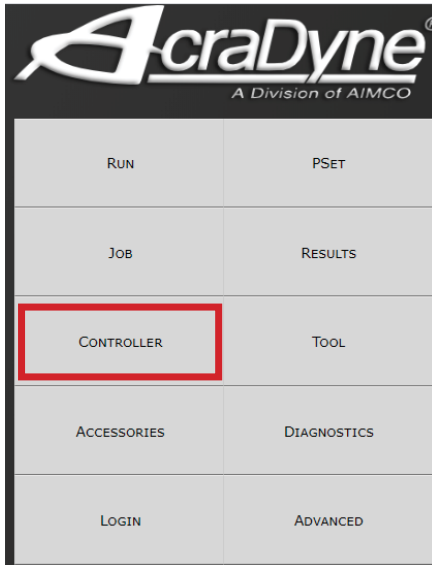
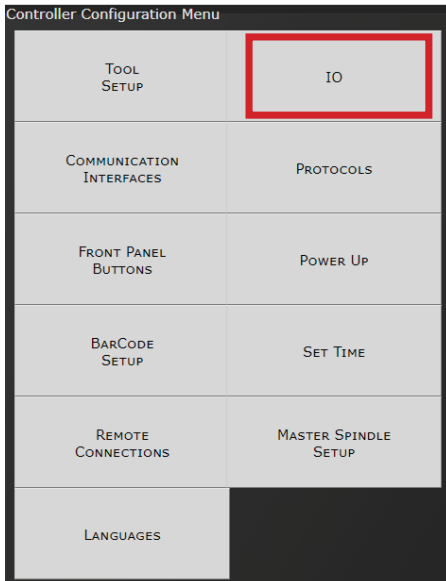


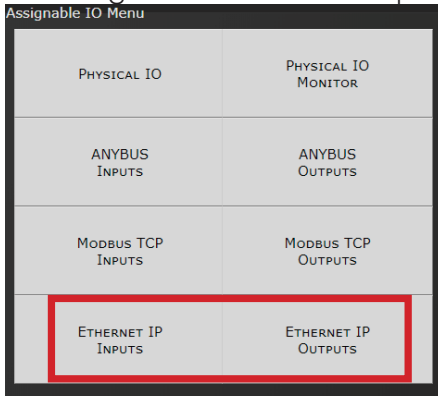
From the main menu, select Controller.



Select IO.



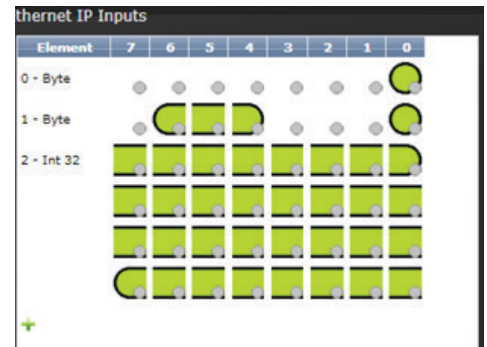
Following are the Ethernet IP options



NOTE: It is recommended that the request packed interval is configured for 100 ms.

### Controller Inputs Addressing

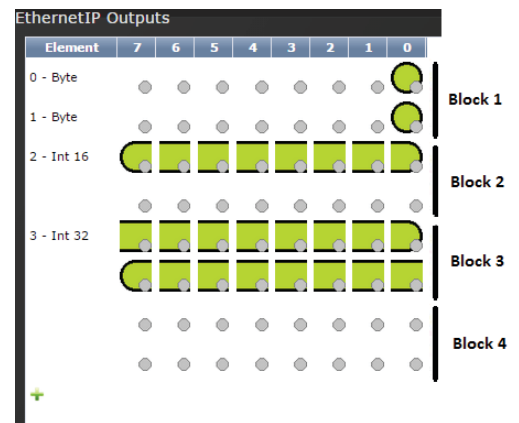
The controller's assignable inputs are mapped to the clients Ethernet/IP outputs. The Ethernet/IP outputs start at assembly instance 112 and uses



block sizes that can be allocated for 8, 16, or 32 bits. These values must match the assignments made on the controller. For most applications, it is helpful to create assignments with a size of INT16. This example is configured for a block size of 4 with a 16-bit data type.

