

**Minland Machine Inc.**

DCB10 Setup Certification				
<b>Machine Serial Number</b>	20022		<b>Machine Parameters As Shipped</b>	
<b>Date Tested</b>	6.10.2010			
<b>Initials</b>	DRB		<b>[AxisPPU]</b>	<b>[Network Settings]</b>
<b>VB Version</b>	6		0PPU=11280	PC IP 192.168.72.20
<b>DII Version</b>	n/a		1PPU=61	ACR9000 IP 192.168.72.21
<b>MotherBoard (SOYO)</b>	MB800			Gateway 192.168.72.1
<b>Motion Card (Type / Buss)</b>	ACR9000		<b>[SystemResolution]</b>	
<b>Operating System</b>	WinXP Pro		0Resolution=0.000714332648	
<b>TouchScreen Port</b>	USB		1Resolution=0.0163940385	
<b>AcroBasic Version</b>	6			
<b>Timer interval</b>	100ms		<b>[SwingArmParameters]</b>	<b>[StopTableParameters]</b>
			MaxAcc=1000	MaxAcc=50
			MaxVel=300	ZeroOffset=231.875
			MaxBendAngle=183	Table_MAXTravel=222.6512
<b>Homing Repeatability@10cycles</b>	0.002	In.	ClampDelay=500	MaxVel=40
<b>Positioning Repeatability</b>	0.002	In.	UnclampDelay=0	Decel=30
<b>Swing Arm Deviation@90</b>	0.2	Degrees	ArmReturnDelay=300	ToolLength=24
<b>24vdc Power Supply Voltage</b>	24.2	Volts	LubeCounter=200	DefaultPositionMode=1
<b>24vdc Supply Model (Keyence)</b>	7.2	Amps	LubeTime=200	DefaultMetric=0
<b>Main AC Power Type 220/440</b>	440	Volts	swingArmFudge=0	AirStopDelay=0
<b>Hydraulic Pres @ Guage</b>	1000 max	PSI	PositionTolerance=.2	SlideClampDelay=300
<b>Hyd Oil Temp @ 1 Hour Runtime</b>	120	Degrees	DeCel=1000	RetractBeforeClamp=0
<b>Air Pressure @ Guage</b>	80 Min.	PSI	armHomeOffset=-.18	ForwardPBdelay=0
			ArmDacOffset=0	PositionTolerance=.002
			ArmReturnPos=.0	StopExtLength=3.5
<b>[ Machine Setup ]</b>			BendTimerLimit=5	StopClearance=4.125
Servo Amp (10 amp Allen Bradley)	AB2098DSD010		ArmReturnPercent=50	EnableExtendedStop=1
Servo Motor (Allen Bradley)	ABTLA220PHJ32AN		JogVel=30	StopsCountLimit=4
Gearhead Ratio	10:01		JogACC=1500	StopUnlockDwell=2
Servo Controller	9000P3U2M0		JogDec=1500	InPosTime=10000
Touch Screen (Planner New Style) 15"	LA1500LTR			TableError=0
<b>[Gains0] Stop Table</b>				HomeStopsIfStopCountChanged=1
PGAIN=0.003			<b>[MachineOptions]</b>	SerialNo=20022
IGAIN=0.5			TimerInterval=100	JogVel=10
ILIMIT=0.5			MandrelOption=0	JogACC=1000
IDELAY=0			IdleTime=60	JogDec=1000
DGAIN=0.000001			Mandrel=False	
DWIDTH=0			dxBackColor=12632256	
FFVEL=0			drawBarFirst=True	
FFACC=0			drawBarInJog=True	
TLM=10			ScannerOption=False	
			RequirePartNo=False	
<b>[Gains1] Swing Arm</b>			TaskBarOFF=True	
PGAIN=0.010000			ForceHoldBendButtons=True	
IGAIN=0.100000			defaultprogrampath=C:\20022 Bender\Program Files\	
ILIMIT=0.250000			ForceExplorerToUseDefaultPath=False	
IDELAY=0				
DGAIN=0.000090				
DWIDTH=0				
FFVEL=0				
FFACC=0				
TLM=10				
			<b>Bender Options</b>	<b>Notes:</b>
			No Mandrel	Oiler Set to 2cc per shot (2sec Oil Time)
<b>Lubrication</b>			3 Button Console	Amp Setup File <b>DCB10-2098-DSD-10.udb</b>
Hydraulic Filter 10 Microns Min			3.5 " Stop Extention	Air Input Must be >= 80 psi or Stop locks will not work
Hydraulic Fluid (40 Gal Approx)	A/W 46 (Citgo)		440Vac 3ph. Main Power	
Way Lube System Oiler (Conaco)	Multi-Way Machine Lubricant			
Pneumatic oiler (Air System)(Conaco)	Velocite Oil #3			
Grease Fittings Grease (Citgo)	MP Lithplex		Bend Cylinder Fr. Chain Conn.	2.44 OAL.