



หมายเลขเอกสาร : QD-F1-248
ชื่อเอกสาร ค่าควบคุมการผลิตบล็อกแก้ว

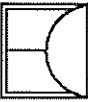
ครั้งที่แก้ไข : 07
หมายเลขหน้า : 1
วันที่บังคับใช้ : 18/05/23

สารบัญ

หมายเลขหน้า	เรื่อง
1	สารบัญ.
2	วัตถุประสงค์และขอบเขต.
3	Automatic Glass Press Machine Line 1.
4	Automatic Glass Welding Machine Line 1.
5	Automatic Glass Press Machine Line 2.
6	Automatic Glass Welding Machine Line 2.
7	Automatic Glass Press Machine Line 3.
8	Automatic Glass Welding Machine Line 3.

*ประวัติการแก้ไขเอกสารสามารถตรวจสอบได้จากประวัติการแก้ไขของเอกสารต้นฉบับ

 (นายจักรกฤษณ์ เนรแขก) ผู้จัดการแผนกขึ้นรูป	 (นายกุลวัฒน์ ชื้อจริง) ผู้จัดการส่วนโรงงาน	 (นายชูชาติ อุ่นอรมย์) QMR
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 B A N G K O K C R Y S T A L	หมายเลขเอกสาร : QD-F1-248	ครั้งที่แก้ไข : 07
	ชื่อเอกสาร ค่าควบคุมการผลิตบล็อกแก้ว	หมายเลขหน้า : 2

วัตถุประสงค์และขอบเขต

มาตรฐานระเบียบปฏิบัติฉบับนี้ครอบคลุมเกี่ยวกับรายละเอียดของการกำหนดค่าต่าง ๆ ที่ใช้ในการผลิตบล็อกแก้ว เพื่อให้มั่นใจว่าระบบคุณภาพของบริษัทที่กำหนดไว้ ถูกนำไปปฏิบัติอย่างมีประสิทธิภาพ

นิยาม

-ไม่มี-

เอกสารควบคุม

AUTOMATIC GLASS PRESS MACHINE LINE 1

INDEXING TABLE			Air Former :										
MOVEMENT TIME :	<table border="1" style="display: inline-table;"><tr><td>1.20</td><td>1.20±1.0</td></tr></table> S	1.20	1.20±1.0		- 1 -	- 2 -	- 3 -						
1.20	1.20±1.0												
DELAY START IND.TABLE :	<table border="1" style="display: inline-table;"><tr><td>0.60</td><td>0.60±1.0</td></tr></table> J	0.60	0.60±1.0		<table border="1" style="display: inline-table;"><tr><td>5</td><td>5±10</td></tr></table>	5	5±10	<table border="1" style="display: inline-table;"><tr><td>4</td><td>4±10</td></tr></table>	4	4±10	<table border="1" style="display: inline-table;"><tr><td>3</td><td>3±10</td></tr></table>	3	3±10
0.60	0.60±1.0												
5	5±10												
4	4±10												
3	3±10												
CUT SETTING 1/MIN :	<table border="1" style="display: inline-table;"><tr><td>20.0</td><td>20.0±20.0</td></tr></table> J	20.0	20.0±20.0		- 4 -	- 5 -							
20.0	20.0±20.0												
			<table border="1" style="display: inline-table;"><tr><td>2</td><td>2±10</td></tr></table>	2	2±10	<table border="1" style="display: inline-table;"><tr><td>2</td><td>2±10</td></tr></table>	2	2±10					
2	2±10												
2	2±10												

PRESSING CYLINDER													
PLUNGER COOLING :	<table border="1" style="display: inline-table;"><tr><td>1.20</td><td>1.20±1.0</td></tr></table>	1.20	1.20±1.0										
1.20	1.20±1.0												
	Position "mm"	Delay time	Time	Pressure	Speed %								
PRESSCYL : ↓	<table border="1" style="display: inline-table;"><tr><td>1.50</td><td>1.50±1.0</td></tr></table> J	1.50	1.50±1.0	<table border="1" style="display: inline-table;"><tr><td>0.25</td><td>0.25±1.0</td></tr></table> J	0.25	0.25±1.0		<table border="1" style="display: inline-table;"><tr><td>50</td><td>50±50</td></tr></table> J	50	50±50	<table border="1" style="display: inline-table;"><tr><td>50</td><td>50±50</td></tr></table> J	50	50±50
1.50	1.50±1.0												
0.25	0.25±1.0												
50	50±50												
50	50±50												
PRESSCYL : ↓			<table border="1" style="display: inline-table;"><tr><td>0.60</td><td>0.60±1.0</td></tr></table> J	0.60	0.60±1.0	<table border="1" style="display: inline-table;"><tr><td>50</td><td>50±50</td></tr></table> J	50	50±50	<table border="1" style="display: inline-table;"><tr><td>50</td><td>50±50</td></tr></table> J	50	50±50		
0.60	0.60±1.0												
50	50±50												
50	50±50												
DWELL TIME :			<table border="1" style="display: inline-table;"><tr><td>0.20</td><td>0.20±1.0</td></tr></table> J	0.20	0.20±1.0	<table border="1" style="display: inline-table;"><tr><td>10</td><td>10±50</td></tr></table> J	10	10±50	<table border="1" style="display: inline-table;"><tr><td>10</td><td>10±50</td></tr></table> J	10	10±50		
0.20	0.20±1.0												
10	10±50												
10	10±50												
PRESSCYL : ↑			<table border="1" style="display: inline-table;"><tr><td>0.05</td><td>0.05±1.0</td></tr></table> J	0.05	0.05±1.0	<table border="1" style="display: inline-table;"><tr><td>50</td><td>50±50</td></tr></table> J	50	50±50	<table border="1" style="display: inline-table;"><tr><td>50</td><td>50±50</td></tr></table> J	50	50±50		
0.05	0.05±1.0												
50	50±50												
50	50±50												
PRESSCYL : ↑	<table border="1" style="display: inline-table;"><tr><td>0.0</td><td>0.0±1.0</td></tr></table> J	0.0	0.0±1.0			<table border="1" style="display: inline-table;"><tr><td>50</td><td>50±50</td></tr></table> J	50	50±50	<table border="1" style="display: inline-table;"><tr><td>50</td><td>50±50</td></tr></table> J	50	50±50		
0.0	0.0±1.0												
50	50±50												
50	50±50												

