

Machine: 500T Press

Date:

No	Description of Operation	Int. or Ext. Time	Add up Run Time	Cycle Time
	Scaling Line			00:06:03
1	Open Door	I	00:00:06	00:00:06
2	Ask Nick something	E	00:00:25	00:00:19
3	collect die spray and return	E	00:00:47	00:00:23
4	Spray die	I	00:01:14	00:00:27
5	walk to rear	I	00:01:25	00:00:11
6	switch off manifolds	I	00:01:50	00:00:25
7	remove pipes from fixed die	I	00:02:12	00:00:22
8	remove pipes from moving die	I	00:02:26	00:00:14
9	walk to front	I	00:02:55	00:00:29
10	clean hands and chat	I	00:03:16	00:00:21
11	remove pipes from dies at front	I	00:03:49	00:00:33
12	close door and close die	I	00:04:13	00:00:24
13	open door	I	00:04:20	00:00:07
14	collect tools and undo m.p. clamp	I	00:05:01	00:00:41
15	w r	I	00:05:12	00:00:11
16	undo m.p. Clamps x2	I	00:06:16	00:01:04
17	close rear door	I	00:06:20	00:00:04
18	w f	I	00:06:34	00:00:14
19	clean hands and chat	I	00:06:45	00:00:11
20	climb onto machine, climb down	I	00:07:06	00:00:21
21	close door	I	00:07:10	00:00:04
22	collect tools, strap and climb up	E	00:07:32	00:00:22
23	prep crane	E	00:07:40	00:00:08
24	check fittings	E	00:08:00	00:00:20
25	climb down	I	00:08:02	00:00:02
26	climb up	I	00:08:14	00:00:12
27	attempt to fit hanging strap	I	00:09:17	00:01:03
28	climb down	I	00:09:20	00:00:03
29	adjust dies and climb up	I	00:09:34	00:00:14
30	fit hanging strap	I	00:10:14	00:00:40
31	drop crane	I	00:10:34	00:00:20
32	attach crane to die	I	00:11:26	00:00:52
33	climb down	I	00:11:41	00:00:15
34	open door	I	00:11:59	00:00:18
35	check everything	I	00:12:20	00:00:21
36	undo f.p. clamps at front x2	I	00:12:45	00:00:25
37	w r	I	00:12:58	00:00:13
38	undo f.p. clamps at rear x2	I	00:13:48	00:00:50
39	w f	I	00:14:01	00:00:13
40	die out and lifted	I	00:14:32	00:00:31
41	move die to pallet	I	00:15:52	00:01:20
42	unhook crane from die	I	00:16:00	00:00:08
43	move crane	I	00:16:05	00:00:05
44	talk to Nick	I	00:16:30	00:00:25
45	move crane to new die	I	00:16:40	00:00:10
46	collect and fit lifting eye	E	00:17:00	00:00:20
47	attach crane to die	I	00:17:18	00:00:18
48	return to machine	I	00:17:34	00:00:16
49	w r and close door	I	00:17:50	00:00:16
50	w f	I	00:18:04	00:00:14
51	close door	I	00:18:15	00:00:11
52	close barrel guard	I	00:18:31	00:00:16
53	withdraw barrel	I	00:18:55	00:00:24
54	open guard	I	00:18:59	00:00:04
55	clean area out	I	00:19:23	00:00:24
56	walk to m/c 6 and return	I	00:20:07	00:00:44
57	attempt to remove adapter	I	00:21:05	00:00:58
58	walk to m/c 6 and return	I	00:21:23	00:00:18
59	attempt to remove adapter	I	00:22:08	00:00:45
60	speak to operator	I	00:22:27	00:00:19
61	attempt to remove adapter	I	00:23:39	00:01:12
62	walk to m/c 4, m/6, speak to Nick	I	00:24:19	00:00:40
63	return to machine	I	00:24:36	00:00:17
64	Nick tries to remove adapter	I	00:26:01	00:01:25
65	close door	I	00:26:06	00:00:05
66	look for lump of steel	E	00:27:27	00:01:21
67	fit into adapter hole	I	00:27:31	00:00:04
68	close barrel guard	I	00:27:34	00:00:03
69	close barrel	I	00:32:25	00:04:51
70	pick up adapter and steel block	I	00:32:38	00:00:13
71	withdraw barrel	I	00:33:24	00:00:46
72	check items for damage	E	00:33:39	00:00:15
73	collect new die	E	00:35:20	00:01:41
74	fit new adapter to die	E	00:36:02	00:00:42
75	open door	I	00:36:10	00:00:08
76	remove clamps from platten	I	00:38:13	00:02:03
77	check m/c 3	E	00:38:39	00:00:26
78	return to machine	E	00:38:44	00:00:05
79	replace clamps on f.p. X2	I	00:40:45	00:02:01
80	w r	I	00:40:59	00:00:14
81	replace clamps on f.p. X2	I	00:43:16	00:02:17
82	w f	I	00:43:29	00:00:13
83	new die moved to machine	I	00:45:11	00:01:42
84	attempt to fit	I	00:45:45	00:00:34
85	w r	I	00:45:55	00:00:10
86	attempt to fit	I	00:46:53	00:00:58
87	w f	I	00:47:04	00:00:11
88	attempt to fit	I	00:48:05	00:01:01
89	remove clamp	I	00:48:45	00:00:58
90	attempt to fit	I	00:49:52	00:01:09
91	w r	I	00:51:04	00:01:12
92	attempt to fit	I	00:51:05	00:00:01
93	drop allen key at front, return	E	00:53:01	00:01:56
94	Adjust m.p. clamps & reposition	I	00:54:38	00:01:37
95	w f	I	00:54:54	00:00:16
96	reposition m.p. clamps x2	I	00:57:39	00:02:45
97	climb onto machine	I	00:57:50	00:00:11
98	undo crane from die	I	00:58:10	00:00:20
99	look for ejector bars	E	1:00:20	00:02:10
100	measure bars and die	E	1:01:20	00:01:00
101	walk to lock-up	E	1:01:32	00:00:12
102	look for ejector bars	E	1:05:15	00:03:43
103	return to machine	E	1:05:50	00:00:35
104	check m/c 8 - not working	E	1:09:02	00:03:12
105	assemble ejector bars	E	1:10:20	00:01:18
106	fit to m.p.	I	1:11:50	00:01:30
107	walk to lock-up	E	1:12:14	00:00:24
108	cut ejector bars to size	E	1:14:14	00:02:00
109	return to machine	E	1:14:41	00:00:27
110	fit bars to machine	I	1:15:21	00:00:40
111	close dies	I	1:18:44	00:03:23
112	adjust ejector bars	I	1:19:31	00:00:47
113	close door	I	1:19:35	00:00:04
114	close platten to the die	I	1:20:21	00:00:46
115	open door	I	1:20:26	00:00:05
116	clamp die to m.p. x2	I	1:21:40	00:01:14
117	w r	I	1:21:59	00:00:19
118	clamp die to m.p. x2	I	1:23:30	00:01:31
119	close door	I	1:23:35	00:00:05
120	w f	I	1:23:48	00:00:13
121	tighten ejector bars	I	1:29:51	00:06:03
122	climb onto machine	I	1:30:01	00:00:10
123	remove hand strap and get down	I	1:30:31	00:00:30
124	setting m/c controls	I	1:31:05	00:00:34
125	open dies	I	1:31:15	00:00:10
126	move ejector bar plate	I	1:31:43	00:00:28
127	fit nuts to ejector bars	I	1:32:28	00:00:45

