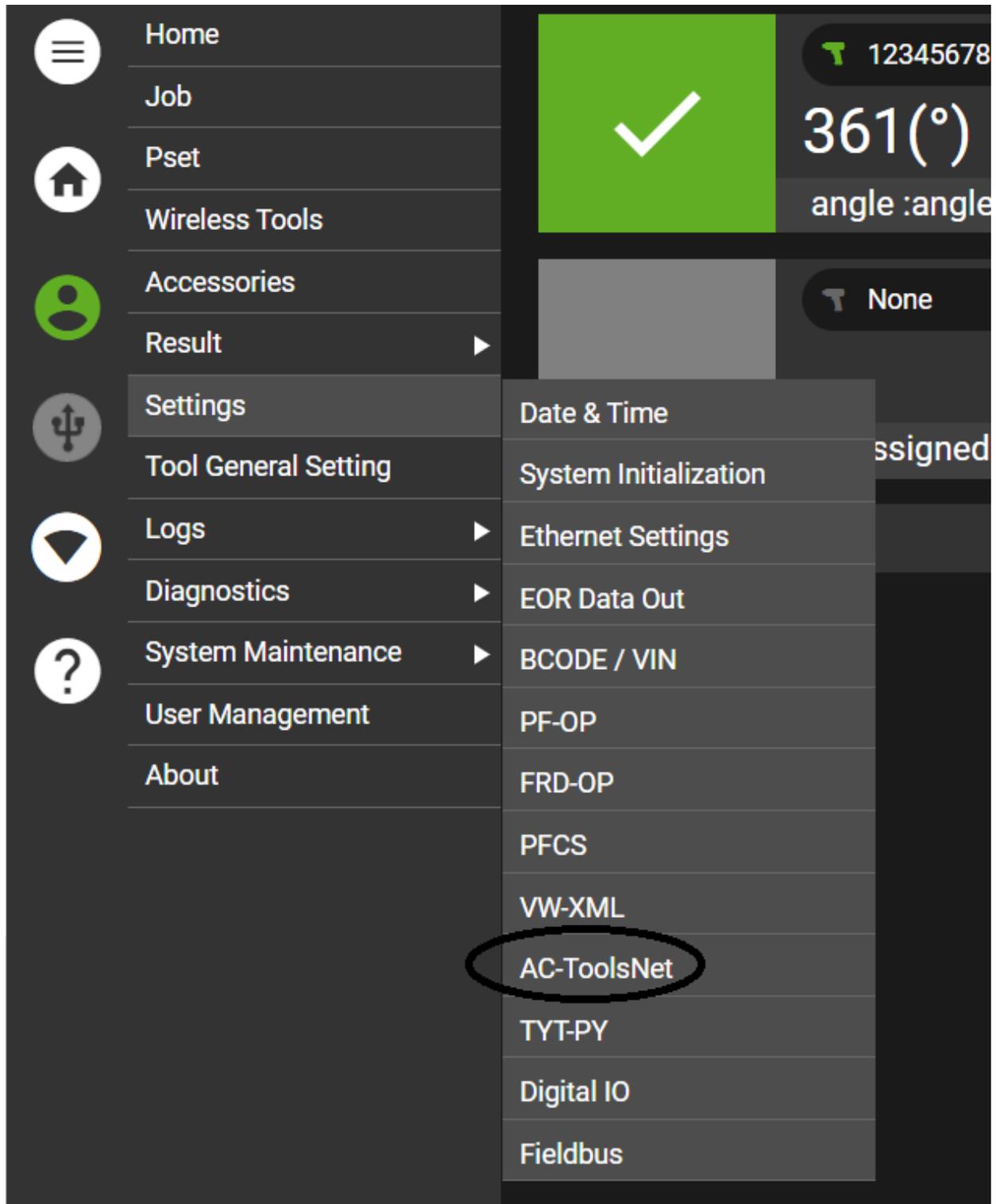
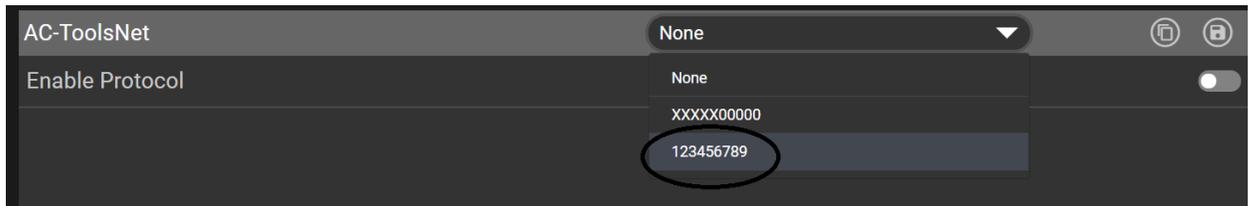


