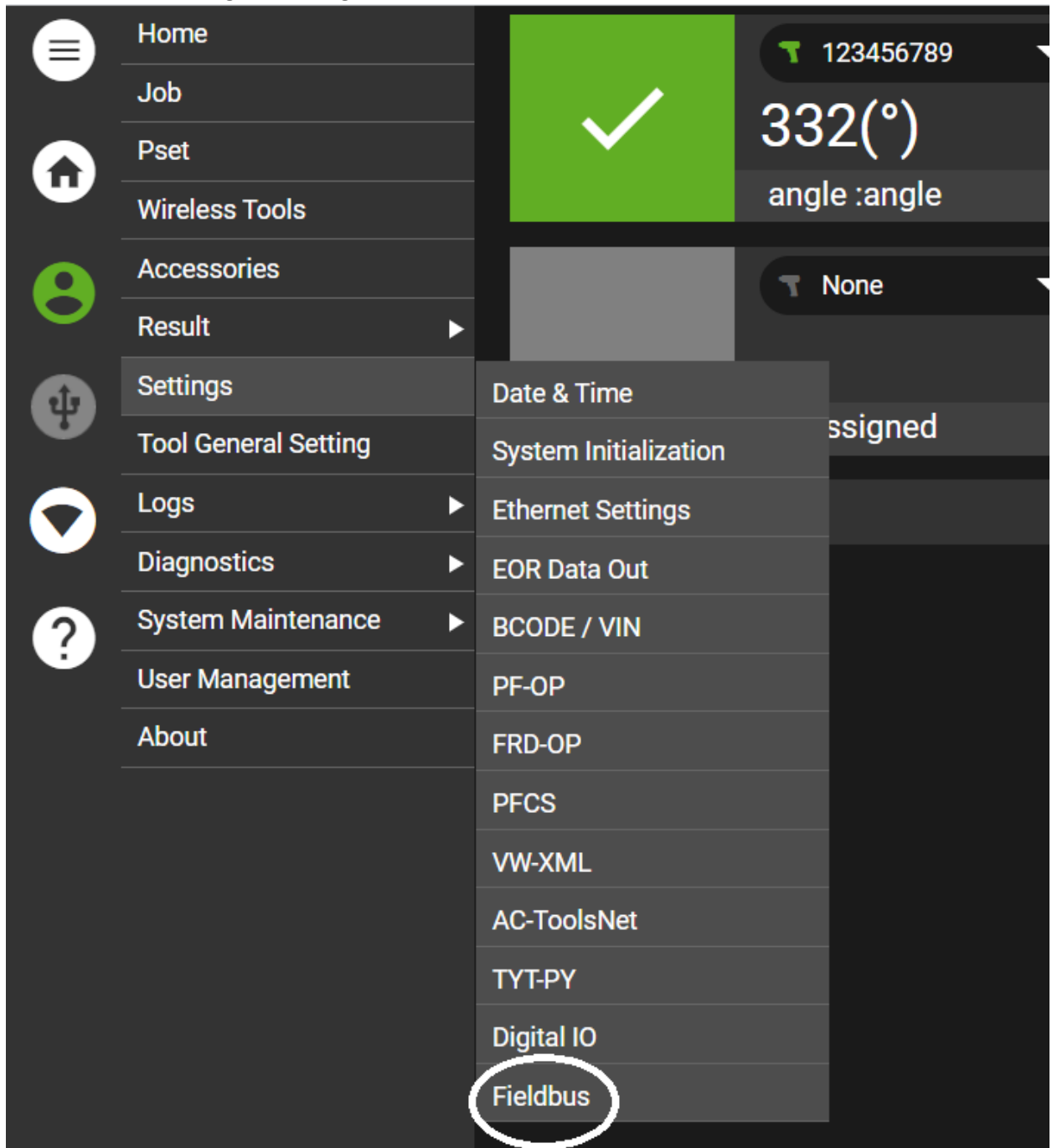
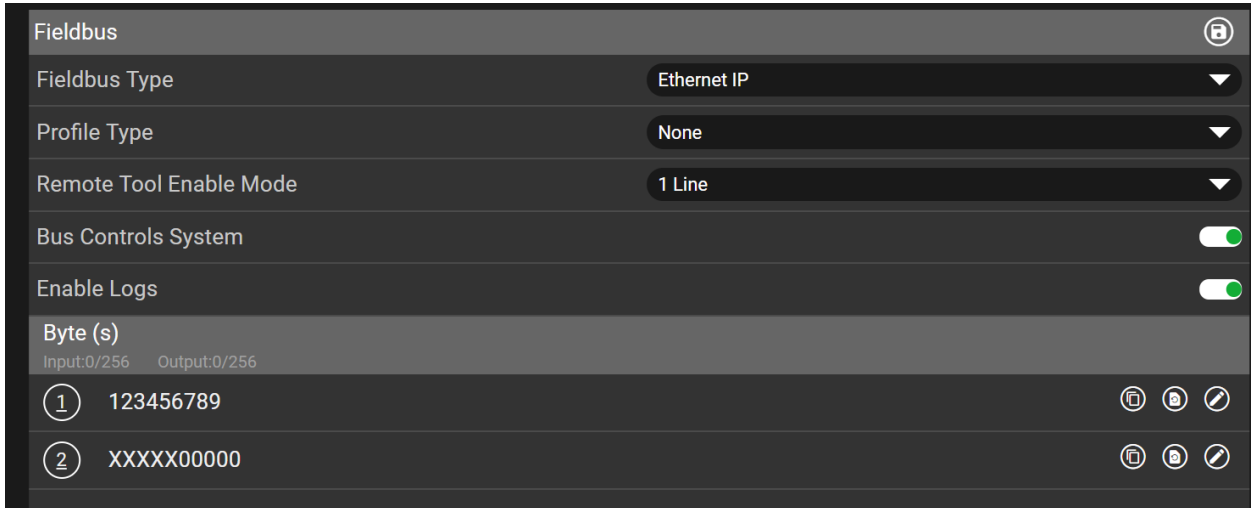


