Mail or fax to:
M. Pandit
Prof. Dr.- Ing. habil

Lehrstuhl für Regelungstechnik u. Signaltheorie
Universität Kaiserslautern
Postfach 3049
67653 Kaiserslautern

Tel. (0631) 205 2088
Fax (0631) 205 4205
email: pandit@eit.uni-kl.de
www.eit.uni-kl.de/AG-Pandit/moma

MoMAS

MoMAS - Mobile Measurement and Automation System for Extruders

- Checklist -

I Extruder, Furnace, Puller

Project: *.....*

Firm: *.....*

Place: *.....* ***Date:*** .....

Product types .....

No. of shifts / per week ..... ***Annual tonnage*** .....

No. of extrusions per die change ..... (typical)

Extruder: *Manufacturer and year of installation.....*

Type:	direct / indirect	Extrusion force:	..... tonnes
Alloy:		Hydraulic control/actuation:	.....
Block length:	..... mm	Control electronics:	Relay / PLC Type: .....
Block-Ø:	..... mm	Velocity control:	Yes / no
Extrusion time / billet	..... s (typical)	Idle time between extrusion cycles	..... s (typical)

Variable which is controlled and which the operator gives as input	*Ram speed*	*Oil flow*	*Valve position* .....

Billet furnace:

Type: Gas / Oil/ Induction

Taper heating: yes / no *No. of zones* .....

Puller: *Details of puller and control of puller motion:* .....

.....

II Process variables and sensors

Sensors available and sensor signals which can be tapped at PLC:

Variable	*Sensor installed yes / no; Sensortype*	*Signal at PLC*
Extrusion speed (Ram velocity)		
Profile velocity		
Profile exit temperature		
Hydraulic pressure		
Billet temperature		
Container temperature		

III Programmable Logic Control (PLC)

Make, Type and Date of installation of PLC .....

.....

Form of Data from and to PLC .....

.....

Contact person for PLC:

Name..... Designation/Position .....

Tel. No. ..... Telefax.....

Email.....

IV Data Bank *.....*

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Contact person for project:

Name..... Designation/Position .....

Tel. No. ..... Telefax.....

Email.....

Date..... *Signature.....*