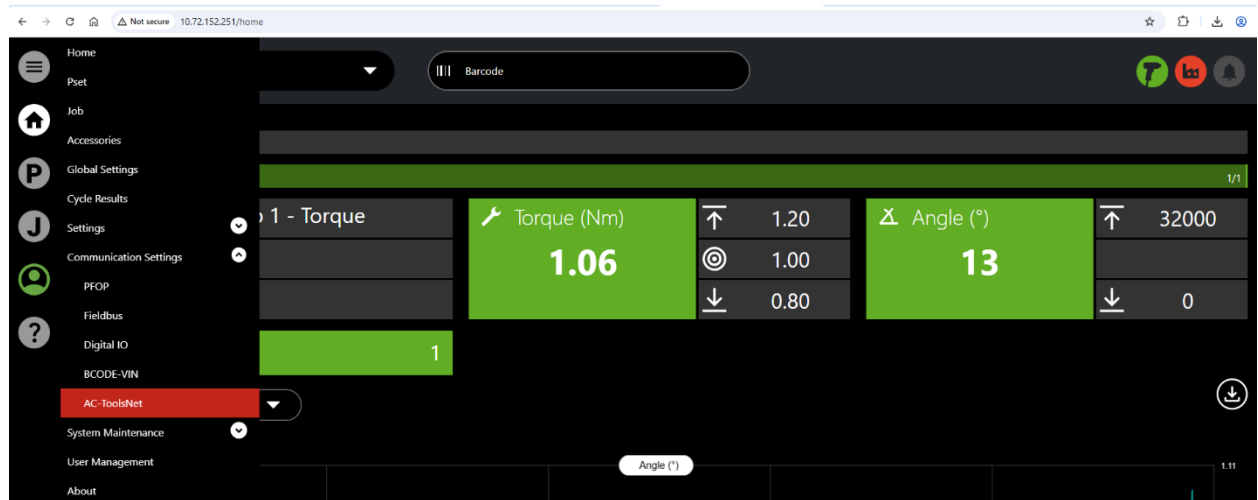
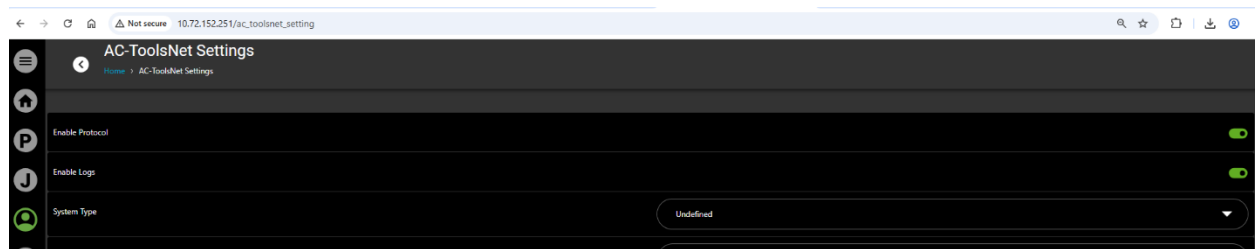


1. From the Main Menu go to Communication Settings->AC Toolsnet.



2. Enable Toolsnet and Enable Logs.



3. 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.