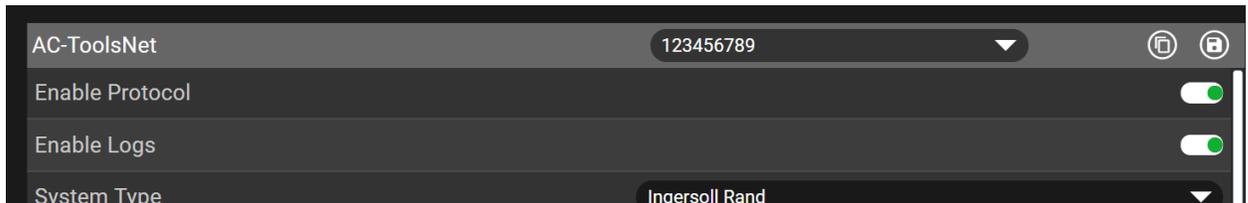
1. Clear the cycle log on the controller prior to enabling ToolsNet.
2. From the Main Menu go to Settings->AC Toolsnet.



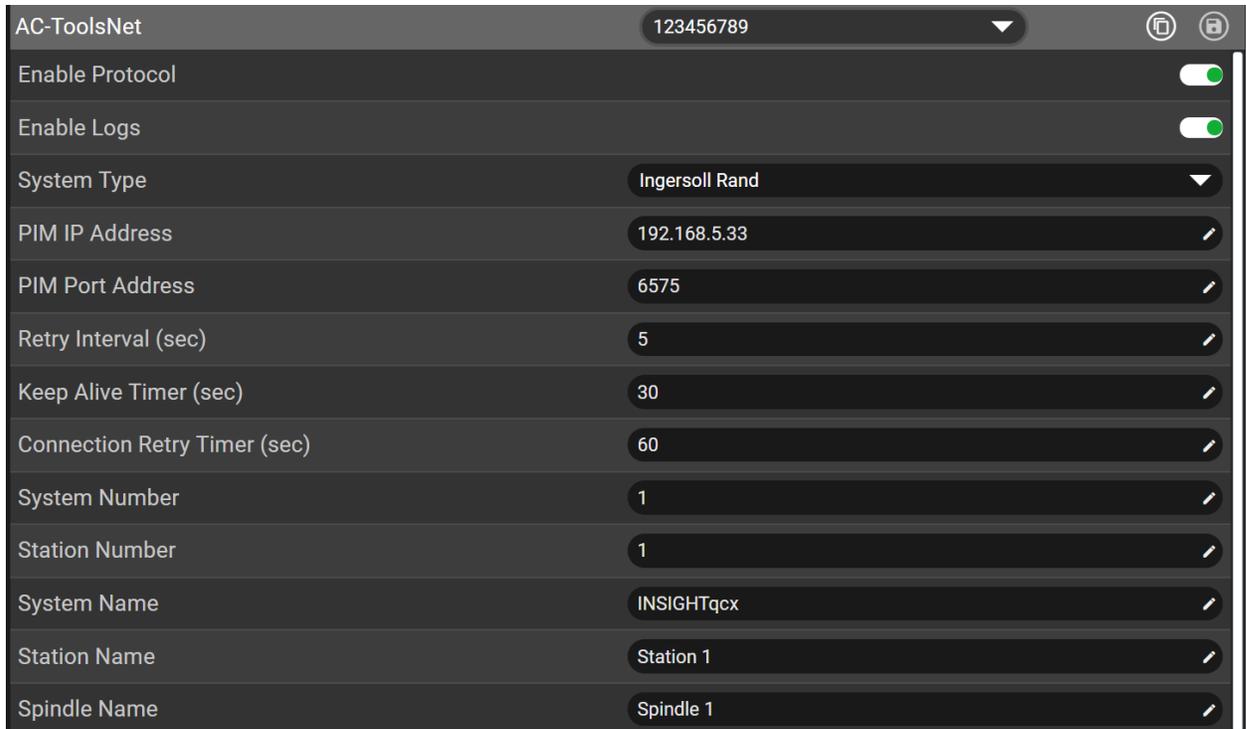
3. Select which tool you want to edit the Toolsnet Settings.



