	Machine:	500T Press			
A. Max. A. Max. B. S.	No			Cycle Time	
		Open Door			00:06:03
	3	collect die spray and return	E		00:00:22
					00:00:08
	7	remove pipes from fixed die			00:00:20
Nome Nome Number of the second se	8	remove pipes from moving die			00:00:15
	10	clean hands and chat			00:00:42
No.Non-solutionNo.No.Non-solutionNo.	12	close door and close die			00:00:05
	14	collect tools and undo m.p. clamp			00:02:10
Del Constructory Del Constructory Constructory <					00:00:12
	18	w f	E		00:00:35
Balance Part Part Part Part Part Part Part Part	20	climb onto machine, climb down			00:01:18
No. </td <td>22</td> <td>collect tools, strap and climb up</td> <td>Е</td> <td></td> <td>00:02:00</td>	22	collect tools, strap and climb up	Е		00:02:00
No. </td <td>24</td> <td>check fittings</td> <td>E</td> <td></td> <td>00:01:31</td>	24	check fittings	E		00:01:31
Partial Partial Partial P	26	climb up	Е		00:02:15
	28	climb down	E		00:02:22
	30	fit hanging strap	Е		00:01:04
	32	attach crane to die	E		00:00:24
SecSecSecConstruct <td>34</td> <td>open door</td> <td></td> <td></td> <td>00:00:27</td>	34	open door			00:00:27
B) B) B) C B) B)	36	undo f.p. clamps at front x2	I		00:00:11
No. <td< td=""><td>38</td><td>undo f.p. clamps at rear x2</td><td>I</td><td></td><td>00:00:25</td></td<>	38	undo f.p. clamps at rear x2	I		00:00:25
No. No. No.	40	die out and lifted			00:00:14
A. S. A	42	unhook crane from die	-		00:00:21
AAAAAAAABAAABAAABAAABBAACAAACBA	44	talk to Nick	I		00:00:24
A. NormalianA. SecondA.	46	collect and fit lifting eye	I I		00:00:41
No. </td <td>48</td> <td>return to machine</td> <td>I I</td> <td></td> <td>00:01:04</td>	48	return to machine	I I		00:01:04
No. No. No. No. No.			I I		00:00:14
No. </td <td></td> <td></td> <td>I</td> <td></td> <td>00:00:21</td>			I		00:00:21
A. B. Aurané A. B. Aurané A. B. Aurané A. B.			-		00:00:02
Second constructSecond construct <td< td=""><td>55</td><td>clean area out</td><td>I I</td><td></td><td>00:01:03</td></td<>	55	clean area out	I I		00:01:03
PinResult of the second se	57	attempt to remove adapter	I I		00:00:14
ABurgs vanue AugusBBCSet Augus Vanue AugusSet Augus Vanue AugusSet Augus Vanue AugusCSet Augus Vanue AugusSet Augus Vanue AugusSet Augus Vanue AugusCSet Augus Vanue AugusSet Augus Vanue AugusSet Augus Vanue AugusCSet Augus Vanue AugusSet Augus Vanue AugusSet Augus Vanue AugusCSet Augus Vanue AugusSet Augus Vanue AugusSet Augus Vanue AugusCSet Augus Vanue AugusSet Augus Vanue AugusSet Augus Vanue AugusCSet Augus Vanue AugusSet Augus Vanue AugusSet Augus Vanue AugusCSet Augus Vanue AugusSet Augus Vanue AugusSet Augus Vanue AugusCSet Augus Vanue AugusSet Augus Vanue AugusSet Augus Vanue AugusCSet Augus Vanue AugusSet Augus Vanue AugusSet Augus Vanue AugusCSet Augus Vanue AugusSet Augus Vanue AugusSet Augus Vanue AugusCSet Augus Vanue AugusSet Augus Vanue AugusSet Augus Vanue AugusCSet Augus Vanue AugusSet Augus Vanue AugusSet Augus Vanue AugusCSet Augus Vanue AugusSet Augus Vanue AugusSet Augus Vanue AugusCSet Augus Vanue AugusSet Augus Vanue AugusSet Augus Vanue AugusCSet Augus Vanue AugusSet Augus Vanue AugusSet Augus Vanue AugusCSet Augus Vanue Aug	59	attampt to remove adapter	I I		00:00:20