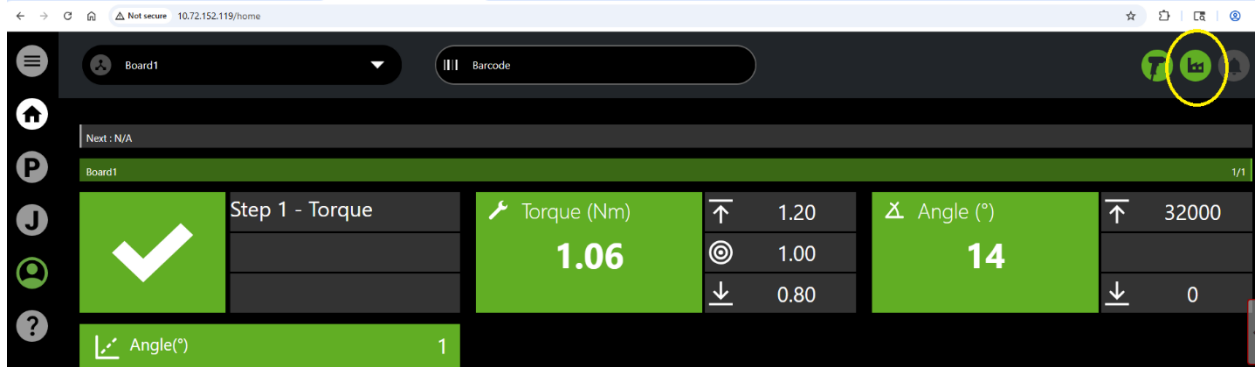
|                        |                                     |
|------------------------|-------------------------------------|
| Enable Protocol        | <input checked="" type="checkbox"/> |
| Enable Logs            | <input checked="" type="checkbox"/> |
| System Type            | Ingersoll Rand                      |
| PIM IP Address         | 10.00.026.51                        |
| PIM Port Number        | 8075                                |
| Retry Interval         | 5 seconds                           |
| Keep Alive Timer       | 30 seconds                          |
| Connection Retry Timer | 60 seconds                          |
| System Number          | 3                                   |
| Station Number         | 1                                   |
| System Name            | INSIGHTig                           |
| Station Name           | TestStation02                       |
| Spindle Name           | Spindle 1                           |

4. After editing the parameters, click on the Save Icon at the bottom of the screen to save the Toolsnet settings.

|                        |            |
|------------------------|------------|
| Retry Interval         | 5 seconds  |
| Keep Alive Timer       | 30 seconds |
| Connection Retry Timer | 60 seconds |
| System Number          | 3          |
| Station Number         | 1          |
| System Name            | INSIGHTig  |

At the bottom right, there are two buttons: "Cancel" and "Save". The "Save" button is highlighted with a yellow circle.

5. The system is setup to communicate with the Toolsnet Server. On the Home Screen, you will see a Green MES icon once communication is established with the server.



6. Below are sample results sent to the Toolsnet Server.

The screenshot shows a 'Results' page with a sidebar menu containing 'Dashboard', 'Reports', 'Command center', and 'Administration'. The main area has filters for 'Date range' (Today), 'Shift' (-), 'Tool structure' (Tool Structure), 'Program' (All), and 'Max results' (200). A 'Run advanced report' button is also present. Below the filters is a 'Result list' table with 12 columns: Status, Identifier 1, Unit name, Program name, Result time, Final torque, Torque status, Final angle, Angle status, Rundown angle, and Trace. The table shows 4 rows of test results, all with a status of 'OK'.

| Status | Identifier 1 | Unit name     | Program name | Result time            | Final torque           | Torque status | Final angle                  | Angle status | Rundown angle | Trace |
|--------|--------------|---------------|--------------|------------------------|------------------------|---------------|------------------------------|--------------|---------------|-------|
| OK     | -            | TestStation22 | Board1       | 05/14/2025 01:25:36 PM | 1.06 (0.80 - 1.20) N-m | OK            | 9.80 (0.00 - 32.000.00) deg  | OK           | -             |       |
| OK     | -            | TestStation22 | Board1       | 05/14/2025 01:25:32 PM | 1.05 (0.80 - 1.20) N-m | OK            | 8.20 (0.00 - 32.000.00) deg  | OK           | -             |       |
| OK     | -            | TestStation22 | Board1       | 05/14/2025 01:25:23 PM | 1.05 (0.80 - 1.20) N-m | OK            | 9.90 (0.00 - 32.000.00) deg  | OK           | -             |       |
| OK     | -            | TestStation22 | Board1       | 05/14/2025 01:25:21 PM | 1.06 (0.80 - 1.20) N-m | OK            | 11.20 (0.00 - 32.000.00) deg | OK           | -             |       |