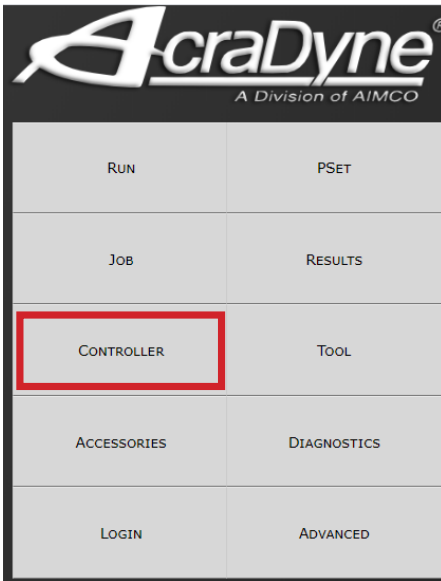
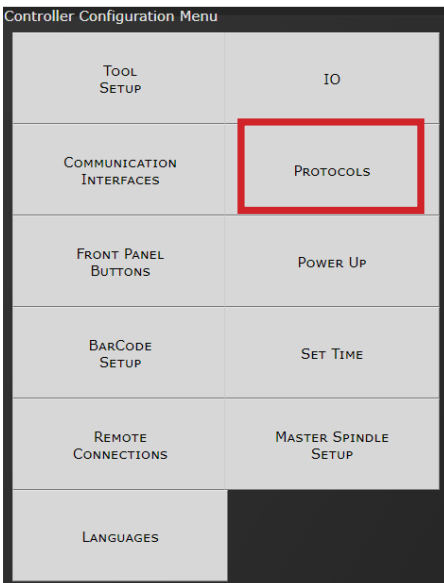


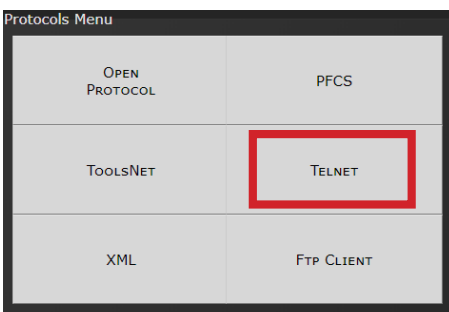
From the main menu, select Controller.



Select Protocols.



Then select Telnet.



Enable: Enable/Disable Telnet feature (It is enabled by default).

Port: The TCP port the controller will listen on and accept a connection. The default is 23.

Port Mode:

- **Serial Output:** Will send out a serial string at the end of each rundown.
- **Barcode Reader:** Acts as a serial barcode reader. Each new string received on this port will be passed to the ID system the same as a serial barcode reader.
- **Serial Output and Barcode Reader:** Is both.

Serial Output Formats:

- Standard
- Standard with PSet
- UEC Serial Modified
- Profibus
- UEC Serial
- CVS String

Output Followed by Null Control Character: Adds a one-byte NULL character to the end of the serial string. Needed by systems that use the NULL character to signify the end of the string. See following section for more information.

Send PSet Change: Sends a serial string any time the PSet is changed. String is in the form '%CAN8X%CAN4YNAC%' where X is the previous pset and Y is the new pset. See following section for more information.

Send Job Completed: Sends a serial string containing "Job Completed" whenever a job has been completed.

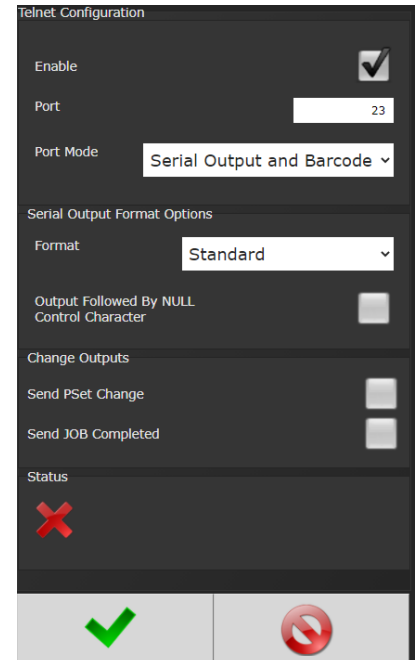
Status:



Indicates no host is connected to the controller.



Indicates there is a host connected. Included are the host IP address and time the connection was established.



Serial Output Format Options

Standard Output Format:

- O P HHHHH LLLLL TTTT P HHHHH LLLLL AAAAA CR CR NULL*
 - O: Overall Pass/Fail
 - 'P' = Pass, 'F' = Fail
 - P: Torque Pass/Fail
 - * 'P' = Pass, 'F' = Fail
 - HHHHH: Torque High Limit
 - Units selected in the PSet X10
 - LLLLL: Torque Low Limit
 - * Units selected in the PSet X10
 - TTTT: Torque Result
 - Units selected in the PSet X10
 - P: Angle Pass/Fail
 - 'P' = Pass, 'F' = Fail
 - HHHHH: Angle High Limit
 - Degrees
 - LLLLL: Angle Low Limit
 - Degrees
 - AAAAA: Angle Result
 - Degrees
 - CR: Carriage return control character
 - CR: Carriage return control character
 - NULL*: Null control character (*if option is selected)

