

**Minland Machine Inc.**

DCB10 Setup Certification					
<b>Machine Serial Number</b>	20021			<b>Machine Parameters As Tested</b>	
<b>Date Tested</b>	1/16/2009				
<b>Initials</b>	D.R.B.		<b>[AxisPPU]</b>		<b>[MachineOptions]</b>
<b>VB Version</b>	4.2		0PPU=1410.78	SerialNo	20021
<b>DII Version</b>	4.0.0		1PPU=15.2	TimerInterval	50
<b>MotherBoard (TecnoLand)</b>	MB800			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>	USB				
<b>AcroBasic Version</b>	4.0				
<b>StopTable Type</b>	4 Stops		<b>[Gains0] Stop Table</b>	<b>[StopTableParameters]</b>	
			PGAIN=0.005	MaxAcc=135	
<b>[ Machine Setup ]</b>			IGAIN=0.5	ZeroOffset=235	
<b>Homing Repeatability@10cycles</b>	0.002	In.	ILIMIT=0.5	ForwardLimit=2365	
<b>Positioning Repeatability</b>	0.002	In.	IDELAY=0	ReverseLimit=0	
<b>Swing Arm Deviation@90</b>	0.2	Degrees	DGAIN=0.00008	ToolLength=24	
<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>	440/480	Volts	FFACC=0	AirStopDelay=2	
<b>Hydraulic Pres @ Guage</b>	900-1000	PSI	TLM=10		
<b>Hyd Oil Temp @ 1 Hour Runtime</b>	120	Degrees			
<b>Air Pressure @ Guage</b>	80	PSI	<b>[Gains1] Swing Arm</b>	ForwardPBdelay=0	
			PGAIN=0.04	PositionTolerance=.002	
<b>[ Machine Connectors ]</b>	<b>Positions</b>	<b>M/F</b>	IGAIN=0.3	Decel=75	
Console to Machine 64pos	64	M	ILIMIT=0.2	MaxVel=75	
Machine to Console 64pos	64	F	IDELAY=0	StopHomeOffset=0.1	
Machine to Rail 32pos	32	F	DGAIN=0.00008	Stop1HomePosition=1.0	
Rail to Machine 32pos	32	M	DWIDTH=0	StopExtLength=3.5	
Machine to Pendant	10	F	FFVEL=0		
Pendant to Machine	10	M	FFACC=0	StopsCountLimit=4	
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	
<b>Encoder Part Number</b>	SSC-DA15-1000-VLD		<b>[SwingArmParameters]</b>	<b>[StopTable Offsets]</b>	
			MaxAcc=1200	Offset 1	0.28
			MaxVel=3000	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
Hall 1	BLU		DeCel=1000	Offset 10	0.28
Hall 2	GRN		ArmHomeOffset=-21	Offset 11	0.28
Hall 3	ORG		ArmDacOffset=0	Offset 12	0.28
			ArmReturnPos=.0		
			90 Deg. Bend Pressure Drop	To 500psi	
<b>NOTES:</b>			<b>ARM PPU 15.2</b>		
1 Parker Servo Valve Type Hydraulics					
2 StopTable is 4 Segmented Type					
3 Not wired for mandrel/no code in VB for it.					
4 Using Nachi Hyd Valves					
5 Accumulator charged to 550 p.s.i.					
6 Using Dual End Bend Cylinder					