

Machine Data Sheet



Company: Lexmark International Order No.: _____
Project Name: _____ Customer P.O. No.: _____
Main Contact: Jon Whitney
Phone: 606-232-2567
Fax: 606-232-3900
Shipping Address: 740 New Circle Rd. N.W.
Lexington, KY 40550

☒ Existing Customer ☐ New Customer

MACHINE: HS DIALOG d.c. 5000 SERIAL # SM6712/04 ENCODER: Novotechnik

CYL. DIA. STROKE

☐ 16

☐ 25

☐ 32

☐ 50

☐ 50

☐ 75

☒ 63

☒ 100

Controller: DIALOG TOUCH 12" SERIAL No. 01064752 Software Version: V6.28
Revision No.: _____

Generator: DYNAMIC d.c. 5000 SERIAL No. 8007/04 Software Version: V2.307
Revision No.: _____

Converter: _____ Serial No.: _____ Revision No.: _____

Converter: _____ Serial No.: _____ Revision No.: _____

Booster: _____ Serial No.: _____ Revision No.: _____

Booster: _____ Serial No.: _____ Revision No.: _____

Weld horn: _____ Serial No.: _____

Additional information

Machine Parameters



DIALOG touch
Date: 10/22/2004

Version: V6.28
Time: 6:57:09 PM

Tel.: 847-985-7344
Fax: 847-985-1470

Application: LEXMARK

Memory: 1

General

Linear Encoder Range	25	mm	Monitoring Time	9.999	s
Machine Type	HS 63/20		Piston Rod Diameter	20	mm
Cylinder Diameter	63	mm	Cylinder Offset	1.6	

Setup

Start Signal	Two-Hand	Return Stroke Pressure	45.0	psi	
Home Position Pressure	45.0	psi	Supply Pressure	101.5	psi
External Trigger Release	no				

Sonic Pulse

Pre Trigger	no	After Burst	no
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Auxiliary Equipment

Auxiliary Equipment 1	None	Auxiliary Equipment 2	None	s
External Memory Selection	inactive	Monitoring Time DIALOG touch	9.999	

Weldhorn position after malfunction:

Weld Process Error Move to HP

Machine Error Move to HP

Linear Encoder Calibration Certificate



Tel.: 847-985-7344

Fax: 847-985-1470

Machine Type: HS 63/20

Date: 10/22/2004

Generator Serial No.: 8007

Calibrated by: F. SANTILLANA

Generator Type: 5000

Machine Serial No:

Linear Encoder Range: 25.00 mm

Depth Adjustment Factor: 0.516529

Gauge Block Size: 10.00 mm

Ext. Position (w/o Gauge Block): 24.00 mm

Ext. Position (with Gauge Block): 14.00 mm

Height Difference: 10.00 mm

Deviation (Actual - Nominal): 0.00 mm

Signature

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Force Calibration Certificate



Tel.: 847-985-7344

Fax: 847-985-1470

Machine Type: HS 63/20

Date: 10/22/2004

Generator Serial No.: 8007

Calibrated by: F. SANTILLANA

Generator Type: 5000

Machine Serial No:

Cylinder Diameter:	63 mm	Counterbalance:	yes
Piston Rod Diameter:	20 mm	Cylinder Offset:	1.6
Weld Horn Weight:	1.10 lb	Force Factor:	0.0654737
Moving Mass Weight w/o Horn:	21.71 lb	Force Offset:	0.0000010
Mounting Position:	vertical down		

Nominal [lbf]	$\pm 5\%$ Tolerance Range [lbf]		Actual [lbf]
25.0	23.75	- 26.25	25.40
50.0	47.50	- 52.50	50.00
75.0	71.25	- 78.75	75.00
112.0	106.40	- 117.60	112.20
113.0	107.35	- 118.65	112.00
150.0	142.50	- 157.50	150.40
220.0	209.00	- 231.00	222.40

Signature

.....

Downspeed Calibration Certificate



Tel.: 847-985-7344

Fax: 847-985-1470

Machine Type: HS 63/20

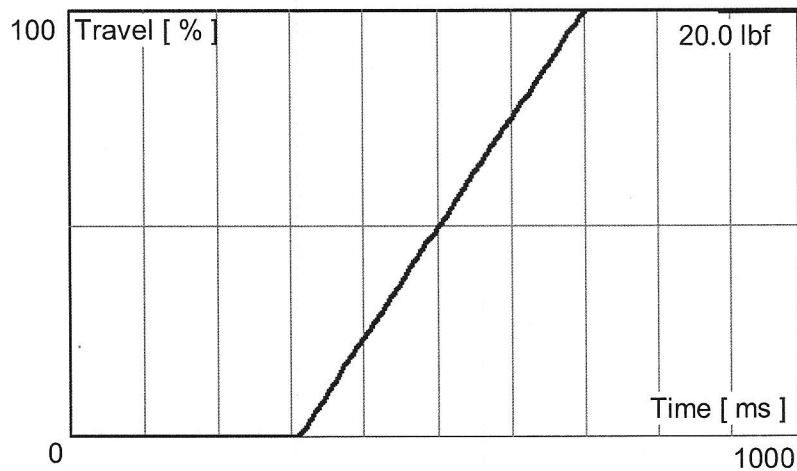
Date: 10/22/2004

Generator Serial No.: 8007

Calibrated by: F. SANTILLANA

Generator Type: 5000

Machine Serial No:



Signature

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Downspeed Calibration Certificate



