



WHEN PERFORMANCE COUNTS...

ROTOCYCLE

DESKTOP SOFTWARE PROGRAM FOR ROTOMOLDING CYCLE SIMULATION.

Machine: Indep. - 3 Arm / 5 Station

No. of Ovens: 1
No. of Wait Stations: 1
No. of Coolers: 1
No. of Load/Unload: 1
No. of Pre-Oven: 1
No. of Arms: 3
Total Stations: 5

Arm Cycle Settings

	Arm 1	Arm 2	Arm 3
Number of Parts	2	2	2
Oven (mins)	14	14	14
Wait (mins)	0	0	0
Cooler 1 (mins)	14	14	14
Demolding (mins)	10	10	10
Pre-Oven Delay (mins)	0	0	0

Oven Door Open/Close (s) 10 Cooler Door Open/Close (s) 10 Arm Move Time (s) 20

Run Time: 8 hours 12 hours 24 hours 5 days

Simulation Summary - Completed Cycles

	8 hours	12 hours	24 hours	5 days
Arm 1	10			
Arm 2	10			
Arm 3	10			
Total Number of Parts	60			

(Complete Cycle = Oven through Demolding) 7.92 hrs

Station % Utilization

Station	% Utilization
Oven	93.4
Wait	0.1
Cool1	90.5
Cool2	0.0
Demold	65.3
PreOven	0.1

RotoCycle Machine Simulation Summary

File Name: Simulation1 Machine Type: Indep. - 3 Arm / 5 Station

	Arm 1	Arm 2	Arm 3
Number of Parts	2	2	2
Oven (mins)	14	14	14
Wait (mins)	0	0	0
Cooler 1 (mins)	14	14	14
Demolding (mins)	10	10	10
Pre-Oven Delay (mins)	0	0	0

Oven Door Move(s) 10 Cooler Door Move(s) 10 Arm Move(s) 20

Completed Cycles

	Arm 1	Arm 2	Arm 3
8 hrs	10	10	10

Simulation Details

	Arm 1	Arm 2	Arm 3	Time(Mins)	(Utilization)
Oven Time - Normal Cycle	154	154	140	448	93.3
Oven Time - Cycle Held-Up					
Move from Oven to Wait	5.5	5.5	5.0	16.0	3.3
Wait Time - Normal Cycle	0.0	0.0	0.0	0.0	0.0
Wait time - Cycle Held-up	0.0	0.0	0.0	0.0	0.0
Move from Wait to Cool1	5.5	5.4	5.0	15.9	3.3
Cool time 1 - Normal Cycle	154.0	140.0	140.0	434.0	90.4
Cool time 1 - Cycle Held-up	0.0	0.0	0.0	0.0	0.0
Move from Cool1 to Demold	5.5	5.0	5.0	15.5	3.2
Demold time - Normal Cycle	100.4	100	110	310.4	64.7
Demold time - Cycle Held-up					
Move from Demold to PreOven	3.3	3.3	3.7	10.3	2.2
PreOven time - Forced Delay	0.0	0.0	0.0	0.0	0.0
PreOven time - Oven Full	46.8	61.3	61.0	169.2	35.2
Move from PreOven to Oven	5.0	5.5	5.4	15.9	3.3

Parts per Arm: Arm 1: 2, Arm 2: 2, Arm 3: 2

Starting Location: Oven, Pre-Oven, Demold

Ending Location: Demold, Wait, Pre-Oven

Total Completed Cycles: 10, 10, 10

Total Number of Parts: 20, 20, 20

8 hours

60

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Ferry is the Exclusive Sales Channel for RotoCycle.

RotoCycle is a Windows® based software package production simulation calculator that aids the user to determine the production output of a machine based on the 9 machine styles (Independent-arm, Fixed-arm Turret, In-Line Shuttle) the configuration (number of arms, stations, indexing time, etc.) and the mix of molding cycle times for each arm. The effect of unbalanced cycles and the bottlenecks created can easily be seen with the onscreen and printable reports.

RotoCycle is intended as an analysis and teaching tool. It can be used for:

- Estimating machine production output
- Illustrating the effect of long or short oven & cooler times on production output
- Estimating waiting times in cooling stations
- Estimating waiting times prior to entering the oven station (operator free time)
- Match cycle station times for maximum output - use multiple station Independent-arm machine more efficiently

- Illustrates the effect of demolding times on productivity
- Calculates total parts per arm to show estimates of total production output
- Includes 5 languages options: English, Spanish, German, Italian and French
- Helps to determine the best product mix on the most common styles of machine for maximum efficiencies

RotoCycle calculates time for each arm at each station to pinpoint delays and bottlenecks in your machine set-up. Compare station utilization with the bar graph and maximize station/oven use as this relates directly to your overall productivity, greatly enhancing efficiencies. Balance station times for maximum arms-per-day on machines with multiple ovens and coolers. See the effect on productivity on a complete machine when time changes on only one arm. Print out detailed simulation results for comparison.

Now you can determine the best product mix on each of your machines for maximum production efficiencies.



ROTOCYCLE