Operation instructions in brief for extruding with

MoMAS®

COLD START

1. Proceed as usual by setting the ram speed / profile speed at a value you think is appropriate at the PL C console.

2. Switch on the **MoMAS**® Computer

3. Activate *PLC.exe*

4. Activate *MoMASPLC.exe*

MoMAS® *synchronises itself with the process after the completion of the current cycle (0th cycle)*

5. From now on **MoMAS**® optimises the process in the background. It gets the speed which has been set by you at the PLC console. On the basis of this, it sets limit values for the ram speed. The set point for the profile temperature is set at 555°C as default. This can be altered, also at the PLC console. *It collects measurement data from the following (1st) cycle via the PLC.*

6. Before the start of the second cycle, using all this data, **MoMAS**® calculates the optimal runs for the ram speed for the cycle and the billet temperature for the fourth cycle and relays these automatically to the PLC.

7. If you want, you can check and change the limit values at any time:

   the Profile Temperature

   the ram speed

   the billet temperature limits.

8. The following cycles run as the second.

WARM START

MoMAS®synchronises itself as in the first cycle, if it is interrupted,

General tips

- *Operation is simple - You can continue your routine at the PLC console as before!*

- *For visualising process data press F6*

- *All collected data is available in text format*