


1. The Wireless Bit Tray comes with the Bit Tray, Controller Interface Module (connects to IR QC-DIO-8CH), Wire Harness, USB-C Charging Cable, and Screwdriver & Accessories.



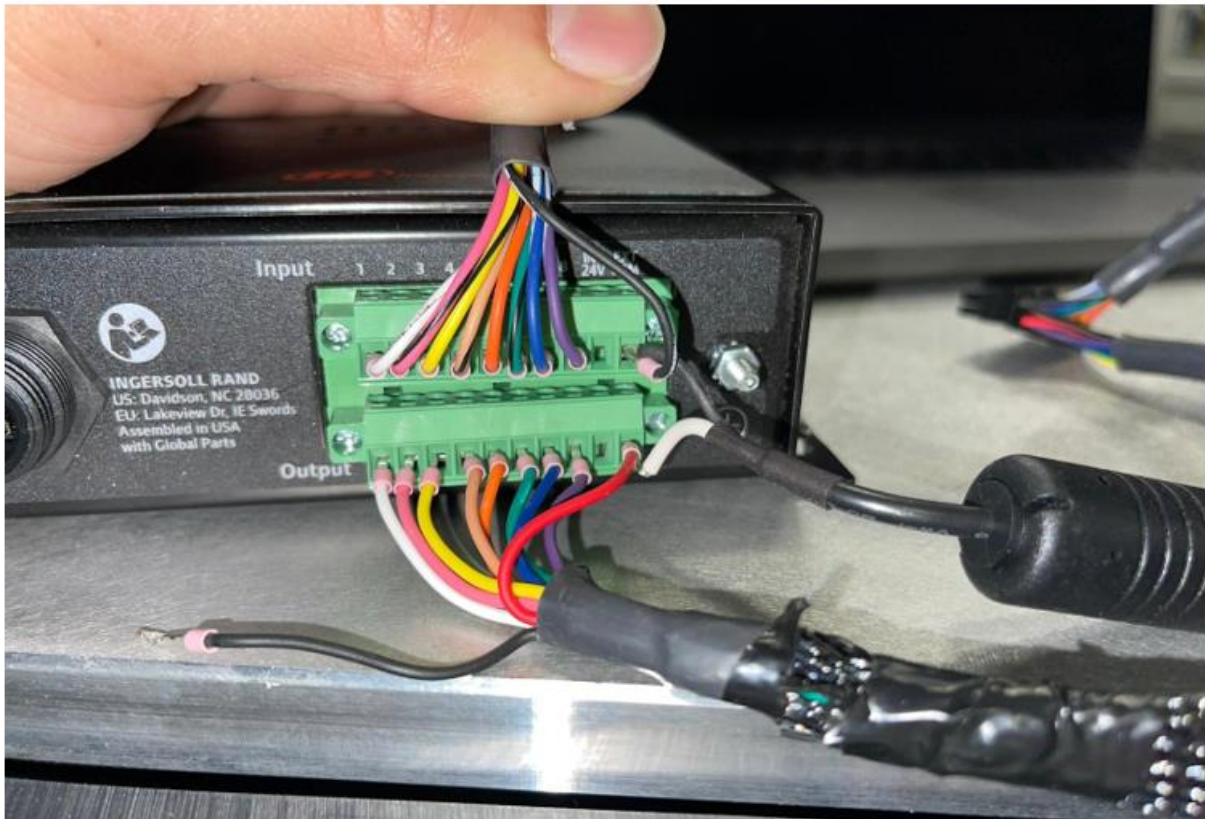
2. Charge the Bit Tray before using.
3. Remove the wires from the two 10 Pin Phoenix connectors on the Wire Harness.
4. Connect the wires to the two 10 Pin Phoenix connectors on the IR QC-DIO- 8CH module following below diagram.