1. From the Main Menu go to Settings-Fieldbus.

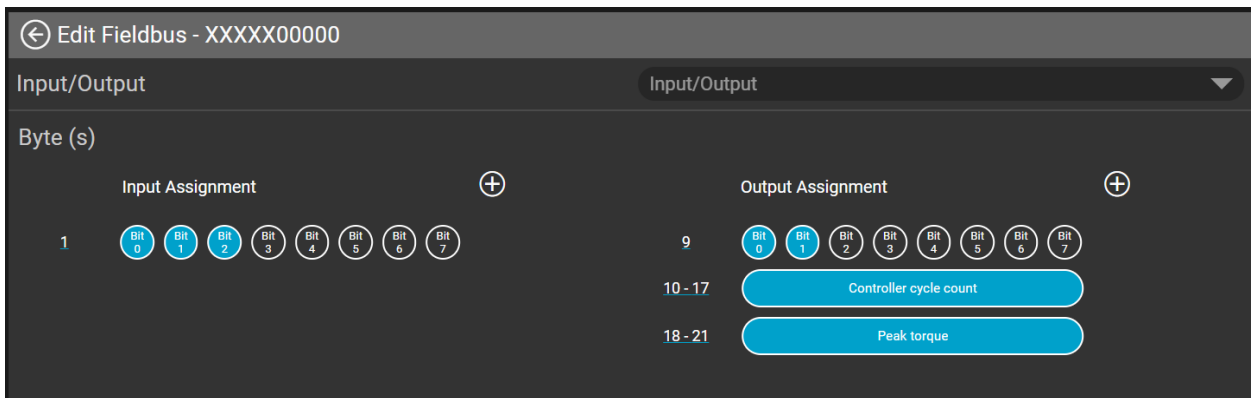
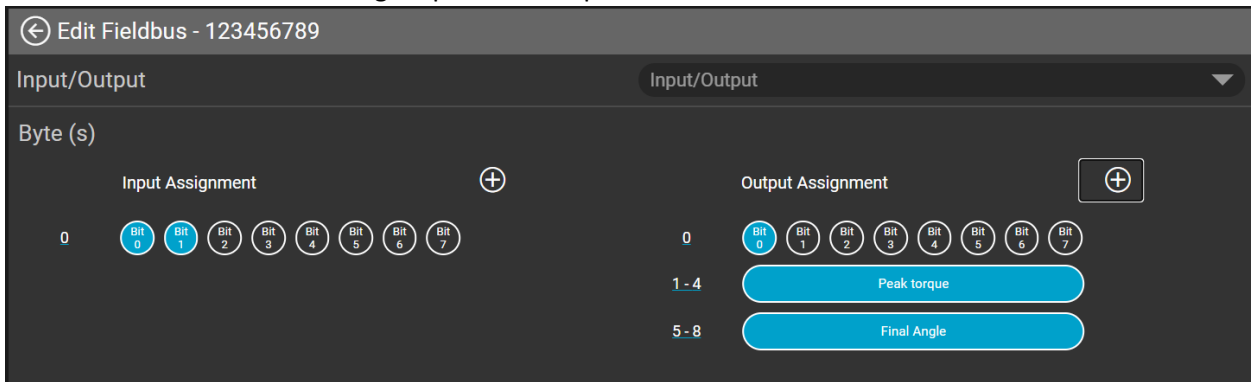