### Controller Outputs Addressing

The controller's assignable outputs are mapped to the clients Ethernet/IP inputs. The Ethernet/IP inputs start at assembly instance 100 and uses

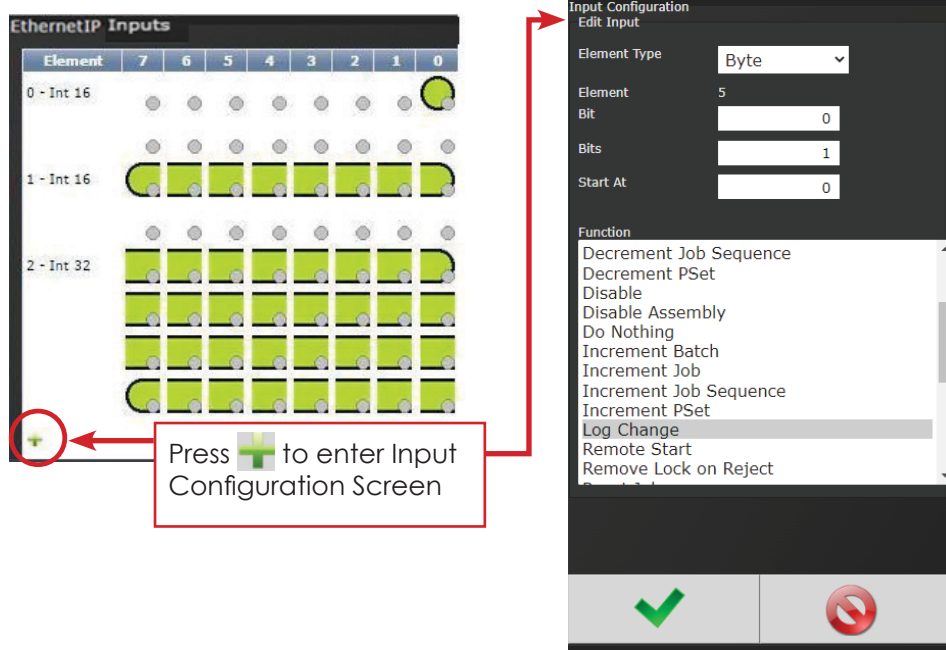


block sizes that can be allocated for 8, 16, or 32 bits.

These values must match the assignments made on the controller. For most applications, it is helpful to create assignments with a size of INT16. This example is configured for a block size of 4 with a 16-bit data type.

## Ethernet IP Inputs

These types of communication are useful for data communication between controller and PLCs. It is an effective, quick way for the data transfer of short data packages.



Press to enter Input Configuration Screen

**Element Type:** Choose from Byte, Int16, Int32, or ASCII.

**Element:** Shows element # being configured

**Bit** (not shown): Enter Bit #.

**Bits:** # of bits the assignment will read.

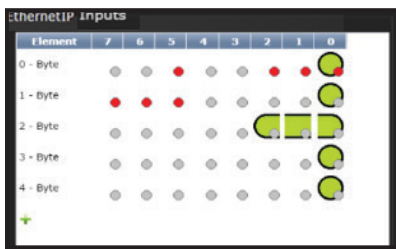
**Start at:** Starting bit location.

**Polarity** (not shown): Select Normally Open (N.O.) or Normally Closed Outputs (N.C.).

**Length** (not shown, available in ASCII ID function): Number of characters desired to send.

**Torque** (not shown, available in Click Wrench function): Torque value to be reported when using Click Wrench input. Value input is what will be sent from controller when Input Signal is received from a Click Wrench. **Value is NOT calculated by the controller rather it is solely what the Click Wrench is calibrated to by outside means.**

Example of the Ethernet IP Input screen with five Inputs set up.



Click on to change an individual Element or return to Input Configuration screen.



Will delete individual Elements.

**Torque Units** (not shown, available with Click Wrench function): Choose from Nm, Kgm, Kgcm, Ftlb, and Inlb.


**Function:** See the Gen IV Controller User Manual for more details. Select desired Input Function(s).

Click on after appropriate selections are made.

## Ethernet IP Outputs

EthernetIP Outputs

Element	7	6	5	4	3	2	1	0
0 - Byte	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>
1 - Byte	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>
2 - Int 16	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
3 - Int 32	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>

Press  to enter Output Configuration Screen

Output Configuration  
Edit Output

Element Type:

Element:

Bit:

Polarity:

Mode:

Function (\* Limited or no functionality on this controller)

- Angle
- Angle High
- Angle Low
- Angle NOK
- Angle OK
- Barcode Scanned
- Batch Complete
- Error
- External Controlled
- Fastener Removed
- Fastening Aborted
- Fastening Complete

**Element Type:** Choose from Byte, Int16, Int32, or ASCII.

**Element:** Shows element # being configured

**Bit:** Enter Bit #.

**Bits (not shown):** # of bits the assignment will read.

**Start at:** Starting bit location.

**Polarity:** Select Normally Open or Normally Closed Outputs.

**Mode:**

- **Normal:** Output signal sent.
- **Timed Signal Sent:** Time entered in seconds
- **Flash Signal Sent:** Time entered in seconds


**Function:** See the Gen IV Controller User Manual for more details on assignable functions.

Click on  after appropriate selections are made.

Example of the Ethernet IP Output screen with five Outputs set up.

EthernetIP Outputs

Element	7	6	5	4	3	2	1	0
0 - Byte	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
1 - Byte	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>
2 - Byte	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
3 - Byte	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>

 Will delete individual Elements.

Click on  to change an individual Element or return to Input Configuration screen.



Will delete individual Elements.