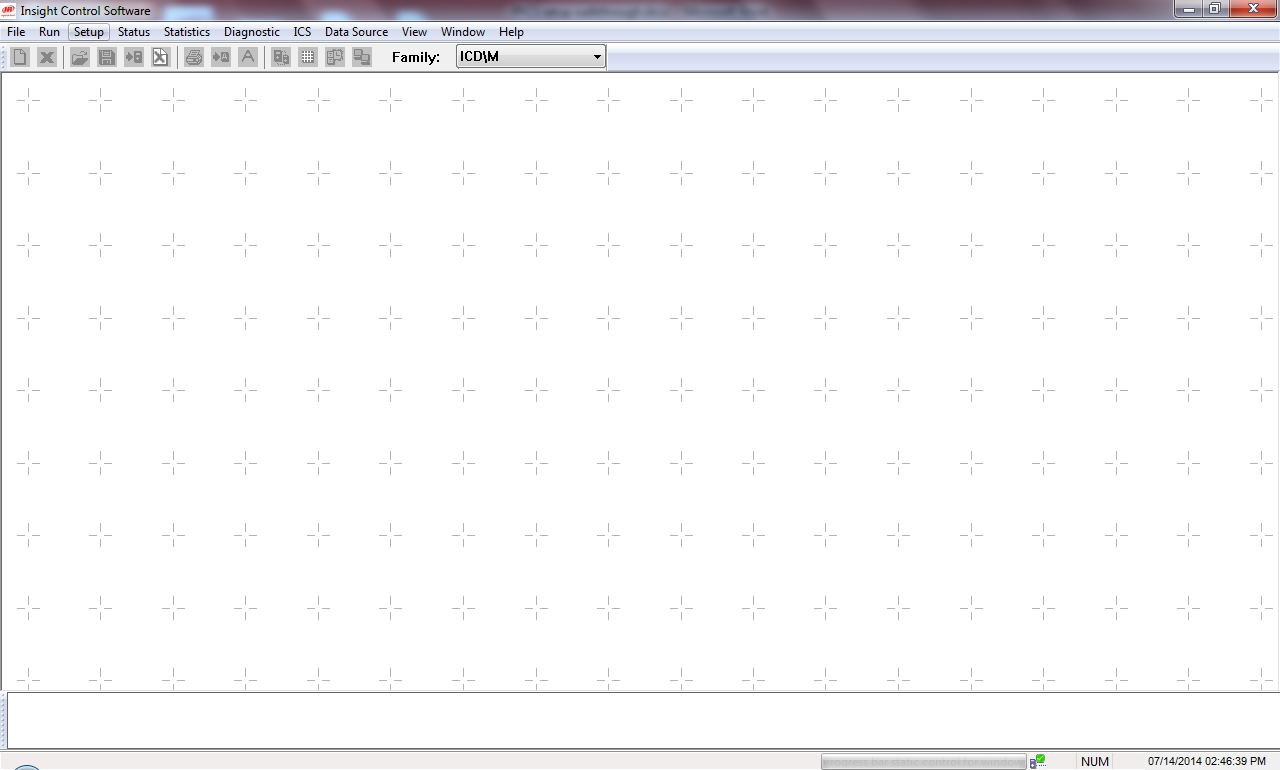
PFCS setup instructions for ICDM.

