

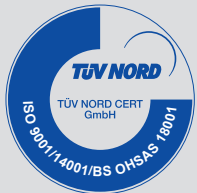
ZDAS

ŽDAS TechForge Automatic Forging



ŽDAS TechForge

is a new software support for open die forging of integrated forging units. It is also suitable for small series of forgings such as squares, plates and shafts.



ŽDAS, a.s.

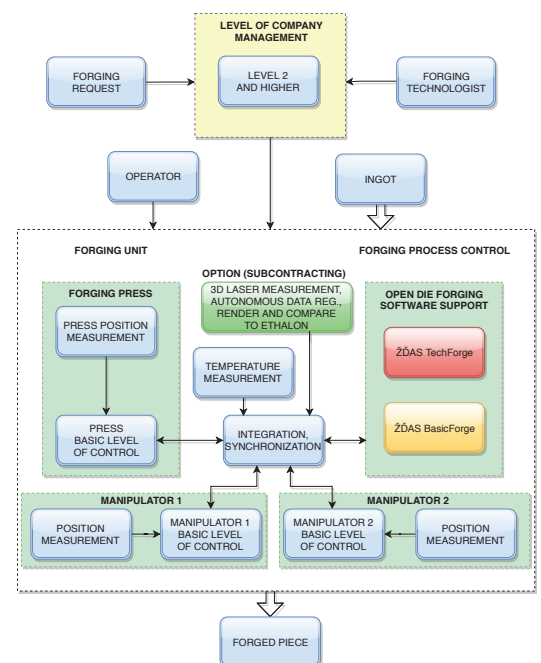
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The joint-stock company ŽDAS has developed and offers an automatic forging software support **ŽDAS TechForge** intended for integrated forging units.

ŽDAS TechForge is a newly developed expert function of software support for open die forging. It is a simple solution without any laser measuring system of forged pieces. Operator selects one of the preset recipes from the database, clamps the ingot manually into the manipulator tongs, loads into the press to the starting point and presses the button to start automatic sequences. Procedure is then performed out in the individual steps that follow each other.

ŽDAS TechForge is programmed in PLC software TIA Portal by Siemens Company. 3D visualization is also included, in order to make work with the forging unit easier. It displays both simplified and complete hydraulic schemes, the current state of all forging unit elements, energy consumption and statistics, detail alarm reporting including archiving and a lot of other useful maintenance and service information.



ŽDAS TechForge automatic forging is designed to meet the most demanding requirements of our customers.

Main advantages:

- Reducing forging time
- Reducing power consumption
- Reducing reheating time
- Reducing oven power consumption
- Increasing operational efficiency
- Increasing competitiveness
- Avoiding forging below the minimum temperature
- Facilitating the operator's work
- Minimizing errors by the operator

Other advantages:

- Easy adjustment of recipes parameters by an operator or technologist
- Simple copying, creating new recipes or deleting unused ones
- Possibility to interrupt and start again automated forging procedure at any time on operator's demand
- Possibility to manually skip to any other recipe step or start the automatic cycle at any step of recipe according to the operator's requirement
- Possibility to manually change parameters and intervene in forging procedure during automated forging
- Possibility to back up the recipes

ZDAS CKV2000 + QKK8NK		Position	T - Presse	Temp. des Blocs	Presse betrieb	Schmiedesattel	T - Linke Mani	T - Rechte Mani	MODUS	RECHENGERÄT	Modus	Service
		957,7 mm	47,9 °C	0 °C	Manueller Modus mit Messung	Manueller Modus	45,3 °C	45,4 °C	SERVICE	08.02.2017 14:01:38	Benutzer:	ABMELDUNG
ARBEITSFENSTER												
08.02.2017 14:00:36 MANIPULATOR LINKS: Kein ausreichender Wasserdurchfluss (DIX 72.0)												

MANIPULATOR LINKS:	POSITION DER PRESSE:	GESCHMIEDETE ABMESSUNGEN	MANIPULATOR RECHTS
Hydraulikantrieb BT101: 45,3 °C BL101: 779 mm BP141: 1 bar BP143: 200 bar ZANGE MOD: Manueller Modus Rechts BS121: 315 ° BP146: 2 bar GESCHW.: 1 KY120: 0 % BP126: 0 bar KY158: 200 bar LAUFWERK MOD: Inkremental Links BS131: 6102 mm BS132: 6101 mm KY130: 0 % KY131: 0 % GESCHW.: 1 ABS: 4473 mm ZANGENTRÄGER MOD: Manueller Modus Parallelhub BG141: 335 mm KY141: 0 % Kippen BG143: 11 mm KY142: 0 % Seitenvorschub BG144: 2 mm BG145: 5 mm AUTOMAT Start position: 1081 mm	958 H: 100 X: 1 P: 80 T: 0 K: 38 F: 0,0 SET 1 AKTUELLE HUBANZAHL: 0 /min AKTUELLE KRAFT: 0 MN SCHMIEDESATTEL -CONTAINER: BG28: 3866 mm PRESSZYLINDER: BP2: 4 bar RÜCKZUGZYLINDER: BP4: 80 bar RECIPE Unterlagen 250vkt C. D [mm] H [mm] INC ANG OFFST INC OFFST senken 0 300 80 200 0 0 1 300 80 200 0 0	LIMIT 0 D1: 390 0 D2: 350 0 D3: 320 0 D4: 300 0 D5: 285 0 D6: 300 LIMIT SCHRITT EXAKT. POS 0 30 2000 INKREMENT WINKEL 200 0	Hydraulikantrieb BT101: 45,4 °C BL101: 725 mm BP141: 1 bar BP143: 183 bar ZANGE MOD: Manueller Modus Links BS121: 360 ° BP146: 2 bar GESCHW.: 1 KY120: 0 % BP126: 0 bar KY158: 200 bar LAUFWERK MOD: Manueller Modus Links BS131: 6982 mm BS132: 6982 mm KY130: 0 % KY131: 0 % GESCHW.: 1 ABS: -1407 mm ZANGENTRÄGER MOD: Achse Parallelhub BG141: 322 mm KY141: 0 % Kippen BG143: 1 mm KY142: 0 % Seitenvorschub BG144: 2 mm BG145: -4 mm AUTOMAT Start position: 1012 mm

F1 PRESSE	F2 MANIPULATOR LINKS	F3 MANIPULATOR RECHTS	F4 BEREITSCHAFT	F5 SCHMIEDESATTEL	F6 TRENDS KAMERAS	F7 REZEPTUREN	F8 ARBEITSFENSTER	F9 ALARME
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