IQi Basic Programming

- Log in to the controller (Default credentials admin/ingersoll).
- To create a Pset click on the P icon and select the Add Pset button.

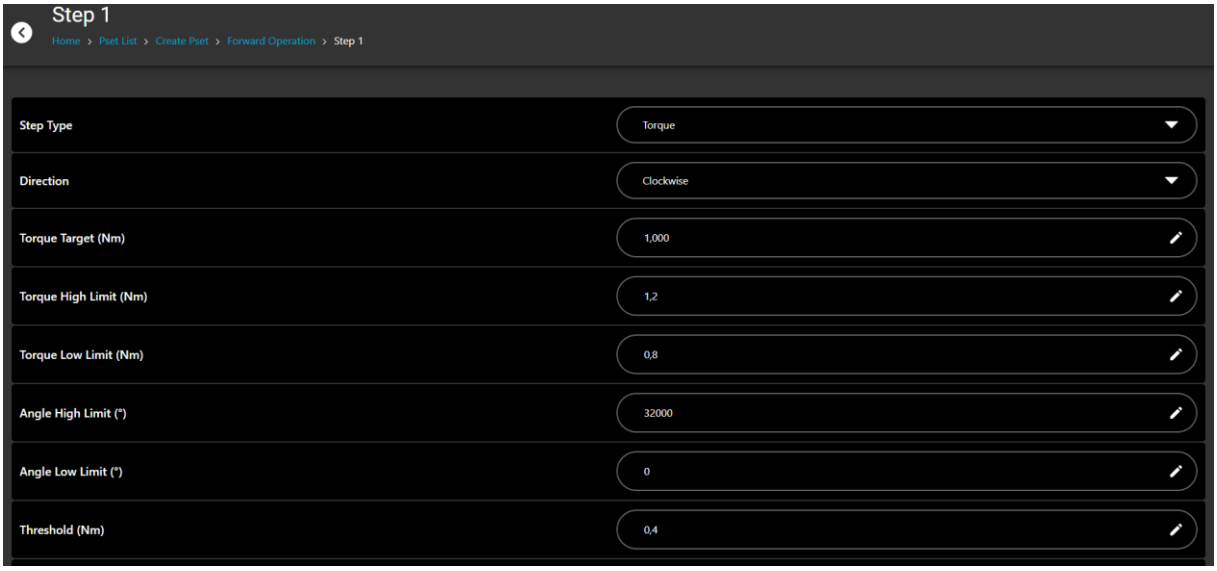
- Name your Pset and go to the Forward Operation submenu.

- The next page is to manage the steps for the Pset. You can have a maximum of 8 steps per Pset. Steps are physical operations that the tool will automatically sequence through with one trigger press.

- Using the different icons you can perform the following functions:
  - Add a step.
  - Delete a step.
  - Duplicate an existing step.
  - Edit the step.
  - Or change the step order.

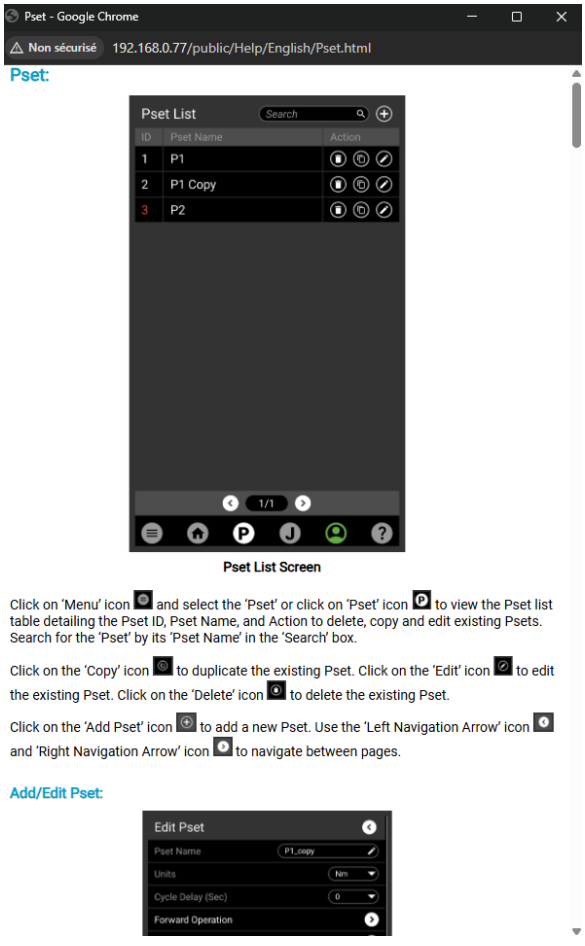
- Press on the pen icon to edit the Step parameters.

