

Minland Machine Inc.

DCB10 Setup Certification					
Machine Serial Number	20018			Machine Parameters As Tested	
Date Tested	2/10/2006				
Initials	DRB			[AxisPPU]	[MachineOptions]
VB Version	3.1.7			0PPU=1409	SerialNo 20018
DII Version	4.0.0			1PPU=15.2	TimerInterval 50
MotherBoard (TecnoLand)	MB800				MandrelOption 0
Motion Card (Type / Buss)	ACR2000 (ISA)				IdleTime 60
Operating System Win98se/NT4.0	Win2000				
TouchScreen Port USB/Serial	USB				
AcroBasic Version	4.0				
StopTable Type	6 Stops			[Gains0] Stop Table	[StopTableParameters]
				PGAIN=0.004	MaxAcc=135
[Machine Setup]				IGAIN=0.5	ZeroOffset=229.875
Homing Repeatability@10cycles	0.002	In.		ILIMIT=0.5	ForwardLimit=231.5
Positioning Repeatability	0.002	In.		IDELAY=0	ReverseLimit=0
Swing Arm Deviation@90	0.2	Degrees		DGAIN=0.00008	ToolLength=22
24vdc Power Supply Voltage	24.4	Volts		DWIDTH=0	DefaultPositionMode=1
24vdc Supply Model 4.6/6.4	4.6	Amps		FFVEL=0	DefaultMetric=0
Main AC Power Type 220/440	220	Volts		FFACC=0	AirStopDelay=0
Hydraulic Pres @ Guage	900-1000	PSI		TLM=10	SlideClampDelay=300
Hyd Oil Temp @ 1 Hour Runtime	120	Degrees			RetractBeforeClamp=0
Air Pressure @ Guage	80	PSI		[Gains1] Swing Arm	ForwardPBdelay=0
				PGAIN=0.045	PositionTolerance=.002
[Machine Connectors]	Positions	M/F		IGAIN=0.1	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=0.00001	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
Encoder Part Number	SSC-DA15-1000-VLD			[SwingArmParameters]	[StopTable Offsets]
				MaxAcc=600	Offset 1 0.28
				MaxVel=2000	Offset 2 0.28
AMC Amp Pot Settings	Resistance			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
AMC Amp Motor Phase Code	Wire Color			PositionTolerance=0.2	Offset 9 0.28
Hall 1	GRN			DeCel=600	Offset 10 0.28
Hall 2	BLU			ArmHomeOffset=-10	Offset 11 0.28
Hall 3	ORG			ArmDacOffset=0	Offset 12 0.28
				ArmReturnPos=.0	
				90 Deg. Bend Pressure Drop	To 500psi
NOTES:					
1	Parker Servo Valve Type Hydraulics				
2	StopTable is 6 Segmented Type				
3	Not wired for mandrel/no code in VB for it.				
4	Nachi Valves				
5	Accumulater charged to 500 p.s.i.				
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