

Minland Machine Inc.					
DCB10 Setup Certification					
Machine Serial Number	20020		Machine Parameters As Tested		
Date Tested	4/25/2007				
Initials	D.R.B.		[AxisPPU]	[MachineOptions]	
VB Version	4.1.9		0PPU=1410.78	SerialNo	20020
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=0.2	Decel=75	
Console to Machine 64pos	64	M	ILIMIT=0.072	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=1500	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=1000	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.					
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