PLUNGER RING													
	Position "mm"	Delay time	Time	Pressure	Speed %								
RING : ↓		<table border="1" style="display: inline-table;"><tr><td>0.02</td><td>0.02±1.0</td></tr></table> J	0.02	0.02±1.0		<table border="1" style="display: inline-table;"><tr><td>80</td><td>80±50</td></tr></table> J	80	80±50	<table border="1" style="display: inline-table;"><tr><td>80</td><td>80±50</td></tr></table> J	80	80±50		
0.02	0.02±1.0												
80	80±50												
80	80±50												
RING : ↑	<table border="1" style="display: inline-table;"><tr><td>0123</td><td>123±1.0</td></tr></table> J	0123	123±1.0	<table border="1" style="display: inline-table;"><tr><td>0.15</td><td>0.15±1.0</td></tr></table> J	0.15	0.15±1.0		<table border="1" style="display: inline-table;"><tr><td>80</td><td>80±50</td></tr></table> J	80	80±50	<table border="1" style="display: inline-table;"><tr><td>80</td><td>80±50</td></tr></table> J	80	80±50
0123	123±1.0												
0.15	0.15±1.0												
80	80±50												
80	80±50												

TAKE-OUT			CONVEYOR I / II								
DELAY START IN :	<table border="1" style="display: inline-table;"><tr><td>0.01</td><td>0.01±1.0</td></tr></table> J	0.01	0.01±1.0		SPEED CONVEYOR I :	<table border="1" style="display: inline-table;"><tr><td>50</td><td>50±50</td></tr></table> J	50	50±50			
0.01	0.01±1.0										
50	50±50										
Mould	Time		SPEED CONVEYOR II :	<table border="1" style="display: inline-table;"><tr><td>20</td><td>20±50</td></tr></table> J	20	20±50					
20	20±50										
TAKE-OUT FORWARE :		Time		Delay Time	Time						
GRIPPER CLOSE : ⇐⇒	<table border="1" style="display: inline-table;"><tr><td>0.50</td><td>0.50±1.0</td></tr></table> J	0.50	0.50±1.0	⇒ <table border="1" style="display: inline-table;"><tr><td>0.60</td><td>0.60±1.0</td></tr></table> J	0.60	0.60±1.0		COOLING COVEYOR I :	<table border="1" style="display: inline-table;"><tr><td>2.20</td><td>2.20±5.0</td></tr></table> J	2.20	2.20±5.0
0.50	0.50±1.0										
0.60	0.60±1.0										
2.20	2.20±5.0										
TAKE-OUT REWARE :		↑ <table border="1" style="display: inline-table;"><tr><td>0.40</td><td>0.40±1.0</td></tr></table> J	0.40	0.40±1.0		ROTATE SECOND HALFT :	<table border="1" style="display: inline-table;"><tr><td>2.50</td><td>2.50±5.0</td></tr></table> J	2.50	2.50±5.0		
0.40	0.40±1.0										
2.50	2.50±5.0										
Conveyor	Time	⇐ <table border="1" style="display: inline-table;"><tr><td>0.60</td><td>0.50±1.0</td></tr></table> J	0.60	0.50±1.0			<table border="1" style="display: inline-table;"><tr><td>2.50</td><td>2.50±5.0</td></tr></table> J	2.50	2.50±5.0		
0.60	0.50±1.0										
2.50	2.50±5.0										
GRIPPER OPEN : ⇐⇒	<table border="1" style="display: inline-table;"><tr><td>0.50</td><td>0.50±1.0</td></tr></table> J	0.50	0.50±1.0								
0.50	0.50±1.0										

