

# Hydraulic Swing Arm Axis

<b>SerialNo</b>	DCB10-20001
<b>Notes</b>	<b>(Uses ini file) using these settings.</b>
<b>Description</b>	Swing Arm(Axis 2)
<b>KP</b>	60
<b>KI</b>	200
<b>KD</b>	60
<b>IL</b>	10
<b>ACCEL</b>	100
<b>VEL</b>	200000
<b>RESOLUTION</b>	4000
<b>Home Offset</b>	10
<b>Home Speed</b>	30000
<b>Home Rapid Rate</b>	60000
<b>Jog feed Rate</b>	40000
<b>SystemMultiplier</b>	0.01637554585
<b>BackLashComp</b>	0
<b>ClampReleaseDela</b>	500
<b>ClampFwdDelay</b>	700
<b>ClampoffDelay</b>	0
<b>Lubecounter</b>	0
<b>JogAcceleration</b>	30
<b>L1</b>	1212

<b>SerialNo</b>	DCB10-20002
<b>Notes</b>	
<b>Description</b>	Swing Arm(Axis 2)
<b>KP</b>	20
<b>KI</b>	30
<b>KD</b>	285
<b>IL</b>	150
<b>ACCEL</b>	600
<b>VEL</b>	1000000
<b>RESOLUTION</b>	4000
<b>Home Offset</b>	12.1
<b>Home Speed</b>	40000
<b>Home Rapid Rate</b>	20000
<b>Jog feed Rate</b>	40000
<b>SystemMultiplier</b>	0.0163940385
<b>BackLashComp</b>	0
<b>ClampReleaseDela</b>	500
<b>ClampFwdDelay</b>	500
<b>ClampoffDelay</b>	200
<b>Lubecounter</b>	100
<b>JogAcceleration</b>	30
<b>L1</b>	1663

<b>SerialNo</b>	DCB10-20003
<b>Notes</b>	
<b>Description</b>	Swing Arm(Axis 2)
<b>KP</b>	20
<b>KI</b>	30
<b>KD</b>	285
<b>IL</b>	150
<b>ACCEL</b>	600
<b>VEL</b>	1000000
<b>RESOLUTION</b>	4000
<b>Home Offset</b>	12.1
<b>Home Speed</b>	40000
<b>Home Rapid Rate</b>	20000
<b>Jog feed Rate</b>	40000
<b>SystemMultiplier</b>	0.0163940385
<b>BackLashComp</b>	0
<b>ClampReleaseDela</b>	500
<b>ClampFwdDelay</b>	500
<b>ClampoffDelay</b>	200
<b>Lubecounter</b>	100
<b>JogAcceleration</b>	30
<b>L1</b>	1663

<b>SerialNo</b>	DCB10-20004
<b>Notes</b>	
<b>Description</b>	Swing Arm(Axis 2)
<b>KP</b>	10
<b>KI</b>	40
<b>KD</b>	300
<b>IL</b>	55
<b>ACCEL</b>	300
<b>VEL</b>	1000000
<b>RESOLUTION</b>	4000
<b>Home Offset</b>	12.8
<b>Home Speed</b>	40000
<b>Home Rapid Rate</b>	20000
<b>Jog feed Rate</b>	40000
<b>SystemMultiplier</b>	0.0163940385
<b>BackLashComp</b>	0
<b>ClampReleaseDela</b>	500
<b>ClampFwdDelay</b>	500
<b>ClampoffDelay</b>	200
<b>Lubecounter</b>	100
<b>JogAcceleration</b>	30
<b>L1</b>	1067