1. Launch “ICS Connect” from programs menu or double click the shortcut on the desktop.

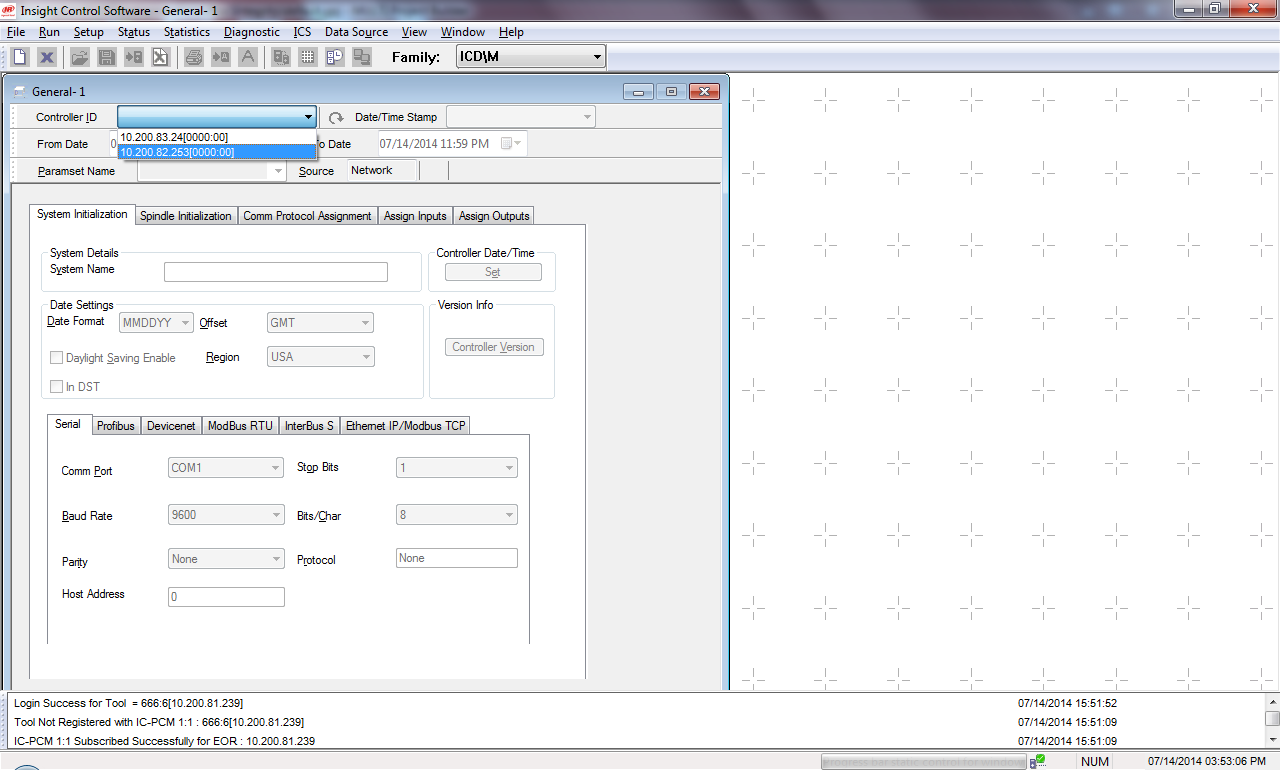
# General Setup

1. Click on Setup -> General.

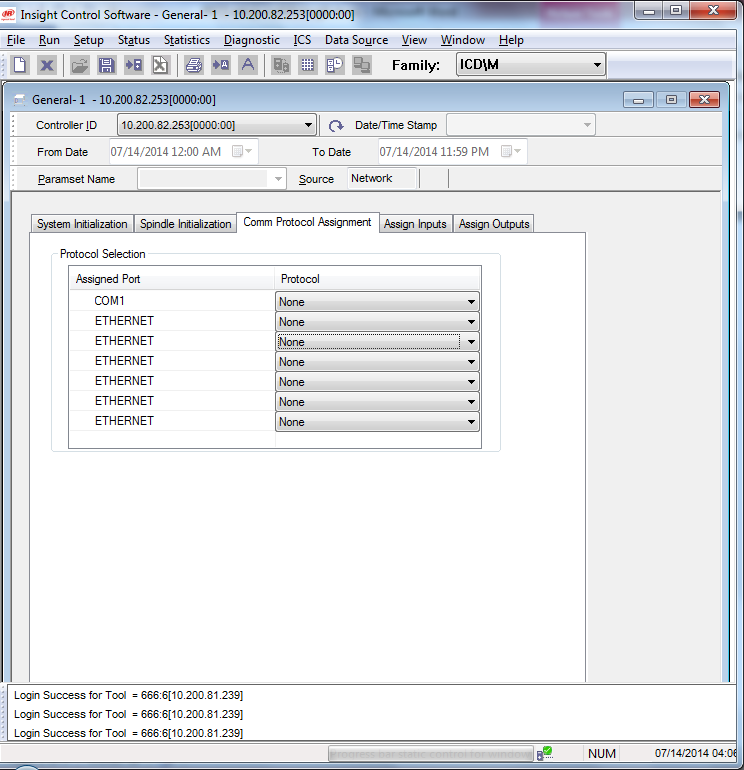


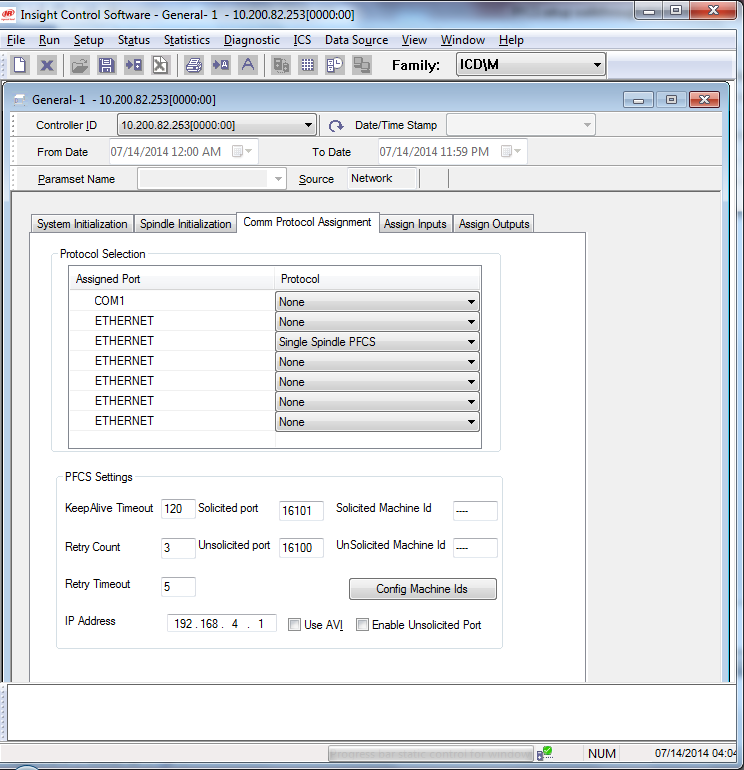
# Controller Selection

1. Select the Controller from controller ID dropdown List.

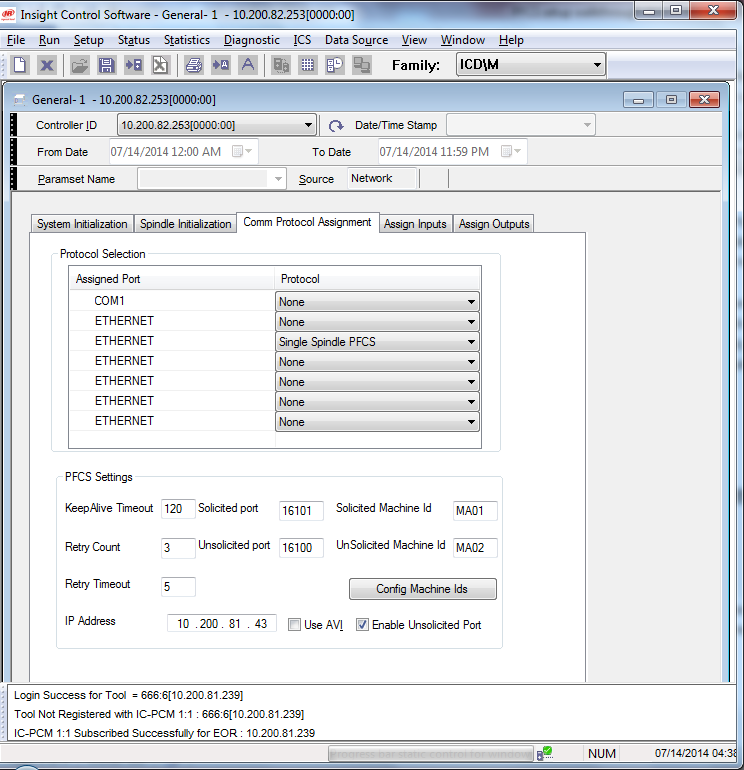


# Enable PFCS

1. Click on “Comm Protocol Assignment” tab to set the PFCS settings. 
2. Select the 3rd dropdown box and select “Single Spindle PFCS”

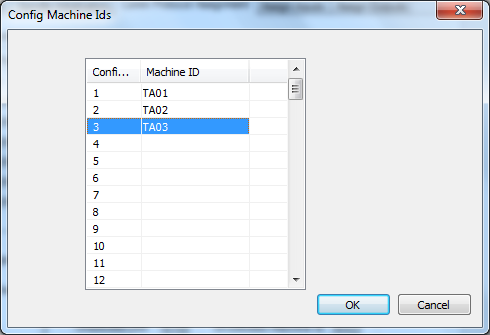


1. Make the necessary setting under PFCS settings such as:
2. KeepAlive Timeout – Time in seconds for every Keepalive message to send.
3. Retry Count – Number of time the Retry should happen.
4. Retry Timeout – Time in seconds for the next retry.
5. IP Address – PFCS server IP address
6. Solicited Port – Port settings for Solicited communication.
7. Unsolicited Port – Port settings for unsolicited communication.
8. Solicited MachineID – Machine ID for Solicited port
9. Unsolicited Machine ID – Machine ID for Unsolicited port.
10. Enable/Disable Unsolicited Port – Check the box to enable the Unsolicited Port.
11. Config Machine IDs – Machine IDs for the corresponding configs/ pset.

