

## Gen IV Controller ToolsNet Instructions

From the main menu, select Controller.

A Division of AIMCO		
Run	PSet	
JOB	RESULTS	
Controller	TOOL	
Accessories	DIAGNOSTICS	
LOGIN	Advanced	

## Select Protocols.

Controller Configuration Menu	
Tool Setup	IO
Communication Interfaces	Protocols
Front Panel Buttons	Power Up
BarCode Setup	Set Time
Remote Connections	Master Spindle Setup
Languages	

## Then select ToolsNet.

Protocols Menu	
Open Protocol	PFCS
TOOLSNET	Telnet
XML	FTP CLIENT

- Server IP Address: The IP address of the Tools Net server. If the server is on another subnet, verification of the gateway in the Ethernet settings is required.
- Server Port Number: The TCP port the server is listening on for a new connection. Default for this is 6547, however, should be verified with the local Tools Net server administrator.



- Station ID: Used to identify data in ToolsNet database. Work with local ToolsNet server administrator to set this correctly.
- System Number: Used to identify data in ToolsNet database. Work with local ToolsNet server administrator to set this correctly.
- Station Number: Used to identify data in ToolsNet database. Work with local ToolsNet server administrator to set this correctly.
- Set Time From Server: ToolsNet includes the current date and time in the messages it sends to the controller. When "Set Time From Server" is enabled the controller will set its clock to match the time sent by ToolsNet. When it is disabled the time sent by ToolsNet is ignored and the controller clock is left unaltered.
- **Curve Option:** The controller has the option to send fastening curve data (torque and angle) to the ToolsNet server. The following options are available:
  - **None:** No curves will be sent to ToolsNet.
  - All: All fastening will send curves to ToolsNet.
    OK: Only OK fastening will send curves to
  - **OK:** Only OK fastening will send curves to ToolsNet.
  - NOK: Only rejected fastenings curves will be sent to ToolsNet.



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