2. Fieldbus Type - Select Ethernet IP.
3. Profile Type - Select None if using Custom Bit Mapping.
  - a. If only using one tool and you require the IC-PCM mapping, select IC-PCM Profile.
4. Remote Tool Enable Mode - Select how the remote enable is configured.
  - a. None – No input is being used to enable/disable the tool.
  - b. 1-Line – Tool is enabled when input is high. Tool is disabled when input is low.

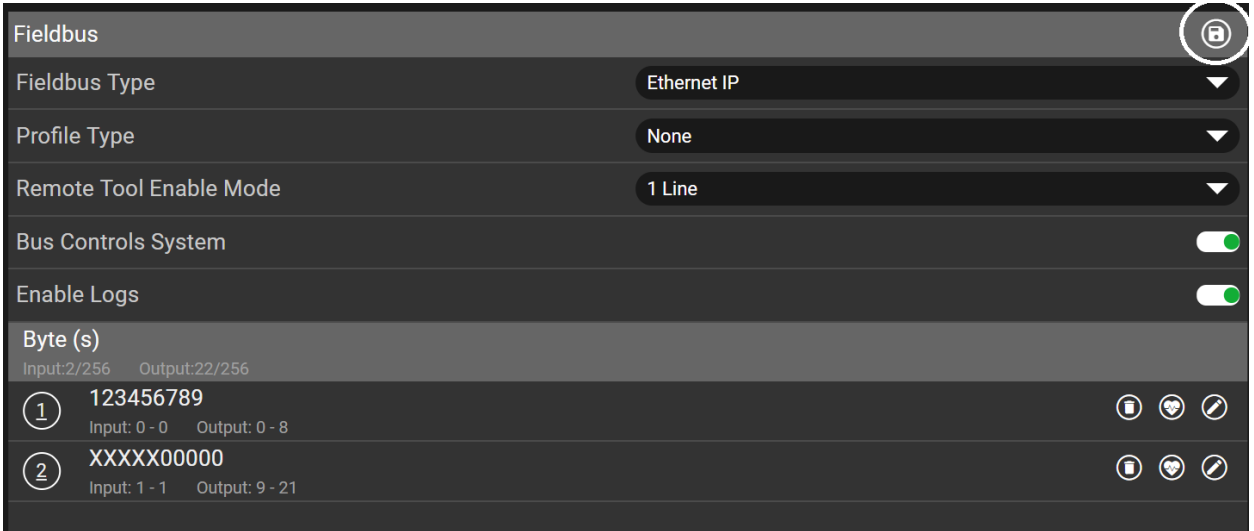
- c. 2-Line – Pulse the enable input to enable the tool. Pulse the disable input to disable the tool.
- 5. Bus Control System - Enable if using inputs to control system behavior.
- 6. Enable Logs – Enable to capture logs for all fieldbus events. This is helpful during initial communication setup.
- 7. The total number of Input and Output bytes allowed is 256.
- 8. All paired tools are listed on the screen.