- For a quick setup just select your strategy, enter the Target value, and save it. The rest of the parameters populate with default values based on your Target.



Notes:

- There is more than one page of parameters, press the down arrow on your keyboard to access the rest of the parameters.
- At any moment, if you have a doubt on the meaning of a given parameter, you can select the ? icon on the left side. An online Help Menu will open to give you definitions.



Pset List Screen

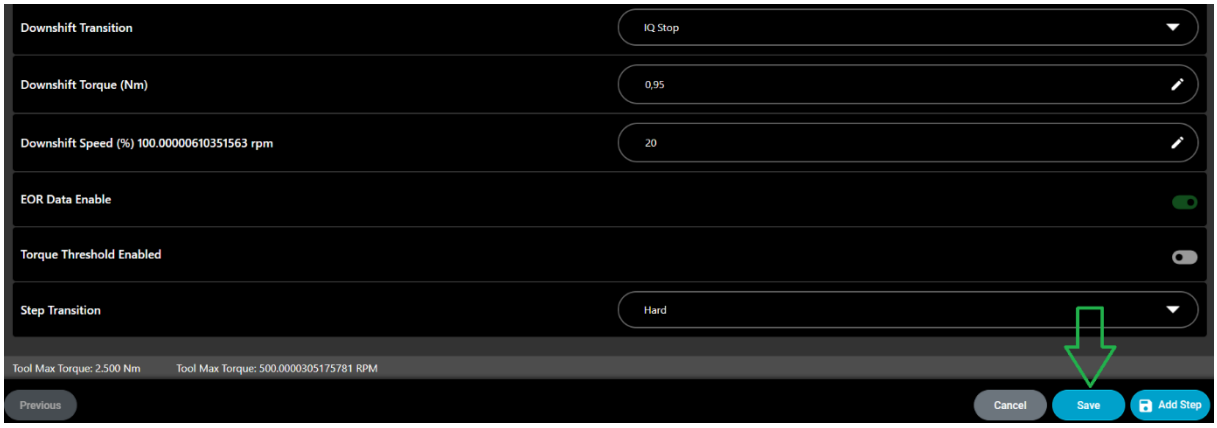
Click on 'Menu' icon and select the 'Pset' or click on 'Pset' icon to view the Pset list table detailing the Pset ID, Pset Name, and Action to delete, copy and edit existing Psets. Search for the 'Pset' by its 'Pset Name' in the 'Search' box.

Click on the 'Copy' icon to duplicate the existing Pset. Click on the 'Edit' icon to edit the existing Pset. Click on the 'Delete' icon to delete the existing Pset.

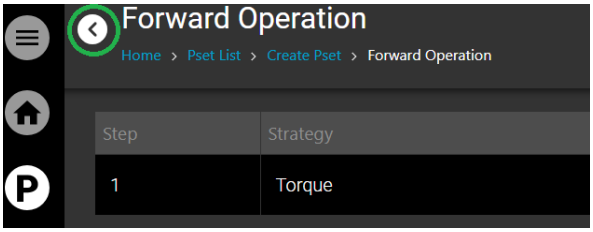
Click on the 'Add Pset' icon to add a new Pset. Use the 'Left Navigation Arrow' icon and 'Right Navigation Arrow' icon to navigate between pages.

