

Minland Machine Inc.

DCB10 Setup Certification				
Machine Serial Number	20016			Machine Parameters As Tested
Date Tested	10/23/2003			
Initials	DRB		[AxisPPU]	[MachineOptions]
VB Version	3.1.3		0PPU=1410.96	SerialNo=20016
DII Version	2.0.0.0		1PPU=15.3	TimerInterval=25
MotherBoard (SOYO)	SY-7VMA-B			MandrelOption=0
Motion Card (Type / Buss)	ACR2000 (ISA)		[SystemResolution]	IdleTime=60
Operating System Win98se/NT4.0	Win98se		0Resolution=0.000714332648	
TouchScreen Port USB/Serial	SERIAL		1Resolution=0.0163940385	
AcroBasic Version	2.0			
			[Gains0] Stop Table	[StopTableParameters]
			PGAIN=0.004	MaxAcc=300
[Machine Setup]			IGAIN=0.3	ZeroOffset=183.437
Homng Repeatability@10cycles	0.002	In.	ILIMIT=0.4	ForwardLimit=163.5
Positioning Repeatability	0.002	In.	IDELAY=0	ReverseLimit=-1
Swing Arm Deviation@90	0.2	Degrees	DGAIN=0.00008	ToolLength=20
24vdc Power Supply Voltage	24.4	Volts	DWIDTH=0	DefaultPositionMode=0
24vdc Supply Model 4.6/6.4	4.4	Amps	FFVEL=0	DefaultMetric=0
Main AC Power Type 220/440	220	Volts	FFACC=0	AirStopDelay=0
Hydraulic Pres @ Guage	1000	PSI	TLM=10	SlideClampDelay=300
Hyd Oil Temp @ 1 Hour Runtime	120	Degrees		RetractBeforeClamp=0
Air Pressure @ Guage	60	PSI	[Gains1] Swing Arm	ForwardPBdelay=0
			PGAIN=0.028	PositionTolerance=.002
[Machine Connectors]	Positions	M/F	IGAIN=1.8	Decel=150
Console to Machine 64pos	64	M	ILIMIT=1.8	MaxVel=300
Machine to Console 64pos	64	F	IDELAY=0	StopHomeOffset=-.100
Machine to Rail 32pos	32	F	DGAIN=0.0001	
Rail to Machine 32pos	32	M	DWIDTH=0.001	[SwingArmParameters]
Machine to Pendant	10	F	FFVEL=0	MaxAcc=1000
Pendant to Machine	10	M	FFACC=0	MaxVel=1000
Machine to Mandrel	10	N/A	TLM=10	MaxBendAngle=183
Table (ServoMotor to Machine)	25	M		ClampDelay=700
Table (Encoder to Machine)	9	M		UnclampDelay=0
Encoder Part Number	SSC-DA15-1000-VLD			ArmReturnDelay=700
				LubeCounter=100
				swingArmFudge=0
AMC Amp Pot Settings	Resistance			PositionTolerance=.1
Loop Gain	6 Ohms			DeCel=250
Current Limit	16.3K			armHomeOffset=-13.5
Gain	0 Ohms			ArmDacOffset=-.3
Offset	21.9 K			
AMC Amp Motor Phase Code	Wire Color			
MOTOR A	RED			
MOTOR B	WHITE			
MOTOR C	BLUE			
NOTES:				
1	Bios Pswd Set to Malachi on 12.10.04 because uses keep changing things Per Dan/Dennis			
2				
3	Updated AcroBasic SDK to Version 4.0			
4				
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