Gen IV iEC4W, iEC4W1, iEC4W2, iEC4WF Controller Operation Manual
1. Safety Information

General Power Tool Safety Warnings

⚠️ WARNING
Read all safety warnings and instructions. Save all warnings and instructions for future reference.

1. Work area safety
   a. Keep work area clean and well lit.
   b. Do not operate power tools in explosive atmospheres, such as in the presence of flammable liquids, gases or dust.
   c. Keep children and bystanders away while operating a power tool.

2. Electrical safety
   a. Power tool plugs must match the outlet. Never modify the plug in any way. Do not use any adapter plugs with earthed (grounded) power tools.
   b. Avoid body contact with earthed or grounded surfaces, such as pipes, radiators, ranges and refrigerators.
   c. Do not expose power tools to rain or wet conditions.
   d. Do not abuse the cord. Never use the cord for carrying, pulling or unplugging the power tool. Keep cord away from heat, oil, sharp edges or moving parts.
   e. When operating a power tool outdoors, use an extension cord suitable for outdoor use.
   f. If operating a power tool in a damp location is unavoidable, use a residual current device (RCD) protected supply.

3. Personal safety
   a. Stay alert, watch what you are doing and use common sense when operating a power tool. Do not use a power tool while you are tired or under the influence of drugs, alcohol or medication.
   b. Use personal protective equipment. Always wear eye protection.
   c. Prevent unintentional starting. Ensure the switch is in the off-position before connecting to power source and/or battery pack, picking up or carrying the tool.
   d. Remove any adjusting key or wrench before turning the power tool on.
   e. Do not overreach. Keep proper footing and balance at all times.
   f. Dress properly. Do not wear loose clothing or jewelry. Keep your hair, clothing and gloves away from moving parts.

4. Power tool use and care
   a. Do not force the power tool. Use the correct power tool for your application.
   b. Do not use the power tool if the switch does not turn it on and off.
   c. Disconnect the plug from the power source and/or the battery pack from the power tool before making any adjustments, changing accessories, or storing power tools.
   d. Store idle power tools out of the reach of children and do not allow persons unfamiliar with the power tool or these instructions to operate the power tool.
   e. Maintain power tools. Check for misalignment or binding of moving parts, breakage of parts and any other condition that may affect the power tools operation. If damaged, have the power tool repaired before use.
   f. Use the power tool, accessories and tool bits etc., in accordance with these instructions, taking into account the working conditions and the work to be performed.

5. Service
   a. Have your power tool serviced by a qualified repair person using only identical replacement parts.
2. Controller Diagram

2.1 Front Panel

<table>
<thead>
<tr>
<th>LED Indicator Lights</th>
<th>Function</th>
</tr>
</thead>
<tbody>
<tr>
<td>Green</td>
<td>Indicates fastening cycle meets specified parameters.</td>
</tr>
<tr>
<td>Red</td>
<td>Indicates fastening cycle rejected for exceeding high torque.</td>
</tr>
<tr>
<td>Red Flashing</td>
<td>Indicates low torque. Fastening cycle was rejected for not achieving low torque.</td>
</tr>
<tr>
<td>Yellow</td>
<td>Indicates High Angle. Fastening cycle was rejected for exceeding high angle.</td>
</tr>
<tr>
<td>Yellow Flashing</td>
<td>Indicates Low Angle. Fastening cycle was rejected for not achieving low angle.</td>
</tr>
<tr>
<td>Blue</td>
<td>Tool is in-cycle, above threshold.</td>
</tr>
</tbody>
</table>

- Ethernet Port RJ45: Connection used to connect external computer to configure/monitor controller.
- PSet/Job Switch: Changes PSet/Job display.
- USB Port: Import and Export of Data.
- Switch System Port: Connection used USB Connection used to connect external computer to configure/monitor the controller.

2.2 Side View

- Power Cord Connection
- Tool Connector: 19 Pin Standard connection point for tool cable.
- Fan Connector: For tools equipped with an on-board cooling fan.
- Torque/Angle
- Power Switch: Turns controller on and off.
3. Initial Setup

**Step 1:** Connect tool cable to Tool Connector. Cable consists of a male pin set housed in a molded 19 pin connector with a polarizing notch. Align tool cable notch with tool connector notch on the controller and insert cable. Securely thread connector coupler to controller body.

**Step 2:** Repeat above process to connect tool cable to AcraDyne tool being used with the controller.

**Step 3:** Plug female end of power cable into Power Cable Connector.

**Step 4:** Plug male end of power cable into appropriate power source.

Due to a variety of 230VAC power outlets, the standard power cable plug-end provided with the controller may need to be modified in order to connect to local 230VAc power outlets. AcraDyne has a wide variety of country-specific power cord options available. Check with your authorized AcraDyne representatives to see if your specific configuration is available. In any case, connection to local power should be made in consultation with a qualified electrician.

**Step 5:** The Secondary Protective Earth Attachment needs to be clamped properly to ground.

**Step 6:** Turn controller on by pushing the Power Disconnect Switch to the POWER ON position, a light indicates power on.

**NOTE:** Warning will appear if the controller is power cycled too quickly. If fault appears, Power Down controller, wait a minimum of 10 seconds between controller Power Down and Power Up to clear error and restart controller.

3.1 Connecting to the Controller

There are three ways to program/communicate with the controller:

- Controller touch-screen console
- System Port: (USB connection) Direct connection to controller.
- Ethernet Port: Via direct connection or LAN.

**Touchscreen Console**

Controller functions and programming can be accessed directly through the touch-screen.

1. Power on controller.
2. Run screen will appear
3. Controller is ready for use.

**Connecting via the System Port Directly to PC**

The following is an example using Window 7. Your screen may look different depending on the operating system.

**Windows USB Setup**

1. Power on PC and controller, allow enough time for them to become fully operational.
2. Attach controller to PC using a USB 2.0 A-B cable. If this is the first time connecting the devices, wait for Windows to install the RNDIS driver. This should happen automatically.
3. After the driver is installed, go to ‘Control Panel’.
**Step 4:** Go to ‘Network and Internet’.

**Step 5:** Go to ‘Network and Sharing Center’.

**Step 6:** Go to ‘Change adapter settings’.

**Step 7:** Find the Local Area Connection that is using the ‘USB Ethernet/RNDIS Gadget’ network. Right click this network and go to ‘Properties’.

**Step 8:** In Properties window select ‘Internet Protocol Version 4’ and click ‘Properties’.

**Step 9:** In ‘Properties’, set the IP address to a static address.

Type an IP address of 192.168.1.5 (Any address on the same subnet as the controller will work). Set subnet mask to 255.255.255.0

**Step 10:** To connect to the controller, open a browser such as Chrome or Firefox. Enter 192.168.1.4, the default system port IP address.
Connecting using the Ethernet Port Directly or via LAN to PC

**Step 1:** Make a physical connection from controller’s Ethernet (1) port to a network router connected to the LAN using an ethernet cable.

**Step 2:** Verify the controller’s Ethernet (1) IP address by using the touchscreen or a system port browser session and going to Controller → Communication Interfaces → Ethernet. For controllers that have an LED display, the IP address can also be found by using the toggle button to show it on the secondary LED display.

**Step 3:** If the controller’s IP address has not been configured, consult your Network Administrator for selecting a correct IP address, Subnet Mask, and Gateway for your network.

**NOTE:** Controller does not have a DHCP client, it will not automatically configure itself with a useable IP address.

**Step 4:** Set the static IP address of the PC to 10.10.30.98 and subnet mask to 255.255.255.0. (For instructions, see the example in “Step 9” earlier in this section.)

**Step 5:** To connect to the controller, open a browser such as Chrome or Firefox and navigate to the controller’s Ethernet address.

If the connection is successful the controller’s run screen will be displayed in the browser.

3.2 Quick Set Up (Default PSets from Tool)

On the Home Page press to accept default PSet Parameters:

This will generate three generic PSets for the tool connected to the controller. It will automatically use the 40%, 60%, and 80% of the rated maximum torque of the tool in a two-stage Torque Control Strategy (TC). A prompt will display rated Max Torque and Max RPM of the connected tool for reference. These Psets can be modified to meet application requirements.
Graph displays curves representing Torque (black trace) and Angle (blue trace). The blue left arrow at the origin of the graph will change the X-axis of the rundown curve from Time (In-Cycle) to Time (Overall) and Angle.

Below the graph is a historical table that will give information and status of the most recent rundowns, including current PSet, accepted/failed rundown status, torque and angle.

Arrows allow user to scroll left or right for viewing real time Job information such as Run Screen or rundown indicators.

Home tab will return user to the Home Page.

Click for curve detail.

Click on blue arrow to change curve X axis.

Choose Time In-cycle, Time Overall, Angle or Angle In-Cycle screen,

Run Screen displays real time Job information.

**4.1 Run**

The Run Screen is essentially the dashboard of the Gen IV controller and provides a look at real-time information regarding rundowns.

| JOB: | Indicates the current JOB. |
| PSet:01 | Indicates the current PSet in which you are operating. |
| ✓ | Indicates accepted rundown. |
| ✗ | Indicates failed rundown. |
| 11.90 Nm 210° | Displays Torque and Angle for current rundown. |
Large Screen Indicators and Audit Information
The large screen indicators are helpful in viewing real time results of the rundown from a distance.

Example of Accepted Job

Example of Failed Job
4.2 PSet

Parameter Settings (PSets) control the fastening process. The following describes the different fastening strategies and how to setup the basic PSet parameters necessary to perform a fastening. Up to 256 PSets are available.

4.2.1 Add New PSet

On Home Page press the **PSet** tab.

On PSets screen press + to add a new Pset.

- **Add a PSet**
- **Edit a PSet**
- **Copy a PSet**
- **Delete a PSet**

**Default PSets:** see "3.2 Quick Set Up" on page 7

**Manage:** (see "4.2.5 Manage PSets" on page 24)

On Add New PSet screen (below) enter appropriate values.

- **PSet Number:** Current PSet to be added.
- **Torque Units:** Unit of measure.
- **In Cycle Torque:** Threshold value at which tool is "In Cycle" and results from the Rundown will be reported.
- **Cycle Complete Torque:** Torque level that determines completion of a fastening cycle.

**Time Limit(s) (sec):** Maximum allowable time tool is allowed to run.

**Advanced Options:** see "4.2.4 Advanced Options" on page 23

Once PSet values are entered press + to enter Add New Stage screen.

4.2.1.1 Add New Stage

A single stage or multiple stages build a PSet. Up to 20 stages can be assigned per PSet.

The following stage options are available:

**Once the desired stage(s) are selected and configured, press + to save stage and again to save the PSet and return to initial PSet menu.**

Next Press + to go to the RUN screen or + to return to the Home page. The tool should now be operational and you are ready to run a configured PSet.
4.2.2 PSet Stages

4.2.2.1 TC Torque Control Stage

Control strategy uses torque as the only control parameter. The tool stops when Torque Target is reached. Rundown is considered to be successful (Accept) if the stage peak torque value falls within the range specified by the Torque High Limit and the Torque Low Limit parameters.

Torque High: The upper control limit of the rundown.

Torque Target: Final desired torque.

Torque Low: The lower control limit of the rundown.

Speed (RPM): Tool Output speed target.

Acceleration (kRPM/s): The length of time it will take for tool to change speed. The lower the value the slower the acceleration (see “Glossary” on page 55 for detailed description).

Stage Timeout (s): Maximum allowable time (in seconds) in this stage. If time is exceeded, the tool will stop and Rundown will be terminated.
4.2.2.2 TC_AM Torque Control Angle Monitor Stage

Control strategy is convenient for detection of cross threaded or stripped fasteners. Rundown is considered to be successful (Accept) if the stage peak torque value falls within range specified by Torque High Limit and Torque Low Limit and final angle value falls within the range specified by Angle High Limit and Angle Low Limit parameters.

Torque High: Upper control limit of the rundown.

Torque Target: Final desired torque.

Torque Low: The lower control limit of the rundown.

Angle Bailout: Determines when to stop the tool on angle during any Torque Control strategy. Should be set equal to or above High Angle. Units are degrees of rotation.

Angle High: Maximum acceptable angle rotation in degrees.

Angle Low: Minimum acceptable angle rotation in degrees.

Angle Reference: (drop down menu)
- Overall Angle: Angle is measured starting from lever/trigger pull.
- In-cycle Angle: Angle is measured from In-Cycle torque value (determined in PSet screen).
- Stage Angle: Angle is measured from Reference Torque. If Stage Angle is selected, this will be the start point (in Torque) at which angle is monitored.

NOTE: Set Reference Torque to zero to measure Stage Angle from the beginning of the stage.

Reference Torque: If Stage Angle is selected in the Reference menu, this will be the Torque start point at which angle is monitored.

Speed (RPM): Tool Output speed target.

Acceleration (kRPM/s): How quickly the tool will change speed. The lower the value the slower the acceleration (see “Glossary” on page 55 for detailed description).

Stage Timeout (s): Maximum allowable time (in seconds) in this stage. If time is exceeded, the tool will stop and the Rundown will be terminated.
4.2.2.3 AC_TM Angle Control Torque Monitor Stage

Control strategy in which the tool stops when Angle Target is reached or Torque High Limit is exceeded. Rundown is considered to be successful (Accept) if the stage peak torque value falls within range specified by torque upper and lower limits and final angle value falls within the range specified by Angle High Limit and Angle Low Limit parameters.