AAA	61	attampt to remove adapter	I		00:00:15
AAAAAAAAAAAAAAAABAAABAAABAAABAAABAAABAAABAAACAAA <trr>CA</trr>	63	return to machine	I		00:00:18
ABBBAAABAA	65	close door	I		00:00:25
Bet NumBet NumBet Num17Keykern Kotk1818Keykern Kotk1819Keykern Kotk1819Keykern Kotk1819Keykern Kotk1819Keykern Kotk1819Keykern Kotk1819Keykern Kotk1810Keykern Kotk1810Keykern Kotk1810Keykern Kotk1811Keykern Kotk1812Keykern Kotk1813Keykern Kotk1814Keykern Kotk1815Keykern Kotk1816Keykern Kotk1817Keykern Kotk1818Keykern Kotk1819Keykern Kotk1819Keykern Kotk1810Keykern Kotk1810Keykern Kotk1811Keykern Kotk1812Keykern Kotk1813Keykern Kotk1814Keykern Kotk1815Keykern Kotk1816Keykern Kotk1817Keykern Kotk1818Keykern Kotk1819Keykern Kotk1819Keykern Kotk1810Keykern Kotk1810Keykern Kotk1811Keykern Kotk1812Keykern Kotk1813Keykern Kotk18<	67	fit into adapter hole	I		00:00:50
Notice MateriaSet ConstructionNotice MateriaSet Construc	69	close barrel	I		00:00:31
73 wicknew 6 1 74 fire adjør 0 de 1 75 wicknew 6 1 76 wicknew 6 1 77 wicknew 6 1 78 wicknew 6 1 79 wicknew 6 1 70 wicknew 6 1 70 wicknew 6 1 70 wicknew 6 1 70 wickne	71	withdraw barrel	I		00:00:08
Pi opc doa' Image: stand set of the stand set of	73	collect new die	I		00:00:25
Pineds au sa hadraIIPineds au sa hadraIPineds au sa hadraI <td>75</td> <td>open door</td> <td></td> <td></td> <td>00:00:18</td>	75	open door			00:00:18
Product days of fy X2I80wrI81wrI82wrI83wrI84dorp of fy X2I84dorp of fy X2I84dorp of fy X2I84dorp of fy X2I84dorp of fy X2I85wrI86dorp of fy X2I87dorp of fy X2I88dorp of fy X2I89dorp of fy X2I80dorp of fy X2I81dorp of fy X2I82dorp of fy X2I83dorp of fy X2I84dorp of fy X2I85dorp of fy X2I86dorp of fy X2I87dorp of fy X2I88dorp of fy X2I89dorp of fy X2I80dorp of fy X2I81dorp of fy X2I82dorp of fy X2I83dorp of fy X2I84dorp of fy X2I84dorp of fy X2I85dorp of fy X2I86dorp of fy X2I87dorp of fy X2I88dorp of fy X2I89dorp of fy X2I80dorp of fy X2I80dorp of fy X2I81dorp of fy X2I82dorp of fy X2I83<	77	check m/c 3			00:00:16
811118287888384848884848488848484888484848884848488848484888584848886848488878484888886848889868488808684888186848882868488848684888486848885868688848686888486868885868688868686888686868886868688868686888686868886868688868686888686868886868688868686888686868886	79	replace clamps on f.p. X2	I I		00:00:11
Setore de monto machineIStamere during fuStaStavr <td< td=""><td>81</td><td>replace clamps on f.p. X2</td><td>I</td><td></td><td>00:00:24</td></td<>	81	replace clamps on f.p. X2	I		00:00:24
SNvrISNvrISN <td>82 83</td> <td>w f new die moved to machine</td> <td>I I</td> <td></td> <td>00:00:24</td>	82 83	w f new die moved to machine	I I		00:00:24
Srr88dempt of189tempts fr190atempts fr191vr192dempts fr193dempts fr194dempts fr195dempts fr196dempts fr197dempts fr198dempts fr199bok fragets fr199bok fragets fr	85	w r	I I		00:00:58
SeriesSeriesSeries90strept is fitSeries91vrSeries92strept is fitSeries93dop and strept strep	87	w f	I I		00:00:45