<i>SerialNo</i>	DCB10-20005
<i>Notes</i>	<b>(Uses ini file) using these settings.</b>
<i>Description</i>	Swing Arm(Axis 2)
<i>KP</i>	20
<i>KI</i>	36
<i>KD</i>	285
<i>IL</i>	150
<i>ACCEL</i>	600
<i>VEL</i>	1000000
<i>RESOLUTION</i>	4000
<i>Home Offset</i>	16.2
<i>Home Speed</i>	40000
<i>Home Rapid Rate</i>	20000
<i>Jog feed Rate</i>	40000
<i>SystemMultiplier</i>	0.0163940385
<i>BackLashComp</i>	0
<i>ClampReleaseDela</i>	500
<i>ClampFwdDelay</i>	500
<i>ClampoffDelay</i>	200
<i>Lubecounter</i>	100
<i>JogAcceleration</i>	30
<i>L1</i>	1698

<b>SerialNo</b>	DCB10-20006
<b>Notes</b>	
<b>Description</b>	Swing Arm(Axis 2)
<b>KP</b>	20
<b>KI</b>	30
<b>KD</b>	285
<b>IL</b>	150
<b>ACCEL</b>	600
<b>VEL</b>	1000000
<b>RESOLUTION</b>	4000
<b>Home Offset</b>	12.1
<b>Home Speed</b>	40000
<b>Home Rapid Rate</b>	20000
<b>Jog feed Rate</b>	40000
<b>SystemMultiplier</b>	0.0163940385
<b>BackLashComp</b>	0
<b>ClampReleaseDela</b>	500
<b>ClampFwdDelay</b>	500
<b>ClampoffDelay</b>	200
<b>Lubecounter</b>	100
<b>JogAcceleration</b>	30
<b>L1</b>	1663

<b>SerialNo</b>	DCB10-20007
<b>Notes</b>	
<b>Description</b>	Swing Arm(Axis 2)
<b>KP</b>	18
<b>KI</b>	30
<b>KD</b>	280
<b>IL</b>	200
<b>ACCEL</b>	600
<b>VEL</b>	1000000
<b>RESOLUTION</b>	4000
<b>Home Offset</b>	12
<b>Home Speed</b>	35000
<b>Home Rapid Rate</b>	35000
<b>Jog feed Rate</b>	35000
<b>SystemMultiplier</b>	0.0163940385
<b>BackLashComp</b>	0
<b>ClampReleaseDela</b>	500
<b>ClampFwdDelay</b>	500
<b>ClampoffDelay</b>	350
<b>Lubecounter</b>	100
<b>JogAcceleration</b>	30
<b>L1</b>	1821

<i>SerialNo</i>	DCB10-20008
<i>Notes</i>	<b>(Uses ini file) using these settings.</b>
<i>Description</i>	Swing Arm(Axis 2)
<i>KP</i>	20
<i>KI</i>	36
<i>KD</i>	285
<i>IL</i>	150
<i>ACCEL</i>	600
<i>VEL</i>	1000000
<i>RESOLUTION</i>	4000
<i>Home Offset</i>	16.2
<i>Home Speed</i>	40000
<i>Home Rapid Rate</i>	20000
<i>Jog feed Rate</i>	40000
<i>SystemMultiplier</i>	0.0163940385
<i>BackLashComp</i>	0
<i>ClampReleaseDela</i>	500
<i>ClampFwdDelay</i>	500
<i>ClampoffDelay</i>	200
<i>Lubecounter</i>	100
<i>JogAcceleration</i>	30
<i>L1</i>	1291



<b>SerialNo</b>	DCB10-20009
<b>Notes</b>	
<b>Description</b>	Swing Arm(Axis 2)
<b>KP</b>	20
<b>KI</b>	36
<b>KD</b>	285
<b>IL</b>	150
<b>ACCEL</b>	600
<b>VEL</b>	1000000
<b>RESOLUTION</b>	4000
<b>Home Offset</b>	16.2
<b>Home Speed</b>	40000
<b>Home Rapid Rate</b>	20000
<b>Jog feed Rate</b>	40000
<b>SystemMultiplier</b>	0.0163940385
<b>BackLashComp</b>	0
<b>ClampReleaseDela</b>	500
<b>ClampFwdDelay</b>	500
<b>ClampoffDelay</b>	200
<b>Lubecounter</b>	100
<b>JogAcceleration</b>	30
<b>L1</b>	1865