Wireless Bit Tray							QC-DIO-8CH		
Connector 1	Pin #	Description	Color	Size	Terminal PN	DIO Connector	Pin #	24V Power Supply	
	1	Input 1, +24V to DIO (From TQ Tool Controller)	WHT	22	43030-0001	DIO -Outputs	1		
	2	Input 2, +24V to DIO (From TQ Tool Controller)	PNK	22	43030-0001	DIO -Outputs	2		
	3	Input 3, +24V to DIO (From TQ Tool Controller)	YEL	22	43030-0001	DIO -Outputs	3		
	4	Input 4, +24V to DIO (From TQ Tool Controller)	TAN	22	43030-0001	DIO -Outputs	4		
	5	Input 5, +24V to DIO (From TQ Tool Controller)	ORG	22	43030-0001	DIO -Outputs	5		
	6	Input 6, +24V to DIO (From TQ Tool Controller)	LT GRN	22	43030-0001	DIO -Outputs	6		
	7	Input 7, +24V to DIO (From TQ Tool Controller)	DK BLU	22	43030-0001	DIO -Outputs	7		
	8	Input 8, +24V to DIO (From TQ Tool Controller)	PPL	22	43030-0001	DIO -Outputs	8		
	10	Not Populated - spare 24V Supply					DIO -Outputs	Not Used	
	9	24V Supply to DIO (From TQ Tool Controller)	RED	22	43030-0001	DIO -Outputs	EXT POWER	White	
11	Output 1, +24V to TQ Tool Controller (From DIO)	WHT/BLK	22	43030-0001	DIO -Inputs	1			
12	Output 2, +24V to TQ Tool Controller (From DIO)	PNK/BLK	22	43030-0001	DIO -Inputs	2			
13	Output 3, +24V to TQ Tool Controller (From DIO)	YEL/BLK	22	43030-0001	DIO -Inputs	3			
14	Output 4, +24V to TQ Tool Controller (From DIO)	TAN/BLK	22	43030-0001	DIO -Inputs	4			
15	Output 5, +24V to TQ Tool Controller (From DIO)	ORG/BLK	22	43030-0001	DIO -Inputs	5			
16	Output 6, +24V to TQ Tool Controller (From DIO)	LT GRN/BLK	22	43030-0001	DIO -Inputs	6			
17	Output 7, +24V to TQ Tool Controller (From DIO)	DK BLU/WHT	22	43030-0001	DIO -Inputs	7			
18	Output 8, +24V to TQ Tool Controller (From DIO)	PPL/WHT	22	43030-0001	DIO -Inputs	8			
19	Ground Reference (From TQ Tool Controller)	BLK	22	43030-0001	Not Used	Not Used			
20	Ground Reference (From TQ Tool Controller)	BLK/WHT	22	43030-0001	DIO -Inputs	EXT COM	Black		

Notes	1	The Wireless Bit Tray will come wired for connection to the PCM controller. You must remove the wires from the 2 Phoenix Connectors and wire to the DIO box connectors.
	2	See the QC-DIO-8CH manual for additional information.
	3	Above is the recommended wiring using an External 24V Power Supply and Sourcing Outputs.

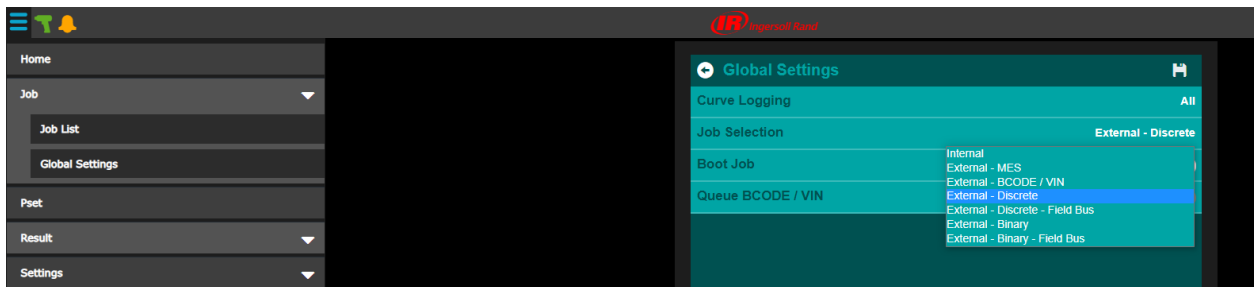
5. Plug the connectors into the QC-DIO-8CH.