- **Angle High**: Maximum allowed angle rotation in degrees.
- **Angle Target**: Angle target desired.
- **Angle Low**: Minimum allowed angle rotation in degrees.
- **Angle Reference**: (drop down menu)
  - **Overall Angle**: Angle is measured starting from lever/trigger pull.
  - **In-cycle Angle**: Angle is measured from In-Cycle torque value (Determined in PSet screen).
  - **Stage Angle**: Angle is measured from Reference Torque.

**Reference Torque**: If Stage Angle is selected in the reference menu, this will be the start point (in Torque) at which angle is monitored.

**NOTE**: Set Reference Torque to zero if you want Stage Angle measured from the beginning of the stage.

- **Torque Bailout**: Determines when to stop the tool based on torque value during any Angle Torque Bailout value should be equal or greater than High Torque.
- **Torque High**: Upper control limit of the rundown.
- **Torque Low**: Lower control limit of the rundown.
- **Speed (RPM)**: Tool Output speed target.
- **Acceleration (kRPM/s)**: How quickly the tool will change speed. The lower the value, the slower the acceleration (see "Glossary" on page 55 for detailed description).
- **Stage Timeout (s)**: Maximum allowable time (in seconds) in this stage. If time is exceeded, the tool will stop and the Rundown will be terminated.
4.2.2.4 TC_AC Torque Control Angle Control Stage

Control strategy in which the tool stops if Target Torque or Target Angle is reached, whichever happens first.

Rundown is considered to be successful (Accept) if the stage peak torque value falls within range specified by Torque High Limit and Torque Low Limit, and final angle value falls within the range specified by Angle High Limit and Angle Low Limit parameters.

Torque High: Upper control limit of the rundown.
Torque Target: Final desired torque.
Torque Low: Lower control limit of the rundown.
Angle High: Maximum allowed angle rotation in degrees.
Angle Target: Angle target desired.
Angle Low: Minimum allowed angle rotation in degrees.
Angle Reference: (drop down menu)
- Overall Angle: Angle is measured starting from lever/trigger pull.
- In-cycle Angle: Angle is measured from In-cycle value (determined in PSet screen.)
- Stage Angle: Angle is measured from Reference Torque.

Reference Torque: If Stage Angle is selected in the Reference Menu, this will be the start point (in Torque) at which angle is monitored.

NOTE: Set Reference Torque to zero if you want Stage Angle measured from the beginning of the stage.

Speed (RPM): Tool Output speed target.

Acceleration (kRPM/s): How quickly the tool will change speed. The lower the value, the slower the acceleration (see “Glossary” on page 55 for detailed description).

Stage Timeout (s): Maximum allowable time (in seconds) in this stage. If time is exceeded, the tool will stop and the Rundown will be terminated.
### 4.2.2.5 Yield Control Stage

#### Yield Target %
Programmable with a default setting of 50%.

The lower this value, the more sensitive the strategy will be. Too low could cause early and false detection.

The higher this value, the less sensitive the strategy will be. A more pronounced change in slope is required for the yield to be determined.

The measurement is joint specific and 0% when parallel to the slope determined to be the elastic range and 100% when the slope is horizontal.

Joint Rate parameters have default settings of 5 samples every 20 degrees. This resolution can be adjusted if needed.

See "AC_TM Angle Control 
Torque Monitor Stage” on page 13 for Torque, Angle, Speed, and Time parameter details.

#### Torque Bailout
Determines when to stop the tool based on torque value during any Angle Torque Bailout value should be equal or greater than High Torque.

#### Torque High
Upper control limit of the rundown.

#### Torque Low
Lower control limit of the rundown.

#### Angle Bailout
Determines when to stop the tool on angle during any Torque Control strategy. Should be set equal to or above High Angle. Units are degrees of rotation.

#### Angle High
Maximum acceptable angle rotation in degrees.

#### Angle Low
Minimum acceptable angle rotation in degrees.

#### Angle Reference
(drop down menu)
- **Overall Angle**: Angle is measured starting from lever/trigger pull.
- **In-cycle Angle**: Angle is measured from In-Cycle torque value (determined in PSet screen).
- **Stage Angle**: Angle is measured from Reference Torque. If Stage Angle is selected, this will be the start point (in Torque) at which angle is monitored.

**NOTE**: Set Reference Torque to zero to measure Stage Angle from the beginning of the stage.

#### Reference Torque
If Stage Angle is selected in the Reference menu, this will be the Torque start point at which angle is monitored.

#### Speed (RPM)
Tool Output speed target.

#### Acceleration(kRPM/s)
How quickly the tool will change speed. The lower the value the slower the acceleration (see “Glossary” on page 55 for detailed description).

#### Stage Timeout (s)
Maximum allowable time (in seconds) in this stage. If time is exceeded, the tool will stop and the Rundown will be terminated.

This strategy detects the yield of the fastener and reports the torque and angle that resulted from the fastening event.

Controlling by detecting Yield is very beneficial on joints where clamp load varies greatly relative to final torque.

This strategy can be used alone or combined with other strategies as steps in a parameter set. As an example, a common fastening strategy could be three steps:

- **Torque Stage** – To set a minimum threshold
- **Yield Stage** – To control clamp load
- **Angle Stage** – To attain a specific bolt stretch above Yield

For more details please go to www.AIMCO-global.com/Resources/Manuals/Yield Control


### 4.2.2.6 Delay Stage

This stage determines the time delay between stages.

**Time Delay (s):** Total time (in seconds) the tool stops and waits before proceeding to the next stage. Default is 0.2 (sec).

![Delay Stage](image)

### 4.2.2.7 Unfasten Stage

This feature is a specific “backoff” stage used, for example, in a Rundown-Backoff or Rundown-Backoff-Rundown configuration. NOTE: In this stage, the tool always runs opposite of the thread direction.

**Angle High:** Maximum allowed angle rotation in degrees.

**Angle Target:** Degrees of rotation the tool will backoff in reverse.

**Angle Low:** Minimum allowed angle rotation in degrees.

**Torque Bailout:** Determines when to stop the tool based on torque value during any Angle Control strategy; should be equal or greater than High Torque.

**Torque High:** Upper control limit of the rundown.

**Torque Low:** Lower control limit of the rundown.

**Speed (RPM):** Tool Output speed target (in the unfastening direction).

**Acceleration (kRPM/s):** How quickly tool will change speed. The lower the value, the slower the acceleration (see "Glossary" on page 55 for detailed description).

**Audit Enable:**

- **False:** When set to False the stage will not be evaluated for pass or fail.
- **True:** When set to True the stage will be evaluated for pass or fail using high and low limits.

**Stage Timeout (s):** Maximum allowable time (in seconds) in this stage. If time is exceeded, the tool will stop and the Rundown will be terminated.
4.2.2.8 Ergo Stop Stage

Ramps cut-off power when fastening achieves Target Torque or Target Angle value. This feature reduces torque reaction to the operator in a hand-held tool as final torque or angle is achieved.

**Ramp Down Time (s):** Total time (in seconds) to ramp down to zero current/torque.

**Torque Current Reduction %:** Amount (in percent) to reduce the current to the motor.

4.2.2.9 Brake Stop Stage

The Brake Stop Stage is used for electronic braking of the tool. It can be helpful in applications where a high RPM is used for the rundown, helping to reduce torque and angle target overshoot.

The Brake Stop stage is also required after a high torque target stage, to prevent the tool motor from springing backwards too fast as the tool gearing relaxes. This motor back drive can cause a voltage spike on the drive DC bus. This spike in voltage can result in drive or other faults to occur. As a guideline, rundown exceeding 1,000Nm should have a brake stop as the final stage.

**Brake Hold Time (s):** Amount of time (in seconds) that brake is applied.

**Duty Cycle %:** Manual control the strength of the brake force – a higher value is stronger

**Auto-Release:** Automatically controls the strength of the brake force and releases when cycle complete torque is reached. It is recommended to enable this when using the brake stop to relax the joint after a high torque rundown, to prevent voltage spikes.
4.2.2.10 AC_TA Angle Control Torque Averaging Stage

Control Strategy that is helpful in applications where the rotational resistance measured can produce a pass or fail reading. This will help in gauging rolling resistance of a given part and aid in detecting latent failures in rotating assemblies.

**Angle Target:** Angle target desired.

**Angle Low:** Minimum allowed angle rotation in degrees.

**Angle Reference:** (drop down menu)
- **Overall Angle:** Angle is measured starting from lever/trigger pull.
- **In-cycle Angle:** Angle is measured from In-Cycle torque value determined in PSet screen).
- **Stage Angle:** Angle is measured from Reference Torque.

**Reference Torque:** If Stage Angle is selected in the Reference menu, this will be the Torque start point at which angle is monitored.

**Torque Bailout:** Determines when to stop the tool based on torque value during any Angle. Torque Bailout value should be equal or greater than High Torque.

**Torque High:** Upper control limit of the rundown.

**Average High:** The average high torque of the rundown.

**Average Low:** The average low torque of the rundown.

**Speed (RPM):** Tool Output speed target.

**Acceleration (kRPM/s):** How quickly the tool will change speed. The lower the value the slower the acceleration (see “Glossary” on page 55 for detailed description).

**Stage Timeout (s):** Maximum allowable time (in seconds) in this stage. If time is exceeded, the tool will stop and the Rundown will be terminated.

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<table>
<thead>
<tr>
<th>Pass</th>
<th>Fail</th>
</tr>
</thead>
<tbody>
<tr>
<td><img src="image1" alt="Pass Graph" /></td>
<td><img src="image2" alt="Fail Graph" /></td>
</tr>
</tbody>
</table>

**Pass**
- Average Torque falls within Avg. Torque limits.
- Reported torque is the average of the torque measured during the AC_TA Stage.
- Notice that final torque is greater than the Avg. Torque High limit.

**Fail**
- Average Torque greater than Avg. Torque High limit.
- Reported torque is the average of the torque measured during the AcTa Stage.
4.2.2.11 AC_TCOMP Angle Control Torque Compensation Stage

The Angle Control Torque Compensation Strategy is used to compensate for the prevailing torque of the fastener. The prevailing torque can be averaged over a set angle and the torque will be adjusted by the average torque measured, allowing its effect to be removed from the final torque applied to the fastener.

Setup: See "AC_TA Angle Control Torque Averaging Stage" on page 18.

This strategy will behave the same as Angle Control Torque Averaging (AC_TA) with the additional re-taring of the torque transducer; it has all the same parameters.

The Problem
In the two following fastening cycles, the final torque is 4Nm. The first fastening has about 1Nm of prevailing torque during the free run and the second has about 2Nm. In the first fastening, about 3Nm of torque goes into the final clamping load of the joint. The second fastening only gets about 2Nm of torque to clamp the part, 33% less than the first.

Removing the Prevailing Torque
The strategy will measure the average prevailing torque over a given angle. At the completion of the stage the torque transducer will have its tare value adjusted by the average torque. Removing the prevailing torque readings for the remainder of the fastening cycle.

In the fastening shown, the first stage is an Angle Control Torque Compensation strategy followed by a torque control strategy to 4Nm. This will allow a consistent 4Nm to be applied to the clamp load of the part.

4.2.2.12 AC_TCOMP Display of Torque Compensation Value

LED Display: The bottom LED display field can be configured to display the Torque Compensation Tare Value by using the toggle button to select ‘COMP’ from the available options.

Run Screen: In addition to the Final Audit Torque, the Final Torque Total and the Torque Compensation Value will be displayed if an AC_TComp stage was completed during the rundown.
### 4.2.2.13 Sync Stage

Set synchronization point between stages for spindle networks. All spindles will wait on this stage until all controllers are ready to proceed to the next stage.

**Stage Timeout (s):** Total time in seconds the controller will wait in this stage before timing out and aborting the rundown.

### 4.2.2.14 Thread Forming Stage

The ‘Thread Forming PSet Strategy’ can be used in fastening applications where the initial thread forming torque is greater than the final torque target to be left on the fastener. This strategy is intended to be used as the first stage of a multistage PSet, prior to the final audit stage.

The Thread Forming Strategy is a variant of the Angle Control Torque Monitoring (AC_TM) Stage, which in addition, includes a reset of the overall peak torque value when the stage completes. This provides a way to reset the peak torque value after thread forming so that only the peak torque from the fastening portion of the rundown is used for the overall evaluation of the rundown and reported.

**Sequence of Operation:** The stage will run until the angle target is reached, or is terminated early. If the stage completes successfully the overall peak torque is reset to the current torque value, then the next stage in the sequence will begin. If the stage is terminated early, or fails on the torque and angle limits, the overall peak torque is not reset and the rundown will be terminated.

**Setup:** See “AC_TM Angle Control Torque Monitor Stage” on page 13 for Torque, Angle, Speed, and Time parameter details.)
4.2.2.15 Homing Stage

Control strategy in which the tool’s output returns to a home position in the direction set in the parent PSet. The home position is defined by the position of the output when the controller is powered on. The stage is considered successful (Accept) if the output travels and stops within the home region, defined by the angle high and low limits. If the output is already in the home region when the stage begins, the tool will perform a revolution first. When the output crosses the lower limit, the tool will brake to a stop. After completing the stage, the position of the output, referenced from the home position, will be reported.