CAM-SHAFT 1-8				FEEDER MECHANISM									
	Start (°)	End (°)		Plunger Stroke (mm) :	<table border="1" style="display: inline-table;"><tr><td>20</td><td>20±100</td></tr></table>	20	20±100	<table border="1" style="display: inline-table;"><tr><td>50</td><td>50±100</td></tr></table>	50	50±100			
20	20±100												
50	50±100												
Start Press :	<table border="1" style="display: inline-table;"><tr><td>272</td><td>272±360</td></tr></table>	272	272±360	<table border="1" style="display: inline-table;"><tr><td>276</td><td>276±360</td></tr></table>	276	276±360		Tube (mm) :	<table border="1" style="display: inline-table;"><tr><td>20</td><td>20±100</td></tr></table>	20	20±100		
272	272±360												
276	276±360												
20	20±100												
Start Welding :	<table border="1" style="display: inline-table;"><tr><td>200</td><td>200±360</td></tr></table>	200	200±360	<table border="1" style="display: inline-table;"><tr><td>210</td><td>210±360</td></tr></table>	210	210±360		Speed Tube (Hz) :	<table border="1" style="display: inline-table;"><tr><td>20</td><td>20±50</td></tr></table>	20	20±50		
200	200±360												
210	210±360												
20	20±50												
Plunger Up :	<table border="1" style="display: inline-table;"><tr><td>100</td><td>100±360</td></tr></table>	100	100±360	<table border="1" style="display: inline-table;"><tr><td>180</td><td>180±360</td></tr></table>	180	180±360		Gob Temperature (°C) :	<table border="1" style="display: inline-table;"><tr><td>1082</td><td>1082±100</td></tr></table>	1082	1082±100		
100	100±360												
180	180±360												
1082	1082±100												
Plunger Down :	<table border="1" style="display: inline-table;"><tr><td>10</td><td>10±360</td></tr></table>	10	10±360	<table border="1" style="display: inline-table;"><tr><td>80</td><td>80±360</td></tr></table>	80	80±360		Temp Bottom Mould :	<table border="1" style="display: inline-table;"><tr><td>300</td><td>300±200</td></tr></table>	300	300±200		
10	10±360												
80	80±360												
300	300±200												
Shear (Reserve)	<table border="1" style="display: inline-table;"><tr><td>0.0</td><td>0.0±360</td></tr></table>	0.0	0.0±360	<table border="1" style="display: inline-table;"><tr><td>0.0</td><td>0.0±360</td></tr></table>	0.0	0.0±360							
0.0	0.0±360												
0.0	0.0±360												
Shear Close :	<table border="1" style="display: inline-table;"><tr><td>130</td><td>130±360</td></tr></table>	130	130±360	<table border="1" style="display: inline-table;"><tr><td>155</td><td>155±360</td></tr></table>	155	155±360							
130	130±360												
155	155±360												
Shear Spray :	<table border="1" style="display: inline-table;"><tr><td>250</td><td>250±360</td></tr></table>	250	250±360	<table border="1" style="display: inline-table;"><tr><td>350</td><td>350±360</td></tr></table>	350	350±360							
250	250±360												
350	350±360												
Shear Lubricat :	<table border="1" style="display: inline-table;"><tr><td>250</td><td>250±360</td></tr></table>	250	250±360	<table border="1" style="display: inline-table;"><tr><td>350</td><td>350±360</td></tr></table>	350	350±360							
250	250±360												
350	350±360												

WATER COOLING PLUNGER					
Water Soft	<input type="checkbox"/>	Inlet (°C)	Outlet (°C)		
Water Chiller	<input type="checkbox"/>	<table border="1" style="display: inline-table;"><tr><td>15±50</td></tr></table>	15±50	<table border="1" style="display: inline-table;"><tr><td>35±50</td></tr></table>	35±50
15±50					
35±50					

