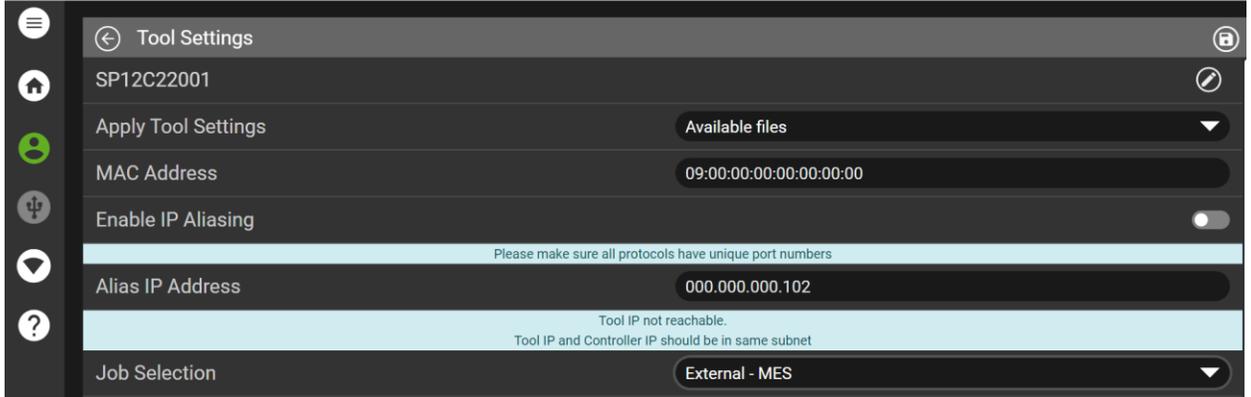
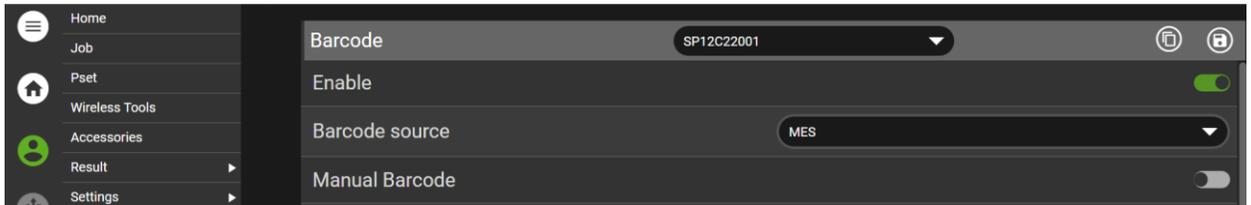


