

Machine: 500T Press

No	Description of Operation	Int. or Ext. Time	Cycle Time
	<b>Scaling Line</b>		00:06:03
1	Open Door	I	00:00:06
2	Spray die	I	00:00:27
3	walk to rear	I	00:00:11
4	switch off manifolds	I	00:00:25
5	remove pipes from fixed die	I	00:00:22
6	remove pipes from moving die	I	00:00:14
7	walk to front	I	00:00:29
8	clean hands and chat	I	00:00:21
9	remove pipes from front	I	00:00:33
10	close door and close die	I	00:00:24
11	open door	I	00:00:07
12	collect tools and undo m.p. clamp	I	00:00:41
13	Walk to rear	I	00:00:11
14	undo m.p. clamps x2	I	00:01:04
15	close rear door	I	00:00:04
16	Walk to front	I	00:00:14
17	clean hands and chat	I	00:00:11
18	climb onto m/c, climb down	I	00:00:21
19	close door	I	00:00:04
20	climb down	I	00:00:02
21	climb up	I	00:00:12
22	climb down	I	00:00:03
23	adjust dies and climb up	I	00:00:14
24	fit hanging strap	I	00:00:40
25	drop crane	I	00:00:20
26	attach crane to die	I	00:00:52
27	climb down	I	00:00:15
28	open door	I	00:00:18
29	check everything	I	00:00:21
30	undo f.p. clamps at front x2	I	00:00:25
31	Walk to rear	I	00:00:13
32	undo f.p. clamps at rear x2	I	00:00:50
33	Walk to front	I	00:00:13
34	die out and lifted	I	00:00:33
35	move die to pallet	I	00:00:31
36	unhook crane from die	I	00:01:20
37	move crane to new die	I	00:00:10
38	attach crane to die	I	00:00:18
39	return to machine	I	00:00:16
40	Walk to rear and close door	I	00:00:16
41	Walk to front	I	00:00:14
42	close door	I	00:00:11
43	close barrel guard	I	00:00:16
44	withdraw barrel	I	00:00:24
45	open guard	I	00:00:04
46	clean area out	I	00:00:24
47	withdraw barrel	I	00:00:46
48	open door	I	00:00:08
49	remove clamps from platten	I	00:02:03
50	replace clamps on f.p. X2	I	00:02:01
51	Walk to rear	I	00:00:14
52	replace clamps on f.p. X2	I	00:02:17
53	Walk to front	I	00:00:13
54	new die moved to machine	I	00:01:42
55	Adjust m.p. clamps & reposition	I	00:01:37
56	Walk to front	I	00:00:16
57	reposition m.p. clamps x2	I	00:02:45
58	climb onto machine	I	00:00:11
59	undo crane from die	I	00:00:20
60	fit to m.p.	I	00:01:30
61	fit bars to machine	I	00:00:40
62	close dies	I	00:03:23
63	adjust ejector bars	I	00:00:47
64	clamp die to m.p. x2	I	00:01:14
65	Walk to rear	I	00:00:19
66	clamp die to m.p. x2	I	00:01:31
67	close door	I	00:00:05
68	Walk to front	I	00:00:13
69	tighten ejector bars	I	00:06:03
70	climb onto machine	I	00:00:10
71	remove hanging strap, get down	I	00:00:30
72	setting m/c controls	I	00:00:34
73	open dies	I	00:00:10
74	move ejector bar plate	I	00:00:28
75	fit nuts to ejector bars	I	00:00:45
76	fit nuts to ejector bars	I	00:03:23
77	setting m/c controls	I	00:03:34
78	pipes fitted f.p. x4	I	00:01:10
79	pipes fitted m.p. x3	I	00:00:26
80	Walk to rear	I	00:00:14
81	pipes fitted on both die halves	I	00:04:24
82	fit loop	I	00:00:07
83	manifold taps on	I	00:00:25
84	close guard on barrel	I	00:00:51
85	close door	I	00:00:27
86	adjust barrel	I	00:00:18
87	setting m/c controls	I	00:00:40
88	setting m/c controls	I	00:02:50
89	close dies	I	00:00:03
90	check dies	I	00:00:50
91	clean barrel end	I	00:00:38
92	close barrel	I	00:00:11
93	open dies	I	00:00:29
94	Spray die	I	00:00:15
95	close door	I	00:00:07
96	close dies	I	00:00:04
97	1st shot die open	I	00:00:53
98	1st part out	I	00:00:06
99	2nd shot out	I	00:01:00
100	3rd shot out - adjust heat, speed	I	00:01:08
101	4th shot out	I	00:01:07
102	5th shot out - increase speed	I	00:01:16
103	6th shot out	I	00:01:01
104	7th shot out	I	00:01:34
105	8th shot out	I	00:01:03
106	9th shot out	I	00:00:56
107	10th shot out	I	00:00:56
108	11th shot out	I	00:00:58
109	12th shot out	I	00:01:03
110	13th shot out	I	00:01:01
111	14th shot out	I	00:00:57
112	15th shot out - increase speed	I	00:00:55
113	16th shot out	I	00:00:56
114	17th shot out	I	00:00:57
115	18th shot out - good shot	I	00:00:58
			<b>1:28:35</b>