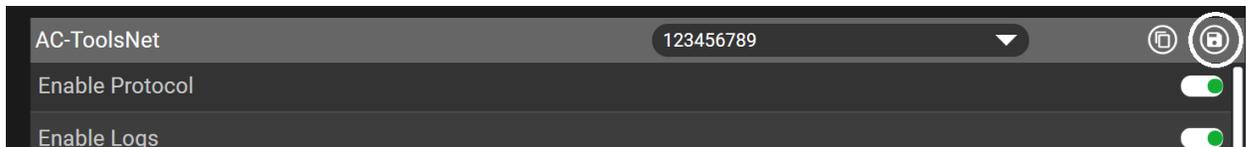
4. Enable Toolsnet and Enable Logs.



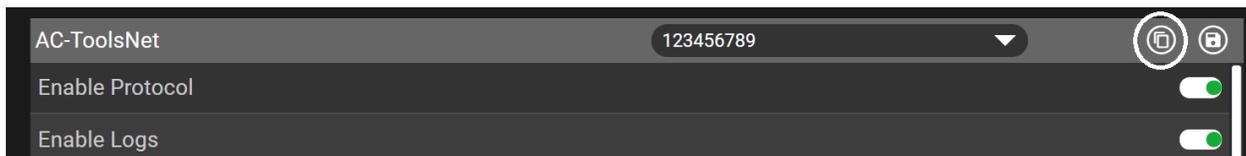
5. The following Toolsnet parameters are defined by the user.
 - a. **System Type:** This should be Ingersoll Rand.
 - b. **PIM IP Address:** This is the address of the PIM server in ToolsNet 3.2. It should be set to the IP address of the ToolsNet client in ToolsNet 8.
 - c. **PIM Port Address:** The TCP port address for PIM communications (Default is 6575).
 - d. **Retry Interval (sec):** The amount of time to wait for message acknowledgement before sending the message again (Default 5).
 - e. **Keep Alive Timer (sec):** Repetition rate for keep alive messages (Default 30 seconds).
 - f. **Connection Retry Timer (sec):** After the number of message retries are exhausted, the connection is closed and reopened after the connection retry interval (Default 60 seconds).
 - g. **System Number:** Four digit System number identifier.
 - h. **Station Number:** Four digit Station number identifier.
 - i. **System Name:** Alphanumeric text identifier for the controller system name.
 - j. **Station Name:** Alphanumeric text identifier for the station.
 - k. **Spindle Name:** Alphanumeric text identifier for the tool.



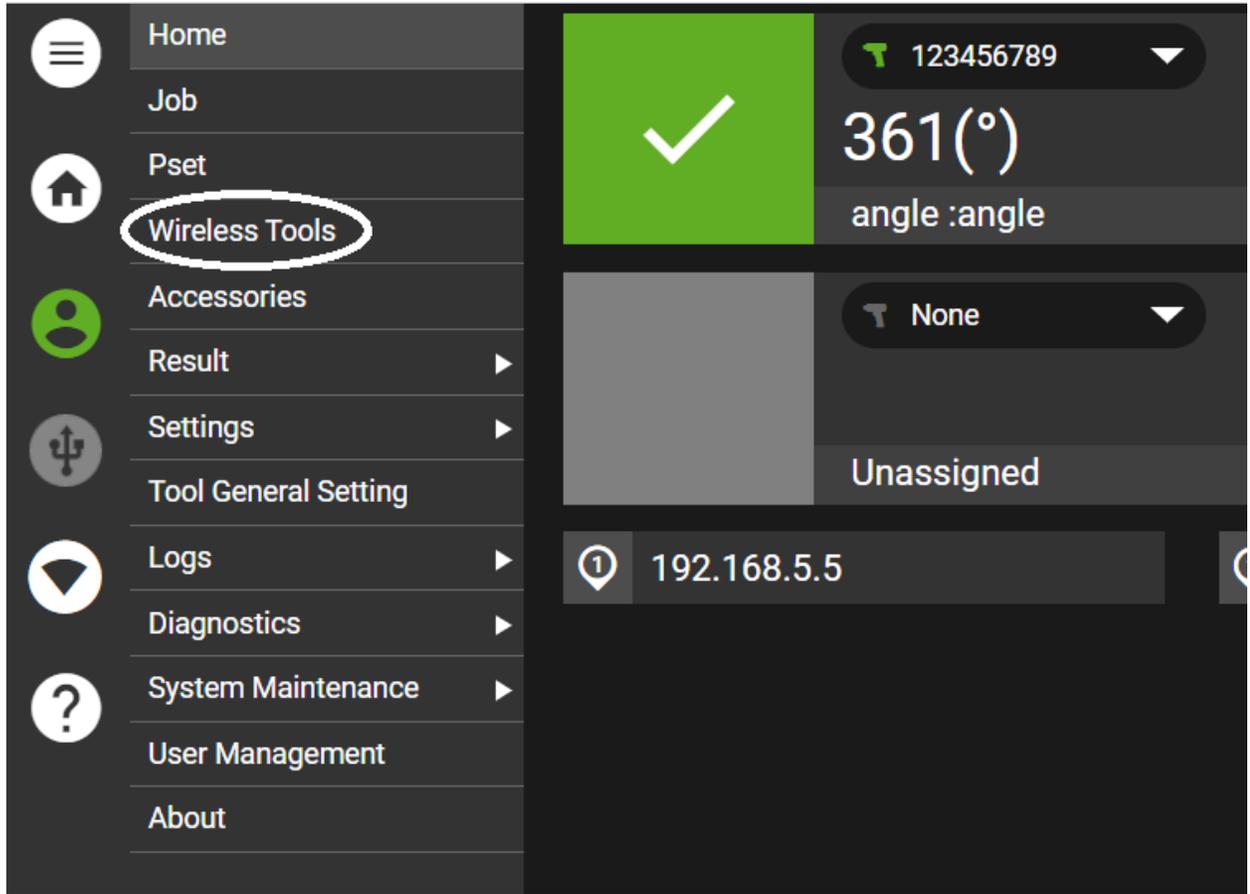
6. Click on the Save Icon in the header to save the Toolsnet settings.



