Punch 30005 Certifcation

Machine Specifcations				**Machine Parameters As Tested**	
Machine Serial Number	**2000**				
Date Tested				**[AxisPPU]**	**[MachineOptions]**
Initials	**DRB**			0PPU=792.65	SerialNo=20005
VB Version	**5.1**				TimerInterval=25
Dll Version	**3**				
MotherBoard (SOYO)	**SY-7VMA-B**			**[SystemResolution]**	**[MachineParameters]**
Processor	PIII-1000MHZ			0Resolution=0.0010	MaxAcc=400
Operating System Win98se/NT4.0	NT4.0				ZeroOffset=3.875
TouchScreen Port USB/Serial	SERIAL			**[Gains0]**	PositionTolerance=.002
Servo Motor	MTS Type			[Gains0]	Decel=150
				PGAIN=0.13	MaxVel=1000
				IGAIN=.65	MaxDecel=200
				ILIMIT=.2	FwdJogFeedrate=0
24vdc Power Supply Voltage	**24.4**	Volts		IDELAY=0	PunchDownDelay=.01
24vdc Supply Model **4.6/6.4**	**4.4**	Amps		DGAIN=0.0004	PunchUpDelay=.01
Main AC Power Type 110/**220/440**	**110**	Volts		FFVEL=0	InpositionDelay=0
Hydraulic Pres@ Guage	**1200**	PSI		FFACC=0	ZeroSwitchDelay=.5
Hyd Oil Temp Warmed up	**120-140**	Degrees		TLM=10	
Air Pressure @ Guage	**80+**	PSI			
				Speeds	[AxisIPB]
Clamp up	20	PSI		ACC=200	**0IPB=.005**
Clamp Down	16	PSI		Dec=200	
Feed Clamp Up		PSI		Vel=1000	
Feed Clamp Down	18	PSI			**AMC Amp Pot Settings**
					Loop Gain = .6 ohms
					Current Limit = 16.3 K
					Gain = 0 ohms
					Offset = 21.9K