



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

AutoPunch 30008 Machine Specifications (8-18-10) Sold to Kinro Inc.

Customer = Kinro Inc.

Machine Specifications	
Machine Serial Number	30008
VB Version	6.0.0
TouchScreen Model	LA1500RTR
MotherBoard	MB800
Gearhead ratio	10:1
Operating System	XPPRO
TouchScreen Port	USB
Servo Motor & Encoder Unit	MPL-A320P-HJ22A
Motion Controller (Network)	ACR9000
Servo Amp	2098-DSD-020 120/240V
Bios Pswd	NOT SET
Network Card Type	ONBOARD
Administratior Acct Password	0
Network Switch	NetGear 4 port

Electrical Power	
I/O Power Supply Voltage	24 Volts
Power Supply Current	7.2 Amps (Keyence)
Main AC Input Power	220 Sgl. PHASE
Total Current Draw	30 Amps

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

Air Pressure Guage Settings	
Main Air Pressure @ Gauge	80 psi Minimum
Clamp Down (Secondary)	8 psi
Feed Clamp Down (primary)	8 psi

Network IP's	
PC	192.168.72.22
Acr9000	192.168.72.23
GateWay	192.168.72.1

Machine Parameters

[JogSpeeds]	[MachineOptions]
JogVel=10	SocketIP=192.168.72.23
JogACC=1000	GateWay=192.168.72.1
JogDec=1000	SerialNo=30008
	TimerInterval=100

[AxisPPU]	[MachineOptions]
0PPU=3945	IdleTime=60
	dxBackColor=12566463
	disableTaskBar=False
	RequirePartNo=True

[SystemResolution]
0Resolution=0.0010

[AxisIPB] = inposition band	[MachineParameters]
0IPB=.005	MaxVel=40
	MaxAcc=600
	MaxDecel=400

[Backlash]	[MachineParameters]
BkI0=0.0	ZeroOffset=2.94
	PunchDownDelay=0.01
	PunchUpDelay=0.01

[Gains0]	[MachineParameters]
MULT=-4	InpositionDelay=0
DACGAIN=-3276.8	ZeroSwitchDelay=0
PGAIN=0.003	disableTaskBar=True
IGAIN=0.2	
ILIMIT=0.1	
IDELAY=0.01	
DGAIN=0.000001	

MOTOR CABLES	
Encoder cable	2090-XXNPMP-16S03
Motor Power Cable	2090-UXNFBMP-S03

ACR9000 Cables	
Encoder Cable	71-022344-04

Feeder Guides/Die Setup	
Feeder Guide's Height	7.062 +/- .002
Die Height	7.062 +/- .002
Die Block	3.5