

Machine: 500T Press

No	Description of Operation	Int. or Ext. Time	Cycle Time
	Scaling Line		00:06:03
1	Open Door	I	00:00:06
2	Spray die	I	00:00:27
3	close door and close die	I	00:00:24
4	climb up	I	00:00:12
5	fit hanging strap	I	00:00:40
6	drop crane	I	00:00:20
7	attach crane to die	I	00:00:52
8	climb down	I	00:00:02
9	walk to rear	I	00:00:11
10	switch off manifolds	I	00:00:25
11	remove pipes from fixed die	I	00:00:22
12	remove pipes from moving die	I	00:00:14
13	undo m.p. clamps at rear x2	I	00:01:04
14	undo f.p. clamps at rear x2	I	00:00:50
15	walk to front	I	00:00:29
16	open door	I	00:00:07
17	remove pipes from front	I	00:00:33
18	undo m.p. clamp	I	00:00:41
19	undo f.p. clamps at front x2	I	00:00:25
20	die out and lifted	I	00:00:31
21	move die to pallet	I	00:01:20
22	unhook crane from die	I	00:00:08
23	move crane to new die	I	00:00:10
24	attach crane to die	I	00:00:18
25	return to machine	I	00:00:16
26	withdraw barrel	I	00:00:24
27	open guard	I	00:00:04
28	clean area out	I	00:00:24
29	remove adapter	I	00:00:10
30	remove clamps from platten	I	00:02:03
31	new die moved to machine	I	00:01:42
32	replace clamps on f.p. X2	I	00:02:01
33	Adjust m.p. clamps & reposition	I	00:01:37
34	Walk to rear	I	00:00:14
35	replace clamps on f.p. X2	I	00:02:17
36	Adjust m.p. clamps & reposition	I	00:01:37
37	Walk to front	I	00:00:11
38	climb onto machine	I	00:00:11
39	undo crane from die, climb down	I	00:00:20
40	fit ejector bars to machine	I	00:00:40
41	tighten ejector bars	I	00:06:03
42	pipes fitted f.p. x4	I	00:01:10
43	pipes fitted m.p. x3	I	00:00:26
44	Walk to rear	I	00:00:14
45	pipes fitted on both die halves	I	00:04:24
46	manifold taps on	I	00:00:25
47	Walk to front	I	00:00:14
48	close dies	I	00:00:03
49	check dies	I	00:00:50
50	open dies	I	00:00:29
51	Spray die	I	00:00:15
52	close door	I	00:00:07
53	close dies	I	00:00:04
54	1st part out	I	00:00:59
55	2nd shot out	I	00:01:00
56	3rd shot out - adjust heat, speed	I	00:01:08
57	4th shot out	I	00:01:07
58	5th shot out - increase speed	I	00:01:16
59	6th shot out	I	00:01:01
			0:46:17