

DUKANE DUAL SERVO SPIN WELDER - SETUP SHEET

APPLICATION		MACHINE MODEL	SVT0__2VR
DATE		MACHINE SETUP NUMBER	

TOUCH SCREEN SETTING				VALUE				
SETUP > PRE- WELD	TOOL SETUP	INERTIA (KG*CM^2)						
		WEIGHT (KG)						
		SPIN DECEL. (%)						
		VAC. SENSE		ON OFF				
		PART PRESENT		ON OFF				
	TOP OF STROKE POSITION		POSITION (MM)					
	TRIGGER POSITION		POSITION (MM)					
	OPTIONS	PART PICKUP	ENABLE	POSITION (MM)	ON OFF			
			THRUST SENSE	THRUST (%)	TIMEOUT (S)	ON OFF		
PRE-SPIN ORIENT		PRE-SPIN		ON OFF				

SETUP > WELD	METHOD (TIME, ROTATION, DISTANCE, ENERGY)			TIME ROT DIST ENERGY				
	WELD PARAMETERS	WELD TIME (S) / WELD ROTATIONS / VERTICAL (MM) / ENERGY (J)						
		COLLAPSE / ABSOLUTE (DISTANCE METHOD ONLY)			COLLAPSE ABSOLUTE			
		VERT. SPEED (MM/S)						
		SPIN RPM						
		DIR.			CW CCW			
	OPTIONS	ORIENTATION	WELD		ON OFF			
		TORQUE TRIGGER	TORQUE (% OF MAX.)	TIMEOUT (S)	ON OFF			
CONSTANT TORQUE		TORQUE (% OF MAX.)	TIMEOUT (S)	ON OFF				

SETUP > POST- WELD	HOLD SETUP	MODE (POSITION, TIME)		POSITION TIME				
		SPEED (MM/S)						
		MOVE TIME (S) / COLLAPSE (MM)						
		DWELL TIME (S)						
		CONSTANT THRUST	THRUST (%)	ON OFF				
	PROCESS LIMITS...	WELD TIME (S)	LOWER LIMIT	UPPER LIMIT				
		WELD ROTATIONS						
		ORIENTATION (DEG.)						
		WELD ENERGY (J)						
		PEAK RPM						
		PEAK TORQUE (% OF MAX.)						
		PEAK THRUST (% OF MAX.)						
		CYCLE TIME (S)						
		VERTICAL WELD END (MM)						
		HOLD COLLAPSE (MM)						
	HOLD END POSITION (MM)							
LATCH ON FAILURE			ON OFF					
FAILURE SWITCH (SUSPECT / BAD)			SUSPECT BAD					

TOOLS > SYSTEM SETUP	VERTICAL TRAVEL LOWER LIMIT	LIMIT POS. (MM)	
	HOME OFFSET (DEG.)		

MANUAL SETTING	VALUE
THRUSTER POSITION ON COLUMN (MM)	