



19801 M-205 (at 5 Points Jct.)
 EDWARDSBURG, MI 49112
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AutoPunch 30007 Machine Specifications (1-08-07)

Machine Specifications

Machine Serial Number 30007
 VB Version 5.3
 DII Version 3.0
 MotherBoard (TECHNOLAND) MB800
 CPU Processor P4-2.6 GHZ
 Operating System 2000
 TouchScreen Port USB
 Servo Motor & Encoder Unit MPM89BSG6JM1N
 Motion Controller Card ACR2000
 Bios Pswd Malachi
 Network Card Type Davicom 9102/A
 Administrator 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 @ Gauge 1500
 Hyd Oil Temp Warm 120-140

Air Pressure Gauge Settings

Main Air Pressure @ Gauge 80 Minimum
 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

PGAIN=0.13
 IGAIN=.65
 ILIMIT=.2
 IDELAY=0
 DGAIN=0.0004
 FFVEL=0
 FFACC=0
 TLM=10

Punch Parameters

ZeroOffset = 2.975
 ZeroSwitchDelay = 0
 PositionTolerance = .005
 PunchDownDelay = .02
 PunchUpDelay = 0
 InpositionDelay = 0

Axis Speeds

ACC=400
 Dec=200
 Vel=1000

Encoder PPU (AXIS)

789.36

In-Position Band (IPB)

0.015

VB Program Timer Speed

TimerInterval = 50

Remarks

1) VB code altered to allow pump to stay on when the Primary Clamp is up when not in cycle. VB Ver = 5.0.3