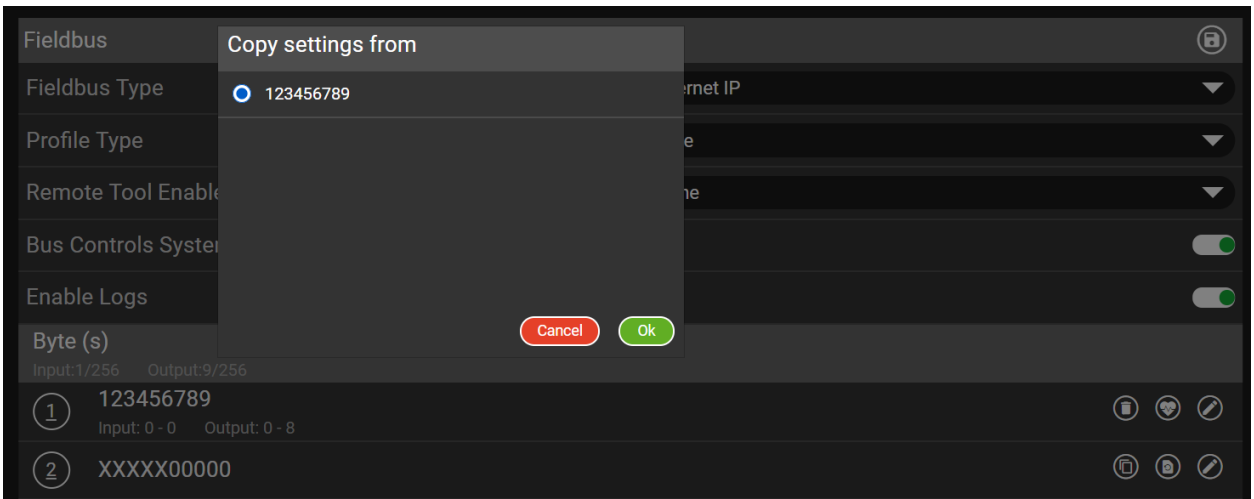
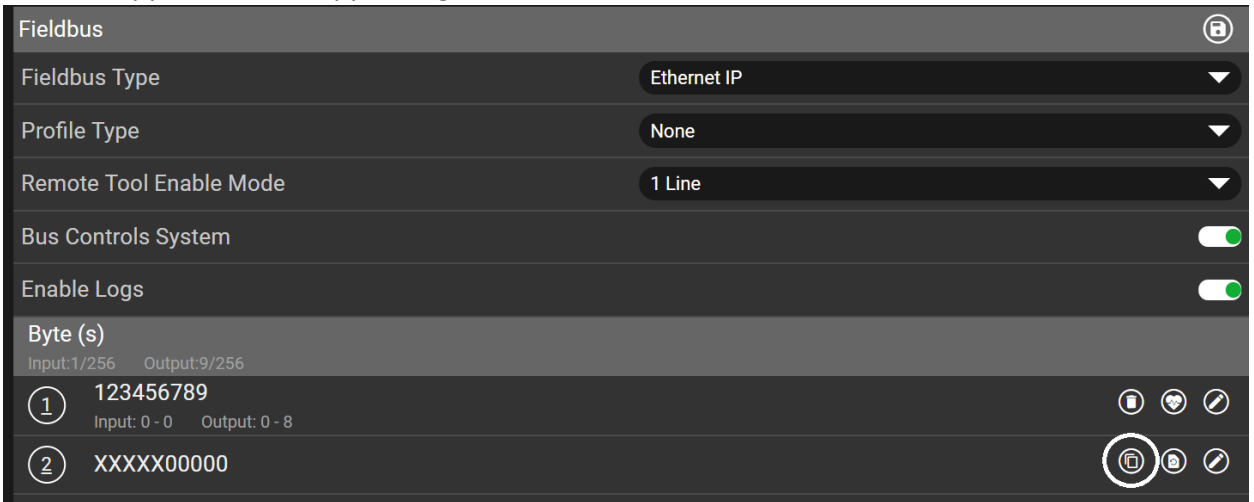
- 9. Select the desired tool and assign inputs and outputs.



