

## Quality Assurance Procedures

Spec 37002 – Machine working rate

Version: 0

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### Machine' Work Rate Chart

Machine Model	Cylinder downward time movement.	*Gas filling time.	* Cylinder downward time movement for sealing.	Sealing time.	Cylinder upward time movement.	Conveyor / Rotating table operating time.	Machine rate including SLB.	Machine rate without SLB.
	seconds	seconds	seconds	seconds	seconds	seconds	cycles per minute	cycles per minute
SM-208 Athena	0.8	1 - 3	0.3	1	0.8	Manual (2.5)	6 - 8	Up to 12
MAP-210 Hera	0.8	1 - 3	0.3	1	0.8	1.5	12 - 15	Up to 18
YY Hermes	0.5	1 - 3	0.2	1	0.5	0.8	15 - 20	Up to 24
PM-1502 Poseidon	0.5	1 - 3	0.2	1	0.5	0.8	10 - 14	Up to 18
MAP 210 Hera + Servo	0.8	1 - 3	0.3	1	0.8	1.5	12 - 18	Up to 20

#### Remarks

- Machines without SLB - Gas filling time and Cylinder downward time movement for sealing – Do **not take into account**.
- The final exact gas filling time to be determined according to customer needs.