Tel.: 847-985-7344

Fax: 847-985-1470

Machine Type: HS 63/20

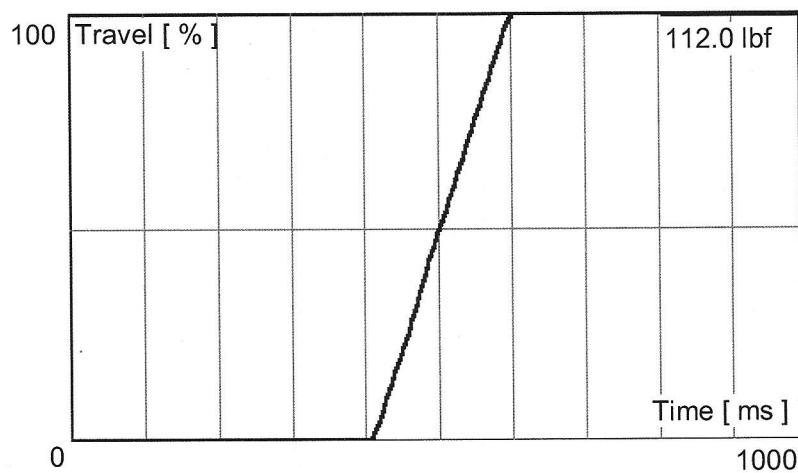
Date: 10/22/2004

Generator Serial No.: 8007

Calibrated by: F. SANTILLANA

Generator Type: 5000

Machine Serial No:



Signature

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Downspeed Calibration Certificate



Tel.: 847-985-7344

Fax: 847-985-1470

Machine Type: HS 63/20

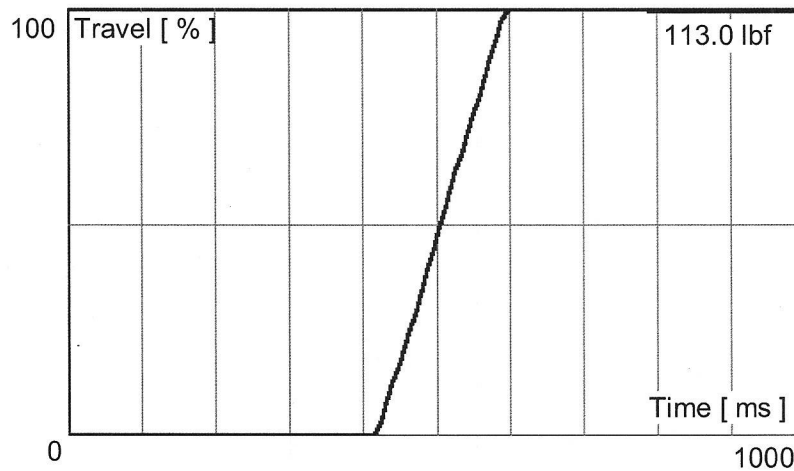
Date: 10/22/2004

Generator Serial No.: 8007

Calibrated by: F. SANTILLANA

Generator Type: 5000

Machine Serial No:



Signature

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Downspeed Calibration Certificate



Tel.: 847-985-7344

Fax: 847-985-1470

Machine Type: HS 63/20

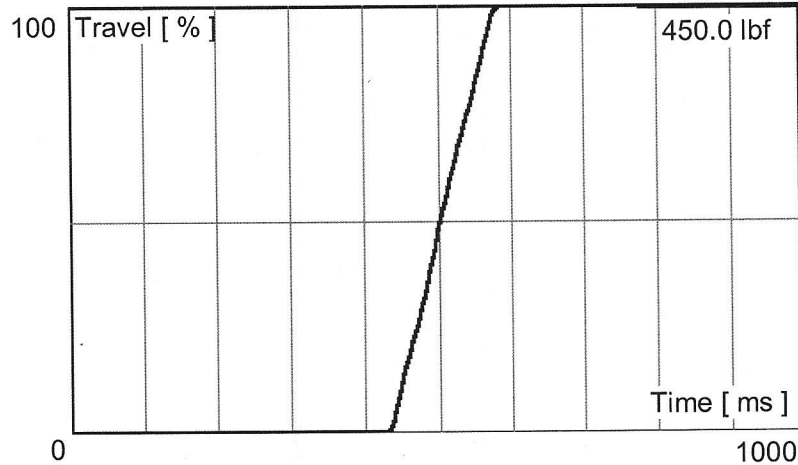
Date: 10/22/2004

Generator Serial No.: 8007

Calibrated by: F. SANTILLANA

Generator Type: 5000

Machine Serial No:



Signature

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Certificate of Calibration

Lexmark International
740 New Circle Rd. N.W.
Lexington, KY 40550

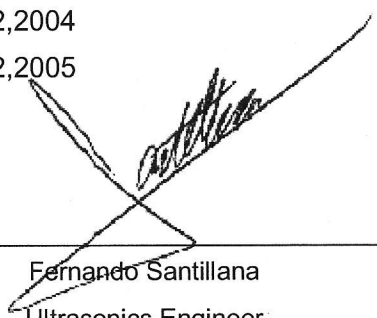
This is to certify that the equipment manufactured by Herrmann Ultrasonics is calibrated to meet all specifications of Herrmann Ultrasonics, Inc.

The procedures used were developed in order to optimize both the operational characteristics and operational life of each piece of equipment manufactured by Herrmann Ultrasonics, Inc.

Machine Type: HS DIALOG d.c. 5000
Serial Number: SM6712/04
Calibration date: October 22, 2004
Next Calibration Due: October 22, 2005

October 27, 2004

Date



Fernando Santillana
Ultrasonics Engineer

Herrmann Ultrasonics Inc.
620 Estes Ave, Schaumburg, IL. 60193
Phone (847)985-7344 Fax (847)985-1470

