

# DUKANE SERVO SPIN WELDER - SETUP SHEET

APPLICATION		MACHINE MODEL	SVT0__2R
DATE		MACHINE SETUP NUMBER	

## MANUAL SETTINGS

SETTING		VALUE
FLAG POSITIONS	HYDRAULIC SPEED CONTROL (MM)	
	MECHANICAL STOP (MM)	
	PRE-TRIGGER (MM)	
	END OF WELD (MM)	
AIR PRESSURE (PSI)		
HYDRAULIC SPEED CONTROL RESISTANCE		
FLOW CONTROL (# OF TURNS OPEN OR BAND COLOR)		
THRUSTER POSITION ON COLUMN (MM)		

## TOUCH SCREEN SETTINGS

SETTING		VALUE		
SETUP -> TRIGGER	RPM	CW   CCW		
	DIR.			
	SPIN DELAY (SEC)			
	TIMEOUT (SEC)			
	PART PICKUP	PICKUP TIME (S)	ON   OFF	
	PRE-SPIN ORIENT	PRE-SPIN	ON   OFF	
	TORQUE	TORQUE (% OF MAX.)	TIMEOUT (SEC.)	ON   OFF
SETUP -> WELD	METHOD (TIME, ROTATION, OR END SWITCH)		TIME   ROT.   END SW.	
	WELD TIME (SEC.) / WELD ROTATIONS / END SWITCH TIMEOUT (SEC.)			
	TOOL INERT. (KG*CM^2)			
	DECEL. (REV/S^2)			
	ORIENTATION...	WELD	ON   OFF	
SETUP -> POST-WELD	HOLD TIME (SEC.)			
	PART TEST FAILURE		SUSPECT   BAD	
	LATCH		ON   OFF	
	PROCESS LIMITS...	WELD TIME (SEC.)	LOWER LIMIT	UPPER LIMIT
		WELD ROTATIONS		
		ORIENTATION (DEG.)		
		WELD ENERGY (J)		
		PEAK RPM		
		PEAK TORQUE (% OF MAX.)		
		DOWNSTROKE TIME (SEC.)		
CYCLE TIME (SEC.)				
TOOLS -> SYSTEM SETUP	HOME OFFSET (DEG.)			