Standard Output with Carriage Return, Line Feed and PSet Format:

- O P HHHHH LLLLL TTTT P HHHHH LLLLL AAAAA T CR LF NULL*
 - O: Overall Pass/Fail
 - 'P' = Pass, 'F' = Fail
 - P: Torque Pass/Fail
 - 'P' = Pass, 'F' = Fail
 - HHHHH: Torque High Limit
 - Units selected in the PSet X10
 - LLLLL: Torque Low Limit
 - Units selected in the PSet X10
 - TTTT: Torque Result
 - Units selected in the PSet X10
 - P: Angle Pass/Fail
 - 'P' = Pass, 'F' = Fail
 - HHHHH: Angle High Limit
 - Degrees
 - LLLLL: Angle Low Limit
 - Degrees
 - AAAAA: Angle Result
 - Degrees
 - 1: PSet
 - PSet('1' - '9') for PSets 1-9, ('A' - 'Z') for PSets 10-35
 - CR: Carriage return control character
 - LF: Line feed control character
 - NULL*: Null control character (*if option is selected)

UEC Serial Modified Format (matches some Gen4 earlier versions):

- # P 1 BB TTT.T AAAA PPPP 0000 J CR NULL*
 - #: Message Start
 - P: PSet
 - PSet('1' - '9') for PSets 1-9, ('A' - 'Z') for PSets 10-35
 - 1: Spindle Number (Always 1)
 - BB: Job Bolt Count
 - Total number of accepts during the Job
 - TTT.T: Torque Result
 - Units selected in the PSet
 - AAAA: Angle Result
 - Degrees
 - PPPP: Pulse Count
 - 0000
 - J: Judgment
 - '@' = Overall Pass, 'H' = Low Torque, 'I' = High Torque, 'J' = Low Angle, 'K' = High Angle, 'G' = Fault During Fastening
 - CR: Carriage return control character
 - NULL*: Null control character (*if option is selected)

Profibus Output Format:

- %CAN T O P HHHHH LLLLL TTTT P HHHHH LLLLL AAAAA NAC% CR LF NULL*
 - %CAN: Message Start
 - 1: PSet
 - * PSet('1' - '9') for PSets 1-9, ('A' - 'Z') for PSets 10-35

- O: Overall Pass/Fail
 - * 'P' = Pass, 'F' = Fail
- P: Torque Pass/Fail
 - * 'P' = Pass, 'F' = Fail
- HHHHH: Torque High Limit
 - * Units selected in the PSet X10
- LLLLL: Torque Low Limit
 - * Units selected in the PSet X10
- TTTT: Torque Result
 - * Units selected in the PSet X10
- P: Angle Pass/Fail
 - 'P' = Pass, 'F' = Fail
- HHHHH: Angle High Limit
 - Degrees
- LLLLL: Angle Low Limit
 - Degrees
- AAAAA: Angle Result
 - Degrees
 - NAC%: Message End
- CR: Carriage return control character
- LF: Line feed control character
- NULL*: Null control character (*if option is selected)

UEC Serial Format (matches UEC 4800 and Gen3):

- # 1 P BB TTT.T AAAA PPPP 0000 J CR NULL*
 - #: Message Start
 - 1: Spindle Number (Always 1)
 - P: PSet
 - * PSet('1' - '9') for PSets 1-9, ('A' - 'Z') for PSets 10-35
 - BB: Job Bolt Count
 - * Total number of accepts during the Job
 - TTT.T: Torque Result
 - * Units selected in the PSet
 - AAAA: Angle Result
 - * Degrees
 - PPPP: Pulse Count
 - L = Low Pulse Count, M = High Pulse Count
 - 0000
 - J: Judgment
 - * '@' = Overall Pass, 'H' = Low Torque, 'I' = High Torque, 'J' = Low Angle, 'K' = High Angle, 'G' = Fault During Fastening, '*' = None of these conditions apply
 - CR: Carriage return control character
 - NULL*: Null control character (*if option is selected)

'CSV String'

- S01,JB01, TTT.T, S, AAA.A, S, O, MM/DD/YYYY HH:MM:SS, VVV<CR><LF>
 - S01: Spindle number
 - JB01: Job number
 - TTT.T: Torque
 - S: Torque Status (A = OK, H = High, L = Low)
 - AAA.A: Angle
 - S: Angle Status (A = OK, H = High, L = Low)
 - O: Overall Status (A = OK, R = NOK)
 - MM: Month
 - DD: Day
 - YYYY: Year
 - HH: Hour
 - MM: Minute
 - SS: Second
 - VVV: 32 character barcode ID
 - <CR>: Carriage Return
 - <LF>: Line Feed

'Output Followed by NULL Character'

- The NULL characters can be seen by using PUTTY and connecting to the controller in 'Raw' mode. Then set logging to log all output and check the log to see the NULL characters.

'Send PSet Change'

- PSets up to 9 match the number, 10-35 are A-Z, greater than 35 is '*':
 - %%CAN8X%% %%CAN4YNAC%%
 - X: Last PSet
 - Y: New PSet



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