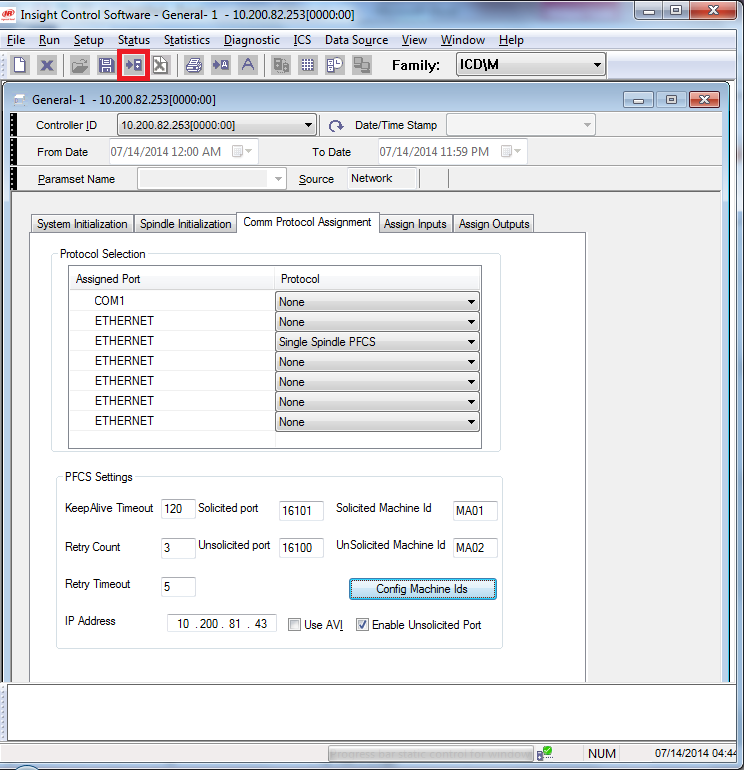


# Map Configuration and Machine IDs

1. Click on “Config Machine IDs” button to set Machine IDs for each PSet/configs.

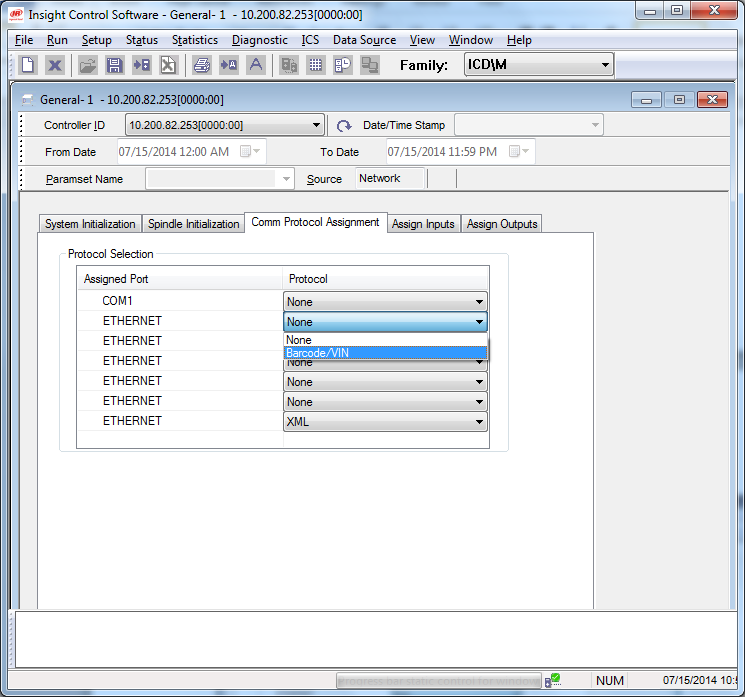


1. Once all the settings are in place click on “Send” button.

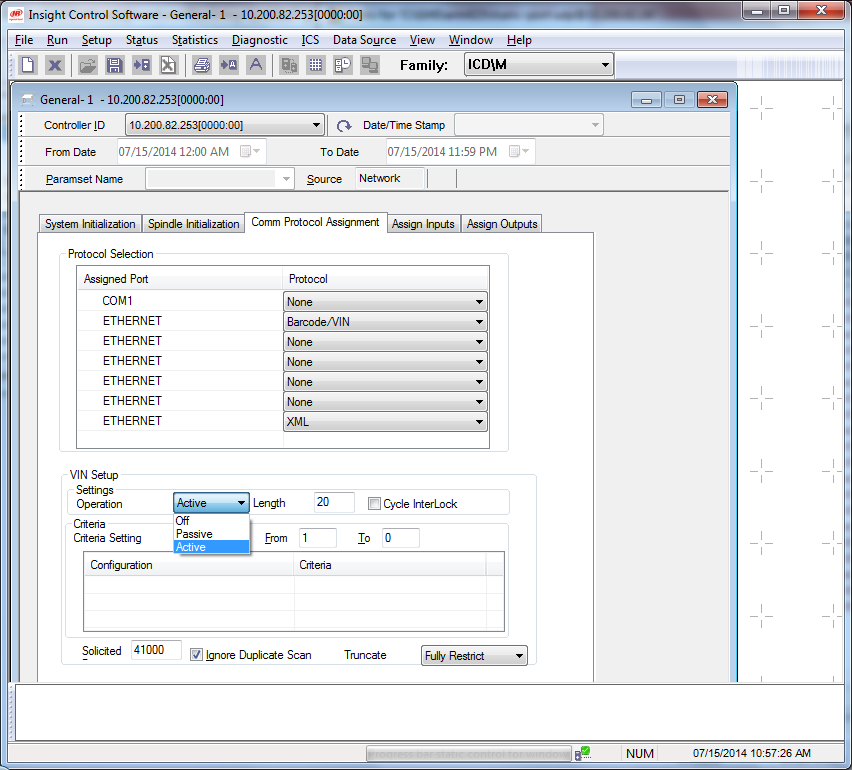


# Barcode Setup

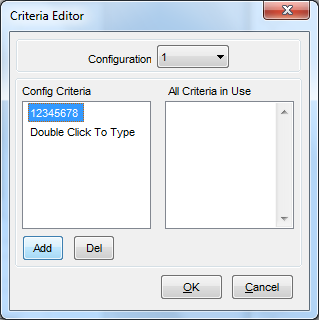