**Angle High:** Upper limit of the Tool Output position defining the home region. (Units: Degrees from the Home position in the direction of rotation defined in the PSet)

**Angle Low:** Lower limit of the Tool Output position defining the home region. (Units: Degrees from the Home position in the opposite direction of rotation defined in the PSet).

**Torque Bailout:** The tool will stop if this torque is exceeded. The Torque Bailout value should be equal or greater than High Torque.

**Torque High:** Upper control limit of the rundown.

**Torque Low:** Lower control limit of the rundown.

**Speed (RPM):** Tool Output speed target.

**Acceleration (kRPM/s):** How quickly the tool will change speed. The lower the value the slower the acceleration (see “Glossary” on page 55 for detailed description).

**Stage Timeout (s):** Maximum allowable time (in seconds) in this stage. If time is exceeded, the tool will stop and the Rundown will be terminated.

**Note:** To maintain the tool’s home position without drifting, some tools will require a more refined value for the tool parameter PPRO. Please contact an AIMCO representative for instructions on how to load this value into the tool if it is needed.
### 4.2.2.16 AC_TM Anti-Necking Stage

**Angle High:** Maximum allowed angle rotation in degrees.

**Angle Target:** Angle target desired.

**Angle Low:** Minimum allowed angle rotation in degrees.

**Angle Reference:** (drop down menu)
- **Overall Angle:** Angle is measured starting from lever/trigger pull.
- **In-cycle Angle:** Angle is measured from In-Cycle torque value (determined in PSet screen).
- **Stage Angle:** Angle is measured from Reference Torque.

**Reference Torque:** If Stage Angle is selected in the Reference menu, this will be the start point (in Torque) at which angle is monitored.

**NOTE:** Set Reference Torque to zero if you want Stage Angle measured from the beginning of the stage.

**Torque Bailout:** Determines when to stop the tool based on torque value during any Angle Torque Bailout value should be equal or greater than High Torque.

**Torque High:** Upper control limit of the rundown.

**Torque Low:** Lower control limit of the rundown.

**Percent Peak Torque Drop:** The maximum allowed percentage torque drop from peak torque during a rundown. If the final torque is too low, a low torque will be reported.

**Speed (RPM):** Tool Output speed target.

**Acceleration (kRPM/s):** How quickly the tool will change speed. The lower the value the slower the acceleration (see "Glossary" on page 55 for detailed description).

**Stage Timeout (s):** Maximum allowable time (in seconds) in this stage. If time is exceeded, the tool will stop and the Rundown will be terminated.

Control strategy in which the tool stops when Angle Target is reached, or Torque High Limit is exceeded. Rundown is considered to be successful (Accept) if the stage peak torque value falls within the range specified by torque upper and lower limits and final angle value falls within the range specified by Angle High Limit and Angle Low Limit parameters. If the final torque of the rundown is not within the parameter specified by Percent Peak Torque Drop, the rundown is considered be unsuccessful and a low torque will be reported.
4.2.3 Edit PSet

On Home page press 

On the PSet screen click on the desired PSet you would like to edit.

Click on the Edit button to make changes in the Edit screen (below).

4.2.4 Advanced Options

If further Stage changes are needed click the Edit button again to enter Edit Stage screen (below).

Once desired changes are made click twice to save changes.

PSet Name: Add PSet name if desired (up to 10 characters).

Thread Direction: Defines fastening direction (default is right hand).

Re-hit/Reject Parameters: Prevents the fastening of an already tightened fastener. If enabled, tool will stop and the rundown will be aborted, if the angle of rotation between the Re-Hit Reference Torque and the In-Cycle Torque is less than the Re-Hit Angle Count.

NOTE: If the attempted rundown is a Re-Hit, it will not be reported or recorded.

Re-hit Reject Enable: Enables the feature.
**Re-Hit Reference Torque**: This torque value is the start of the angle count that determines a Re-Hit. (This value should be lower than the In Cycle Torque specified in the PSet.)

**Re-Hit Angle Count**: If the angle count between the Re-Hit Reference Torque and the In Cycle Torque is less than this value, the rundown is determined to be a Re-Hit.

**Joint Compensation Ratio**: Adjusts the target torque of the tool to compensate for joint characteristics. This value has an inverse relationship with the target torque (Output torque = Target Torque / Ratio). Ratio values above 1.0 result in a lower output torque where values below 1.0 result in higher output torques.

**Report Trigger Loss as NOK**: If enabled and a rundown is terminated early before completion:

- The overall result of the rundown will be reported as a reject.
- The torque and angle status will be reported as evaluated with the following exception: If torque and angle are both within limits, the torque and angle status will both be reported as low. This is done to further indicate that the rundown was terminated before completion.

### 4.2.5 Manage PSets

**Save PSets to Browser**

Allows the PSet information to be saved to the local PC connected to controller. PSet information is saved as a .txt file and can be opened using any text editor such as WordPad. It can also be opened with Excel. The format of the .txt file is tab separated values.

**Export PSets to Browser**

Save the PSets as a database file to the PC connected to controller. These PSets can later be imported to another controller.

**Import PSets from Browser**

Import previously exported PSets to controller.

**Delete PSets**

Enables deletion of selected PSets.
4.2.6 Multistage Rundown Evaluation and Reporting

If a rundown cycle completes, or is terminated early while in or after the final audit stage of the PSet:
• The overall evaluation of the rundown will be determined using the torque and angle limits set in the final audit stage.
• The peak torque and angle achieved during the rundown, are used for the evaluation and reported.
• The torque and angle status, and overall result reported, will reflect this evaluation.

Note: The fastening torque must achieve the In-Cycle torque value set in the PSet for the rundown to be evaluated or reported.

If a rundown is terminated early before reaching the final audit stage:
• The overall result of the rundown will be reported as a reject.
• The torque and angle evaluation will be determined using the limits set in the stage that was running when the rundown was terminated.
• The torque and angle at the point in time when the rundown was terminated, is used for the stage evaluation.
• The torque and angle status reported will reflect this stage evaluation with the following exception:
  ○ If torque and angle are both within limits of the stage that was running, or if the stage was a non-audit stage, the torque and angle status will both be reported as low. This is done to further indicate that the rundown terminated before reaching the final audit stage.
• The peak torque and angle achieved during the rundown will be reported.

Note: The fastening torque must achieve the In-Cycle torque value set in the PSet for the rundown to be evaluated or reported.

Unfastening Stage special considerations:
• Rundown Back-Off multi stage PSet (Unfastening as the last stage)
  ○ If the unfasten stage is set to ‘Non Audit’:
    ▪ The peak torque and angle reported from the fastening portion of the rundown will be used for the evaluation and reported.
  ○ If the unfasten stage is set to ‘Audit’:
    ▪ The final torque and angle in the unfastening direction, at the point in time when the run cycle completes or is terminated, will be used for the evaluation and reported.
    ▪ The final torque and angle will be reported as negative in the unfastening direction.
    ▪ If the rundown cycle is terminated before reaching the final unfastening audit stage, the final torque and angle values will be reported as zero and the torque and angle status will be reported as low.
• Rundown Back-Off Rundown multi stage PSet (Unfastening as a middle stage)
  ○ The value for peak torque in the forward direction, will be reset to zero when tool begins an unfastening portion of the rundown.
  ○ If the rundown is terminated during the unfastening stage, the final torque and angle values will be reported as zero and the torque and angle status will be reported as low.

Torque Averaging Stages (AC_TA and AC_TCOMP) reporting exception:
• If a torque averaging stage fails to complete, or is the final audit stage, and the peak torque is less than the high torque limit, the final torque reported will be the torque average during that stage.

Torque and angle measurement details:
• Peak Torque is used for the overall evaluation and reported:
  ○ The peak torque achieved, from the start of the rundown to the when the torque falls below the cycle complete value set in the PSet
• Torque is used for the stage evaluation:
  ○ The torque at the point in time when the stage was terminated or completed
• Peak Angle is used for the overall evaluation and reported:
  ○ The peak angle achieved, measured from the angle reference set in the final audit stage, to the when the torque falls below the cycle complete value set in the PSet
  Note: If an angle reference is not defined in the final audit stage, the angle is measured from when the torque first crosses the In-Cycle torque set in the PSet.
• Angle is used for the stage evaluation:
  ○ The angle at the point in time when stage was terminated or completed, measured from the angle reference set in the stage.
  Note: ‘Audit Stages’ are stages that have torque and angle limits defined. These stages include:
    ▪ TC Stage
    ▪ TC_AM Stage
    ▪ TC_AC Stage
    ▪ AC_TM Stage
    ▪ AC_TA Stage
    ▪ AC_TCOMP Stage
    ▪ Unfastening Stage (If Audit is selected)
  Note: If the evaluation of any stage during the rundown fails, or a bail out limit is exceeded, the fastening cycle will be terminated early and any subsequent stages will not run.
4.2.7 Multiple Stage Rundown Examples

**EXAMPLE:** Two-stage rundown with downshift

This example shows a typical two stage rundown with a higher first stage free speed and slower down shift speed to minimize overshooting of the target torque.

**EXAMPLE:** Three stage rundown with unfasten on the last stage. (Rundown Back-off)

This example shows a typical three stage rundown with a back-off stage at the end of the rundown.

**NOTE:** The unfasten stage’s audit parameter is set to false, therefore, the torque and angle reported are from the fastening portion of the rundown.

**EXAMPLE:** Four stage rundown with an unfasten stage in the middle. (Rundown back off Rundown)

**NOTE:** The peak torque was reset at the start of the fastening stage. The torque reported was from the final stage.
4.3 Job

A Job is a collection of PSets which can be run when performing multiple fastening operations on a single application.

Jobs provide:
- Error proofing
- Logical grouping of PSets
- Fastening order
- Job status

4.3.1 Add New Job

To add a new Job press on the Home Page. Press on Jobs screen (above) to enter Add New Job screen (below)

Job Number: Up to 99 Jobs can be configured.

Job Name: Enter Job Name

Job Action:
- **Disable Tool:** Enable/Disable Job function.

After appropriate values are entered, press to go to Add New Job Sequence screen.

4.3.1.1 Advanced Options

Enter Advanced Options if needed

Lock on Reject
Enable: When enabled, this prevents tool from starting a new rundown if the result of the last rundown was a reject. Tool remains locked until one of the four Unlock Mode conditions are satisfied.

Unlock Mode:
- **Reverse:** Running tool in disassembly mode.
- **Reverse and Throttle:** Running tool in disassembly mode.
- **Reverse and Unlock Torque:** Exceeding “Unlock Torque” while tool is in the disassembly direction (backing off a rejected fastener).
- **Any MFB Press:** Setting an MFB button on tool (regardless of MFB configuration).

Once values are entered press two times to return to Job screen.
Unlock Torque: If Unlock Mode is set to “Reverse and Unlock Torque”, this torque value must be exceeded when the tool is in the disassembly direction in order to unlock the tool.

Limit Reject Parameters:
   Enable/Disable
   Maximum Rejects: Enter # of rejects allowed

Report Missing Fasteners:
Add an option to each JOB that would allow us to report any missing fasteners. When it is set, the controller will report an NOK rundown for each fastener that is defined in the JOB but has not been ran. These NOK results will be reported whenever a new job is started AND the prior JOB is incomplete.

These generated NOK results are treated like any other fastening. They are displayed on the run screen, stored in the results and transmitted on all protocols.

4.3.2 Jobs “Enabled” Display and Button Function

- Pressing the toggle button will change secondary display between:
  - Units of measure
  - Ethernet 1 IP address
  - System port IP address
  - Angle report
  - Bolt count
  - Job sequence

NOTE: Job sequence shows which PSet you are currently on in the job (this is not the pset number). The first pset in the job is always job sequence 1, and the next is 2, etc.

Bolt count is shown as current bolt count out of total number of bolts. Example: If you have 3 total bolts. When you start the job you will see 0.3. After one rundown you will see 1.3 and then 2.3 on the next run and so on until the job is completed.
4.4 Results

This screen provides a history of rundowns performed. Information such as ID Number, Time Stamp, Parameter Set#, Accept/Reject status, and Torque and Angle are recorded for each rundown.

Click on Individual Runs for Rundown Information.

Example: Rejected Rundown Information.

4.4.1 Saving Rundown(s)

Click on in main rundown screen to view/save total rundown(s).

Then click on on the PC to save or open the file using a text editor such as Notepad. The format of the Rundown file is tab separated variables and can be viewed using Excel. The raw data can now be imported to Excel to build graphs, charts etc. Contact AIMCO Technical Service for pre-made Torque and Angle Templates.

Individual Rundowns

Click on an individual run to view/save rundown information.

Rundown Information View

Sample of Individual Rundown Information
4.5 Controller

The controller menu is where all of the settings for the Gen IV controller are configured. All of the different configuration capabilities are explained below.

4.5.1 Tool Setup

In this screen user can enable/disable various tool functions.

4.5.1.1 Lock Tool On Reject

When enabled, this prevents tool from starting a new rundown if the result of the last rundown was a reject. Tool remains locked until one of the four Unlock Mode conditions above are satisfied.

Unlock Mode: The action that re-enables the tool for use.
- Reverse: Running tool in disassembly mode.
- Reverse and Throttle: Running tool in disassembly mode.
- Reverse and Unlock Torque: Exceeding “Unlock Torque” while tool is in the disassembly direction (backing off a rejected fastener).
- Any MFB Press: Pressing MFB button on tool (regardless of MFB configuration).