9/1 ví 1 92 atempto far 1 93 dop alle ky af ford, return 1 94 Alghus np. climps Reposition 1 95 v f 1 96 reposition np. climps 2 1 97 climb doto machine 1 98 uido carae form de 1 99 bok for ejector bars 1 90 kok for ejector bars 1 910 walk to ka-up 1 9111 walk to ka-up 1 9122 kok for ejector bars 1 9133 kok for ejector bars 1 9144 kok a-up 1 9155 kok for ejector bars 1 9165 kok for ejector bars 1 9175 kok for ejector bars 1 9186 for machine 1 9187 for machine 1 9188 kof ejector bars 1 9117 walk to ka-up 1	89	remove clamp	I		00:01:12
93 dop alles ky at font, reum 1 94 Adjust mp. champs & Reposition 1 95 w f 1 96 reposition mp. champs & 2 1 97 clab not machine 1 98 Mole crane from de 1 99 look crane from de 1 99 look crane from de 1 100 mexatre bars and de 1 101 walk to kedvap 1 102 look for ejector bars 1 103 return to machine 1 104 sexmbel ejector bars 1 105 sexmbel ejector bars 1 106 from achine 1 107 walk to kedvap 1 108 ejector bars 1 109 look for ejector bars 1 1014 ejector bars 1 1015 sexmbel ejector bars 1 1116 for o harbine 1 1117 walk to kedvan	91	w r	I I		00:00:17
Adjust no. champs & reposition I 95 w f I 95 w f I 96 reposition mp.champs & Z I 97 chim not makine I 98 undo crame from die I 99 look for rejostro baris I 100 measure from die I 101 wak to beck up I 102 look for rejostro baris I 103 return to machine I 104 check we S - not working I 105 assemble ejecter baris I 106 fit to m.p. I 107 wak to beck up I 108 assemble ejecter baris I 109 fit to m.p. I 1016 fit to m.p. I 1017 wak to beck up I 118 carelefet baris to size I 119 fit taris I 110 fit baris to mechine I <tr< td=""><td>93</td><td>drop allen key at front, return</td><td>I I</td><td></td><td>00:00:05</td></tr<>	93	drop allen key at front, return	I I		00:00:05
97Cimb oto machine198look for ejsctor bars199look for ejsctor bars1100mesaure bars and die1101walk to lock-up1102look for ejsctor bars1103return to machine1104look for ejsctor bars1105senthe ejsctor hars1106die die die die die die die die die die	95	w f	I		00:00:03
98 undo cran from die 1 99 bok far eigetor bars 1 100 mexame bars and die 1 101 watk to lock op 1 102 lock for ejector bars 1 103 return to machine 1 104 dock nrk 3 - not working 1 105 alsemble ejector bars 1 106 dick nrk 3 - not working 1 107 watk to lock nrk 3 - not working 1 108 dock nrk 3 - not working 1 109 fit to np. 1 1016 fit to np. 1 1017 walk to lock-up 1 1018 cut ejector bars to size 1 1019 return to machine 1 1109 return to machine 1 1110 fit bars to machine 1 1111 close doar 1 1112 dajust ejector bars 1 1113 fit bars to machine 1 1115	97	climb onto machine	I I		00:00:13 00:00:46
Initial Initial 1010 walk to lock-up I 1012 lock for ejector bars I 1013 return to machine I 1014 check mc ² s not working I 1015 assemble ejector bars I 1016 fit to m, p. I 1017 walk to lock-up I 1018 cut ejector bars I 1019 eturn to machine I 1010 fit to m, p. I 1011 walk to lock-up I 1011 walk to lock-up I 1011 fit hor sp. I 1011 fit hor sp. I 1011 fit hor sp. I 1110 fit hor sp. I 1111 chose dos I 1112 afjust ejector bars I 1113 chose dor I 1114 chose platen to the die I 1115 open dor I 1116	99	look for ejector bars	I I		00:00:08