6. Using the provided USB cable, plug the DIO box into one of the USB ports on the QCD/QCXD controller.

## Programming the controller for Simple Bit Tray

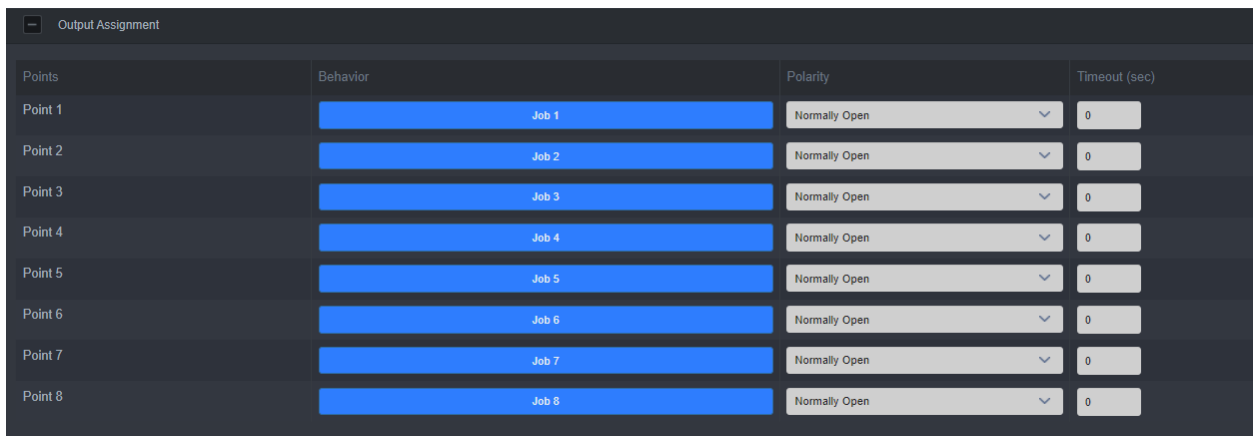
7. On the controller, set the Job Selection Mode to External Discrete.



