

**Minland Machine Inc.**

DCB10 Setup Certification					
<b>Machine Serial Number</b>	20017			<b>Machine Parameters As Tested</b>	
<b>Date Tested</b>	3/1/2005				
<b>Initials</b>	DRB			<b>[AxisPPU]</b>	<b>[MachineOptions]</b>
<b>VB Version</b>	3.1.7			0PPU=1409	SerialNo 20017
<b>DII Version</b>	4.0.0			1PPU=15.2	TimerInterval 25
<b>MotherBoard (SOYO)</b>	SY-7VMA-B				MandrelOption 0
<b>Motion Card (Type / Buss)</b>	ACR2000 (ISA)				IdleTime 60
<b>Operating System Win98se/NT4.0</b>	Win2000				
<b>TouchScreen Port USB/Serial</b>	SERIAL				
<b>AcroBasic Version</b>	4.0				
<b>StopTable Type</b>	6 Stops			<b>[Gains0] Stop Table</b>	<b>[StopTableParameters]</b>
				PGAIN=0.004	MaxAcc=75
<b>[ Machine Setup ]</b>				IGAIN=0.5	ZeroOffset=236.94
<b>Homing Repeatability@10cycles</b>	0.002	In.		ILIMIT=0.5	ForwardLimit=231.700
<b>Positioning Repeatability</b>	0.002	In.		IDELAY=0	ReverseLimit=0
<b>Swing Arm Deviation@90</b>	0.2	Degrees		DGAIN=0.00008	ToolLength=22
<b>24vdc Power Supply Voltage</b>	24.4	Volts		DWIDTH=0	DefaultPositionMode=1
<b>24vdc Supply Model 4.6/6.4</b>	4.6	Amps		FFVEL=0	DefaultMetric=0
<b>Main AC Power Type 220/440</b>	440	Volts		FFACC=0	AirStopDelay=0
<b>Hydraulic Pres @ Guage</b>	1000	PSI		TLM=10	SlideClampDelay=300
<b>Hyd Oil Temp @ 1 Hour Runtime</b>	120	Degrees			RetractBeforeClamp=0
<b>Air Pressure @ Guage</b>	60	PSI		<b>[Gains1] Swing Arm</b>	ForwardPBdelay=0
				PGAIN=0.026	PositionTolerance=.002
<b>[ Machine Connectors ]</b>	<b>Positions</b>	<b>M/F</b>		IGAIN=0.2	Decel=75
Console to Machine 64pos	64	M		ILIMIT=0.3	MaxVel=75
Machine to Console 64pos	64	F		IDELAY=0	StopHomeOffset=0.1
Machine to Rail 32pos	32	F		DGAIN=0	Stop1HomePosition=1.0
Rail to Machine 32pos	32	M		DWIDTH=0	StopExtLength=2.5
Machine to Pendant	10	F		FFVEL=0	EnableExtendedStop=1
Pendant to Machine	10	M		FFACC=0	StopsCountLimit=6
Machine to Mandrel	10	N/A		TLM=10	StopClearance=4.125
Table (ServoMotor to Machine)	25	M			StopUnlockDwell=1.0
Table (Encoder to Machine)	9	M			InPosTime=6000
<b>Encoder Part Number</b>	SSC-DA15-1000-VLD			<b>[SwingArmParameters]</b>	<b>[StopTable Offsets]</b>
				MaxAcc=1000	Offset 1 0.28
				MaxVel=2000	Offset 2 0.28
<b>AMC Amp Pot Settings</b>	<b>Resistance</b>			MaxBendAngle=183	Offset 3 0.28
Loop Gain	6 Ohms			ClampDelay=500	Offset 4 0.28
Current Limit	16.3K			UnclampDelay=0	Offset 5 0.28
Gain	0 Ohms			ArmReturnDelay=300	Offset 6 0.28
Offset	21.9 K			LubeCounter=100	Offset 7 0.28
				swingArmFudge=0	Offset 8 0.28
<b>AMC Amp Motor Phase Code</b>	<b>Wire Color</b>			PositionTolerance=0.2	Offset 9 0.28
MOTOR A	RED			DeCel=1000	Offset 10 0.28
MOTOR B	WHITE			armHomeOffset=-11.5	Offset 11 0.28
MOTOR C	BLUE			ArmDacOffset=0	Offset 12 0.28
				ArmReturnPos=.0	
<b>NOTES:</b>					
1	Parker Servo Valve Type Hydraulics				
2	StopTable is 6 Segmented Type				
3	wired for Mandrel to Plug/no code in VB for it.				
4					
5					
6					