onto the machine by one person", consider this. For a small investment you

can install an overhead gantry system for loading the larger sheets. In fact, it is something you should consider regardless of sheet size. Apart from OSH obligations it makes good business sense, releasing the operator from the burden of lifting heavy panels will ensure they remain fresh and productive throughout the day.

There will always be an exception to the rule, but in most cases using larger sheets will save you time and give a better material yield. Although sheet size choice is something that can easily be overlooked when faced with all the options available on a CNC routing machine, it is something that should be considered thoughtfully as the concept 'maximum output vs minimum labour & materials' lies at the heart of the NBM philosophy.