8. Assign the Inputs for Job selection as shown below.



9. Assign the Outputs for Job indicator as shown below.

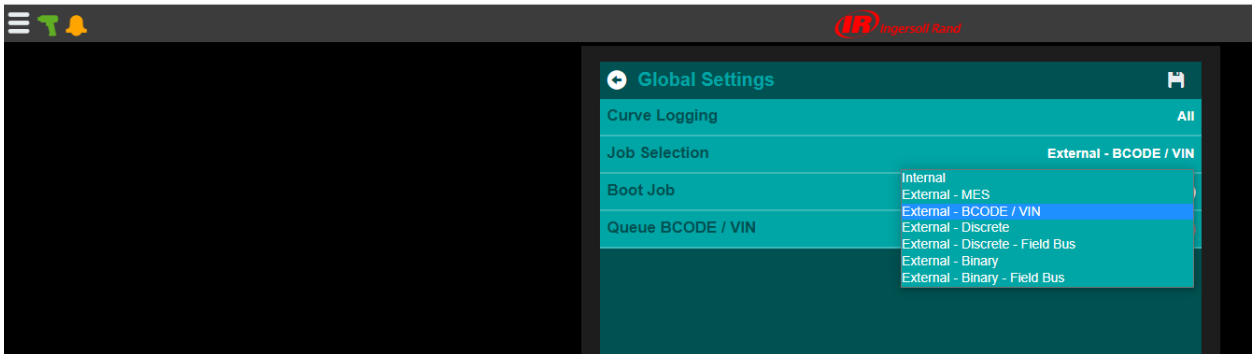


10. Selecting a bit from the bit tray will select the corresponding Job on the controller.

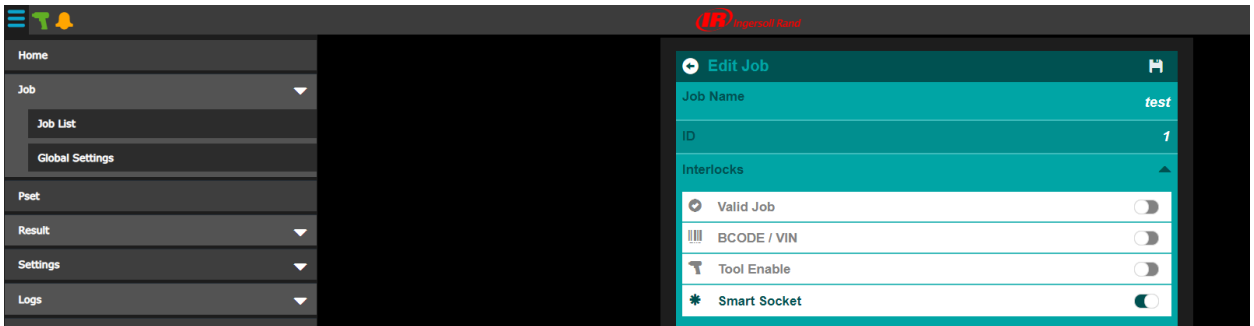
## Programming the Controller for Smart Bit selection

Note: In this mode, the LEDs guide the operator in which bit to pick. This requires Job selection from some other external device, such as discrete inputs, barcode reader, open protocol, fieldbus, etc.

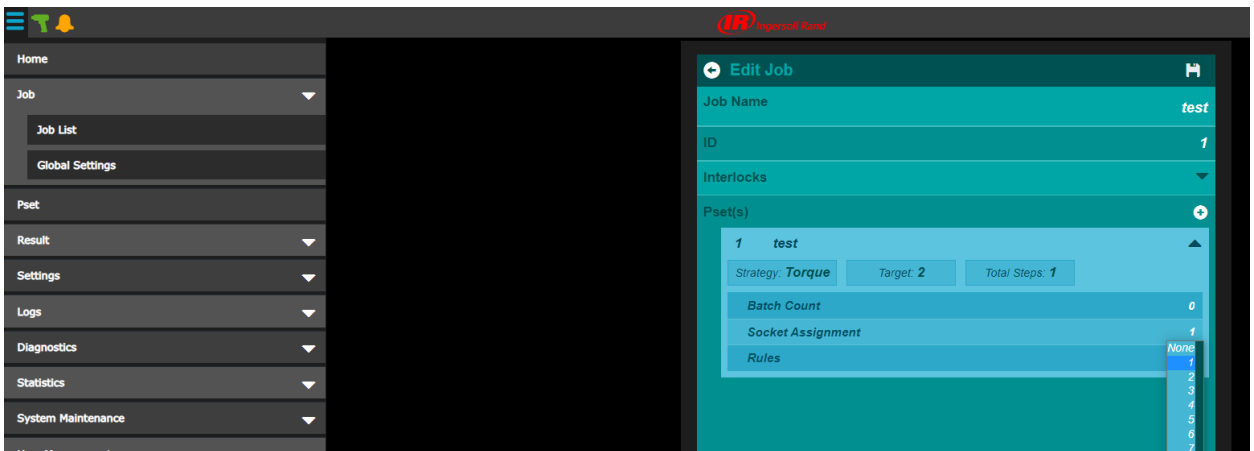
11. On the controller, select the appropriate Job Selection Mode.