Add/Edit Pset:

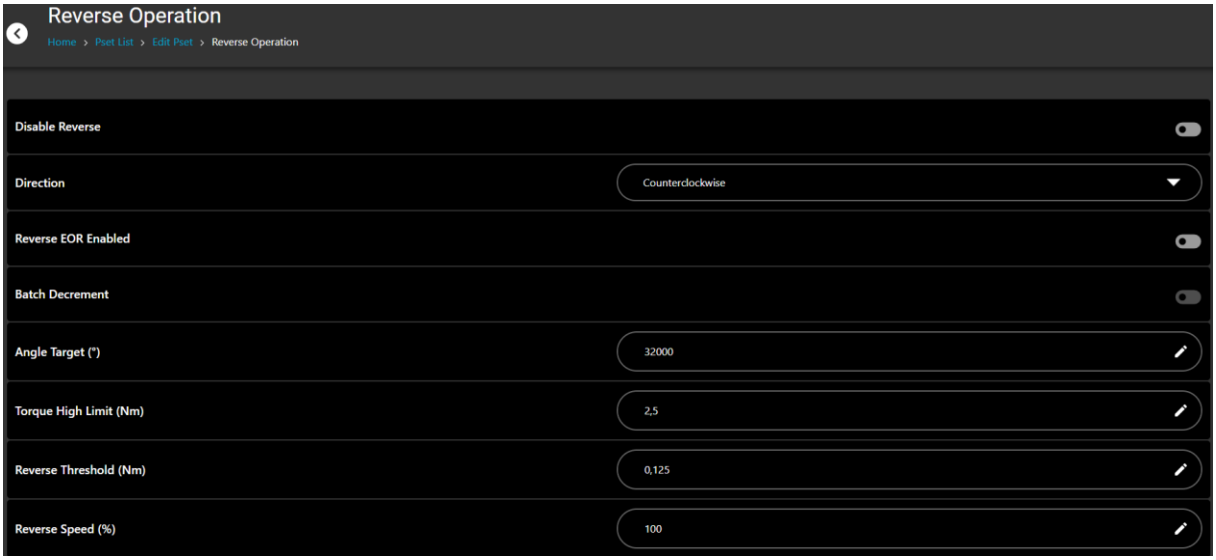
- IQ Stop is a new feature for Ingersoll Rand tightening tools.
  - IQ Stop transforms the fastening operation by delivering faster, more efficient, and precise tightening. It ensures a seamless transition from rundown speed to final tightening speed, without stopping, and maximizing output while maintaining quality.
- Once your setup is finished, click the Save button to save your settings.



- If you do not want to modify the step architecture, select the back icon to go back to the general Pset menu.

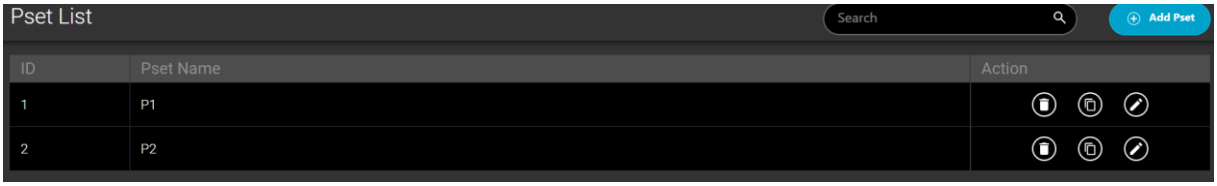


- Select the Reverse Operation tab to modify the Reverse Step parameters.
- The Reverse Operation contains all the parameters that will be used when the reverse trigger is pulled. By default, the parameters are max tool speed, max tool torque, max angle (32000 degrees). These parameters can be customized on this screen.



- Select the Advanced Settings tab to modify any Advanced Setting.
  - The advanced Pset settings contains all the parameters that are global to the Pset and not individual steps.