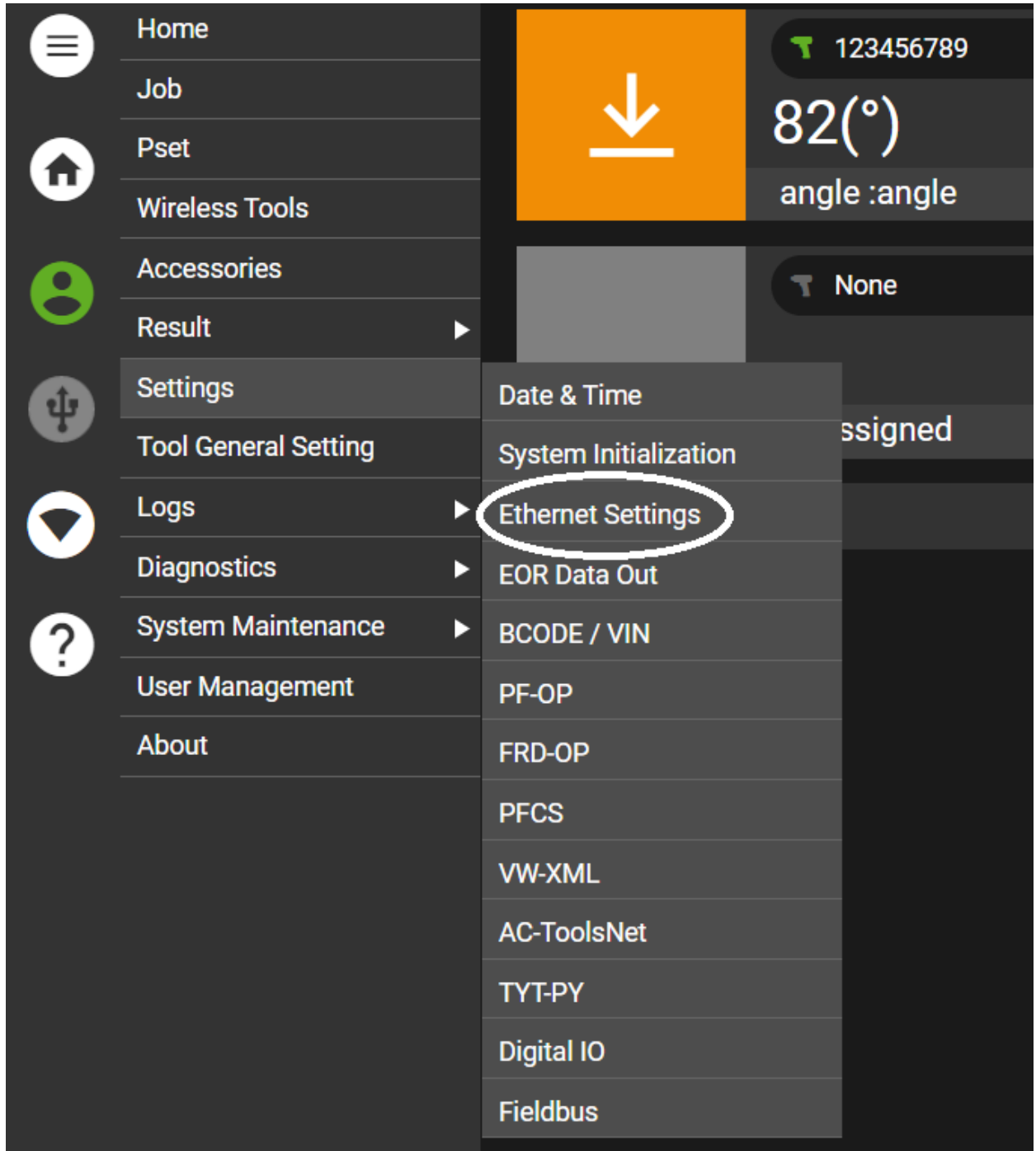
10. When complete select the Save icon.



