

Minland Machine Inc.

| DCB10 Setup Certification | | | | | |
|---|-------------------|------------|--|-------------------------------------|------------------------------|
| Machine Serial Number | 20019 | | | Machine Parameters As Tested | |
| Date Tested | 1/8/2007 | | | | |
| Initials | D.R.B. | | | [AxisPPU] | [MachineOptions] |
| VB Version (shipped with 4.1.9) | 4.2.2 | | | 0PPU=1410.78 | SerialNo 20019 |
| 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=0.1 | ZeroOffset=235.125 |
| Homing Repeatability@10cycles | 0.002 | In. | | ILIMIT=0.5 | ForwardLimit=236.625 |
| Positioning Repeatability | 0.002 | In. | | IDELAY=0 | ReverseLimit=0 |
| Swing Arm Deviation@90 | 0.2 | Degrees | | DGAIN=0.00008 | ToolLength=24 |
| 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=2 |
| Hydraulic Pres @ Guage | 900-1000 | PSI | | TLM=10 | |
| Hyd Oil Temp @ 1 Hour Runtime | 120 | Degrees | | | |
| Air Pressure @ Guage | 80 | PSI | | [Gains1] Swing Arm | ForwardPBdelay=0 |
| | | | | PGAIN=0.004 | PositionTolerance=.002 |
| [Machine Connectors] | Positions | M/F | | IGAIN=0.3 | Decel=75 |
| Console to Machine 64pos | 64 | M | | ILIMIT=0.032 | 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=7.5 |
| Machine to Pendant | 10 | F | | FFVEL=0 | |
| 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 | | | |
| Table (Encoder to Machine) | 9 | M | | | InPosTime=10000 |
| Encoder Part Number | SSC-DA15-1000-VLD | | | [SwingArmParameters] | [StopTable Offsets] |
| | | | | MaxAcc=1500 | Offset 1 0.28 |
| | | | | MaxVel=3000 | 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=3000 | Offset 10 0.28 |
| Hall 2 | BLU | | | ArmHomeOffset=-2.2 | Offset 11 0.28 |
| Hall 3 | ORG | | | ArmDacOffset=0 | Offset 12 0.28 |
| | | | | ArmReturnPos=.0 | |
| | | | | 90 Deg. Bend Pressure Drop | To 500psi |
| NOTES: | | | | ARM PPU 15.2 | |
| 1) Parker Servo Valve Type Hydraulics | | | | | |
| 2) StopTable is 6 Segmented Type | | | | | |
| 3) Not wired for mandrel/no code in VB for it. | | | | | |
| 4) Using Nachi Hyd Valves | | | | | |
| 5) Accumulator charged to 500 p.s.i. | | | | | |
| 6) Upgraded exe to 4.2.2 9.11.10 (added unlock dwell to end of placestop sub for positioning err) | | | | | |