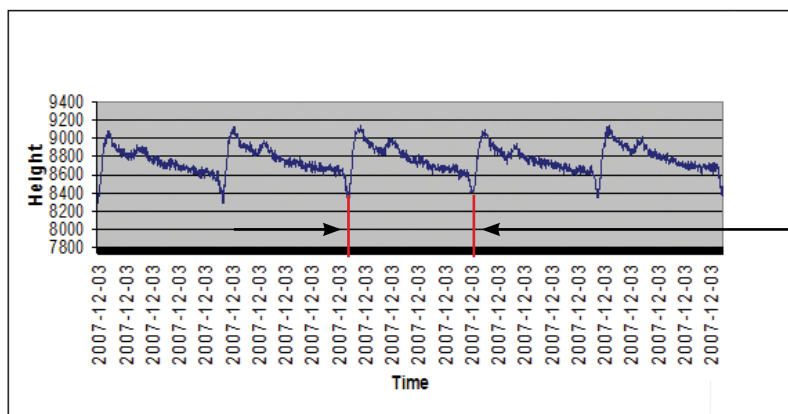
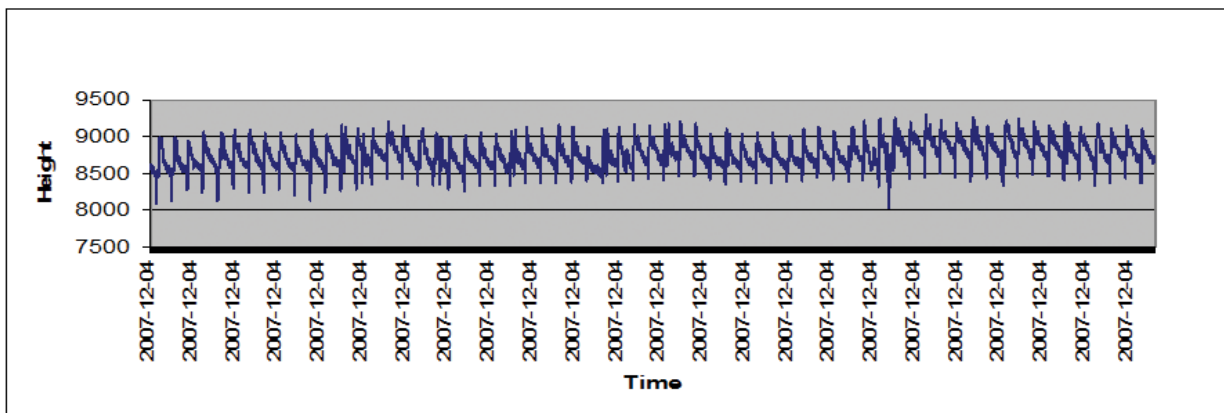


Understanding Periodic Behavior Using Profile360

Starrett-Bytewise...leading the way with on-line profile inspection for rubber extrusions

It is typical for extrusion lines to exhibit some degree of periodicity, or a cyclical pattern of dimensional variation. Periodicity has many different causes, such as puller drive control, puller belt splice effect, windup cycle control, cutter cycling, and thermal cycling of the heating bath system. Profile360 data can be analyzed to determine the time-frequency of the period, which can then be used to diagnose the extruder line and down-stream processes. Reduction in the magnitude of these periodic changes reduces the standard deviation of the dimensional values and results in a better cp and cpk.



6 minute 20 second period

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