11. Use the Copy function to copy settings from one tool to another.

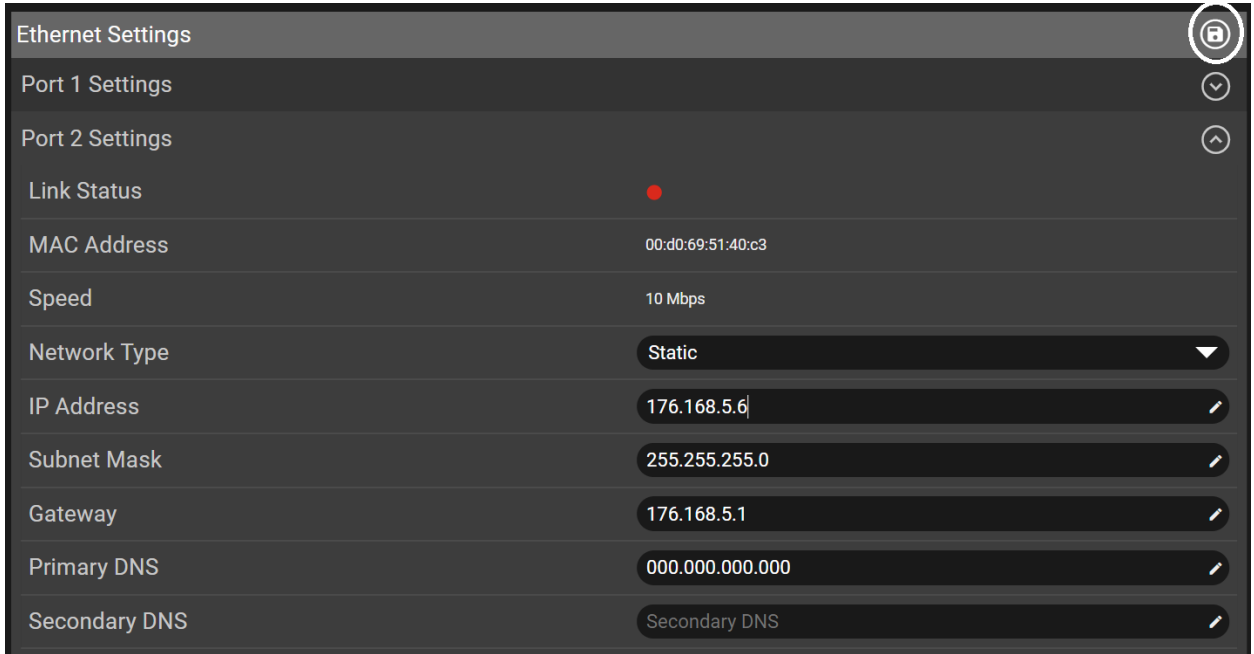


12. Once the Inputs and Outputs are assigned and saved, from the Main Menu, go to Settings- Ethernet Settings to assign the Network Settings for Ethernet IP communication.