Unlock Torque: If Unlock Mode is set to “Reverse and Unlock Torque”, this torque value must be exceeded when tool is in the disassembly direction in order to unlock tool.
4.5.1.2 Buzzer

Set the way the buzzer behaves in OK/NOK situations. Menu options are:
- Silent
- Constant
- Beep

If a rundown is rejected, the beeping can be stopped by making a successful rundown or by using the MFB.

4.5.1.3 Headlight

Headlight Enable: Enables or Disables the Headlight (pistol style tools only).

4.5.1.4 Start Input

Start from IO: Start tool through I/O from external source.

Start From Tool Buttons: Normal operating condition: Tool lever and MFB control tool operation.

Start From Master Tool: Used when one tool’s start lever in the multispindle machine will be used as the start command for the entire system.

Start From Remote Start: Used when the system start command would come over the Eth port connection.

Tool Throttle Configuration: Four options are available:
- Lever or PTS (Push to Start): This the default configuration. Pressing either the Lever or PTS will start the tool.
- Lever and PTS (Push to Start): Both the Lever and the PTS need to be pressed in order to start the tool.
- Lever: Only the Lever will start the tool.
- PTS: Only the PTS will start the tool.

Latching Options:
- Not Latched: Start Input is not latched.
- Latched on Time: Start Input latches if lever is pressed for a set time.
- Latched on MFB: Latches on the following sequence:
  - Press and hold lever.
  - Press MFB while lever is still being held down.
  - Release the lever.
  - Release the MFB.

Latch Hold Time (s): Amount of time (in seconds) the lever needs to be depressed to latch throttle (if Latched on Time is selected above).

NOTE: Throttle will unlatch automatically at the end of the rundown or when the lever is repressed. If the tool is installed with dual levers requiring two-handed operation, the above Start Input Configuration settings will be ignored (see Dual Lever Two Handed Tools section).
4.5.1.5 MFB (Multi-Function Button)

The MFB Mode configures the multiple function button for handheld AcraDyne tools. The button can be configured to operate in any of the following modes:

**Tap Mode:** Actions will commence if MFB is held less than hold time.

- **Disabled:** MFB button will not work.
- **Disassembly Toggle:** Depress the MFB each time to switch between forward and reverse.
- **Disassembly One Shot:** Tool will automatically return to forward after fastening. The MFB will NOT have to be depressed for forward operation.
- **Change PSET:** Tapping MFB button toggles between PSet A and PSet B. Status lights flash once indicating PSET A is selected or twice indicating PSET B is selected.
- **Change Job:** Tapping MFB button changes jobs.
- **Arming:** Tapping MFB button arms (activates) the Start function but does not start the tool. Blue status light illuminates indicating tool is Armed. Arming resets in three seconds if tool Start is not initiated.
- **Stop Reject Tone:** Tapping MFB silences the audible reject tone.
- **Increment PSET Number:** Tapping MFB will switch upward to next PSet.
- **Increment Job Number:** Tapping MFB switches upward to next Job.
- **Increment Job Sequence:** Tapping MFB switches to next PSet in the current Job.

**Tap A Parameter:** Assign a specific PSet (Job) to the “A” parameter, toggle back and forth between “A” and “B” parameters using MFB.

**Tap B Parameter:** Assign a specific PSet (or Job) to the “B” parameter.

**Hold Time (s):** Amount of time (in seconds) required to hold the MFB until Hold Action is triggered.

**Hold Mode:** Actions will commence after Hold timer preset time has elapsed (Adjustable in Hold Time window). Default value is one second.

**NOTE:** The same options are available in Hold mode as in Tap mode.
4.5.1.6 Disassembly

**Overall Timeout (s):** Total amount of time, in seconds, after throttle is depressed that tool will operate.

**Speed (RPM):** Maximum speed of the Output spindle.

**Acceleration (kRPM/s):** Rate at which tool is set to ramp up to maximum RPM.

**Report Disassembly:** If enabled, disassembly events will be reported and logged.

**Threshold Torque:** Disassembly will be reported only if this torque value is reached. This is entered as a positive value.

**Torque Units:** Units for the Disassembly Threshold Torque

**Decrement Fastener Count:** If Disassembly is detected the fastener count in JOBS

- **Never:** Decrement count will be ignored
- **Always:** Decrement will always be active
- **Only after NOK:** Decrement only occurs after a tightening has been judged to be NOK (Reject)

**When a disassembly event is reported:**
The disassembly will be displayed on the run screens and logged in the rundown record, containing the following:

- Overall evaluation will be marked as ‘Disassembled’ Peak torque during the disassembly (torque shown as negative).
- Peak overall angle during the disassembly (angle shown as negative).
- Curve data from the disassembly
- Parameters from the current PSet selected
- Fastening events from the disassembly.

All of the controller’s status LEDs will be turned OFF. The LED display will show peak torque and angle as negative

**I/O Considerations:**
When disassembling, all assignable IO outputs that report rundown status will remain in the state from the last fastening cycle. This includes:

- Ok and Nok signals
- Torque/Angle high or low signals
- Torque and Angle Values

All assignable I/O outputs reporting a fastening events will not change state during the disassembly. This includes:

- Fastening Complete
- In Cycle
- Fastening Stopped
- Fastening Aborted

**NOTE:** When the tool is placed into disassembly mode, all of the tool’s LEDs flash and the Horn beeps. This will continue until the tool is placed back into fastening mode.
4.5.1.7 Tubenut

**Trigger Action:** Two options are available

- **Release and Repress**: Socket will return Home on release and repress of main lever.
  
  **NOTE:** If the main lever is released while homing in this configuration the tool will stop and will continue to Home once the lever is repressed.

- **Release**: Socket will return Home upon release of main lever.

**Speed (RPM):** The speed in RPMs which a tubenut tool will return to the open position (default 50 RPM).

**Acceleration (kRPM/s):** Rate at which tool is set to ramp up to maximum homing RPM.

**Reverse Dwell Time (s):** Amount of time (in seconds) before Output attempts to return Home, after Home command is initiated (default 500ms).

**Hold at Home Dwell Time (s):** Amount of time (in seconds) Output is held at Home position (default 500ms).

**Retry Home when Disabled:** This will allow a retry of the tube-nut homing sequence (by releasing then repressing the lever) even if the controller has been disabled or the stop input is on.

**NOTE:** Output is held at Home for the Home Dwell Time to prevent socket from bouncing back to partially closed position.

---

4.5.1.8 Past Due Service Calibration

**Service Past Due:** Four options are available:

- **No Action**: No Action will be taken.
- **Log Error**: Errors will be saved on Service Log.
- **Display Error**: Calibration/Service message will appear on screen between each rundown. Tool remains functional.
- **Disable Tool**: Disable tool in preset Service period. Exceeded (date/ time) LED warning appears on the controller.

**Calibration Past Due:** Same options as above
### 4.5.2 I/O

**NOTE:** See Gen IV IEC Manual section "11 Assignable I/O" for more detail on Input Functions.

#### 4.5.2.1 Modbus TCP/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.

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

**Element:** Shows element # being configured.

**Bit:** Enter Bit #.

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

**Start at:** Starting bit location.

**Length** (not shown): Number of Characters desired to send when in ASCII ID function.

**Torque** (not shown): 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.**

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

**Function:** See Gen IV IEC Manual section "11 Assignable I/O" for more detail on Input Functions.

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

**Will delete individual Elements.**

Example of the Anybus Input screen with five inputs set up.

Press [ ] to enter Input Configuration Screen.
### 4.5.2.2 Modbus TCP/Ethernet IP Outputs

**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** (not shown): 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 Gen IV IEC Manual section "11 Assignable I/O" for more detail on Output Functions.

Click on ![ ] after appropriate selections are made.

Example of the Anybus Output screen with five Outputs set up.

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

Will delete individual Elements.
4.5.3 Communication Interfaces

### 4.5.3.1 Ethernet

<table>
<thead>
<tr>
<th>Ethernet</th>
<th>System Port</th>
</tr>
</thead>
<tbody>
<tr>
<td>Ethernet</td>
<td>Serial USB</td>
</tr>
</tbody>
</table>

**IP Address:** IP address of controller’s Ethernet port.

**Subnet Mask:** Subnet mask of the controller.

**Gateway:** Gateway is the IP address of the gateway computer that provides access beyond the local network.

**Note:** Consult your local System Administrator to connect the controller to your Network and assign IP addresses.

### 4.5.3.2 System Port

**IP Address:** The IP address of controller’s System Port (Default is 192.168.1.4)

**Subnet Mask:** The Subnet Mask of controller’s System Port.

**Note:** It is not recommended to change this setting.

### 4.5.3.3 Spindle USB Port

This can be used to set up a 2 spindle network through the USB port.
4.5.3.4 Serial Port

**Serial Output Formats:** See "Serial Output Format Options" on page 39 for details.
- 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.

**Gen IV Serial Port Pin-out**

<table>
<thead>
<tr>
<th>Pin</th>
<th>Signal</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td></td>
</tr>
<tr>
<td>2</td>
<td>RX</td>
</tr>
<tr>
<td>3</td>
<td>TX</td>
</tr>
<tr>
<td>4</td>
<td>DTR</td>
</tr>
<tr>
<td>5</td>
<td>GND</td>
</tr>
<tr>
<td>6</td>
<td></td>
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<td>7</td>
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<td>9</td>
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</tbody>
</table>

<table>
<thead>
<tr>
<th>Pin 1</th>
<th>Pin 5</th>
</tr>
</thead>
<tbody>
<tr>
<td>Pin 6</td>
<td>Pin 9</td>
</tr>
</tbody>
</table>

**Port Mode:** The following modes are available:
- **PI Line Control:** This is customer specific. Please reference PI Line Control Document on Aimco Website/Product Manuals.
- **Serial Output:** A serial data string will be Output in the following format after each rundown:
  - `# P 1 BB TTT.T AAAA 0000.0000 J`
    (Notice the decimal point next to the least significant T)
  - P: Parameter set ("1" – "9") for PSets 1-9, ("A" – "W") for PSets 10-32.
  - B: Job count
  - T: Torque result
  - A: Angle result
  - J: Judgment (@=overall pass, H=low torque, I (eye)=hi torque, J=low angle, K=hi angle)
- **Barcode Reader:** See "5. Barcode Reader Details" on page 54 for Barcode setup.
- **Serial Output and Barcode Reader:** Select from dropdown and configure per hardware requirements
- **Open Protocol:** Select from dropdown and configure per hardware requirements
- **PFCS:** Select from dropdown and configure per hardware requirements

**Baud:** Serial ports can be configured for different baud rates available.
- 75, 110, 300, 1200, 2400, 4800, 9600, 19200, 38400, 57600, 115200

**Data Bits / Stop Bits / Parity:** Configure per hardware requirements
### Serial Output Format Options

#### Standard Output Format:
- O P HHHHH LLLL TTTT P HHHHH LLLL AAAAA CR CR NULL*
  - O: Overall Pass/Fail
  - P: Torque Pass/Fail
    - * P = Pass, 'F' = Fail
  - HHHHH: Torque High Limit
    - Units selected in the PSet X10
  - LLLL: Angle High 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 LLLL TTTT P HHHHH LLLL AAAAA 1 CR LF NULL*
  - O: Overall Pass/Fail
  - P: Torque Pass/Fail
    - * P = Pass, 'F' = Fail
  - HHHHH: Torque High Limit
    - Units selected in the PSet X10
  - LLLL: Angle High Limit
    - Degrees
  - AAAAA: Angle Result
    - Degrees
  - CR: Carriage return control character
  - CR: Carriage return control character
  - NULL*: Null control character (if option is selected)

#### UEC Serial Modified Format (matches some Gen4 earlier versions):
- # P 1 BB TTT.T AAAAA 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
  - CB: Job Bolt Count
    - * Total number of accepts during the Job
  - TTT.T: Torque Result
    - * Units selected in the PSet
  - AAAAA: Angle Result
    - * Degrees
  - PPPP: Pulse Count
  - 0000
  - J: Judgment
    - CR: Carriage return control character
    - NULL*: Null control character (if option is selected)

#### Profibus Output Format:
- %CAN 1 P HHHHH LLLL TTTT P HHHHH LLLL 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/Fall
    - * ‘P’ = Pass, ‘F’ = Fail
  - P: Torque Pass/Fail
    - * ‘P’ = Pass, ‘F’ = Fail
  - HHHHH: Torque High Limit
    - * Units selected in the PSet X10
  - LLLL: 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
  - LLLL: 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)

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Fault During Fastening
- Torque, 'J' = Low Angle, 'K' = High Angle, 'G' = Fault During Fastening
- CR: Carriage return control character
- NULL*: Null control character (if option is selected)

### CSV String:
- S01,JB01,TTT.T, S, A, A, S, O, MM/DD/YYYY HH:MM:SS, VVV<CR><LF>
  - S01: Spindle number
  - JB01: Job number
  - TTT.T: Torque
  - S: Angle Status (A = OK, H = High, L = Low)
  - AAAAA: Angle Result
    - Degrees
  - PPPP: Pulse Count
  - 0000
  - J: Judgment
    - CR: Carriage return control character
    - NULL*: Null control character (if option is selected)

### 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:
- PSet up to 9 match the number, 10-35 are A-Z, greater than 35 is *:
  - %CANX%Y%Z%CAN4YNAC%
  - X: Last PSet
  - Y: New PSet
4.5.4 Protocols

For information about these settings, see individual protocol instructions on AIMCO’s website at www.aimco-global.com

4.5.6 Power Up

Allows user several “Job” choices upon controller Power Up:

**Power Up Job Number:** Controller will power up on the job # selected.
- **Last Job:** When “Last job” is selected, controller will power up on last job selected prior to being Powered Down.

