



**19801 M-205 (at 5 Points Jct.)  
EDWARDSBURG, MI 49112  
(269) 641-7998 FAX (269) 641-7793**

**AutoPunch 30006 Machine Specifications (12-28-04)**

**Machine Specifications**

Machine Serial Number	30006
VB Version	5.3
DII Version	3.0
MotherBoard (SOYO)	P41845PEISA
CPU Processor	P4-2.6 GHZ
Operating System	2000
TouchScreen Port	SERIAL
Servo Motor & Encoder Unit	MPM89BSG6JM1N
Motion Controller Card	ACR2000
Bios Pswd	Malachi
Network Card Type	Davicom 9102/A
Adminstrator Acct Password	12162
OEM User Acct Name	Operator
OEM User Acct Password	

**Electrical Power**

I/O Power Supply Voltage	24 Volts
Power Supply Current	4.6 Amps
Main AC Input Power	220 3 Phase
Total Current Draw	30 Amps

**Hydraulic Settings**

Hydraulic Pres @ Guage	1500
Hyd Oil Temp Warm	120-140

**Air Pressure Guage Settings**

<b>Main Air Pressure @ Guage</b>	<b>80 Minimum</b>
Clamp up	20
Clamp Down	16
Feed Clamp Up	20
Feed Clamp Down	16

**AMC Amp Pot. Settings**

Loop Gain (Pot 1)	0.6 OHMS
Current Limit (Pot 2)	16.3 K
Gain (Pot 3)	0 ohms
Offset (Pot 4)	21.9 K

**Amp 10 pos DipSwitch Setup**

Switch 1	OFF
Switch 2	ON
Switch 3	OFF
Switch 4	OFF
Switch 5	ON
Switch 6	OFF
Switch 7	OFF
Switch 8	ON
Switch 9	ON
Switch 10	ON

**Machine Parameters**

Axis Gains	Punch Parameters
PGAIN=0.13	ZeroOffset = 2.89
IGAIN=.65	ZeroSwitchDelay = 0
ILIMIT=.2	PositionTolerance = .005
IDELAY=0	PunchDownDelay = .01
DGAIN=0.0004	PunchUpDelay = 0
FFVEL=0	InpositionDelay =0
FFACC=0	
TLM=10	

**Axis Speeds**

ACC=300  
Dec=200  
Vel=1000

**Encoder PPU**

788.05

**In-Position Band**

0.005

**VB Program Timer Speed**

TimerInterval = 50

**Remarks**

1) Motor Connectors rewired to the Copley Cable Set Config. 2) VB code altered to allow pump to stay on when the Primary Clamp is up when not in cycle. VB Ver = 5.0.3