IS MACHINES · FORMING · JOB CHANGES

IS PRODUCTION & MAINTENANCE.

> "The IS production is the cornerstone where everything materialises... All spotlights are on us!"

Empakglass's IS Machines & Production department provides its partners with technical support that ranges from the initial installation project to the everyday operation and troubleshooting.

Our goal is to give our partners the tools to become the problem solver, and to build the IS production efficiency themselves.

That is why we prepare and help our partners to analyse, plan and perform, on a consistent and standardised basis, all the tasks that lead, at the end of the day, to pallets filled with containers that meet the filler's quality requirements. Collaboration and communication with the other departments is fundamental for an optimal flow of information.

FORMING & JOB CHANGES.

FORMING AND GLASS CONDITIONING

1. Understand how the different forehearth designs work and influence the operation and the thermal homogeneity of the gob.
2. Set up the proper operation according to the riser, working end and gob temperatures for the required pull.
3. Prepare the forehearths for a job change with different weights and operating temperatures: forehearth set-ups.
4. Forehearth refractory and burner preventive maintenance.
5. When to change orifice rings, revolving tubes, plungers and stirrers: accessories and standard wear rate.
6. Troubleshooting glass defects generated in forehearths (blisters and stones), using the Troubleshooting Manual for a faster assessment of the cause.

JOB CHANGES

1. Understand the influence of a job change and start-up on the overall performance of a glass plant.
2. Influence of production planning on the total monthly job change time: the Job Change Index (JCI) and KCR.
3. Main objective: reduce the non-production time (t1) caused by job changes and improve the ramp-up time (t2), by doing it right the first time.
4. Identify the areas and factors that influence job change time and coordinate them into improvement modules with a defined team.
5. Organise the job on / job off meetings and collect and use the necessary data.
6. Gob ready before the end of the IS mechanical job change (forehearth, feeder and delivery systems ready).
7. The proper gob for each specific job, and the factors that take most time in making it.
8. Standard procedure for orifice ring changes; the “Team Gob” objective control datasheet; gob and process data collection.
9. Job change SMED, and all components (IS accessories, tools, moulds…) ready and in proper condition before the job change stop.

MAINTENANCE & START-UP.

IS MAINTENANCE

1. Establish the procedures for good and consistent IS maintenance.
2. Minimise IS machine interruptions due to accessory failure.
3. Preventive maintenance plan for IS parts: every accessory on the machine in good condition.
4. Standardise the IS accessories and components.
5. Controlled and scheduled preventive check-up of all IS accessories (neck ring arms, holders…).
6. Assess the containers and related accessories in use on the existing IS lines.
7. The importance of standardised, defined mould design set-ups.

IS PRODUCTION START-UP

1. Get all IS sections under glass as fast as possible after the IS mechanical job change.
2. Optimise the “cold run” set-up (without glass).
3. Change all transport components (pushers…) before the start-up under glass.
4. Transport quality: no bottles falling on the conveyors to the lehr.
5. Reduce, step by step, the minutes between the first gob in the first section and all sections at 90% PTM: the job change index in action.
6. Fast defect identification and correction during start-up; troubleshooting the most common defects of each plant.
7. Standard procedure for the start-up of IS machines.
8. Hot end coating set-up and control; lehr set-up and control.







TALK TO OUR TEAM

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