

# ECN

*Extrusion Control Network  
Production Manager System*

## *Die Oven Managing*

# 2015

# Die Oven Managing




## Problems Extruding with a Cold Die:

- Die breaks
- Hard Extrusion Starting
- Tricky Profile Forming

# Die Oven Managing

S.A.I. AUTOMATION - BRESCIA (ITALY) - ECN EXTRUSION CONTROL - DIE OVEN

Die Oven 1

Z1	Z2	Z3	Z4	Z5	Z6	Z7	Z8	Z9
								
ABX319/1	MT25/1	KNR103/1	0	0	0	0	0	0
SOAK TIME 04:12:44	SOAK TIME 02:33:27	SOAK TIME 00:59:55	SOAK TIME 0	SOAK TIME 0	SOAK TIME 0	SOAK TIME 0	SOAK TIME 0	SOAK TIME 0
DIE INFO	DIE INFO	DIE INFO	DIE INFO	DIE INFO	DIE INFO	DIE INFO	DIE INFO	DIE INFO

INSERT      HOME      TAKE OUT

Insert

Select Die (PgUp - PgDown to scroll the list)

ABX319/1

Select Oven

1 2 3 4 5 6 7 8 9

Take Out

Select Oven

1 2 3 4 5 6 7 8 9

**Display of Die Status  
and Heating Time.**

**When a die is ready, it  
becomes available to  
be extruded.**

# Die Oven Managing

Order	Die Code	Qty Bars (nr)	Bars Length (mm)	Holes	Butt End (mm)	Profile Weight (gr/m)	Saw Scrap (mm)	Stretcher Scrap (mm)	Bill To Extr (nr)	Prof Len (m)	Bill Len (mm)	Extr Date	Next	Se	Oven Nr	Ready
1236544	E 4145/3	30	6000	1	25	1270	0	1800	4	55.4	836	27/04/2014	1	0	4	NO
123654777	E 8250/03	200	4000	1	25	1801	0	1800	19	45.8	1023	27/04/2014	0	0	2	YES
12365444	E 3532/1	100	6000	2	25	886	0	1800	7	37.65	792	27/04/2014	0	0	6	YES
123656444	E 4200/1	80	6000	2	25	851	0	1800	6	49.8	1006	27/04/2014	0	0	7	YES
5345345	E 8981/01	330	6000	4	25	284	0	1800	7	55.58	751	27/04/2014	0	0		
10860866	E 7370/01	334	6000	1	25	1674	0	1800	40	55.58	1094	27/04/2014	0	0	3	YES
▶ 10864089	E 2930/07	163	9000	2	25	692	0	1100	13	55.1	909	27/04/2014	0	▼ 0	5	NO
12222	E 5244	110	6000	1	25	1519	0	1800	13	55.8	1009	27/04/2014	0	0	1	YES

**Detalhes Ordem 10864089**

Cuts per Bill <b>1</b>	Prof Len (m) <b>55.1</b>	Bars (nr) <b>163</b>	Liga <b>6060</b>
Bill per Cuts <b>1</b>	Bill Len (mm) <b>909</b>	Bars Len (mm) <b>9000</b>	Tempera <b>T5</b>
Cuts nr <b>5</b>	1° Bill Len (mm) <b>909</b>	Saw Scrap (mm) <b>0</b>	Acabamento <b>Natural</b>
	Bill To Extr (nr) <b>13</b>	Stret Scrap (mm) <b>1100</b>	
	Saw Pos (m) <b>55.1</b>		

Comment **0**

COPY ORDER	NEW ORDER	EDIT ORDER	RECIPE DETAIL
OPERATOR CONSOLE	PROCESS TRENDS	ALERTS	DIE OVEN
			UTILITIES

**Immediate  
visualization of Die  
Status from Order  
page**

# Die Oven Managing

S.A.I. AUTOMATION - BRESCIA (ITALY) ECN - EXTRUSION CONTROL \*\* ORDERS MANAGER \*\*

Order	Die Code	Qty Bars (nr)	Bars Length (mm)	Holes	Butt End (mm)	Profile Weight (gr/m)	Saw Scrap (mm)	Stretcher Scrap (mm)	Bill To Extr (nr)	Prof Len (m)	Bill Len (mm)	Extr Date	Next	Se	Oven Nr	Ready
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12222	E 5244	110	6000	1	25	1519	0	1800	13	55.8	1009	27/04/2014	0	0	1	YES

**C236\_EC\_N\_CBA** [X]

THE DIE INTO THE OVEN IS NOT READY. ARE YOU SURE?

OK

**Detalhes Ordem 10864089**

Cuts per Bill <input type="text" value="1"/>	Prof Len (m) <input type="text" value="55.1"/>	Bars (nr) <input type="text" value="163"/>	Liga <input type="text" value="6060"/>
Bill per Cuts <input type="text" value="1"/>	Bill Len (mm) <input type="text" value="909"/>	Bars Len (mm) <input type="text" value="9000"/>	Tempera <input type="text" value="T5"/>
Cuts nr <input type="text" value="5"/>	1° Bill Len (mm) <input type="text" value="909"/>	Saw Scrap (mm) <input type="text" value="0"/>	Acabamento <input type="text" value="Natural"/>
	Bill To Extr (nr) <input type="text" value="13"/>	Stret Scrap (mm) <input type="text" value="1100"/>	
	Saw Pos (m) <input type="text" value="55.1"/>		

Comment

COPY ORDER

NEW ORDER

EDIT ORDER

RECIPE DETAIL

OPERATOR CONSOLE

PROCESS TRENDS

ALERTS

DIE OVEN

UTILITIES

**Alert Message to avoid cold die in Extrusion**