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

	← Tool Settings			8
0	SP12C22001			\bigotimes
	Apply Tool Settings		Available files	
0	MAC Address		09:00:00:00:00:00:00	
Ŧ	Enable IP Aliasing			•
		Please make sure all protocol	s have unique port numbers	
	Alias IP Address		000.000.000.102	
?		Tool IP not r	eachable.	
	Job Selection		External - MES	

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

	Home					
	Job	Barcode	SP12C22001		6	•
$\mathbf{\Omega}$	Pset	Enable				
	Wireless Tools					
•	Accessories	Barcode source		MES		<u> </u>
	Result 🕨 🕨	Manual Baroodo				
	Settings >					

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

T SP12C22001	Device Detected	20	8 🛛 🛇 🗘
Next: T8 T8	Please assign the name to the newly connected device. Device Type : Serial		1 /1
Step#1	Select/Add name	0 X Angle(0 88	°)
Torque vs. Angle 🛛 🔻			
SP12C22001	Device Detected	90	8 🖻 오 \tag
 SP12C22001 Next: T8 T8 	Device Detected Please assign the name to the newly connected device. Device Type : Serial	36	
 SP12C22001 Next: T8 T8 Step#1 	Device Detected Please assign the name to the newly connected device. Device Type : Serial Select/Add name Add name	0 <u>×</u> Angle(0 88	 2 (a) 2 (b) 2 (c) 3 (c) 4 (c)

T SP12C22001	Device Detected		<u>ju</u>	8 🖬 🛇 🔕
Next: T8 T8	Please assign the name to the newly connected device.			1 /1
Step#1	тоно	0		↑ 32000
		0	88	<u>↓</u> 0
Torque vs. Angle				8

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.

		·		
ТҮТ-РҮ	SP12C22001		Ō	•
Enable Protocol				
Enable Logs				
Test Mode				
TYT-PY Version				13.2
TYT-PY Source	None			
Please make sure to program the settings as : P	Add source			÷
Step flow after tightening NG	None			
	тоно			

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.

Accessories		All Devices	
Device Name	Device Туре	Device Assigned to	Action
	Serial		\ni

\odot	(8
Device Type	Serial	
Device Name	Select/Add name	
Baud Rate	9600	
Parity	None	
Stop Bits	(1	
Data Bits	(8	
Device Assigned to		
🕞 ТОНО1		Ð
TOH01	(Serial	
TOHO1 Device Type Device Name	Serial	×
TOH01Device TypeDevice NameBaud Rate	Serial TOHO1 9600	a X
TOHO1Device TypeDevice NameBaud RateParity	Serial TOHO1 9600 None	• •
TOHO1Device TypeDevice NameBaud RateParityStop Bits	Serial TOHO1 9600 None 1	
TOHO1Device TypeDevice NameBaud RateParityStop BitsData Bits	Serial TOHO1 9600 None 1 8	
TOHO1Device TypeDevice NameBaud RateParityStop BitsData BitsDevice Assigned to	Serial TOHO1 9600 None 1 8	

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.

			<u> </u>
$\overline{\bigcirc}$			•
Device Type	Serial		
Device Name	Select/Add name		
Baud Rate	Add name	ŧ	
Parity	None		
Stop Bits	1		
Data Bits	8		
Device Assigned to			

тоно		•
Device Type	Serial	
Device Name	тоно	×
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.