Minland Machine Inc.

DCB10 Setup Certifcation

Machine Serial Number	**20015**	
Date Tested	**10/13/2003**	
Initials	**DRB**	
VB Version	**3.1.3**	
Dll Version	**2.0.0.0**	
MotherBoard (SOYO)	**SY-7VMA-B**	
Motion Card (Type / Buss)	**ACR2000 (ISA)**	
Operating System **Win98se/NT4.0**	**Win98se**	
TouchScreen Port **USB/Serial**	**SERIAL**	
AcroBasic Version	**2.0**	

[Machine Setup]		
Homing Repeatability@10cycles	**0.002**	In.
Positioning Repeatability	**0.002**	In.
Swing Arm Deviation@90	**0.2**	Degrees
24vdc Power Supply Voltage	**24.4**	Volts
24vdc Supply Model 4.6/6.4	**4.4**	Amps
Main AC Power Type 220/440	**220**	Volts
Hydraulic Pres @ Guage	**1000**	PSI
Hyd Oil Temp @ 1 Hour Runtime	**120**	Degrees
Air Pressure @ Guage	**60**	PSI

[Machine Connectors]	**Positions**	**M/F**
Console to Machine 64pos	**64**	M
Machine to Console 64pos	**64**	F
Machine to Rail 32pos	**32**	F
Rail to Machine 32pos	**32**	M
Machine to Pendant	**10**	F
Pendant to Machine	**10**	M
Machine to Mandrel	**10**	N/A
Table (ServoMotor to Machine)	**25**	M
Table (Encoder to Machine)	**9**	M
Encoder Part Number	**TRD-SHT-1000VD**	
	Alt-encoder Non-Stardard	

AMC Amp Pot Settings	**Resistance**
Loop Gain	**6 Ohms**
Current Limit	**16.3K**
Gain	**0 Ohms**
Offset	**21.9 K**

AMC Amp Motor Phase Code	**Wire Color**
MOTOR A	**RED**
MOTOR B	**WHITE**
MOTOR C	**BLUE**

NOTES:

1 Alternate Encoder Used … PN# TRD-SHT-1000VD
2 CR1-8 Blade relays Replaced with Omron Solid State Relays PN# MSC … 78327319
3 Using AcroBasic Version 2.0
4
5
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Machine Parameters As Tested

[AxisPPU]
0PPU=1410.96
1PPU=15.3

[SystemResolution]
0Resolution=0.000714332648
1Resolution=0.0163940385

[Gains0] Stop Table
PGAIN=0.004
IGAIN=0.3
ILIMIT=0.4
IDELAY=0
DGAIN=0.00008
DWIDTH=0
FFVEL=0
FFACC=0
TLM=10

[Gains1] Swing Arm
PGAIN=0.028
IGAIN=1.8
ILIMIT=1.8
IDELAY=0
DGAIN=0.0001
DWIDTH=0.001
FFVEL=0
FFACC=0
TLM=10

[MachineOptions]
SerialNo=2015
TimerInterval=25
MandrelOption=0
IdleTime=60

[StopTableParameters]
MaxAcc=300
ZeroOffset=183.437
ForwardLimit=163.5
ReverseLimit=-1
ToolLength=20
DefaultPositionMode=0
DefaultMetric=0
AirStopDelay=0
SlideClampDelay=300
RetractBeforeClamp=0
ForwardPBdelay=0
PositionTolerance=.002
Decel=150
MaxVel=300
StopHomeOffset=.100

[SwingArmParameters]
MaxAcc=1000
MaxVel=1000
MaxBendAngle=183
ClampDelay=700
UnclampDelay=0
ArmReturnDelay=700
LubeCounter=100
swingArmFudge=0
PositionTolerance=.1
DeCel=250
armHomeOffset=-6.5
ArmDacOffset=-.3