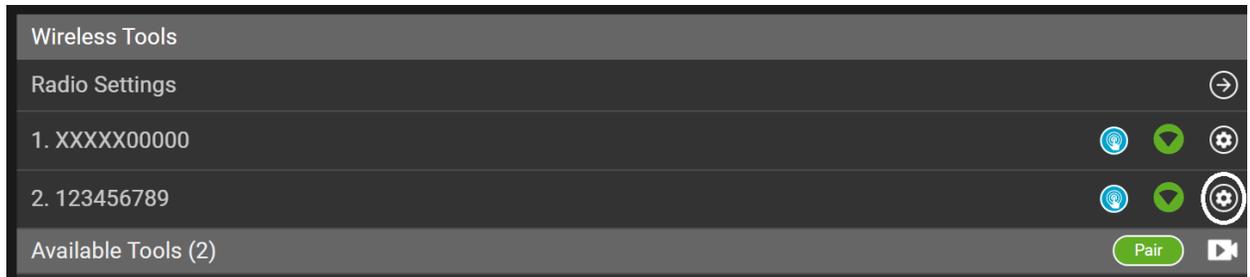
7. Click on the Copy Icon in the header to copy Toolsnet settings from one tool to another.



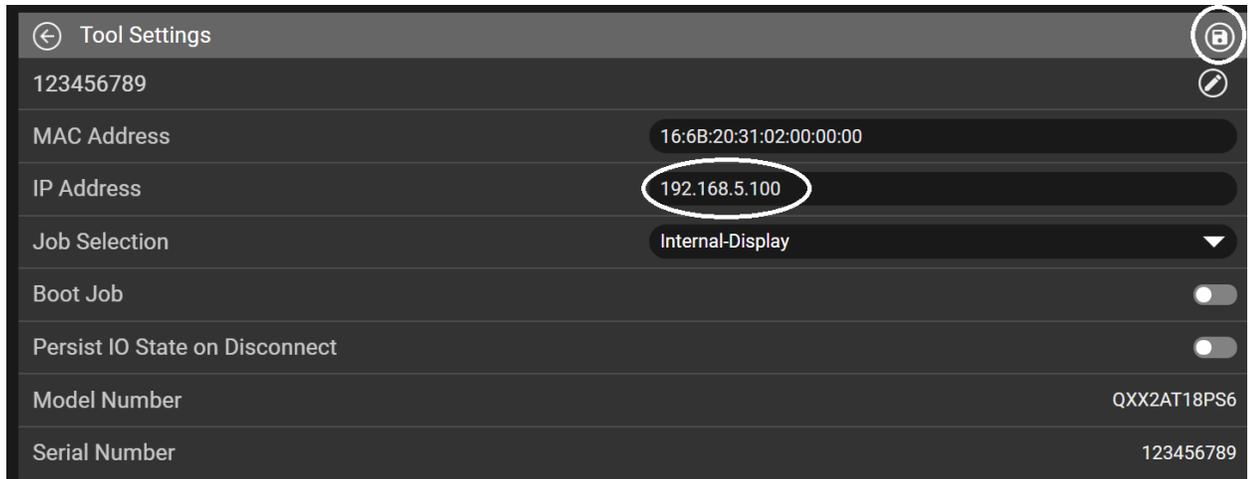
8. Assign a unique IP Address for each tool. Ensure that the IP Addresses have the same subnet as the first Ethernet port (0).
 - a. From the Main Menu, go to Wireless Tools.