128	close dies slightly	I	1:32:42		0:00:14
129	fit nuts to ejector bars	I	1:36:05		0:03:23
130	setting m/c controls	I	1:39:39		0:03:34
131	pipes fitted f.p. x4	I	1:40:49		0:01:10
132	pipes fitted m.p. x3	I	1:41:15		0:00:26
133	find another water loop and return	E	1:42:46		0:01:31
134	w r	I	1:43:00		0:00:14
135	pipes fitted on both die halves	I	1:47:24		0:04:24
136	find another water loop and return	E	1:48:19		0:00:55
137	fit loop	I	1:48:26		0:00:07
138	manifold taps on	I	1:48:51		0:00:25
139	collect air line	E	1:51:06		0:02:15
140	speak to operator	E	1:51:35		0:00:29
141	collect fittings for air line	E	1:53:57		0:02:22
142	fit air line to die, front and rear	E	1:54:59		0:01:02
143	close guard on barrel	I	1:55:50		0:00:51
144	close door	I	1:56:17		0:00:27
145	collect cardboard box and return	E	1:57:21		0:01:04
146	tape box and position	E	1:57:57		0:00:36
147	adjust barrel	I	1:58:15		0:00:18
148	setting m/c controls	I	1:58:55		0:00:40
149	reset m/c - off/on	E	1:59:19		0:00:24
150	setting m/c controls	I	2:02:09		0:02:50
151	close dies	I	2:02:12		0:00:03
152	check dies	I	2:03:02		0:00:50
153	clean barrel end	I	2:03:40		0:00:38
154	close barrel	I	2:03:51		0:00:11
155	open dies	I	2:04:20		0:00:29
156	collect lube spray - Nick, store	E	2:06:10		0:01:50
157	Spray die	I	2:06:25		0:00:15
158	close door	I	2:06:32		0:00:07
159	close dies	I	2:06:36		0:00:04
160	1st shot die open	I	2:07:29		0:00:53
161	1st part out	I	2:07:35		0:00:06
162	2nd shot out	I	2:08:35		0:01:00
163	3rd shot out - adjust heat, speed	I	2:09:43		0:01:08
164	4th shot out	I	2:10:50		0:01:07
165	5th shot out - increase speed	I	2:12:06		0:01:16
166	6th shot out	I	2:13:07		0:01:01
167	7th shot out	I	2:14:11		0:01:04
168	8th shot out	I	2:15:14		0:01:03
169	9th shot out	I	2:16:10		0:00:56
170	10th shot out	I	2:17:06		0:00:56
171	11th shot out	I	2:18:04		0:00:58
172	12th shot out	I	2:19:07		0:01:03
173	13th shot out	I	2:20:08		0:01:01
174	14th shot out	I	2:21:05		0:00:57
175	15th shot out - increase speed	I	2:22:00		0:00:55
176	16th shot out	I	2:22:56		0:00:56
177	17th shot out	I	2:23:53		0:00:57
178	18th shot out - good shot	I	2:24:51		0:00:58
				2:24:51	