Operator : _____ Leader : _____

AUTOMATIC GLASS WELDING MACHINE LINE 1

INDEXING TABLE											
B-MARK CUT : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>10.0</td><td>10.0±10</td></tr></table> pcs/min.	10.0	10.0±10	MOVEMENT TIME : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>1.40</td><td>1.40±1.0</td></tr></table> s	1.40	1.40±1.0						
10.0	10.0±10										
1.40	1.40±1.0										
	DELAY START IND.TANBLE : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>1.00</td><td>1.00±1.0</td></tr></table> loading	1.00	1.00±1.0								
1.00	1.00±1.0										
	TIME CAW LOCKING UP : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>0.10</td><td>0.10±1.0</td></tr></table> loading	0.10	0.10±1.0								
0.10	0.10±1.0										
	TIME CAW UNLOCKING DOWN : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>0.30</td><td>0.30±1.0</td></tr></table> take-out	0.30	0.30±1.0								
0.30	0.30±1.0										
CLOSING CYLINDER											
COLS CYL : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>20.0</td><td>20.0±50</td></tr></table>	20.0	20.0±50	DEALL TIME : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>0.25</td><td>0.25±1.0</td></tr></table>	0.25	0.25±1.0	Time : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>0.60</td><td>0.60±1.0</td></tr></table>	0.60	0.60±1.0	Speed % : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>90</td><td>90±100</td></tr></table>	90	90±100
20.0	20.0±50										
0.25	0.25±1.0										
0.60	0.60±1.0										
90	90±100										
COLS CYL : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>8.0</td><td>8.0±50</td></tr></table>	8.0	8.0±50		Time : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>0.60</td><td>0.60±1.0</td></tr></table>	0.60	0.60±1.0	Speed % : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>10</td><td>10±100</td></tr></table>	10	10±100		
8.0	8.0±50										
0.60	0.60±1.0										
10	10±100										
		Time : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>0.60</td><td>0.60±1.0</td></tr></table>	0.60	0.60±1.0	Speed % : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>50</td><td>50±100</td></tr></table>	50	50±100				
0.60	0.60±1.0										
50	50±100										
			Speed % : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>90</td><td>90±100</td></tr></table>	90	90±100						
90	90±100										
TURNING GRIPPER NEW											
Position 1 : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>0.0</td><td>0.0±180</td></tr></table>	0.0	0.0±180	Position 2 : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>180.0</td><td>180±180</td></tr></table>	180.0	180±180	Speed % : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>550</td><td>550±500</td></tr></table>		550	550±500		
0.0	0.0±180										
180.0	180±180										
550	550±500										
	Time : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>0.50</td><td>0.50±1.0</td></tr></table>	0.50	0.50±1.0								
0.50	0.50±1.0										
Delay Close Gripper : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>0.50</td><td>0.50±1.0</td></tr></table>	0.50	0.50±1.0									
0.50	0.50±1.0										
TAKE-OUT											
FORWARD : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>85</td><td>85±100</td></tr></table>	85	85±100	FORWARD DOWN : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>60</td><td>60±100</td></tr></table>	60	60±100	FORWARD UP : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>60</td><td>60±100</td></tr></table>	60	60±100	REWARD : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>80</td><td>80±100</td></tr></table>	80	80±100
85	85±100										
60	60±100										
60	60±100										
80	80±100										
TURN & DOWN : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>30</td><td>30±100</td></tr></table>	30	30±100	REWARD DOWN : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>40</td><td>40±100</td></tr></table>	40	40±100	TURNING : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>65</td><td>65±100</td></tr></table>	65	65±100	UNLOAD TIME : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>0.65</td><td>0.65±1.0</td></tr></table>	0.65	0.65±1.0
30	30±100										
40	40±100										
65	65±100										
0.65	0.65±1.0										
REW. UP : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>55</td><td>55±100</td></tr></table>	55	55±100	BASE POSITION FORWARD : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>85</td><td>85±100</td></tr></table>	85	85±100						
55	55±100										
85	85±100										
OPENING CYLINDER											
OPENING CYLINDER : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>0.35</td><td>0.35±1.0</td></tr></table>	0.35	0.35±1.0	UNLOCKING : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>0.45</td><td>0.45±1.0</td></tr></table>	0.45	0.45±1.0	Time : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>0.50</td><td>0.50±1.0</td></tr></table>	0.50	0.50±1.0			
0.35	0.35±1.0										
0.45	0.45±1.0										
0.50	0.50±1.0										
CHUTE / LIFTING TABLE											
TIME CUT DOWN : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>0.10</td><td>0.10±1.0</td></tr></table>	0.10	0.10±1.0	DELAY START CR. TABLE : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>0.20</td><td>0.20±1.0</td></tr></table>	0.20	0.20±1.0	CROSS TABLE FORWARD : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>0.50</td><td>0.50±1.0</td></tr></table>	0.50	0.50±1.0	DELAY CR. TABLE REWARD : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>0.30</td><td>0.30±1.0</td></tr></table>	0.30	0.30±1.0
0.10	0.10±1.0										
0.20	0.20±1.0										
0.50	0.50±1.0										
0.30	0.30±1.0										
DELAY CR. TABLE REWARD : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>0.30</td><td>0.30±1.0</td></tr></table>	0.30	0.30±1.0	CROSS TABLE REWARD : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>0.40</td><td>0.40±1.0</td></tr></table>	0.40	0.40±1.0	LIFTING TABLE : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>0.10</td><td>0.10±1.0</td></tr></table>	0.10	0.10±1.0	DELAY LIFT TABLE DOWN : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>0.12</td><td>0.12±1.0</td></tr></table>	0.12	0.12±1.0
0.30	0.30±1.0										
0.40	0.40±1.0										
0.10	0.10±1.0										
0.12	0.12±1.0										
SWIVEL COLUMN NEW											
Delay start to take-off position : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>0.10</td><td>0.10±1.0</td></tr></table>	0.10	0.10±1.0	Take-off position : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>0.0</td><td>0.0±90</td></tr></table>	0.0	0.0±90	Speed % : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>500</td><td>500±500</td></tr></table>	500	500±500	Unload position : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>90.0</td><td>90±90</td></tr></table>	90.0	90±90
0.10	0.10±1.0										
0.0	0.0±90										
500	500±500										
90.0	90±90										
	Delay Finger : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>0.35</td><td>0.35±1.0</td></tr></table>	0.35	0.35±1.0	Time Finger : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>0.40</td><td>0.40±1.0</td></tr></table>	0.40	0.40±1.0	Unload Time : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>0.40</td><td>0.40±1.0</td></tr></table>	0.40	0.40±1.0		
0.35	0.35±1.0										
0.40	0.40±1.0										
0.40	0.40±1.0										
	Time Swivel Open : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>0.05</td><td>0.05±1.0</td></tr></table>	0.05	0.05±1.0	in the loading : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>0.45</td><td>0.45±1.0</td></tr></table>	0.45	0.45±1.0	Delay claw lock up : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>0.00</td><td>0.00±1.0</td></tr></table>	0.00	0.00±1.0		
0.05	0.05±1.0										
0.45	0.45±1.0										
0.00	0.00±1.0										
		in the welding : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>0.45</td><td>0.45±1.0</td></tr></table>	0.45	0.45±1.0							
0.45	0.45±1.0										
ANNEARING LEHR TEMPERATURE											
Zone 1A : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>500</td><td>500±50</td></tr></table>	500	500±50	Zone 3 : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>480</td><td>480±50</td></tr></table>	480	480±50	Zone 6 : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>360</td><td>360±50</td></tr></table>	360	360±50	Zone 9 : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>160</td><td>160±50</td></tr></table>	160	160±50
500	500±50										
480	480±50										
360	360±50										
160	160±50										
Zone 1B : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>500</td><td>500±50</td></tr></table>	500	500±50	Zone 4 : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>450</td><td>450±50</td></tr></table>	450	450±50	Zone 7 : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>290</td><td>290±50</td></tr></table>	290	290±50	Belt speed : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>30</td><td>30±50</td></tr></table> em/min	30	30±50
500	500±50										
450	450±50										
290	290±50										
30	30±50										
Zone 2 : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>500</td><td>500±50</td></tr></table>	500	500±50	Zone 5 : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>430</td><td>430±50</td></tr></table>	430	430±50	Zone 8 : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>230</td><td>230±50</td></tr></table>	230	230±50			
500	500±50										
430	430±50										
230	230±50										
MELTING BURNER											
Gas Supply Pressure : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>100</td><td>100±250</td></tr></table> mbar	100	100±250	Air Supply Pressure : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>200</td><td>200±250</td></tr></table> mbar	200	200±250						
100	100±250										
200	200±250										
Burner No.1 : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>40</td><td>40±250</td></tr></table> mbar	40	40±250	Burner No.2 : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>40</td><td>40±250</td></tr></table> mbar	40	40±250	Burner No.3 : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>40</td><td>40±250</td></tr></table> mbar	40	40±250	Air : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>60</td><td>60±250</td></tr></table> mbar	60	60±250
40	40±250										
40	40±250										
40	40±250										
60	60±250										
			Air : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>60</td><td>60±250</td></tr></table> mbar	60	60±250						
60	60±250										
			Air : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>60</td><td>60±250</td></tr></table> mbar	60	60±250						
60	60±250										
			Air : <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>60</td><td>60±250</td></tr></table> mbar	60	60±250						
60	60±250										
Operator : _____		Leader : _____									

