

Minland Machine Inc.

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DCB10 Setup Certification			Machine Parameters As Tested	
Machine Serial Number	20010 to 13		[AxisPPU]	[MachineOptions]
Date Tested			0PPU=1410.96	
Initials	DRB		1PPU=15.3	TimerInterval=50
VB Version	3.1.1		2PPU=0	MandrelOption=0
DII Version	2.0.0.0		3PPU=0	IdleTime=60
MotherBoard (SOYO)	SY-7VMA-B		4PPU=0	Mandel=False
Motion Card (Type / Buss)	ACR2000 (ISA)		5PPU=0	drawBarFirst=True
Operating System Win98se/NT4.0	Win98se		6PPU=0	drawBarInJog=True
TouchScreen Port USB/Serial	USB		7PPU=0	ScannerOption=False
				RequirePartNo=False
[Machine Setup]			[SystemResolution]	
Homing Repeatability@10cycles	0.002	In.	0Resolution=0.000714332648	[StopTableParameters]
Positioning Repeatability	0.002	In.	1Resolution=0.0163940385	MaxAcc=150
Swing Arm Deviation@90	0.2	Degrees	2Resolution=0.000063803	ZeroOffset=238.75
24vdc Power Supply Voltage	24.4	Volts	3Resolution=0.000063803	ForwardLimit=224
24vdc Supply Model 4.6/6.4	4.4	Amps	4Resolution=.0002	ReverseLimit=-1
Main AC Power Type 220/440	220	Volts	5Resolution=.00024414	ToolLength=24
Hydraulic Pres @ Guage	1000	PSI	6Resolution=.0002	DefaultPositionMode=0
Hyd Oil Temp @ 1 Hour Runtime	160	Degrees	7Resolution=.0002	DefaultMetric=0
Air Pressure @ Guage	60	PSI	HandWheelPPR=100	AirStopDelay=0
				SlideClampDelay=300
[Machine Connectors]	Positions	M/F	[Gains0] Stop Table	RetractBeforeClamp=0
Console to Machine 64pos	64	M	PGAIN=.004	ForwardPBdelay=0
Machine to Console 64pos	64	F	IGAIN=.3	PositionTolerance=.002
Machine to Rail 32pos	32	F	ILIMIT=.4	Decel=150
Rail to Machine 32pos	32	M	IDELAY=0	MaxVel=200
Machine to Pendant	10	F	DGAIN=0.00008	StopHomeOffset=.100
Pendant to Machine	10	M	DWIDTH=0	
Machine to Mandrel	10	N/A	FFVEL=0	[SwingArmParameters]
Table (ServoMotor to Machine)	25	M	FFACC=0	MaxAcc=700
Table (Encoder to Machine)	9	M	TLM=10	MaxVel=700
Encoder Part Number	SSCDA15 1000 5VLD			MaxBendAngle=183
	ADC 256D		[Gains1] Swing Arm	ClampDelay=700
			PGAIN=0.028	UnclampDelay=0
AMC Amp Pot Settings	Resistance		IGAIN=1.8	ArmReturnDelay=700
Loop Gain	6 Ohms		ILIMIT=1.8	LubeCounter=100
Current Limit	16.3K		IDELAY=0	HomeOffset=-6.0
Gain	0 Ohms		DGAIN=0.0001	swingArmFudge=0
Offset	21.9 K		DWIDTH=0.001	PositionTolerance=.1
			FFVEL=0	DeCel=250
AMC Amp Motor Phase Code	Wire Color		FFACC=0	armHomeOffset=-.7
MOTOR A	RED		TLM=10	ArmDacOffset=-.200
MOTOR B	WHITE			
MOTOR C	BLUE			