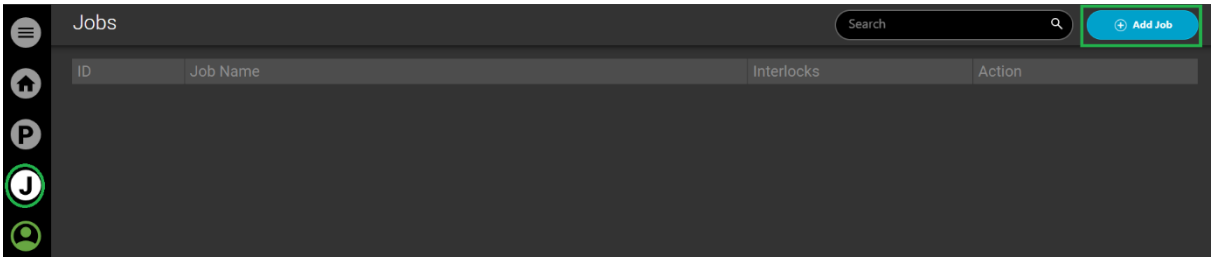
  - New parameter highlights:
    i. Tilt angle: Can be used to ensure the tool is aligned with the joint to avoid misalignment or thread damage. 0 is for vertical position, output of the tool facing down. 90 would be horizontal.
    ii. Hold torque: (only available for torque strategy), this will hold the torque for some time at the end of the cycle. It may help to reduce the joint relaxation on specific joints.
- Once you save your Pset, it will be added to the Pset list:



- You can either delete, copy or edit the Psets from that list, or add a new one.

Job management

- In order to run the tool, you will have to create at least one job. Click on the J icon to enter the job menu, then add a new job.

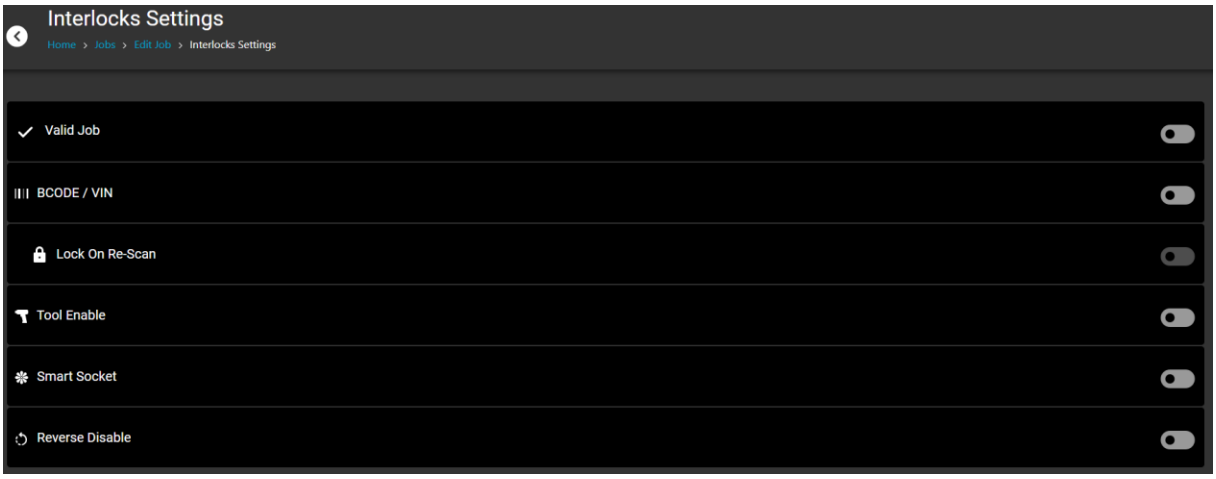


- Modify the Job name and job ID if required, then add a Pset to the job.

- Select at least one Pset to add to the job. If several Psets are selected, they will be automatically sequenced in the order they were selected.

- Click the back arrow when done.
- You may want to edit the Pset properties in that job to specify a bolt count or Socket Assignment, for example. Select the pen icon.

- Select the back arrow.
- Select Interlocks to see the various interlock options.



