Aluminum Extrusion Press Log

How-to guide: what the workbook does, how to use it and what every number means. mfgcalcs.com

Aluminum Extrusion Press Log

Log every die run and see billet recovery, where the billet goes (butt, ends, saw offcuts, defects) and accepted output per press hour, by press, die and week.

For: Extrusion plant managers, press supervisors, die shop and quality engineers, and cost accountants in aluminum extrusion.

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Quick start

1. On Setup, choose your mass unit and recovery target, then replace the example presses (with each press's required output rate), dies and defect types.
2. On Press Log, add one row per die run: billets, billet input, good profile, butt, ends, saw offcuts, defect scrap and press hours.
3. Read the Check column: good profile plus scrap can never weigh more than the billet input.
4. Use the Dashboard filters to look at one press, one die or one week.

What is in the workbook

Start Here	Read this first: what the workbook does and how to use it.
Setup	Your plant, mass unit and recovery target, and the press, die and defect lists.
Press Log	One row per die run: billets in, good profile out, the scrap split by type and press hours.
Dashboard	Billet recovery, losses and accepted output, for the presses, dies and dates you choose.
Method	How every number is calculated, with assumptions, limits and sources.
Verify	Self-check: the workbook's formulas recomputed on fixed inputs against an independent reference.
About MFG Calcs	Everything MFG Calcs offers, free: calculators, templates, tariff tools, data and the Calkee AI helper.

What each number means

Quantity	How it is calculated	Units
Billets, billet input, good profile and scrap	Typed per run; scrap is weighed as butt, ends, saw offcuts and defect scrap.	count, mass
Press hours	Typed per run: elapsed time from the first billet to the last, with stops.	h

Quantity	How it is calculated	Units
Scrap total	Butt + ends + saw offcuts + defect scrap.	mass
Unaccounted	Billet input - good profile - scrap total.	mass
Recovery	Good profile / billet input.	%
Gap to target	(Recovery target - recovery) x 100; positive = below target.	points
Non-good billet	Billet input - good profile.	mass
Profile extruded	Billet input - butt: the profile that left the press.	mass
Acceptance	Good profile / profile extruded.	%
Accepted rate	Good profile / press hours.	mass/h
Rate margin	Accepted rate - the press's required rate.	mass/h
Required output	Required rate x press hours.	mass
Required rate and profile	Looked up from the Presses and Dies lists on Setup (INDEX/MATCH).	mass/h, text
Dashboard roll-ups	Every figure is a SUMIFS over the Press Log restricted to rows whose View date is filled in (inside the filters), e.g. recovery = SUMIFS(good profile) / SUMIFS(billet input), required rate = SUMIFS(required output) / SUMIFS(press hours).	-

Assumptions, limitations, sources and the self-check (the Verify sheet, which recomputes the workbook's formulas on fixed test inputs) are in the workbook. The last page shows the Dashboard with the example data for Fernhollow Extrusions, a fictional business.

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Engineering estimates for planning and improvement work. Verify the results against your own process, data and standards before you rely on them.

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Billet recovery, losses and accepted output, for the presses, dies and dates you choose.

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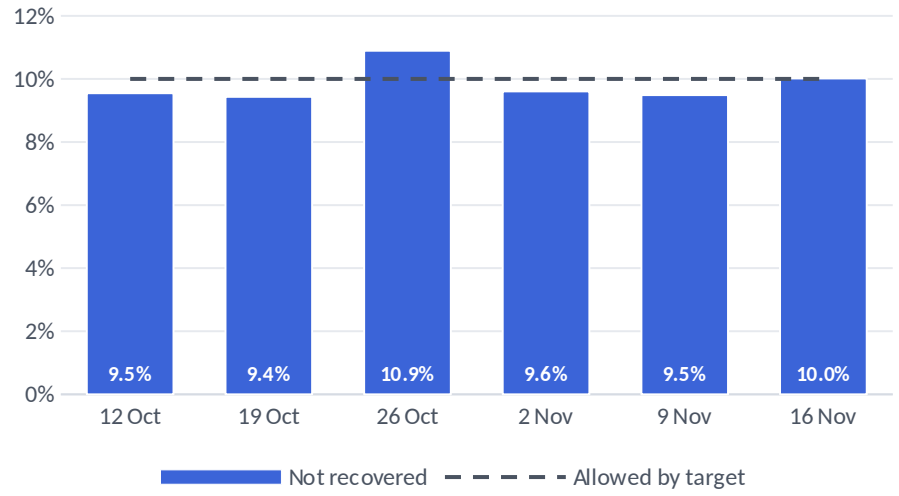
Press		From	
Die		To	

Showing 225 die runs. Leave the filters blank to include everything; dates are inclusive. Weights in kg, rates in kg per press hour.

BILLET RECOVERY	ACCEPTED RATE (kg/h)	ACCEPTANCE	NON-GOOD BILLET (kg)
90.17%	**1,288**	**93.0%**	**176,573**
Target 90.00%	Required 1,148	Good profile / profile extruded	Billet input - good profile
On target	On target		

Billet not recovered, by week



Billet losses by press

