

ข้อมูลการผลิตบล็อกแก้ว

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JOB CHANGE DATA FOR PRESS MACHINE

Model.....

Line 1 2

Date...../...../.....

Machine Speed (pcs./nim)
 Gob Weight (g.)
 Gob Temperature (C°)

Cooling Air Former ST.3 (Level)
 Cooling Air Former ST.4 (Level)
 Cooling Air Former ST.5 (Level)
 Cooling Air Former ST.6 (Level)
 Cooling Air Former ST.7 (Level)

Plunger Feeder (Size)
 Orifice Ring (Size)
 Shear Blade (Size)
 Plunger (No.)
 Mould Ring (No.)
 Mould Bottom (No.)

Mould Cooling
 Cooling Bottom Mould 1 (Level)
 Cooling Bottom Mould 2 (Level)

Plunger Height (mm.)
 Rotary Tube Height (mm.)
 Speed Rotary Tube (Hz.)

Mould Cooling ST.10
 Upper (% ,bar)
 Lower (% ,bar)

Temperature Plunger (C°)
 Water Cooling Plunger Chiller Normal
 Temp.Mould Ring St.10 (C°)
 Temp.Mould Bottom St.10 (C°)

Speed Conveyor 1
 Speed Conveyor 2

Rotate Second Half
 DelayTime Time

Pressing Cylinder

Plunger Cooling	Position "mm"	Delay Time	Time	Pressure	Speed %
PressCYL. ↓	<input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>
PressCYL. ↓	<input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>
Dwell Time			<input type="text"/>	<input type="text"/>	<input type="text"/>
PressCYL. ↑	<input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>
PressCYL. ↑	<input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>

Plunger Ring

Ring	Position "mm"	Delay Time	Time	Pressure	Speed %
Ring ↓	<input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>
Ring ↑	<input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>	<input type="text"/>

Cooling Pipe

Cooling Pipe	Dwell Time	Time To Up Position
Camshaft 1 - 8	<input type="text"/>	<input type="text"/>

	Start	End	Take out	Time
Start Press	<input type="text"/>	<input type="text"/>	Delay Start - IN	<input type="text"/>
Start Welding	<input type="text"/>	<input type="text"/>		
Plunger Up	<input type="text"/>	<input type="text"/>	Take - Out Forward	<input type="text"/>
Plunger Down	<input type="text"/>	<input type="text"/>	Gripper Closed	<input type="text"/>
Shear (Reserve)	<input type="text"/>	<input type="text"/>	Take - Out Reward	<input type="text"/>
Shear Close	<input type="text"/>	<input type="text"/>	Gripper Open	<input type="text"/>
Shear Spray	<input type="text"/>	<input type="text"/>		
Shear Lubricat.	<input type="text"/>	<input type="text"/>	Take Out Height (cm.)	<input type="text"/>

Check By.....

Leader / Engineer.....