Instructions for Setting Up an MTC Controller at Toyota

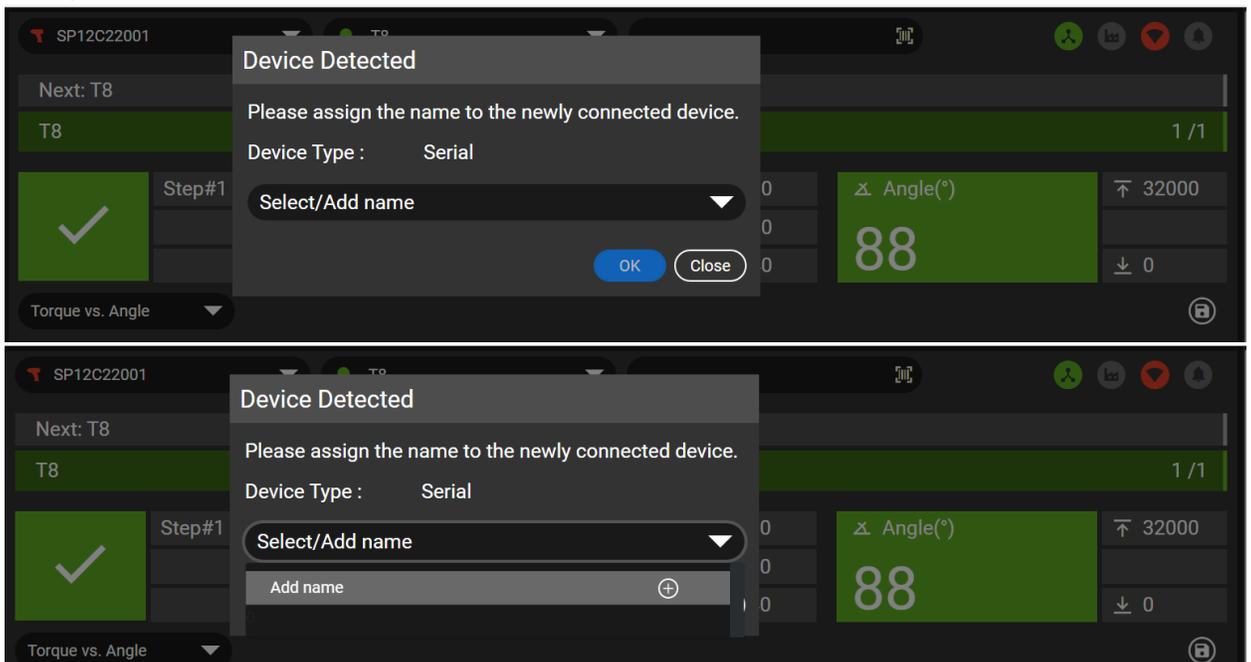
- 1) Update controller to latest version (100.1.2.25 or later)
- 2) Update tool(s) to compatible version
- 3) Program required Psets and Jobs
- 4) Set the tool(s) to use External MES for job selection