AUTOMATIC GLASS PRESS MACHINE LINE 2

Cycles <input type="text" value="30.00"/> <input type="text" value="30.00-10.0"/> Pcs / Min.				Glass thickness measuring Setpoint <input type="text" value="5"/> <input type="text" value="5.0-5.0"/> Threshold maximal <input type="text" value="0.10"/> <input type="text" value="0.10-1.0"/> Threshold minimal <input type="text" value="-0.10"/> <input type="text" value="-0.10-1.0"/> Maximal Reset <input type="text" value="1.0"/> <input type="text" value="1.0-1.0"/> Minimal Reset <input type="text" value="-1.0"/> <input type="text" value="-1.0-1.0"/> Scaling +/- <input type="text" value="1.20"/> <input type="text" value="1.20-2.0"/> Glass thickness OK <input type="text" value="5"/> mm Act value thickness measuring <input type="text" value="5"/> mm			
Shaft <input type="text" value="40"/> <input type="text" value="40-100"/> Stroke <input type="text" value="100"/> <input type="text" value="100-100"/> Shear cut <input type="text" value="100"/> <input type="text" value="100-100"/> Angle (°) <input type="text" value="0.0"/> <input type="text" value="0.0-360"/> <input type="text" value="100"/> <input type="text" value="100-360"/> <input type="text" value="300"/> <input type="text" value="300-360"/> <input type="text" value="0.0"/> <input type="text" value="0.0-360"/> Position (mm) <input type="text" value="100"/> <input type="text" value="100-360"/> <input type="text" value="140"/> <input type="text" value="140-360"/> <input type="text" value="120"/> <input type="text" value="120-360"/> <input type="text" value="0.0"/> <input type="text" value="0.0-360"/> Accl (10°/mm / °) <input type="text" value="4.0"/> <input type="text" value="4.0-360"/> <input type="text" value="6.0"/> <input type="text" value="6.0-360"/> <input type="text" value="8"/> <input type="text" value="8.0-360"/> <input type="text" value="0.0"/> <input type="text" value="0.0-360"/> No.1 <input type="text" value="5"/> <input type="text" value="5-10"/> No.2 <input type="text" value="5"/> <input type="text" value="5-10"/> No.3 <input type="text" value="5"/> <input type="text" value="5-10"/> No.4 <input type="text" value="5"/> <input type="text" value="5-10"/> No.5 <input type="text" value="5"/> <input type="text" value="5-10"/> No.6 <input type="text" value="5"/> <input type="text" value="5-10"/> Air former <input type="text" value="5"/> <input type="text" value="5-10"/> <input type="text" value="5"/> <input type="text" value="5-10"/> <input type="text" value="5"/> <input type="text" value="5-10"/> <input type="text" value="5"/> <input type="text" value="5-10"/> <input type="text" value="5"/> <input type="text" value="5-10"/> <input type="text" value="5"/> <input type="text" value="5-10"/>				Base frame adjustment X - Forw./Reaward <input type="text" value="10.0"/> <input type="text" value="10-100"/> <input type="text" value="10.0"/> <input type="text" value="10-100"/> <input type="text" value="50"/> <input type="text" value="50-50"/> <input type="text" value="50"/> <input type="text" value="50-50"/> Y - Left / Right <input type="text" value="10.0"/> <input type="text" value="10-100"/> <input type="text" value="10.0"/> <input type="text" value="10-100"/> <input type="text" value="50"/> <input type="text" value="50-50"/> <input type="text" value="50"/> <input type="text" value="50-50"/> Z - Up / Down <input type="text" value="10.0"/> <input type="text" value="10-100"/> <input type="text" value="10.0"/> <input type="text" value="10-100"/> <input type="text" value="50"/> <input type="text" value="50-50"/> <input type="text" value="50"/> <input type="text" value="50-50"/>			
Delay time start <input type="text" value="0.10"/> <input type="text" value="0.10-1.0"/> Rapid down <input type="text" value="250"/> <input type="text" value="250-100"/> Slow down / Press-time 1 <input type="text" value="0.50"/> <input type="text" value="0.50-1.0"/> Press-time 2 <input type="text" value="0.10"/> <input type="text" value="0.10-1.0"/> Actual press position <input type="text" value="300"/> <input type="text" value="300-100"/> Slow up <input type="text" value="5"/> <input type="text" value="5-50"/> Enable table <input type="text" value="225"/> <input type="text" value="225-100"/> Rapid up <input type="text" value="200"/> <input type="text" value="200-100"/> Acceleration <input type="text" value="80"/> <input type="text" value="80-100"/> % Plunger outside cooling right side <input type="text" value="1"/> <input type="text" value="1.0-1.0"/> <input type="text" value="0.10"/> <input type="text" value="0.10-1.0"/> <input type="text" value="0.50"/> <input type="text" value="1.0-1.0"/> Plunger outside cooling left side <input type="text" value="1"/> <input type="text" value="1.0-1.0"/> <input type="text" value="0.10"/> <input type="text" value="0.10-1.0"/> <input type="text" value="0.50"/> <input type="text" value="1.0-1.0"/>				Mould temperature Mould Actual Mould 1 <input type="text" value="450"/> <input type="text" value="450-200"/> Mould 2 <input type="text" value="450"/> <input type="text" value="450-200"/> Mould 3 <input type="text" value="450"/> <input type="text" value="450-200"/> Mould 4 <input type="text" value="450"/> <input type="text" value="450-200"/> Mould 5 <input type="text" value="450"/> <input type="text" value="450-200"/> Mould 6 <input type="text" value="450"/> <input type="text" value="450-200"/> Mould 7 <input type="text" value="450"/> <input type="text" value="450-200"/> Mould 8 <input type="text" value="450"/> <input type="text" value="450-200"/> Mould 9 <input type="text" value="450"/> <input type="text" value="450-200"/> Mould 10 <input type="text" value="450"/> <input type="text" value="450-200"/> Mould 11 <input type="text" value="450"/> <input type="text" value="450-200"/> Mould 12 <input type="text" value="450"/> <input type="text" value="450-200"/>			