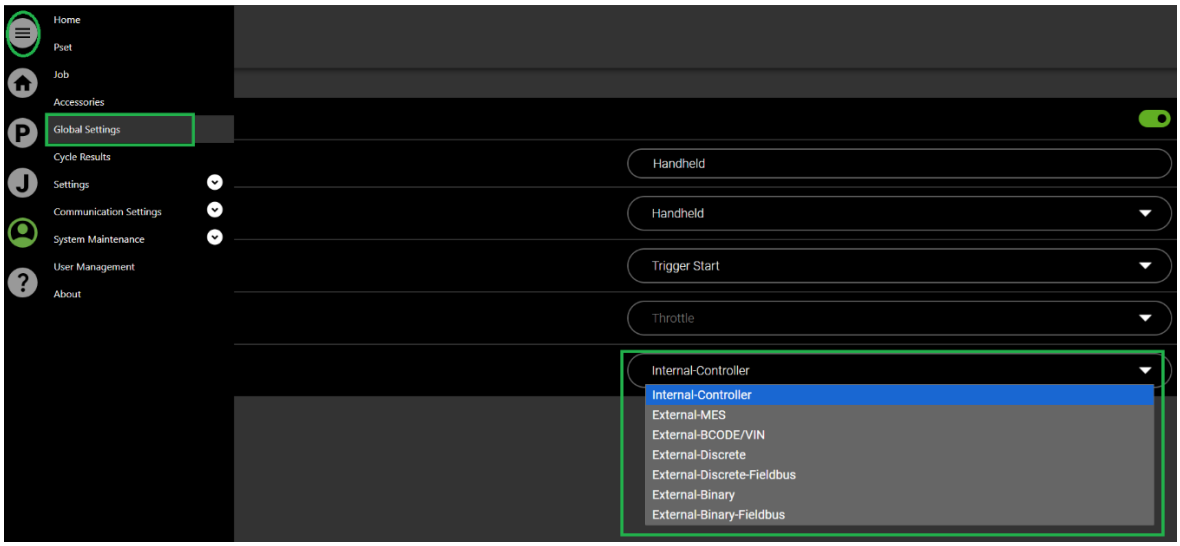
1. Valid job will automatically unselect the job at the end of the batch count or sequence.
2. Barcode / Vin will require a scan in order to run the tool.
3. Tool enable will require an enable signal to run the tool.
4. Smart socket is to be used with socket or bit trays.
5. Reverse disable will disable the tool when the switch is moved to the reverse position.

- Once you save your job, it will be added to the Job list:

- You can either delete, copy or edit the Jobs from that list, or add a new one.

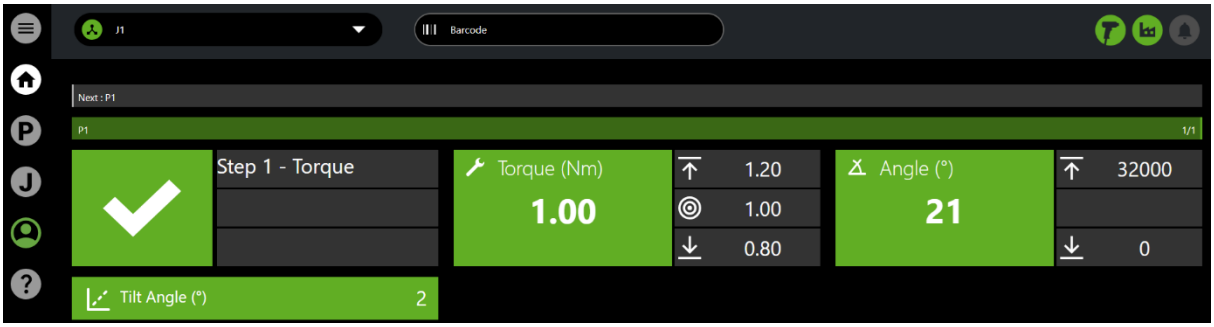
<u>Job selection</u>

- By default, the Job Selection Mode is set to Internal Controller, this allows for Job Selection from the Home screen on the controller or remote web browser. Go to the global settings to change the selection mode if required.



Run the tool.

- If a job is selected, you should be able to run the tool, and results will show on the Home screen.



- The tool may not run for two main reasons:
  - If an interlock is active, it indicates you are missing at least one condition to run the tool. In this case the interlock icon will be red.

  - If you set up a tilt angle window and are outside of the specified High and Low Limits the status will change to orange, and the tool will not run. Note: if you go outside of the limits during a cycle, the tool will stop.