1. When Unsolicited Port is enabled, Barcode can be sent as unsolicited message to select the config.
2. In order to setup the barcode, select the second dropdown box and select Barcode/Vin



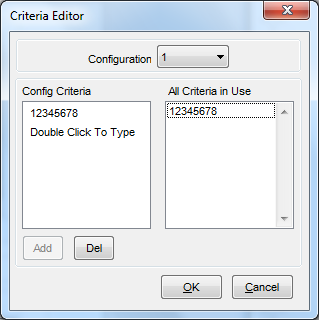
1. Barcode can be set to OFF, Active or Passive. Set it to Active.



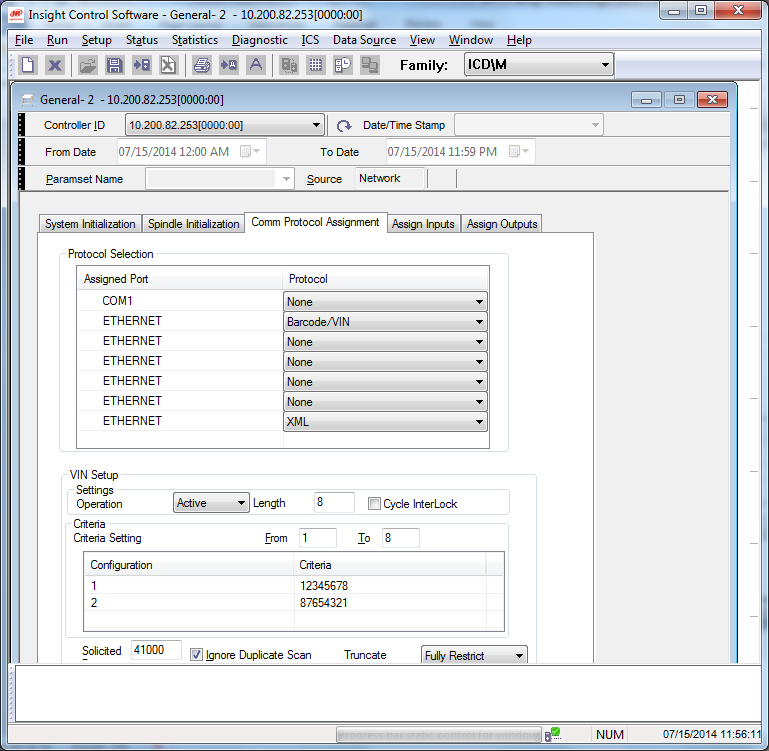
1. Set the Length of the barcode as 8.
2. Set Criteria setting, 1 in “From” and 8 in “To”.
3. Double click on the Grid.