Delay time start <input type="text" value="0.0"/> <input type="text" value="0.0-1.0"/> Rapid down <input type="text" value="380"/> <input type="text" value="380-500"/> Slow down <input type="text" value="0.10"/> <input type="text" value="0.10-1.0"/> Slow up <input type="text" value="395"/> <input type="text" value="395-500"/> Enable table (Safety position) <input type="text" value="390"/> <input type="text" value="390-500"/> Rapid up <input type="text" value="370"/> <input type="text" value="370-500"/> Acceleration <input type="text" value="300"/> <input type="text" value="300-1000"/> % Plunger outside cooling right side <input type="text" value="1"/> <input type="text" value="1.0-1.0"/> <input type="text" value="0.10"/> <input type="text" value="0.10-1.0"/> <input type="text" value="0.50"/> <input type="text" value="1.0-1.0"/> Plunger outside cooling left side <input type="text" value="1"/> <input type="text" value="1.0-1.0"/> <input type="text" value="0.10"/> <input type="text" value="0.10-1.0"/> <input type="text" value="0.50"/> <input type="text" value="1.0-1.0"/>				Cooling pipe Pipe 1 <input type="text" value="1.0"/> <input type="text" value="1.0-1.0"/> <input type="text" value="0.01"/> <input type="text" value="0.01-1.0"/> Pipe 2 <input type="text" value="1.0"/> <input type="text" value="1.0-1.0"/> <input type="text" value="0.01"/> <input type="text" value="0.01-1.0"/> Pipe 3 <input type="text" value="1.0"/> <input type="text" value="1.0-1.0"/> <input type="text" value="0.01"/> <input type="text" value="0.01-1.0"/> Pipe 4 <input type="text" value="0"/> <input type="text" value="0.0-1.0"/> <input type="text" value="0"/> <input type="text" value="0.0-1.0"/> Pipe 5 <input type="text" value="0"/> <input type="text" value="0.0-1.0"/> <input type="text" value="0"/> <input type="text" value="0.0-1.0"/> Blowing out nozzle Delay time (s) <input type="text" value="0.10"/> <input type="text" value="0.10-1.0"/> <input type="text" value="0.85"/> <input type="text" value="0.85-1.0"/>			
Shear drive Shear cut <input type="text" value="100"/> <input type="text" value="100-360"/> Pre-select <input type="text" value="1"/> <input type="text" value="1.0-2.0"/> Spraying Water left <input type="text" value="0.50"/> <input type="text" value="0.50-1.0"/> <input type="text" value="0.50"/> <input type="text" value="0.50-1.0"/> Air left <input type="text" value="0.50"/> <input type="text" value="0.50-1.0"/> <input type="text" value="0.50"/> <input type="text" value="0.50-1.0"/> Water right <input type="text" value="0.50"/> <input type="text" value="0.50-1.0"/> <input type="text" value="0.50"/> <input type="text" value="0.50-1.0"/> Air right <input type="text" value="0.50"/> <input type="text" value="0.50-1.0"/> <input type="text" value="0.50"/> <input type="text" value="0.50-1.0"/> Blowing off <input type="text" value="0.30"/> <input type="text" value="0.30-1.0"/> <input type="text" value="0.15"/> <input type="text" value="0.15-1.0"/> Blowing off 2 <input type="text" value="0.30"/> <input type="text" value="0.30-1.0"/> <input type="text" value="0.15"/> <input type="text" value="0.15-1.0"/>				Conveyor Conveyor 1 <input type="text" value="300"/> <input type="text" value="300-500"/> <input type="text" value="100"/> <input type="text" value="100-100"/> % Acceleration <input type="text" value="100"/> <input type="text" value="100-100"/> % Deceleration <input type="text" value="100"/> <input type="text" value="100-100"/> % Designation Cooling 1 <input type="text" value="10"/> <input type="text" value="10-360"/> <input type="text" value="200"/> <input type="text" value="200-360"/> Cooling 2 <input type="text" value="50"/> <input type="text" value="50-360"/> <input type="text" value="100"/> <input type="text" value="100-360"/> Glass block turning 1 <input type="text" value="0.0"/> <input type="text" value="0.0-360"/> <input type="text" value="0.0"/> <input type="text" value="0.0-360"/> Glass block turning 2 <input type="text" value="0.0"/> <input type="text" value="0.0-360"/> <input type="text" value="0.0"/> <input type="text" value="0.0-360"/> Conveyor 2 <input type="text" value="350"/> <input type="text" value="350-500"/> <input type="text" value="100"/> <input type="text" value="100-100"/> % Speed Conveyor <input type="text" value="350"/> <input type="text" value="350-500"/> <input type="text" value="100"/> <input type="text" value="100-100"/> % Acceleration <input type="text" value="100"/> <input type="text" value="100-100"/> % Deceleration <input type="text" value="100"/> <input type="text" value="100-100"/> %			
Event I/O ON (°) OFF (°) Shear cut <input type="text" value="100"/> <input type="text" value="100-36"/> Chute forward / back <input type="text" value="115"/> <input type="text" value="115-30"/> Option <input type="text" value="165"/> <input type="text" value="165-36"/> Release from press <input type="text" value="195"/> <input type="text" value="195-36"/> Head cooling <input type="text" value="60"/> <input type="text" value="60-360"/> <input type="text" value="150"/> <input type="text" value="150-36"/> ZF 2 <input type="text" value="0.0"/> <input type="text" value="0.0-360"/> <input type="text" value="0.0"/> <input type="text" value="0.0-360"/> ZF 3 <input type="text" value="250"/> <input type="text" value="250-36"/> <input type="text" value="19"/> <input type="text" value="19-360"/> ZF 4 <input type="text" value="330"/> <input type="text" value="330-36"/> <input type="text" value="200"/> <input type="text" value="200-36"/> ZF 5 <input type="text" value="45"/> <input type="text" value="45-360"/> <input type="text" value="170"/> <input type="text" value="170-36"/>				Take out Delay time start <input type="text" value="0.10"/> <input type="text" value="0.10-1.0"/> Stroke down <input type="text" value="350"/> <input type="text" value="350-500"/> Gripper close <input type="text" value="0.05"/> <input type="text" value="0.05-1.0"/> Pick up position <input type="text" value="600"/> <input type="text" value="600-500"/> <input type="text" value="1500"/> <input type="text" value="1500-1000"/> Stroke up <input type="text" value="0.10"/> <input type="text" value="0.10-1.0"/> Gripper open <input type="text" value="50"/> <input type="text" value="50-500"/> Lay down position <input type="text" value="35"/> <input type="text" value="35-500"/> <input type="text" value="1500"/> <input type="text" value="1500-1000"/> Acceleration <input type="text" value="100"/> <input type="text" value="100-100"/> % Deceleration <input type="text" value="100"/> <input type="text" value="100-100"/> %			
Operator _____				Leader _____			