Index Index Index 102 lock m/s Index 103 return to machine Index 104 check m/s Index 105 assemble ejector hars Index 106 fit to m, p. Index 107 walk to lock-up Index 108 cut-glector hars to ize Index 109 return to machine Index 100 fit to m, p. Index 110 fit hars to machine Index 110 fit hars to machine Index 111 close dor Index 112 adjust ejector hars Index 113 close dor Index 114 close glatent to the die Index 115 open door Index 116 clamp die to mp. x2 Index 117 w r Index 118 clamp die to mp. x2 Index 119 clamp die to mp. x2 Index 1119	100	measure bars and die walk to lock-up			00:02:01
104check mc & - not working1105assemble ejector bars1106fit to mc,1107walk to lock-up1108cut ejector bars to ize1109return to machine1101fit bars, cut ejector bars1102state machine1113close des1114close platen to the de1115open dor1116close dor1117w fr1118close dor1119close dor11114close platen to the die1115open dor1116clamp die to mp. X21117w fr1118clamp die to mp. X21119clase door1110clamp die to mp. X211112ighten cjector bars1112ighten cjector bars1113clamp die to mp. X21114clase door1115clamp die to mp. X21116clamp die to mp. X21117w fr1118clamp die to mp. X21119clase door1110ighten cjector bars11112ighten cjector bars11120ighten cjector bars11131clamp ciector bars11142clamp ciector bars11153clamp ciector bars<	102 103	look for ejector bars return to machine	I I		00:02:17
Info fit on p. I 107 wake to kok-up I 108 cut ejctor bars to size I 109 return to machine I 100 fit bars to machine I 110 fit bars to machine I 111 close dies I 1111 close dies I 1112 adjust ejector bars I 1113 close door I 113 close door I 114 close diet no the die I 115 open door I 116 close plate no the die I 117 wr I I 118 obes diet on the 2 I I 119 close plate no the die I I 119 close door I I 119 close door I I 119 close door I I 120 wr I I	104 105	check m/c 8 - not working	I I		00:01:42
full cut gicor hars to size I 109 return to machine I 110 fit bars to machine I 111 choice disc I 111 choice disc I 112 adjust ejector hars I 113 choice disc I 114 choice disc I 115 open door I 116 chang dis to mp. x2 I 117 wr I 118 chang dis to mp. x2 I 119 chang dis tomp. x2 I 1119 chang dis tomp. x2 I 1111 chang dis tomp. x2 I 11110 </td <td>106</td> <td>fit to m.p.</td> <td>I I</td> <td></td> <td>00:00:10</td>	106	fit to m.p.	I I		00:00:10
fit ars or machine I 110 fitars for machine I 111 close disc I 112 adjust ejector bars I 113 close doar I 114 close doar I 113 close doar I 114 close doar I 115 open doar I 116 clamp dist to mp. 22 I 117 w r I 118 clamp dist to mp. 22 I 119 clamp dist to mp. 24 I 119 clamp dist to mp. 24 I 119 clamp dist to mp. 24 I 1119 clamp dist to mp. 24 I 1120 machine I 1211 fighten ejector bars I 1212 fighten ejector bars I 12	108	cut ejector bars to size	I I		00:00:11
