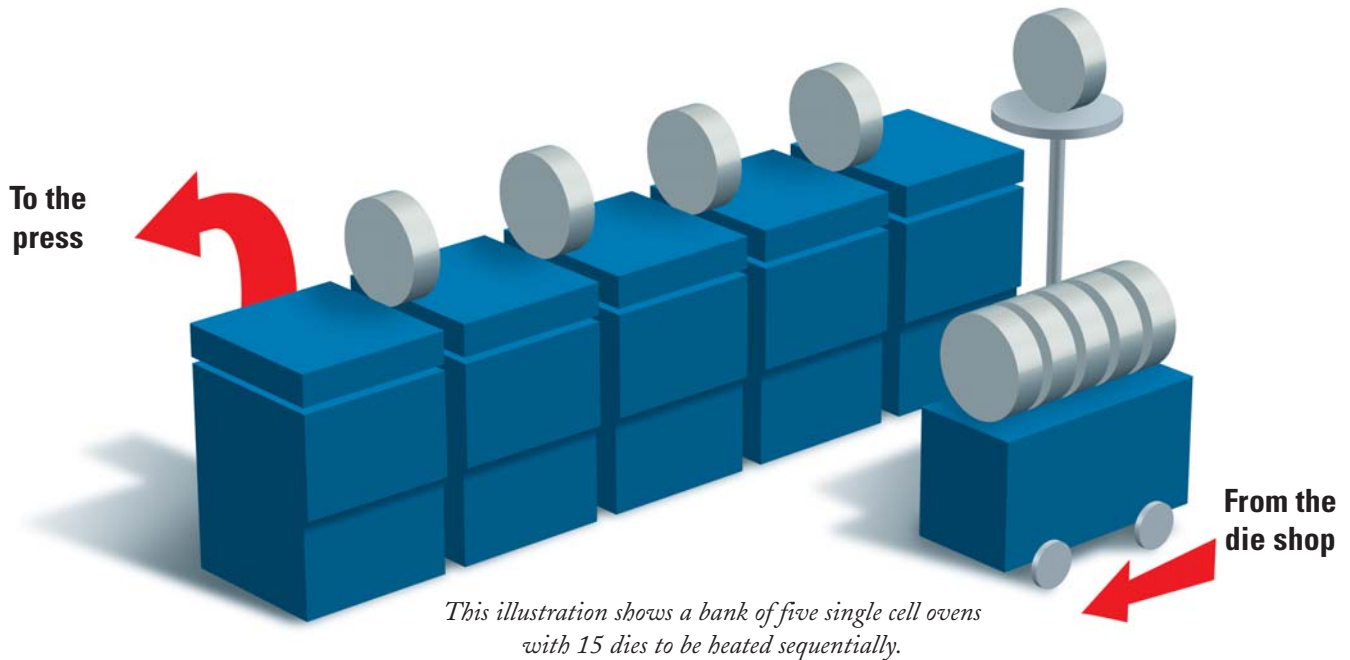


VISUAL MANAGEMENT

Made Easy with Castool Single Cell Ovens



An increasingly costly result of the trend to short runs is the amount of non-productive time while changing dies, between the end of one run and the start of the next.

The advantages of using Castool Single Cell Die Ovens to bring extrusion dies quickly and uniformly to operating temperatures are well known. They are detailed in "Die Oven Solutions". An important feature that is sometimes underestimated, however, is the value of knowing fairly accurately the length of time required to heat the die, and keeping the press operator visually informed at all times of the status of the next die he will use.

The technique of visual management, which requires that everyone can clearly see what is to be done next, pays big dividends in press downtime reduction.

When programmed for a particular die, the Castool Die Oven Controller immediately calculates the estimated necessary heating time. When the heating cycle begins, a yellow indicator light on the die oven comes on. The controller shows "Time to Temperature", and begins to count down.

When the die is uniformly at the correct operating tempera-

ture, a green indicator light comes on, and the controller begins to show "Time at Temperature". The operator knows at a glance that this is the next die to go on his press, and that it is ready.

In a major extrusion plant when a bank of single cell die ovens are installed side by side, each oven is loaded in sequence to match the production schedule. The ovens are then switched on in turn, with the controllers set to bring each die to the desired operating temperature at the scheduled time. The next sequence of prepared dies is brought to the ovens to fill the vacant cells as the dies go to the press.

Some extruders ensure control of the sequence by placing the waiting dies, along with their production orders, on top of each oven. This begins, of course, with the second oven.

Using Castool Single Cell Die Ovens and visual management, if the extruder has a sincere commitment to ongoing improvement, and accurately records the length of time taken for each die change, a considerable reduction in press downtime can be guaranteed.