**Power Up Job Action**
- **Reset Job:** Job will be reset when controller is Powered Up.
- **Wait for job Reset:** Controller will wait for an External Job reset command upon Power Up and will retain job information existing prior to power down.

4.5.5 Front Panel Buttons

Enable/ Disable front panel buttons on controller console.

4.5.7 Set Time

Set time and date. If connected to a PC, use PC Time to set controller time.
4.5.8 Remote Connections

Sets number of remote browser connections to controller.

Displays the IP addresses of remote browser connections to the controller.

4.5.9 Master Spindle Setup

Several Gen IV controllers can be linked together via an Ethernet connection to create a multi-spindle network. Operations requiring multiple fasteners to be inserted simultaneously or in a synchronized fashion is possible with this setup. Up to 10 tools can be operated from one master controller. The spindle network can be controlled via physical IO or across supported protocols. PSets will be synchronized across the spindle network so PSets and Jobs will only need to be set up on the master controller. Spindle rundown results are also viewable from the master.

Click "Master Enable" to enter Master Spindle Configuration screen.

Master Enabled: Enable or disable the spindle network.

Stop on Error: All spindles will stop if any problem is reported (bad rundown, a stop condition, or a cable disconnection has occurred on any spindle). If this option is not checked, spindles will finish the current rundown even if an error has occurred on one spindle.

Spindles: Use Dropdown to select number of Spindles to be connected in a Multispindle configuration

Trigger Source: Select whether the start input for running the spindle network comes from the master spindle’s tool trigger, IO, or Remote Start.

*All spindles need to have their start input set to respond to the master tool in order to have them all run from a single trigger or IO start signal. This is configured under Controller → Tool Setup → Start Input and set the input source to ‘Start from Master Tool’.

Latching Options: Select latching throttle option. If Latch on Time is selected, the spindle network will continue to run after the throttle has been held down for the selected amount of time.
4.5.10 Setting up Multi-Spindle Network

**Hardware**
Connect the master controller and slave spindles together via an Ethernet switch. Ensure that all controllers have the appropriate tools connected and apply power.

**Software**
Steps to enable the multi-spindle network:
1. **Configure the IP address of each spindle**: Ensure that they are all on the same subnet.
2. **Set each controller to be controlled from the master controller**: Go to Controller → Tool Setup → Start Input and set the input source to ‘Start from Master Tool’.
3. **Enable the master controller**: The configuration screen for setting up the master spindle controller is found under Controller → Master Spindle Setup. To begin setup, enable the master spindle by clicking on the red X under ‘Master Enabled’. This will unroll several new options. Now set the number of spindles and add their IP addresses to the list. Click OK to add the slave spindles to the master controller. Clicking OK will synchronize PSets and time across the controllers.
4. **Add a PSet**: Once the PSet is saved then it is ready to be run.
5. **View the results**: Spindle network results can be found under the “Spindle Results” tab now appearing on the main menu. Clicking on a spindle result will show the results of each individual spindle.

**Spindle IP Addresses**: The number of spindles listed depends on the number of spindles enabled. Add the IP addresses of the slave spindles to add them to the spindle network.

**PSet**: **Synchronizing Stages**
When setting up a PSet, the Sync stage is available to synchronize spindle rundown. Sync stages allows each spindle to pause between stages and wait for other spindles to reach the same stage before proceeding.

For example, a PSet set up to perform TC, Sync, Unfasten, Sync, TC will ensure that all spindles reach the target torque before going to the unfasten stage. At that time, all spindles will unfasten to the desired angle and will not proceed until each spindle has completed that stage before running down to the final torque. The rundown curve for this type of PSet is shown with four spindles.

**PSet with Sync Example**

<table>
<thead>
<tr>
<th>PS 1 (4Nm, Sync, Unfasten, Sy...)</th>
</tr>
</thead>
<tbody>
<tr>
<td>1 - TC (4, 100RPM)</td>
</tr>
<tr>
<td>2 - Sync (55Sec)</td>
</tr>
<tr>
<td>3 - Unfasten (180°, 200RPM)</td>
</tr>
<tr>
<td>4 - Sync (55Sec)</td>
</tr>
<tr>
<td>5 - TC (8, 100RPM)</td>
</tr>
</tbody>
</table>

Clicking on a spindle result item will display results of each spindle used in the operation.
4.5.11 Languages

Select from:
- English
- Chinese
- Japanese
- Korean
- Spanish
- Portuguese

External Multiplier: Configures tool to include gearing added to the base model.
Units: Gear Ratio * 100 (Example: Adding a multiplier with a gear ratio of 5:1, Multiplier setting = 5).

Gear Inversion: 1 = tool Output rotates same direction as motor
-1 = tool Output rotates in opposite direction as motor.

High Resolution Pulses Per Revolution: Determines resolution of the tool motor hall sensors

Tube Nut Parameters
See “13. Tubenut Tool Setup Details” on page 62 for more information

Obstruction Torque (in-lbf): First 90° of rotation in the fastening direction. Cycle will be aborted if this torque is exceeded. If the tool rotates 90° and stops without any obstruction, the value is too low.

Hold At Home Torque (in-lbf): After reaching the open position, this is the torque preventing socket from bouncing to a partially closed position. This torque should be set to a value slightly less than the tubenut Home torque.

Home Detection Torque (in-lbf): In the reverse direction, reaching this torque indicates to controller that socket is in open position. If socket does not attempt to return to open position, this value is too low. AcraDyne recommends starting at approximately 12 in-lbs.

4.6 Tool

4.6.1 Tool Setup

Allows user to make changes to Tool Setup.

Model Number: Tool model number of tool connected to controller.

Serial Number: Serial Number of current tool connected to controller.

Cycle Count: Total number of cycles since last reset.
4.6.2 Service Log

Service Parameters are stored in memory of tool and can be viewed in this screen. ‘Next Service’ or ‘Next Cal’ will turn red if value entered is exceeded.

4.6.3 Button Calibration

After a tool has been worked on, it is possible the relationship between hall sensors and magnet have changed. Using the ‘Button Calibration’ screen calibrates the field between the two.

Select “Button Calibration” from the Tool Menu.

Tool disable confirmation screen will appear.

Test throttle and MFB (Multi-Function Button), send values to Tool ID board in this screen. Follow the on-screen instructions for button calibration.

4.6.4 Torque Calibration

Manually calibrate and reset tool to Factory Calibration.

4.6.5 Torque Calibration Routine

Used to calibrate tool using a Master Transducer. The following are steps to calibrate tool.

1. Press the “Start Calibration” button.
2. Run Tool to Final Torque.
3. Enter external transducer (Master) value in Measured Torque box.
4. Press “Send New Cal Values to Tool” button.
5. ‘New Cal’ value is calculated automatically and assigned to tool ID Board.
4.6.6 TID Parameters

Used by factory to load Tool ID parameters into tool.

4.6.7 TID Memory

Allows a Qualified Service Technician to view or edit tool.

4.7 Accessories

This screen shows accessories configured in the controller. New accessories can be added, edited, and deleted using the buttons at the bottom of the table. The gear icon navigates to the Accessory Scanning and Setup page.

The Smart Arm Accessory allows an articulated arm with encoders to be used with the Gen IV controller. Fastener locations can be programmed into the controller so that the controller will perform specific actions when the tool is located on a specific fastener.

For more specific instruction contact: AIMCO Technical Service, Toll Free 1-800-852-1368 or go to http://www.aimco-global.com/Resources/Manuals and download the Gen-IV Controller Smart Arm Configuration Manual.
## 4.8 Diagnostics

The Diagnostics menu contains all pertinent information regarding unusual behavior of the system. Detailed descriptions are given in the following sections.

### 4.8.1 Controller Overview

- **Model Number:** Model Number of the controller.
- **Serial Number:** Serial Number of the controller.
- **Type:** Type of controller:
  - **IEC:** Intelligent Electric Controller
  - **IEC4W:** Intelligent Electric Controller 4 Mobile
- **SYSREL:** System Release # shown
- **Application:** Current Application software version.
- **Firmware:** Current Firmware software version.
- **Servo:** Current Servo Drive
- **Available Hardware:** Available hardware on the controller.

### 4.8.2 Controller Status

Shows “Live” status of controller, voltages, active faults, and temperature.

- **Bus Voltages:** Alarm icon will appear on controller console and under “Active Faults” (see below) if any of these values are out of range:
  - **Servo Power:** Live monitoring of power demand from tool to controller
  - **24 Vdc:** Represents voltage from 24V power supply. Value is reported as on or off (.0-24.0 volts) and is for external use via 24V I/O port.
  - **9 Vdc:** Represents voltage from 9V power supply powering Tool electronics.
  - **5 Vdc:** Represents voltage from 5V power supply powering controller electronics.
  - **3.3 Vdc:** Represents controller electronics internal 3.3V Bus voltage.
  - **SOM 1.8 Vdc:** Represents controller electronics internal 1.8V Bus voltage
- **CPU Temperature (° C):** Represents temperature of CPU measured in Celsius.
- **Mainboard Temperature (° C):** Represents temperature inside controller measures in Celsius.
- **Active Faults:** Any tool/ controller faults will be shown in this area.
4.8.3 Tool Overview

This “read only” screen gives an overview of the tool connected to the controller. The information is stored in the memory on the Tool ID board (TID).

- **Model Number:** Model number of tool connected to controller.
- **Serial Number:** Serial number of tool connected to controller.
- **Cycle Count:** Number of fastening cycles tool has performed since counter was reset.
- **Max Speed (RPM):** Maximum free speed of tool output.
- **Max Torque (Nm):** Maximum torque output of tool.

The following information is used internally by AcraDyne Technicians and not generally relevant to the end user:

- **Gear Ratio After Transducer:** Any gearing between transducer and tool output.
- **Gear Inversion:**
  - 1 = Tool Output rotates same direction as motor.
  - -1 = Tool Output rotates in opposite direction as motor. (Example: Tube nut tools typically show -1 for gear inversion)
- **Ext. Multiplier:** Gear ratio of external “after market” multiplier.
- **Pulses/Rev Output:** Number of motor hall pulses that occur per one revolution of motor Output.
- **Transducer Full Scale:** Full scale torque rating of transducer.

4.8.4 Live Tool

Shows a live view of tool transducer in volts. Voltage will be approximately 2.0 volts (± 0.005 Vdc) when tool is at rest and torque is zero (verify the voltage is within the green zone in the graph).

During a rundown, tool transducer voltage increases as torque increases.

Motor Hall sensors A, B, C will be monitored along with tool throttle, Multi-Function Button, and RPM.

4.8.5 Indicators

Allows user to test tool LEDs, headlight, and buzzer.
4.8.6 Identify Controller

‘Identify Controller’ will cause lights on controller and tool to flash making the system easy to locate. This is especially helpful when programming is being done and multiple controllers are being used in close proximity to each other.

4.8.7 Record Logs

Logs information describing usage of controller and tools that have been used with that controller.

4.8.7.1 Change Log
Log displays changes made to tool or controller.

4.8.7.2 Information Log
Log displays all information entries.

4.8.7.3 Error Log
Log displays ONLY Error Entries.

4.8.7.4 All
Displays all Changes, Information and Error entries.

4.8.8 System Status

Network Diagnostics can be useful in troubleshooting Ethernet communication issues

4.8.9 Network Diagnostics

The I/O Diagnostics screen shows a log of all IO state changes from any assignable input or output. This can aid in verifying the correct functionality for IO configuration.

The refresh button will update the screen with the most recent IO changes. The save button will generate a log file that can be viewed on a PC. This file can be downloaded when viewing from a PC or saved to a USB drive when using the controller touch screen. This saved CSV file contains much more detailed information (timing, IO settings, etc) than can be displayed on the controller screen.

Ethernet: Shows if the Ethernet port is physically connected and if the hardware is operational.

Test Connection: Provides a way to check the ethernet connection to other devices on the same network.

Capture: Captures and saves the ethernet traffic for evaluation.
4.8.10 Extended Logging

Extended Logging can provide more details to the rundown’s curve data.

If Extended Logging is enabled, extra fastening events are logged in the curve data.

**NOTE:** Care should be taken when using this feature, as it will require more memory to store the curves and make the saved rundown records larger.

4.9 Login

When a password is required it can be entered in this screen.

Three levels of access to the controller are available:

- **Operator:** Run/Login screens available.
- **Technician:** Run/PSet/Job/Diagnostics and Login screens available.
- **Administrator:** All screens available.

4.10 Advanced

The ‘Advanced’ menu handles complex settings within the controller. Detailed descriptions are given in the following sections.

4.10.1 Default Login Setup

This screen allows the user to select the default Login level upon controller start up.