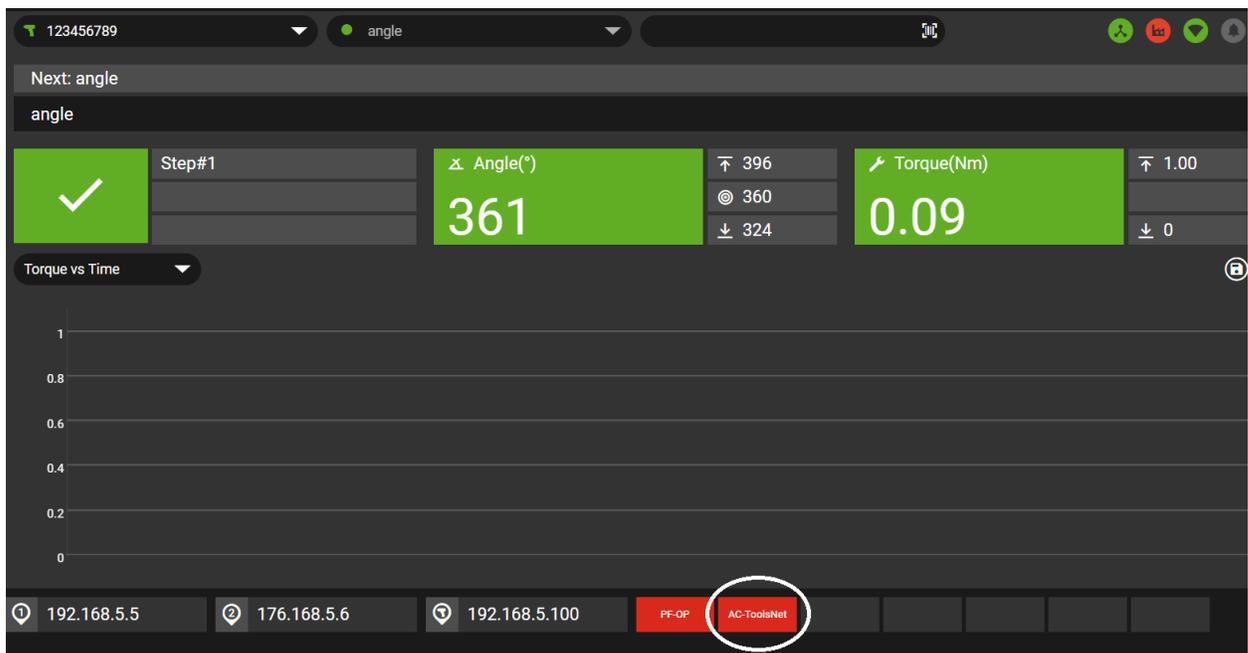
b. Select a tool and go to Tool Settings.



c. Assign the appropriate IP Address and Save.



9. When connected to the Toolsnet server, the AC Toolsnet status button on the Home screen will turn Green.



10. Below are sample results using a Toolsnet simulator.

ToolsNet Simulator 0.0.2

Server IP: 192.168.5.33 PIM port: 6575

Tool: 192.168.5.100 Tools connected: 1

System type: 0019 System number: 0001
 Station number: 0001 Connection: Online

System name: INSIGHTqcx
 Station name: Station 1
 Spindle name: Spindle 1

Cycle count: 1147 Monitor comms

Programs

Job Id	Job Name
0003	job2-A-100-200

Comms monitor

192.168.5.102 192.168.5.103

Additional VIN Info

VIN Identi...	VIN No
0001	
0002	
0003	

Parameter Info

Spindle No	Program ...	ID	Name	Value	Type	Unit	Step ...
0000	0003	00001	Angle				

Cycle results Graphs

Tool IP	System Type	System Number	Station Number	Timestamp	Rundown Seq...	VIN
192.168.5.100	0019	0001	0001	2021-07-08 10:51:02	01145	
192.168.5.100	0019	0001	0001	2021-07-08 10:51:06	01146	
192.168.5.100	0019	0001	0001	2021-07-08 10:51:07	01147	

Stop Online cycle results 1 to 3 of 3