adjust ejector bars I 112 adjust ejector bars I 113 close dor I 114 close platent to the die I 115 open dor I 116 clamp die to mp. s2 I 117 w r I 118 clamp die to mp. s2 I 119 ver dor I 119 clamp die to mp. s2 I 119 clamp die to mp. s2 I 119 clamp die to mp. s2 I 120 w f I 121 ighten ejector bars I 122 fabrit ejector bars I 123 remove hand trap and get dow I	110	fit bars to machine	I		00:00:38
I14 close platen to the die I1 I15 open door I I16 champ die to mp. \$2 I I17 w r I I18 champ die to mp. \$2 I I19 obse door I I19 clase door I I19 clase door I I19 clase door I I19 clase door I I100 w f I I200 w f I I210 ighten ejector bars I I210 ejector bars I I212 climb ontor machine I I220 emote hand strap and get down I	112	adjust ejector bars	I		00:01:12
Inference Inference Inference 116 champ die to m.p. x2 Inference I	114	close platten to the die	I		00:00:137
118 clamp die to m.p. x2 I 119 close door I 110 of die to m.p. x2 I 111 close door I 120 w f I 121 tighten ejector bars I 122 cimb onto machine I 123 remove hand strap and get down I	116	clamp die to m.p. x2	I		00:02:45
120 wf I 121 tighten ejector bars I 122 cimb on machine I 123 remove hand strap and get down I	118	clamp die to m.p. x2	I		00:00:20
122 climb onto machine I 123 remove hand strap and get down I	120	w f	I		00:01:30
	122	climb onto machine	I		00:03:23 00:00:47 00:00:04
124 setting m/c controls		setting m/c controls	I		00:00:46

125	open dies	T	00:00
126	move ejector bar plate	I	
120	fit nuts to ejector bars	I	
127	close dies slightly	I	00001
120	fit nuts to ejector bars	I	00000
129		I	00000
130	setting m/c controls	I	0000
	pipes fitted f.p. x4		
132	pipes fitted m.p. x3	I	0000:
133	find another water loop and return	I	00:00:
134	w r	I	00000
135	pipes fitted on both die halves	I	00:00:
136	find another water loop and return	I	00:00:
137	fit loop	I	00:00:
138	manifold taps on	I	00:00:
139	collect air line	I	00:03:
140	speak to operator	I	00:03::
141	collect fittings for air line	I	00:01:
142	fit air line to die, front and rear	I	00:00:
143	close guard on barrel	I	00:00:
144	close door	I	00043
145	collect cardboard box and return	I	00001
146	tape box and position	I	00000
147	adjust barrel	I	00000
147	setting m/c controls	I	0000.
140	reset m/c - off/on	I	
149	setting m/c controls	1	00000
150		I	0000
	close dies		
152	check dies	I	00000
153	clean barrel end	I	00:00:
154	close barrel	I	00000
155	open dies	I	00:00:
156	collect lube spray - Nick, store	I	00:00:
157	Spray die	I	00:00:
158	close door	I	00:00:
159	close dies	I	00:00:
160	1 st shot die open	I	00:00:
161	1 st part out	I	00:00:
162	2nd shot out	I	00:01:
163	3rd shot out - adjust heat, speed	I	00:01:
164	4th shot out	I	00:01:
165	5th shot out - increase speed	I	0001:
166	6th shot out	I	10000
167	7th shot out	I	10000
168	8th shot out	I	00001
169	9th shot out	I	20000 00000000000000000000000000000000
170	10th shot out	I	0000
170	11th shot out	I	
171	12th shot out	I	20000 (10300)
172		I	2000 10000 10000
	13th shot out		
174	14th shot out	I	
175	15th shot out - increase speed	I	00000
176	16th shot out	I	:0000
177	17th shot out	I	00:00:
178	18th shot out - good shot	I	00:00:
			1:49:1