

Machine: 500T Press

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

125	open dies	I		00:00:05
126	move ejector bar plate	I		00:01:14
127	fit nuts to ejector bars	I		00:00:19
128	close dies slightly	I		00:01:31
129	fit nuts to ejector bars	I		00:00:05
130	setting m/c controls	I		00:00:13
131	pipes fitted f.p. x4	I		00:06:03
132	pipes fitted m.p. x3	I		00:00:10
133	find another water loop and return	I		00:00:30
134	w r	I		00:00:34
135	pipes fitted on both die halves	I		00:00:10
136	find another water loop and return	I		00:00:10
137	fit loop	I		00:00:28
138	manifold taps on	I		00:00:14
139	collect air line	I		00:03:23
140	speak to operator	I		00:03:34
141	collect fittings for air line	I		00:01:10
142	fit air line to die, front and rear	I		00:00:26
143	close guard on barrel	I		00:00:14
144	close door	I		00:04:24
145	collect cardboard box and return	I		00:00:07
146	tape box and position	I		00:00:25
147	adjust barrel	I		00:00:51
148	setting m/c controls	I		00:00:27
149	reset m/c - off/on	I		00:00:18
150	setting m/c controls	I		00:00:40
151	close dies	I		00:02:50
152	check dies	I		00:00:03
153	clean barrel end	I		00:00:50
154	close barrel	I		00:00:38
155	open dies	I		00:00:11
156	collect lube spray - Nick, store	I		00:00:29
157	Spray die	I		00:00:15
158	close door	I		00:00:07
159	close dies	I		00:00:04
160	1st shot die open	I		00:00:53
161	1st part out	I		00:00:06
162	2nd shot out	I		00:01:00
163	3rd shot out - adjust heat, speed	I		00:01:08
164	4th shot out	I		00:01:07
165	5th shot out - increase speed	I		00:01:16
166	6th shot out	I		00:01:01
167	7th shot out	I		00:01:04
168	8th shot out	I		00:01:03
169	9th shot out	I		00:00:56
170	10th shot out	I		00:00:56
171	11th shot out	I		00:00:58
172	12th shot out	I		00:01:03
173	13th shot out	I		00:01:01
174	14th shot out	I		00:00:57
175	15th shot out - increase speed	I		00:00:55
176	16th shot out	I		00:00:56
177	17th shot out	I		00:00:57
178	18th shot out - good shot	I		00:00:58
				1:49:05