<p>Deflector</p> <p>When turning starts down, which half is coming to the sensor ? Lower Brick Half</p> <p>Brick between sensor <--> Deflector 2</p> <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:30%;">Designation</td> <td style="width:30%;">Start (°)</td> <td style="width:40%;">End (°)</td> </tr> <tr> <td>Brick on sensor</td> <td><input style="width:40px; height:20px;" type="text"/></td> <td><input style="width:40px; height:20px;" type="text"/></td> </tr> <tr> <td>Control time</td> <td><input style="width:40px; height:20px;" type="text"/></td> <td><input style="width:40px; height:20px;" type="text"/></td> </tr> <tr> <td>Deflector forward</td> <td><input style="width:40px; height:20px;" type="text"/></td> <td><input style="width:40px; height:20px;" type="text"/></td> </tr> </table>	Designation	Start (°)	End (°)	Brick on sensor	<input style="width:40px; height:20px;" type="text"/>	<input style="width:40px; height:20px;" type="text"/>	Control time	<input style="width:40px; height:20px;" type="text"/>	<input style="width:40px; height:20px;" type="text"/>	Deflector forward	<input style="width:40px; height:20px;" type="text"/>	<input style="width:40px; height:20px;" type="text"/>	<p>Loading system turning / loading arm</p> <table style="width:100%; border-collapse: collapse;"> <thead> <tr> <th></th> <th style="text-align: center;">Position (°)</th> <th style="text-align: center;">Time (s)</th> <th style="text-align: center;">Velocity (°/s)</th> </tr> </thead> <tbody> <tr> <td>Turning pick up position </td> <td style="border: 1px solid black; padding: 2px;">0.0</td> <td style="border: 1px solid black; padding: 2px;">0.0±100</td> <td style="border: 1px solid black; padding: 2px;">600</td> <td style="border: 1px solid black; padding: 2px;">600±500</td> </tr> <tr> <td>Delay time gripper closed</td> <td></td> <td style="border: 1px solid black; padding: 2px;">0.22</td> <td style="border: 1px solid black; padding: 2px;">0.22±1.0</td> <td></td> </tr> <tr> <td>Time gripper close </td> <td></td> <td style="border: 1px solid black; padding: 2px;">0.30</td> <td style="border: 1px solid black; padding: 2px;">0.30±1.0</td> <td></td> </tr> <tr> <td>Turning lay down position </td> <td style="border: 1px solid black; padding: 2px;">180</td> <td style="border: 1px solid black; padding: 2px;">180±100</td> <td style="border: 1px solid black; padding: 2px;">580</td> <td style="border: 1px solid black; padding: 2px;">580±500</td> </tr> <tr> <td>Time gripper open </td> <td></td> <td style="border: 1px solid black; padding: 2px;">0.15</td> <td style="border: 1px solid black; padding: 2px;">0.15±1.0</td> <td></td> </tr> <tr> <td>Turning waiting position </td> <td style="border: 1px solid black; padding: 2px;">90</td> <td style="border: 1px solid black; padding: 2px;">90±100</td> <td style="border: 1px solid black; padding: 2px;">600</td> <td style="border: 1px solid black; padding: 2px;">600±500</td> </tr> <tr> <td>Start loading arm</td> <td style="border: 1px solid black; padding: 2px;">150</td> <td style="border: 1px solid black; padding: 2px;">150±100</td> <td></td> <td></td> </tr> </tbody> </table> <table style="width:100%; 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AUTOMATIC GLASS PRESS MACHINE

