start Correction

1.Be shure about the Problem

1.1 Length differece?

1.1.1 All Temperatures are ok?

1.1.1.1 Die	450°C to 470°C - All around the Die no bigger difference than 5°C start first billet 20°C warmer
1.1.1.2 Billet	- Hollow Die 490° to 460° C - Flat Die 470 to 440°C heating works correct
1.1.1.3 Container	- 400° to 420°C
1.1.1.4 run out	Profile runout Temperature should be between 540° and max. 570° C

1.1.1.5. Material flow is equal!

If the flow is not equal, the Mandrel moves and you get a length Problem

1.1.2 Bolster

1.1.2.1 use the optimal Bolster (5 -15mm Distance to the Backer)

1.1.2.2 be sure that the Bolster is absolutly flat

- short Check every time after using, and onth a year a currently Check

1.1.2.3 to critical Profiles and big die size warm up also the Bolster to 250°

1.1.3 Extrusion Press Adjustment

1.1.3.1 Container Center to the die Center in a circle of 1mm

- Check it minimum every week

1.1.3.2 Die Holder stay in Angel to the Plate

start Correction

2.2 Problem with Profil Form

2.2.1 Temperatures are ok

2.2.1.1 Die min.440°C to 490°C
2.2.1.2 Billet start Billet 20°C warmer
2.2.1.3 Container heating works correct (400°C to 420°C)
2.2.1.4 run out Profil runout Temperatur should be over 540°C

2.2.2 Bolster

2.2.2.1 use the optimal Bolster (10-15mm distance to the Profile)
2.2.2.2 be shure that the Bolster is flat!
2.2.2.3 to critical Profiles warm up also the Bolster to 250° - 300°C

2.2.3 Machine adjust

2.2.3.1 Press alignment and Container to the die in a circle of 1mm
2.2.3.2 Die Holder stay in Angel to the Plate

2.2.4 Die design

2.2.4.1 check the inlaid proportion

- 2.2.4.1.1 use a list to find out wich proportion is the right for your Presses

2.2.4.1.2 but thinking about the difference to the material flow on a differnt lay out

2.2.4.2 can the material goes to the press canal in the same time

- 2.2.4.2.1 this is not always easy, but very important

2.2.4.3 Prevent, that big details at the Profile are not in a direct material flow
2.2.4.4 Mandrel under cut

- 2.2.4.4.1 be shure that the under cut is all over the same
  - because it is not, you have a different lever and the mandrel goes away

2.2.4.4.2 Also you can do more under cut on the outside, because you can stabilised for the flexion