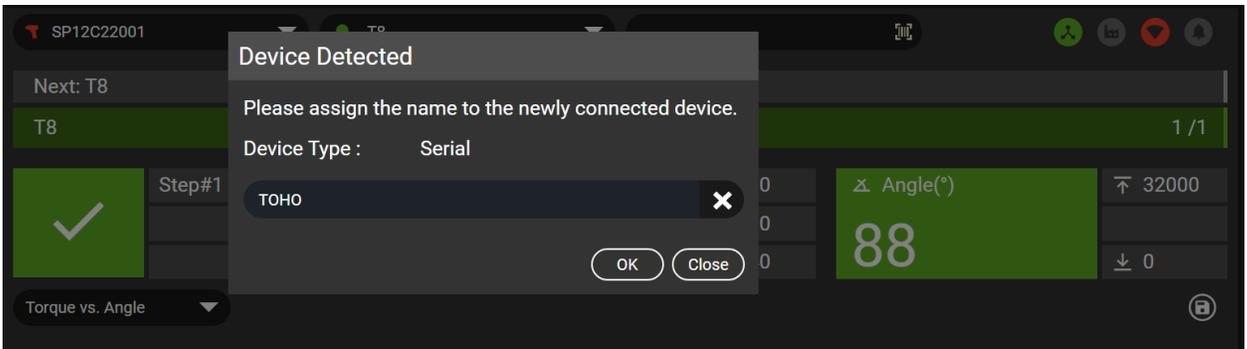


- 5) Enable barcode settings for the tool(s) and set the source as MES

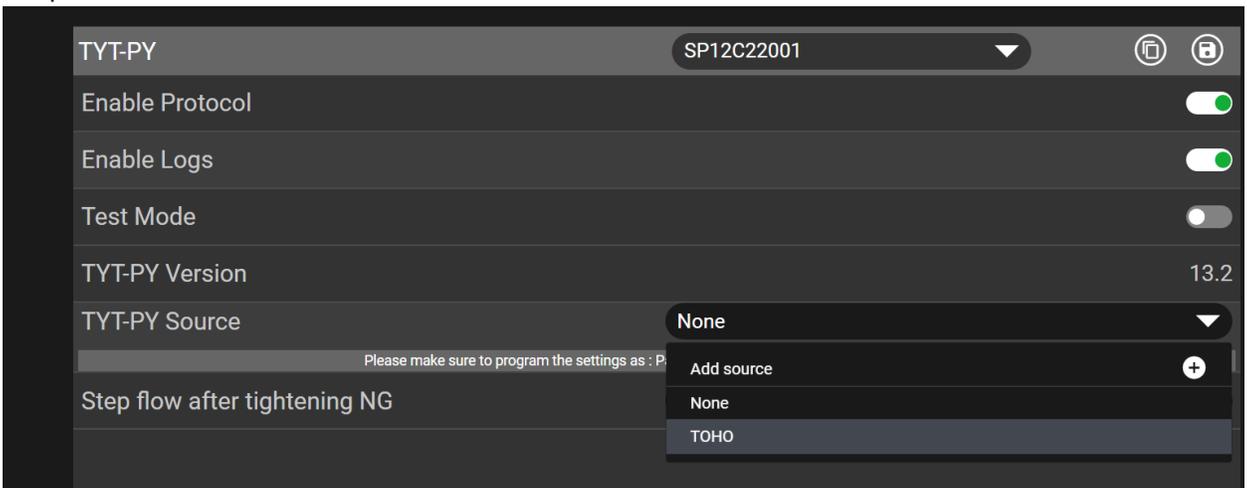


- 6) Plug in the serial to USB adapter and assign a name to it when the popup comes up – TOHO for example

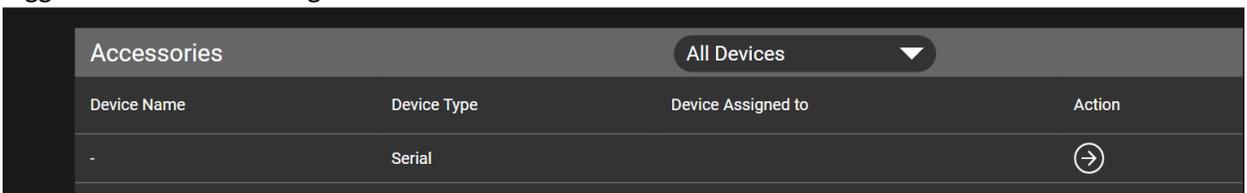




- 7) Enable the TYT-PY protocol and select the serial to USB adapter above as the source. The step flow after tightening can vary from plant to plant and should be set according to the needs of the plant at that station.



- 8) If the pop-up did not show or the supervisor/admin was not logged in at the time the serial to USB converter was plugged in, the name can be assigned from the accessories screen once logged in. All other settings can remain as default.



←		🔒
Device Type	Serial	
Device Name	Select/Add name ▼	
Baud Rate	9600 ▼	
Parity	None ▼	
Stop Bits	1 ▼	
Data Bits	8 ▼	
Device Assigned to		

← TOH01		🔒
Device Type	Serial	
Device Name	TOH01 ✕	
Baud Rate	9600 ▼	
Parity	None ▼	
Stop Bits	1 ▼	
Data Bits	8 ▼	
Device Assigned to		

- 9) In the case that the controller is taken offline for a time and then put back on, the serial to USB adapter may need to have its name assigned so that the TYT-PK protocol can communicate. This can be done at the accessories screen or the pop-up if it show.

←		🔒
Device Type	Serial	
Device Name	Select/Add name ▼	
Baud Rate	Add name +	
Parity	None ▼	
Stop Bits	1 ▼	
Data Bits	8 ▼	
Device Assigned to		

TOHO	
Device Type	Serial
Device Name	TOHO
Baud Rate	9600
Parity	None
Stop Bits	1
Data Bits	8
Device Assigned to	

NOTE: It is important that the name of the serial to USB adapter match exactly the name shown on the TYT-PY screen if the controller is put back on the line after some time and the adapter needs to be renamed or the name reassigned for the adapter.

NOTE: Some Toyota plants are using ToolsNet for data collection for quality. When enabling ToolsNet, make sure to clear the cycle log before enabling ToolsNet. When ToolsNet connects it sends the last record it received which is usually 0 for a new controller. The controller will then send all results it has accumulated to date which is not usually what the customer needs at that moment. There is a button to delete the old results from the cycle results screen.