LINE 3

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AUTOMATIC GLASS WELDING MACHINE

LINE 3

<p>Deflector</p> <p>When turning starts down, witch half is coming to the sensor ? Lower Brick Half</p> <p>Brick between sensor < - - > Deflector 2</p> <p>Designation Start (°) End (°)</p> <p>Brick on sensor </p> <p>Control time </p> <p>Deflector forward </p>	<p align="center">Loading system turning / loading arm</p> <table border="1" style="width:100%; border-collapse: collapse;"> <thead> <tr> <th></th> <th>Position (°)</th> <th>Time (s)</th> <th>Velocity (°/s)</th> </tr> </thead> <tbody> <tr> <td>Turning pick up position</td> <td>0.0 0.0±100</td> <td></td> <td>750 750±100</td> </tr> <tr> <td>Delay time gripper closed</td> <td></td> <td>0.95 0.95±1.0</td> <td></td> </tr> <tr> <td>Time gripper close</td> <td></td> <td>0.25 0.25±1.0</td> <td></td> </tr> <tr> <td>Turning lay down position</td> <td>180 180±100</td> <td></td> <td>700 700±100</td> </tr> <tr> <td>Time gripper open</td> <td></td> <td>0.20 0.20±1.0</td> <td></td> </tr> <tr> <td>Turning waiting position</td> <td>90 90±100</td> <td></td> <td>300 300±100</td> </tr> <tr> <td>Start loading arm</td> <td>150 150±100</td> <td></td> <td></td> </tr> <tr> <td>Acceleration</td> <td>100 100±10 %</td> <td>Deceleration</td> <td>100 100±10 %</td> </tr> <tr> <td>Loading arm lay down position</td> <td>90 90±100</td> <td></td> <td>200 200±100</td> </tr> <tr> <td>Stroke up</td> <td>70 70±50</td> <td></td> <td></td> </tr> <tr> <td>Delay stroke down</td> <td></td> <td>0.80 0.80±1.0</td> <td></td> </tr> <tr> <td>Loading arm pick up position</td> <td>0.0 0.0±50</td> <td></td> <td>300 300±100</td> </tr> <tr> <td>Enable position index table BSV</td> <td>50 50±50</td> <td></td> <td></td> </tr> <tr> <td>Acceleration</td> <td>100 100±10 %</td> <td>Deceleration</td> <td>100 100±10 %</td> </tr> </tbody> </table>		Position (°)	Time (s)	Velocity (°/s)	Turning pick up position	0.0 0.0±100		750 750±100	Delay time gripper closed		0.95 0.95±1.0		Time gripper close		0.25 0.25±1.0		Turning lay down position	180 180±100		700 700±100	Time gripper open		0.20 0.20±1.0		Turning waiting position	90 90±100		300 300±100	Start loading arm	150 150±100			Acceleration	100 100±10 %	Deceleration	100 100±10 %	Loading arm lay down position	90 90±100		200 200±100	Stroke up	70 70±50			Delay stroke down		0.80 0.80±1.0		Loading arm pick up position	0.0 0.0±50		300 300±100	Enable position index table BSV	50 50±50			Acceleration	100 100±10 %	Deceleration	100 100±10 %												
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