- **Operator**
- **Technician**
- **Administrator**
Approximately one million rundown can be stored. Twenty files with approximately 50,000 rundown are maintained at a time. The user can, at any time, save the runs to either a USB stick or to the Web as a USV file imported directly into an Excel spreadsheet.

Using the touchscreen console, you can select multiple files to save.

Using the web option, you can select one of these files at a time to save (web option is default).

Select either USB or Web Archive location.

Example of Saved Excel File:

<table>
<thead>
<tr>
<th>Rundown</th>
<th>Job Num</th>
<th>Job Name</th>
<th>Sequence</th>
<th>Bolt count</th>
<th>Status</th>
<th>Date</th>
<th>Time</th>
<th>Torque</th>
<th>Angle</th>
<th>Status</th>
<th>PSet Num</th>
<th>PSet Name</th>
<th>Tool</th>
<th>Mode</th>
<th>Tool Serial ID</th>
<th>Tool ID</th>
<th>Tool ID</th>
<th>Tool ID</th>
<th>Tool ID</th>
</tr>
</thead>
<tbody>
<tr>
<td>2068</td>
<td>0</td>
<td>0</td>
<td>0</td>
<td>0</td>
<td>P</td>
<td>11:11:42</td>
<td>5.08 P</td>
<td>480</td>
<td>---</td>
<td>1</td>
<td>1</td>
<td>0</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>2069</td>
<td>0</td>
<td>0</td>
<td>0</td>
<td>0</td>
<td>P</td>
<td>11:11:49</td>
<td>5.054 P</td>
<td>535</td>
<td>---</td>
<td>1</td>
<td>1</td>
<td>0</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>2070</td>
<td>0</td>
<td>0</td>
<td>0</td>
<td>0</td>
<td>P</td>
<td>11:11:50</td>
<td>5.002 P</td>
<td>450</td>
<td>---</td>
<td>1</td>
<td>1</td>
<td>0</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>2071</td>
<td>0</td>
<td>0</td>
<td>0</td>
<td>0</td>
<td>P</td>
<td>11:11:52</td>
<td>5.013 P</td>
<td>595</td>
<td>---</td>
<td>1</td>
<td>1</td>
<td>0</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>2072</td>
<td>0</td>
<td>0</td>
<td>0</td>
<td>0</td>
<td>P</td>
<td>11:11:53</td>
<td>5.085 P</td>
<td>495</td>
<td>---</td>
<td>1</td>
<td>1</td>
<td>0</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>2073</td>
<td>0</td>
<td>0</td>
<td>0</td>
<td>0</td>
<td>P</td>
<td>11:11:54</td>
<td>5.1 P</td>
<td>440</td>
<td>---</td>
<td>1</td>
<td>1</td>
<td>0</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>2074</td>
<td>0</td>
<td>0</td>
<td>0</td>
<td>0</td>
<td>P</td>
<td>11:11:56</td>
<td>5.089 P</td>
<td>575</td>
<td>---</td>
<td>1</td>
<td>1</td>
<td>0</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>
4.10.3 Import Settings

This allows the user to download any previously saved settings onto the controller (refer to ‘Export Controller’ for help with saving data).

1. Plug the USB with an export file into any port on the controller.
2. From the Home screen, navigate to Advanced → Import Settings.
3. Select the settings to be checking the corresponding box.

Operations: This includes PSets and Jobs.
I/O: This includes I/O settings for the local I/O, Anybus, Modbus, and EtherNet/IP.
Configuration: This includes all settings of the controller except I/O, Master Spindle, Rundowns, PSets or Jobs.
Spindle: This includes any Master Spindle setup (i.e. number of spindles, slave IP addresses, etc).

4. Press ✓ to accept the changes.
5. Press ✓ to proceed.
6. Press ✓ when the import is complete and the controller will restart.

Import settings that were exported from another controller via a USB flash drive. Use this to quickly apply the same settings across several controllers. For example, it is common to have multiple controllers with the same I/O configuration. Set up one controller with the correct I/O configuration and export the controller from Advanced → Export Controller. Now the I/O settings can be imported using this screen.

NOTE: Setting can only be imported from controllers running the same version of software.

4.10.4 Export Controller

This allows the user to save Configuration, Operations, I/O, and Spindle settings onto a USB flash drive.

1. Plug a USB into any port on the controller.
2. From the Home screen, navigate to Advanced → Export Controller.
3. Press ✓ to continue, and the controller will begin the export process.
4. Press ✓ to complete the export.

4.10.5 Update Controller

NOTE: Updated firmware versions will typically be sent via email zip file. Always save PSet and IP address information before upgrading controller.

Upgrading the AIMCO Gen IV Controller
Using the TouchScreen or a System Port browser session, navigate to the ‘Advanced’ menu. Click ‘Update Controller’ and select the latest release.

Click the green checkmark when ready.
4.10.7 Restore Factory Defaults

This allows the user to reset the controller's parameters to factory settings.

1. From the Home screen, navigate to Advanced → Restore Factory Defaults.
2. Select the settings to be changed and accept.
   - **Operations**: This includes PSets and Jobs.
   - **I/O**: This includes I/O settings for the local I/O, Anybus, Modbus, and EtherNet/IP.
   - **Configuration**: This includes all settings of the controller except I/O, Master Spindle, Rundowns, PSets or Jobs.
   - **Results**: This includes all rundown data/information.
   - **Log**: This includes the Change, Information, Error, and Combined logs.
3. Press to accept the changes.
4. Press to proceed.
5. Press when the calibration is complete, the controller will restart.

After the controller restarts, the user should see the following messages:

**Updating System**

**Do not unplug USB**

**Do not Power Off Controller**

This may take a few minutes...

Controller Upgrade Notification

When the controller has finished, navigate to Diagnostics → Controller Overview to view any changes to the 'Software Versions'. Any system settings (Ethernet IP address, PSets, Jobs, etc.) will remain unchanged.

### 4.10.6 Backup Restore

The Backup function allows the user to create an image of the controller software/firmware including all Configurations, Operations, I/O, and Spindle settings. This is used to create a point in which the controller can restore to if the need arises. In that case, the Restore function would be used.

1. From the Home screen, navigate to Advanced → Backup Restore.
2. Press Backup to initialize the backup process.
3. Press to replace previous backup with current system, the backup process will begin.
4. Press Restore to initialize the restore process.
5. Press to restore all settings and firmware to last backup, the restore process will begin.
6. The controller will restart when finished.
### 4.10.8 Previous Software

The ‘Previous Software’ page enables users to change the software to an alternate version. When the controller is updated, the previous version will be retained to easily revert versions. Settings are not affected. Any changes to settings are retained when changing to an alternate version. The screen shows the current version along with the version information of the alternate version.

This feature is only available for versions 3R19 going forward. It is not possible to revert to a release earlier than 3R19.

### 4.10.9 Calibrate Touch Screen

Custom and Factory default calibration are available on the controller console.

1. From the Home screen, navigate to Advanced → Calibrate Touch Screen.
2. Press ✔️ to disable the tool.
3. Select the desired calibration

**Custom Calibration:**
This allows the user to create a custom calibration setting for the touch screen.

**Factory Default Calibration:** This calibrates the touchscreen to the factory defaults.

4. Press ✔️ to accept the selection.

5. Press ✔️ to proceed.

In the case of custom calibration, a screen will appear with instructions on how to increase precision.

6. Press ✔️ when the calibration is complete, the controller will restart.

**NOTE:** The controller may need to be reset before the custom calibration is possible.

### 4.10.10 Soft Reboot

Restart the controller without turning the power off.

1. From the Home screen, navigate to Advanced → Soft Reboot.
2. Press ✔️ to proceed, the controller will restart.
5. Barcode Reader Details

The Gen IV controller supports the following barcode reader functionality:

- Support up to four identifiers.
- Each rundown result can be associated with up to four identifiers.
- Identifier(s) can be used to select a parameter set or a job.
- Display identifier(s) on controller.
- Ability to lock-out tool until correct identifier(s) is entered.
- Ability to block barcode reads while a job is in progress.
- Barcode reads (identifiers) can come from any or all the following sources:
  - Serial barcode reader
  - Open protocol
  - Fieldbus network
  - Telnet port

Solution

Regardless of the source (serial barcode reader, telnet, fieldbus, or protocol) each new string is passed through the same process:

- All four identifiers are reset to an empty string on power-up.
- Each received barcode is processed through a Barcode Match Table to look for a match, if one is found the barcode is accepted.
- Each fastening will then be associated with the received barcode(s) until a new one is received or they are reset.

Parameters

The parameters that pertain to the processing of barcode strings:

- The Barcode Match Table is used to identify the newly received barcode string.
- Which of the four Identifiers (ID#1-4) are required to enable the tool?
- Which of the four Identifiers (ID#1-4) to reset on a job complete?
- Parameter to disable all barcode reads while a job is in progress. If set, barcode reads will be disabled after the first fastener is ran until job is complete.

Barcode Match Table

The Barcode Match Table is used to identify which barcode has been received. The controller can have up to 99 entries (rows) in the table. Each entry has actions that will be performed when a matching barcode is received. The table is searched from top to bottom in an attempt to find a matching barcode. If none are found, the barcode is ignored.

**Mask**

The Mask is a string used to compare against the received barcode. The received barcode must be at least as long in length as the Mask. The Mask can also contain “don’t care” characters of a decimal point or period in the string. These “don’t care” characters are counted in the length but the actual received character in that position doesn’t matter.

**Identifier Type**

The “Identifier Type” field identifies which identifier (ID#1-4) the received barcode will be stored in.

**Action**

Action can be one of the following:

- None
- Select PS#1-256
- Select Job#1-20

**Reset ID**

The “Reset ID” has the ability to reset other identifiers (ID#1-4) when barcode is received.

**Examples**:

**Operator Scans**

When a vehicle enters the station, the operator scans the VIN. The controller selects the correct job number and enables the tool. Each fastener will be identified with this VIN stored locally, and/or sent to a server for storage. The job settings will disable the tool when the job is complete.

**Setup**

In this example, there are three possible vehicle types each with its own job. The barcode scan will select the correct job (enabling the tool) and the scan will be stored into ID#1.

<table>
<thead>
<tr>
<th>Mask</th>
<th>ID type</th>
<th>Action</th>
<th>Reset ID</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>ID#1</td>
<td>Select</td>
<td>ID#1</td>
</tr>
<tr>
<td></td>
<td></td>
<td>Job#</td>
<td>No</td>
</tr>
<tr>
<td></td>
<td>ID#2</td>
<td>Select</td>
<td>ID#2</td>
</tr>
<tr>
<td></td>
<td></td>
<td>Job#</td>
<td>No</td>
</tr>
<tr>
<td></td>
<td>ID#3</td>
<td>Select</td>
<td>ID#3</td>
</tr>
<tr>
<td></td>
<td></td>
<td>Job#</td>
<td>No</td>
</tr>
<tr>
<td></td>
<td>ID#4</td>
<td></td>
<td>ID#4</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>No</td>
</tr>
</tbody>
</table>
## 6. Glossary of Terms