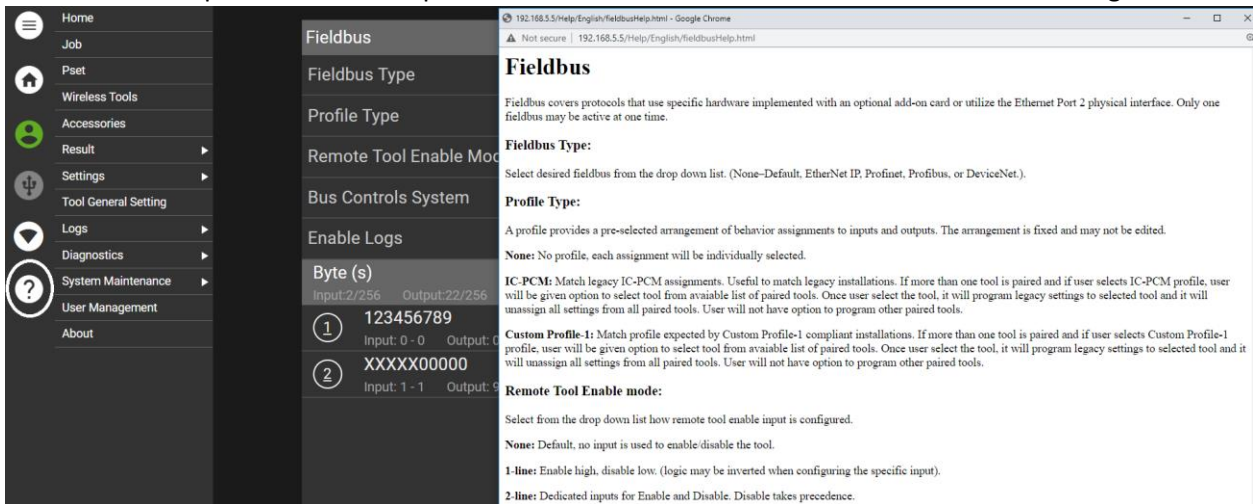


13. Port 2 is a 10/100 Kbps port and is dedicated to Fieldbus. This port should be on a different subnet than port 1.

14. Once complete, use the save icon to save the settings.



15. The onboard Help Menu has a complete list of definitions for all Ethernet and Fieldbus settings.



16. You can use the Diagnostic Mode to confirm Fieldbus functionality.

**Fieldbus**

Fieldbus Type: Ethernet IP







Profile Type: None

Remote Tool Enable Mode: 1 Line

Bus Controls System:

Enable Logs:

Byte (s)  
Input: 2/256    Output: 22/256

①	123456789	Input: 0 - 0    Output: 0 - 8	  
②	XXXXX00000	Input: 1 - 1    Output: 9 - 21	  

← Fieldbus Diagnostics - 123456789

Fieldbus Master Disconnected

Input/Output: Input/Output

Force Output:

Byte (s)

Input Assignment		Output Assignment	
0	<input checked="" type="radio"/> Bit 0 <input checked="" type="radio"/> Bit 1 <input type="radio"/> Bit 2 <input type="radio"/> Bit 3 <input type="radio"/> Bit 4 <input type="radio"/> Bit 5 <input type="radio"/> Bit 6 <input type="radio"/> Bit 7	0	<input checked="" type="radio"/> Bit 0 <input type="radio"/> Bit 1 <input type="radio"/> Bit 2 <input type="radio"/> Bit 3 <input type="radio"/> Bit 4 <input type="radio"/> Bit 5 <input type="radio"/> Bit 6 <input type="radio"/> Bit 7
		1 - 4	Peak torque
		5 - 8	Final Angle

**Note:** The PLC and controller must be on similar timing. The INSIGHT controller expects data no faster than every 50 ms. The customer PLC should have cycle rates no faster than 100 ms or communications issues could arise.