



19801 M-205 (at 5 Points Jct.)
 EDWARDSBURG, MI 49112
 (269) 641-7998 FAX (269) 641-7793

AutoPunch 30008 Machine Specifications (8-18-10) Sold to Kinro Inc.
 Customer = Kinro Inc.

| Machine Specifications | |
|-------------------------------------|-----------------------|
| Machine Serial Number | 30008 |
| VB Version | 6.0.0 |
| TouchScreen Model | LA1500RTR |
| MotherBoard | MB800 |
| Gearhead ratio | 10:1 |
| Operating System | XPPRO |
| TouchScreen Port | USB |
| Servo Motor & Encoder Unit | MPL-A320P-HJ22A |
| Motion Controller (Network) | ACR9000 |
| Servo Amp | 2098-DSD-020 120/240V |
| Bios Pswd | NOT SET |
| Network Card Type | ONBOARD |
| Administratior Acct Password | 0 |
| Network Switch | NetGear 4 port |

| Electrical Power | |
|----------------------------|-----------------------|
| I/O Power Supply Voltage | 24 Volts |
| Power Supply Current | 7.2 Amps (Keyence) |
| Main AC Input Power | 220 Sgl. PHASE |
| Total Current Draw | 30 Amps |

| Hydraulic Settings | |
|------------------------|---------|
| Hydraulic Pres @ Guage | 1500 |
| Hyd Oil Temp Warm | 120-140 |

| Air Pressure Guage Settings | |
|----------------------------------|-----------------------|
| Main Air Pressure @ Gauge | 80 psi Minimum |
| Clamp Down (Secondary) | 8 psi |
| Feed Clamp Down (primary) | 8 psi |

| Network IP's | |
|--------------|---------------|
| PC | 192.168.72.22 |
| Acr9000 | 192.168.72.23 |
| GateWay | 192.168.72.1 |

Machine Parameters

| [JogSpeeds] | [MachineOptions] |
|-------------|------------------------|
| JogVel=10 | SocketIP=192.168.72.23 |
| JogACC=1000 | GateWay=192.168.72.1 |
| JogDec=1000 | SerialNo=30008 |
| | TimerInterval=100 |

| [AxisPPU] | [MachineOptions] |
|-----------|----------------------|
| 0PPU=3945 | IdleTime=60 |
| | dxBackColor=12566463 |
| | disableTaskBar=False |
| | RequirePartNo=True |

| [SystemResolution] |
|---------------------------|
| 0Resolution=0.0010 |

| [AxisIPB] = inposition band | [MachineParameters] |
|-----------------------------|---------------------|
| 0IPB=.005 | MaxVel=40 |
| | MaxAcc=600 |
| | MaxDecel=400 |

| [Backlash] | [MachineParameters] |
|------------|---------------------|
| BkI0=0.0 | ZeroOffset=2.94 |
| | PunchDownDelay=0.01 |
| | PunchUpDelay=0.01 |

| [Gains0] | [MachineParameters] |
|-----------------|---------------------|
| MULT=-4 | InpositionDelay=0 |
| DACGAIN=-3276.8 | ZeroSwitchDelay=0 |
| PGAIN=0.003 | disableTaskBar=True |
| IGAIN=0.2 | |
| ILIMIT=0.1 | |
| IDELAY=0.01 | |
| DGAIN=0.000001 | |

| MOTOR CABLES | |
|-------------------|-------------------|
| Encoder cable | 2090-XXNPMP-16S03 |
| Motor Power Cable | 2090-UXNFBMP-S03 |

| ACR9000 Cables | |
|----------------|--------------|
| Encoder Cable | 71-022344-04 |

| Feeder Guides/Die Setup | |
|-------------------------|----------------|
| Feeder Guide's Height | 7.062 +/- .002 |
| Die Height | 7.062 +/- .002 |
| Die Block | 3.5 |