<table>
<thead>
<tr>
<th>Term</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Acceleration</strong></td>
<td>This setting controls how quickly the tool comes to programmed RPM. The value is stated in thousand(k) revolutions per minute (RPM) per second(s). Default setting is 10 which means that at the start of the rundown or stage, the tool will reach 10,000 RPMs in a one second period of time. Given the speed ratings of the tools in the AcraDyne range, this means that the programmed RPM will instantly be running at the throttle press, or start, of the stage. To increase the time in which the tool comes up to speed (aka Soft Starting) the value should be reduced to the level desired. Controller Firmware will limit the programmed value to effect the tool down to 10% of its rated speed. This means that a 1,000 RPM tool can be set to accelerate at 100 RPM/Second. Should an entry be made that is lower than this value, the Firmware of the controller will run the step/stage at no less than 100 RPM/Second. For a theoretical example: A setting of 1 will result in the tool accelerating (reaching the programmed RPM setting) in a 1,000 RPM step over a time period of 1 second. If the programmed speed was 2,000 RPM it would take 2 seconds to reach that 2,000 RPM setting during that step or stage of the rundown. A setting of .5 will result in the tool accelerating (reaching the programmed RPM setting) in a 500 RPM step over a time period of 1 second. Using the 2,000 RPM example, it would take the tool 4 seconds to reach 2,000 RPM. <strong>Summary:</strong> Lower values equal slower ramp up to programmed speed.</td>
</tr>
<tr>
<td><strong>Accept Tone</strong></td>
<td>Controls tone made from handle of handheld tools for accepted fastening cycles.</td>
</tr>
<tr>
<td><strong>Angle</strong></td>
<td>Degree fastener rotates from snug, or threshold level, to peak torque.</td>
</tr>
<tr>
<td><strong>Cycle Complete</strong></td>
<td>Torque level that determines completion of a fastening cycle.</td>
</tr>
<tr>
<td><strong>High Angle</strong></td>
<td>When peak angle recorded exceeds High Angle, the fastening cycle is recorded as a reject for High Angle, the High Angle light (flashing yellow) illuminates, and fastening cycle is given an overall status of NOK.</td>
</tr>
<tr>
<td><strong>High Torque</strong></td>
<td>When peak torque recorded exceeds the High Torque, the fastening cycle is recorded as a reject for High Torque, the High Torque light (flashing red) illuminates, and fastening cycle is given an overall status of NOK.</td>
</tr>
<tr>
<td><strong>Job</strong></td>
<td>A Job is a collection of Psets or Multi-stages, which are useful when performing several multiple fastening operations, each with different requirements. This is convenient since the operator does not have to select a new Pset or Multistage for every fastening.</td>
</tr>
<tr>
<td><strong>Low Angle</strong></td>
<td>When the peak angle recorded during the Angle Audit Step fails to reach the Low Angle, fastening cycle is recorded as a reject for Low Angle, the low angle light (flashing yellow) illuminates, and fastening cycle is given an overall status of NOK.</td>
</tr>
<tr>
<td><strong>Low Torque</strong></td>
<td>When the peak torque recorded fails to reach the Low Torque, fastening cycle is recorded as a reject for Low Torque, the Low Torque light (flashing red) illuminates, and fastening cycle is given an overall status of NOK.</td>
</tr>
<tr>
<td><strong>MFB</strong></td>
<td>Multi-Function Button</td>
</tr>
<tr>
<td><strong>Multi-stage</strong></td>
<td>In some instances, it is necessary to perform a fastening in several stages. This requires specific fastening strategies. Multi-stage allows user to create linear sequences up to 256 Psets to perform a fastening divided into stages.</td>
</tr>
<tr>
<td><strong>Parameter Set</strong></td>
<td>A Parameter Set is a collection of instructions that define how the tool should perform the fastening process. It may be selected from the console or device such as a socket tray or PC.</td>
</tr>
<tr>
<td><strong>Snug Torque</strong></td>
<td>Controller begins to monitor tool for angle at a preselected threshold torque. Any increase in angle, after the snug point, results in a corresponding increase in tension or clamp load within the joint.</td>
</tr>
<tr>
<td><strong>Speed</strong></td>
<td>Speed at which tool operates during the initial portion of the fastening cycle prior to downshift.</td>
</tr>
<tr>
<td><strong>Spindle</strong></td>
<td>A spindle represents a connection to a handheld, or fixtured, tool connected to a controller.</td>
</tr>
<tr>
<td><strong>Strategy</strong></td>
<td>Identifies the variables being used to control tool during a fastening cycle.</td>
</tr>
<tr>
<td><strong>Thread Direction</strong></td>
<td>Sets assembly direction to clockwise (CW) or counter clockwise (CCW).</td>
</tr>
<tr>
<td><strong>Threshold Torque</strong></td>
<td>Sets point at which tool is “In Cycle”.</td>
</tr>
<tr>
<td><strong>Torque Calibration</strong></td>
<td>Determines how torque values are assigned to the electrical signals for torque transducer on tool. Value is unique to each tool and changes over time.</td>
</tr>
<tr>
<td><strong>Torque Target</strong></td>
<td>When the tool is being controlled for torque, the torque target instructs controller when to shut off tool. Torque target should be greater than Low Torque and less than High Torque, this is required for torque control.</td>
</tr>
</tbody>
</table>
## 7. Icons Defined

<table>
<thead>
<tr>
<th>Icon</th>
<th>Description</th>
<th>Function</th>
<th>Where Used</th>
</tr>
</thead>
<tbody>
<tr>
<td>🔐</td>
<td>Home Navigation Button</td>
<td>Navigate to the main menu (“HOME”) screen.</td>
<td>All screens except for edit screens.</td>
</tr>
<tr>
<td>➡️</td>
<td>Run Navigation Button</td>
<td>Navigate to the Run Screen.</td>
<td>All screens except for edit screens.</td>
</tr>
<tr>
<td>➡️</td>
<td>Run Screen Select Buttons</td>
<td>Switch between the different run screen pages.</td>
<td>Run Screen</td>
</tr>
<tr>
<td>⬆️</td>
<td>Go Back Button</td>
<td>Navigate to one menu level back.</td>
<td>All screens except for edit screens.</td>
</tr>
<tr>
<td>✅</td>
<td>Accept Changes Button</td>
<td>Accept the changes made and return to the parent screen.</td>
<td>Edit screens</td>
</tr>
<tr>
<td>🔴</td>
<td>Cancel Changes Button</td>
<td>Reject the changes made and return to the parent screen.</td>
<td>Edit screens</td>
</tr>
<tr>
<td>✅</td>
<td>Add New Button</td>
<td>Add a new item (Pset, Stage, Job, and other).</td>
<td>PSet and Job edit screens.</td>
</tr>
<tr>
<td>✏️</td>
<td>Edit Button</td>
<td>Edit selected item.</td>
<td>PSet and Job edit screens.</td>
</tr>
<tr>
<td>🔧</td>
<td>Move Up and Down Buttons</td>
<td>Move selected item up or down in the sequence order.</td>
<td>PSet and Job edit screens.</td>
</tr>
<tr>
<td>📋</td>
<td>Copy Button</td>
<td>Copy selected Items</td>
<td>PSet, Job, and other edit screens.</td>
</tr>
<tr>
<td>🗑</td>
<td>Delete Button</td>
<td>Remove or un-assign selected items.</td>
<td>Edit and list view screens.</td>
</tr>
<tr>
<td>🔼</td>
<td>Filter Button</td>
<td>Filter Items in a list or table.</td>
<td>List view screens</td>
</tr>
<tr>
<td>📝</td>
<td>Save Button</td>
<td>Save selected item to file.</td>
<td>List view screens</td>
</tr>
<tr>
<td>🔍</td>
<td>Barcode Scan Required Indicator</td>
<td>A barcode is required to enable the tool.</td>
<td>Run Screen</td>
</tr>
<tr>
<td>�(Have a barcode image)</td>
<td>Job Complete Indicator</td>
<td>Job is complete.</td>
<td>Run Screen</td>
</tr>
</tbody>
</table>
8. Stop Codes

If a Stop condition is detected that prevents the tool from running, a code will appear on the LED display. Any active stop conditions are also displayed on the RUN screen.

<table>
<thead>
<tr>
<th>Code</th>
<th>Icon</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>IO</td>
<td>![Stop Icon]</td>
<td>Stopped or Disabled from Physical 24 volt IO input</td>
</tr>
<tr>
<td>ABUS</td>
<td>![Stop Icon]</td>
<td>Stopped or Disabled from ANYBUS</td>
</tr>
<tr>
<td>MODB</td>
<td>![Stop Icon]</td>
<td>Stopped or Disabled from Modbus</td>
</tr>
<tr>
<td>EIP</td>
<td>![Stop Icon]</td>
<td>Stopped or Disabled from Ethernet IP</td>
</tr>
<tr>
<td>RTU</td>
<td>![Stop Icon]</td>
<td>Stopped or Disabled from Modbus RTU</td>
</tr>
<tr>
<td>OP</td>
<td>![Stop Icon]</td>
<td>Stopped or Disabled from Open Protocol</td>
</tr>
<tr>
<td>OP</td>
<td>![Stop Icon]</td>
<td>Lost Open Protocol Connection</td>
</tr>
<tr>
<td>REV</td>
<td>![Stop Icon]</td>
<td>Disassembly Disabled</td>
</tr>
<tr>
<td>ARM</td>
<td>![Stop Icon]</td>
<td>Tool Requires Arming – MFB button configured to enable the tool to run.</td>
</tr>
<tr>
<td>JOB</td>
<td>![Stop Icon]</td>
<td>Job Sequence Complete</td>
</tr>
<tr>
<td>JOB</td>
<td>![Stop Icon]</td>
<td>Job Complete</td>
</tr>
<tr>
<td>JOB</td>
<td>![Stop Icon]</td>
<td>XML Count Complete</td>
</tr>
<tr>
<td>LOR</td>
<td>![Stop Icon]</td>
<td>Locked on Reject</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Code</th>
<th>Icon</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>BRCD</td>
<td>![Bar Code Icon]</td>
<td>Bar Code ID scan required to enable tool</td>
</tr>
<tr>
<td>SRVC</td>
<td>![Service Icon]</td>
<td>Tool Disabled For Service - Tool service or calibration interval has expired</td>
</tr>
<tr>
<td>INVP</td>
<td>![Invalid PSet Icon]</td>
<td>Invalid PSet - Parameter set number for a non-existent Pset has been selected to run. Most likely via one of the following methods: ○ Job ○ MFB ○ I/O</td>
</tr>
<tr>
<td>INVP</td>
<td>![Invalid PSet Icon]</td>
<td>PSet outside of Job - Parameter set number outside of the job has been selected. Most likely via one of the following methods: ○ MFB ○ I/O</td>
</tr>
<tr>
<td>INVP</td>
<td>![Invalid Job Icon]</td>
<td>Invalid Job - Job number for a non-existent Job has been selected to run. Most likely via one of the following methods: ○ MFB ○ I/O</td>
</tr>
<tr>
<td>PSET</td>
<td>![Mismatch Icon]</td>
<td>PSet Mismatch</td>
</tr>
<tr>
<td>SPND</td>
<td>![Spindle Not Configured Icon]</td>
<td>Spindle Not Configured – Spindle selected to run from a Multi-Spindle Job has not been configured</td>
</tr>
<tr>
<td>NET</td>
<td>![XML Disconnected Icon]</td>
<td>XML Disconnected</td>
</tr>
<tr>
<td>XML</td>
<td>![Stop from XML Icon]</td>
<td>Stop from XML</td>
</tr>
<tr>
<td>NOK</td>
<td>![XML Max Rejects Exceeded Icon]</td>
<td>XML Max Rejects Exceeded</td>
</tr>
<tr>
<td>FLT</td>
<td>![Controller Fault Icon]</td>
<td>Controller Fault - Error has been detected. See fault code list for details</td>
</tr>
</tbody>
</table>
9. Error Codes

If an error condition is detected that prevents the tool from running, a fault code will appear on the LED display. Any active faults are also displayed on GUI RUN screen. Fault history can be viewed in the Controller Error Log.

Gen4 Common Hardware Fault Codes

<table>
<thead>
<tr>
<th>Code</th>
<th>Fault Type</th>
<th>Description</th>
<th>Possible Causes</th>
</tr>
</thead>
<tbody>
<tr>
<td>FH17</td>
<td>1.8vdc MB out of tolerance</td>
<td>Main board 1.8 bus voltage exceeds electrical limits</td>
<td>• Faulty Controller main board or other Controller electronics</td>
</tr>
<tr>
<td>FH18</td>
<td>1.8vdc SOM out of tolerance</td>
<td>System on Module 1.8 bus voltage exceeds electrical limits</td>
<td>• Faulty Controller main board or other Controller electronics</td>
</tr>
<tr>
<td>FH19</td>
<td>3.3vdc out of tolerance</td>
<td>Main board 3.3 bus voltage exceeds electrical limits</td>
<td>• Faulty Controller main board or other Controller electronics</td>
</tr>
<tr>
<td>FH20</td>
<td>5vdc out of tolerance</td>
<td>5 Volt bus voltage out of range</td>
<td>• Faulty power supply or wiring</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>• Faulty Controller main board or other Controller electronics</td>
</tr>
<tr>
<td>FH21</td>
<td>9vdc out of tolerance</td>
<td>9 Volt bus voltage out of range</td>
<td>• Faulty power supply or wiring</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>• Faulty Controller main board or other Controller electronics</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>• Faulty tool cable</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>• Faulty tool electronics or wiring</td>
</tr>
<tr>
<td>FH22</td>
<td>24 volt level low</td>
<td>24 Volt I/O power not detected</td>
<td>• Faulty power supply or wiring</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>• Short or other problem with external connections to the 24Volt I/O port.</td>
</tr>
<tr>
<td>FH23</td>
<td>Controller temp high</td>
<td>Controller’s internal temperature exceeds limit</td>
<td>• Ambient air temperature exceeds rating of Controller</td>
</tr>
<tr>
<td>FH24</td>
<td>+15vdc out of tolerance</td>
<td>+15 Volt bus voltage out of range</td>
<td>• Faulty power supply or wiring</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>• Faulty Controller main board or other Controller electronics</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>• Faulty tool cable</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>• Faulty tool electronics or wiring</td>
</tr>
<tr>
<td>FH25</td>
<td>-15vdc out of tolerance</td>
<td>-15 Volt bus voltage out of range</td>
<td>• Faulty power supply or wiring</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>• Faulty Controller main board or other Controller electronics</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>• Faulty tool cable</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>• Faulty tool electronics or wiring</td>
</tr>
<tr>
<td>FH32</td>
<td>Processor Fault</td>
<td>RTOS processor not communicating with the Application processor</td>
<td>• Faulty mainboard electronics</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>• RTOS processor firmware corrupted or not loaded</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>• Faulty SOM board or connector</td>
</tr>
</tbody>
</table>
### IEC (AcraDyne DC Tool) Specific Fault Codes