1. Click on “Add” button to add the config Criteria.

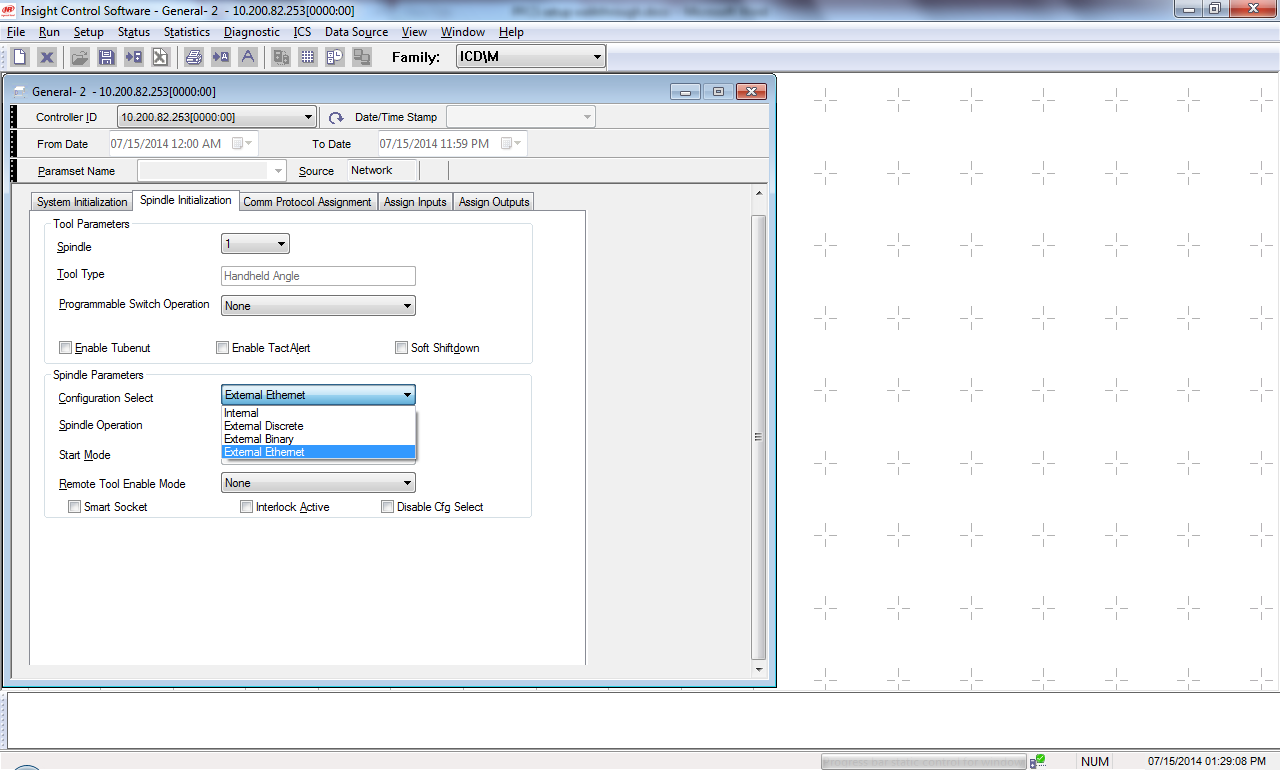


1. Repeat the steps for configuration 2 from the dropdown box window.
2. Once the settings are complete, click on “OK” and the settings will be reflected as below.



1. Click on Send button and reboot controller after 30 sec in order to reflect the changes.

# Configuration Selection type

1. In order to use PFCS on ICDM controller, Configuration select should be set to “External Ethernet”. This setting can be found under “Setup->General” and “Spindle Initialization” tab. 
2. Click on Send button.

Controller is ready for PFCS protocol communication.