12. Enable Smart Socket Interlock for each Job.



13. Assign a Socket Assignment for each Job.



14. Assign the Inputs for Socket Selection as shown below.

Points	Behavior	Polarity
Point 1	Socket 1	Normally Close
Point 2	Socket 2	Normally Close
Point 3	Socket 3	Normally Close
Point 4	Socket 4	Normally Close
Point 5	Socket 5	Normally Close
Point 6	Socket 6	Normally Close
Point 7	Socket 7	Normally Close
Point 8	Socket 8	Normally Close

15. Assign the Outputs for Socket indicators as shown below.

Points	Behavior	Polarity	Timeout (sec)
Point 1	Socket 1	Normally Open	0
Point 2	Socket 2	Normally Open	0
Point 3	Socket 3	Normally Open	0
Point 4	Socket 4	Normally Open	0
Point 5	Socket 5	Normally Open	0
Point 6	Socket 6	Normally Open	0
Point 7	Socket 7	Normally Open	0
Point 8	Socket 8	Normally Open	0

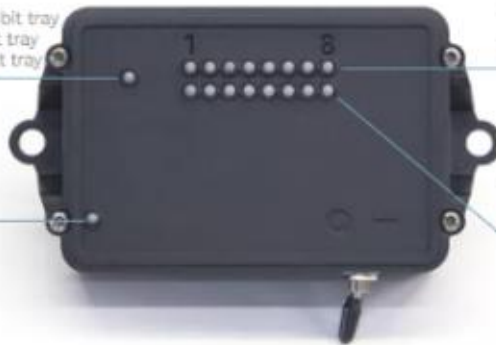
16. For this case, the Barcode scan selects the Job. The corresponding LED will light on the Bit Tray. The operator will pull the corresponding Bit from the Bit Tray and the tool will run the correct Job.

## LED Indicators - DIO

### Communication Status

- Blue = on & not connected to bit tray
- Green = on & connected to bit tray
- Red = Lost connection with bit tray

Power Indication - Red when on



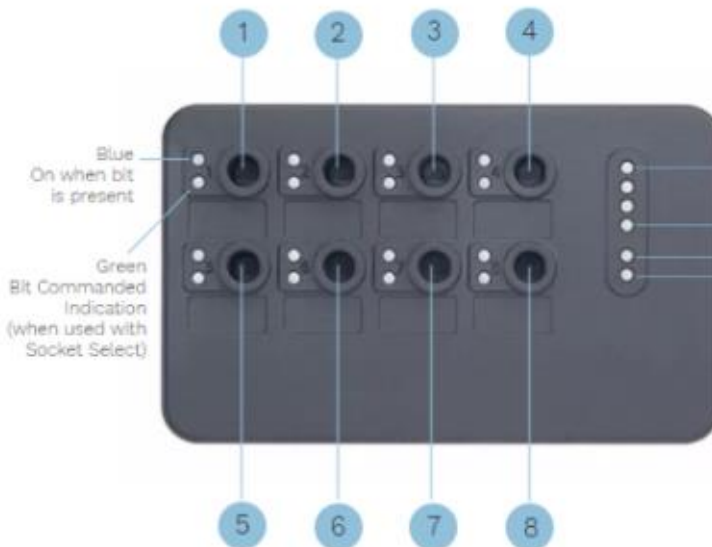
### Upper row of 8 - Blue

- Triggered by the outputs of the controller
- #1 is the left, #8 is far right.

### Lower row of 8 - Green

- Bit Presence Indicator
- Will be blue if a bit is sensed.

## LED Indicators - Bit Tray



### Charge Status

- All 4 Green = fully charged

### Charging Status

- Blue = charging
- Green = fully charged

### Communication Status

- Blue = on, not connected to DIO
- Green = on & connected to DIO
- Yellow flashing = low battery
- Red = lost connection