<table>
<thead>
<tr>
<th>CODE</th>
<th>Fault Type</th>
<th>Description</th>
<th>Possible Causes</th>
</tr>
</thead>
<tbody>
<tr>
<td>FT01</td>
<td>Tool not connected</td>
<td>Tool communication timeout</td>
<td>• Tool not connected&lt;br&gt;• Faulty tool cable&lt;br&gt;• Faulty tool electronics or wiring</td>
</tr>
<tr>
<td>FT02</td>
<td>Invalid TID parameters</td>
<td>Tool parameter file not compatible with Controller</td>
<td>• Corrupt tool ID memory location&lt;br&gt;• TID file not loaded in tool</td>
</tr>
<tr>
<td>FT04</td>
<td>Torque signal out of Range</td>
<td>Tool torque signal voltage is beyond electrical limits</td>
<td>• Tool not connected&lt;br&gt;• Faulty tool cable&lt;br&gt;• Faulty transducer&lt;br&gt;• Transducer electronics not calibrated&lt;br&gt;• Faulty tool/controller electronics or wiring</td>
</tr>
<tr>
<td>FT05</td>
<td>Torque tare value out of range</td>
<td>Tool torque signal no load voltage is out of range</td>
<td>• Transducer electronics significantly out of calibration&lt;br&gt;• Faulty transducer&lt;br&gt;• Faulty tool cable&lt;br&gt;• Tool gear binding&lt;br&gt;• Faulty controller electronics or wiring</td>
</tr>
<tr>
<td>FT06</td>
<td>Motor hall states invalid</td>
<td>Hall signals states are all high or all low</td>
<td>• Tool not connected&lt;br&gt;• Faulty tool cable&lt;br&gt;• Faulty tool electronics or wiring&lt;br&gt;• Faulty motor halls or wiring</td>
</tr>
<tr>
<td>FT07</td>
<td>Motor halls skipping states</td>
<td>Hall signal sequence incorrect</td>
<td>• Faulty tool cable&lt;br&gt;• Faulty tool electronics or wiring&lt;br&gt;• Faulty motor hall or wiring&lt;br&gt;• Hall signal leads are connected incorrectly&lt;br&gt;• Too many tool extension cables</td>
</tr>
<tr>
<td>FT08</td>
<td>Tool ground not connected</td>
<td>Tool ground conductors not connected</td>
<td>• Tool not connected&lt;br&gt;• Faulty tool cable&lt;br&gt;• Faulty tool ground wires&lt;br&gt;• Faulty tool electronics or wiring</td>
</tr>
<tr>
<td>FD12</td>
<td>Drive not connected</td>
<td>Drive CAN communication timeout</td>
<td>• Faulty Controller main board electronics&lt;br&gt;• Faulty drive electronics or connection</td>
</tr>
<tr>
<td>FD13</td>
<td>Drive Fault SW</td>
<td>Drive reporting fault via CAN communication</td>
<td>• Tool not connected&lt;br&gt;• Faulty tool cable&lt;br&gt;• Faulty tool motor&lt;br&gt;• Application exceeds capability of drive&lt;br&gt;• Faulty drive</td>
</tr>
<tr>
<td>FD14</td>
<td>Drive Fault HW</td>
<td>Drive reporting fault via IO signal</td>
<td>• Tool not connected&lt;br&gt;• Faulty tool cable&lt;br&gt;• Faulty tool motor&lt;br&gt;• Application exceeds capability of drive&lt;br&gt;• Faulty drive</td>
</tr>
<tr>
<td>FD15</td>
<td>Drive Vbus high</td>
<td>Drives DC bus voltage exceeds electrical limits</td>
<td>• AC supply power exceeds voltage ratings of Controller</td>
</tr>
<tr>
<td>FD16</td>
<td>Drive Vbus low</td>
<td>Dives DC bus voltage is too low to run tool</td>
<td>• Supply power cycled too quickly. Five second delay required after switching off the Controller before turning back on.</td>
</tr>
<tr>
<td>FS26</td>
<td>Power on throttle</td>
<td>Run command on power up</td>
<td>• Tool laying on lever on power up&lt;br&gt;• Tool buttons out of calibration&lt;br&gt;• Run command from logic I/O on power up.</td>
</tr>
<tr>
<td>FS27</td>
<td>Locked rotor</td>
<td>Motor has stalled for more than 100 milliseconds</td>
<td>• Poor parameter settings for application.&lt;br&gt;• Torque signal out of calibration&lt;br&gt;• Faulty tool gearing or motor&lt;br&gt;• Corrupted TID parameters&lt;br&gt;• Faulty Controller or tool electronics</td>
</tr>
<tr>
<td>FS28</td>
<td>Target out of range of tool</td>
<td>Parameter set torque target out of range of rated tool capability</td>
<td>• Target torque exceeds tool capability&lt;br&gt;• Joint Compensation Ratio set too low.&lt;br&gt;• Corrupted TID parameters</td>
</tr>
<tr>
<td>FS29</td>
<td>Invalid tool</td>
<td>Tool configuration not compatible with parameter set</td>
<td>• Tubenut tool commanded to run a parameter set with left hand thread direction or with an unfastening stage&lt;br&gt;• Tubenut tool commanded to go in the disassembly direction</td>
</tr>
<tr>
<td>FS31</td>
<td>Lost Master Start Signal</td>
<td>Lost Connection to Master Spindle</td>
<td>• Faulty Ethernet Connection&lt;br&gt;• RTOS processor firmware corrupted or not loaded&lt;br&gt;• Faulty SOM board or connector</td>
</tr>
</tbody>
</table>
10. Dual-Lever Tools Requiring Two-Handed Operation

Two Handed Functionality

- Tool will not run unless both switches are pressed within one second of each other.
- If the one second timer times out, both switches must be released to reset the timer.
- If either trigger is released the tool stops.
- To restart the tool, both switches must be released and pressed within one second of each other.

**NOTE:** All settings in Controller → Start Input Configuration will be ignored.
- I/O cannot be used to start a two-handed tool.
- Latching throttle is disabled for a two-handed tool.

- Exceptions exist for Tubenut tool homing.

Tubenut Tool Homing Exceptions for Two Handed Functionality

- If controller’s tubenut homing configuration is set to RELEASE:
  - Releasing either, or both, of the levers will initiate the homing sequence.
  - Homing will continue until sequence is complete.
- If controller’s tubenut homing configuration is set to RELEASE AND REPRESS:
  - Releasing either of the levers, then pressing both levers will initiate the homing sequence.
  - Homing will continue while both of the levers are being pressed.
  - If either lever is released, before homing is complete, tool will stop and homing will pause until both levers are pressed.
  - To restart tool, after homing is complete, both switches must be released and pressed within one second of each other.
11. Dimensions

- **Electrical:**
  - Supply Voltage: iEC4W 120 Vac / 230 Vac
  - iEC4W1 120 Vac
  - iEC4W2 230 Vac
  - Phase: 1Φ
  - Frequency: 50/60 Hz
  - Power: 3.5 kW
  - Maximum Continuous Current Draw: 15 Amps

- **Mechanical:**
  - Dimensions:
    - Width: 6.25 in (159 mm)
    - Height: 15.75 in (400 mm)
    - Depth: 12.5 in (316 mm)
  - Weight:
    - iEC4W: 18.6 lbs (8.4 kg)
    - iEC4W1: 18.6 lbs (8.4 kg)
    - iEC4W2: 18.6 lbs (8.4 kg)

- **Operating Conditions:**
  - Temperature: 32 to 122 °F (0 to 50 °C)
  - Humidity: Non-condensing
  - Ingress Protection: IPx4

- **Absolute Supply Voltage Ranges**
  - iEC4W: 90 – 132 Vac / 180 – 264 Vac
  - iEC4W1: 90 – 132 Vac
  - iEC4W2: 180 – 253 Vac

- 15 – 20A, dedicated service recommended when supplying 120Vac
- 10 – 15A, dedicated service recommended when supplying 230Vac

- **Power Cord Receptacle Type:** IEC 320-C20
13. Tubenut Tool Setup Details

13.1 Overview

The following describes the setup required for tubenut tool operation. This includes determining the values for tubenut specific TID parameters (parameters residing in the tool memory) and Gen IV controller parameters.

13.2 Tubenut Homing

13.2.1 Tubenut Home TID parameters

The tubenut TID parameters can be viewed and modified from the Tool → Tool Setup screen. The tool to be configured must be connected to the controller.

- **Home Detection Torque - Home (in*Lb)**
  - When tool is homing, reaching this torque indicates to controller that the tool output socket has reached the Home stop and is in the open position.
  - If tool output does not attempt to return, or does not completely reach the Home position, this value is too low.
  - **NOTE:** Setting this value too high can potentially damage the tool.
  - Units: lbf-in
  - TID memory location: 53

- **Hold at Home Torque - Open Loop (in*Lb)**
  - After reaching the Home position, this torque is applied against the Home stop to prevent socket from bouncing to a partially closed position.
  - This value is typically set to a value slightly lower than the Home detection torque.
  - If socket is bouncing back to a partially closed position, after reaching the Home stop, this value is too low.
  - **NOTE:** Setting this value too high can cause the socket to snap back to the Home stop too quickly and potentially damage the tool.
  - Units: lbf-in (approximation)
  - TID memory location: 54

13.3 Setting the Tool’s Tubenut Home TID Parameters

- Set the Hold at Home Torque = 0
- Set the Home Detection Torque = 1
- Free-run tool and watch the homing routine while making the adjustments below.
- Gradually increase the value for the Home Detection Torque until tool reliably returns to the Home position.

- When a good value for the Home Detection Torque is found, if the tool is bouncing back to a partially closed position after hitting the Home stop, gradually increase the value for the Hold at Home Torque until bounce back is eliminated.

13.4 Controller Parameters Affecting Tubenut Homing

Controller parameters for tubenut operation can be viewed and modified from the Controller → Tool Setup → Disassembly and Tubenut screen.

- **Tubenut Homing Max Speed:**
  - Speed the tool output socket travels when returning to the Home position.
  - Decreasing this can reduce the impact force when hitting the Home stop.
  - **NOTE:** Care must be taken, increasing the speed above the default value; too high of a value can greatly increase how hard the output will hit the Home stop and potentially damage the tool.
  - Units: RPM of the tool output socket in the homing direction.
  - Default value: 50 RPM
  - Range: 1 to 200 RPM

- **Tubenut Homing Acceleration:**
  - Rate at which speed of tool ramps to the homing speed.
  - Units: kRPM/second
  - Default value: 0.5 seconds
  - Range: 0.1 to 10 seconds

- **Tubenut Homing Reverse Dwell Time:**
  - Amount of time before the output is allowed to Home, after rundown is complete and tool lever is released.
  - Units: Seconds
  - Default value: 0.5 seconds
  - Range: 0 to 2 Seconds

- **Tubenut Home Dwell Time:**
  - Amount of time tool holds at Home to prevent bounce back
  - Too short of Home dwell time can increase the occurrence of bounce back. However, decreasing the homing speed can decrease the severity of bounce back after the Home stop is reached and allow for a shorter dwell time.
  - Units: Seconds
  - Default value: 0.5 Seconds
  - Range: 0 to 2 Seconds
13.5 Tubenut Pinch Detection

13.5.1 Obstruction Detection TID Parameters

The tubenut TID parameters can be viewed and modified from the Tool → Tool Setup screen. The tool to be configured must be connected to controller.

- Obstruction Detection Torque - \((\text{in} \times \text{Lb})\)
  - At start of rundown, before the output rotation has passed though the Obstruction Check Zone (where output is open at the start of the fasting cycle), the tool will stop and fastening cycle will be aborted if this torque is exceeded.
  - If tool stops, when output is open during this first part of the rundown, without any obstruction, the value is too low.
  - Units: lbf-in
  - TID memory location: 53

13.5.2 Setting the Tool’s Tubenut Obstruction Detection

Parameters
- Set value for the obstruction torque just high enough so tool will reliably overcome gear friction and make it past the obstruction checking zone.
- Check torque of the stop on obstruction feature by measuring the actual “pinch” torque the tube nut produces at the start of the rundown when the jaws are open (within the obstruction detection angle range). This can be done on a semi-tightened joint simulator set for a hard joint, while auditing the torque.
  \textbf{NOTE:} Gear friction in the tubenut head can greatly affect the ability to reliably detect an obstruction.

13.5.3 Controller Parameters Affecting Tubenut Pinch Detection

Controller parameters for tubenut operation can be viewed and modified from the Controller → Tool Setup → Disassembly and Tubenut screen.

- Obstruction Check Angle
  - Angle of travel from start of fasting cycle where, if an obstruction is detected inside this zone, the tool will stop and the fastening cycle will be aborted.
  - Units: Degrees of rotation of the output from Home to where the output is closed.
  - Default value: 90 Degrees
  - Range: 0 to 180 Degrees
- Obstruction Check Speed Limit
  - Maximum speed output will run during the check for obstructions.
  - Decreasing this can reduce the impact force when hitting an obstruction.
  \textbf{NOTE:} Care must be taken increasing the speed above the default value. Too high of a value can greatly increase how hard the output will hit the obstruction.
  - Units: RPM of the tool output
  - Default: 70 RPM
  - Range: 1 to 200 RPM

13.5.4 Tubenut Homing Start Input Logic Selection

The controller parameter for tubenut homing Start Input Logic can be viewed and modified from the controller → Tool Setup → Start Input screen.

- Tubenut Homing Start Input logic:
  - Lever action required to start the Home sequence.
  - Options:
    - Home on release and repress of the lever (default)
    - Home on release of the lever
14. Troubleshooting

Issue: System Port IP Address Drivers

Solution: NOTE: In the event the RNDIS drivers do not install themselves, the following are the steps to install new drivers in order to get the system port working.

RNDIS driver is a part of the Windows 7 operating system, but the OS fails to detect it automatically. The following steps will help the user to install the RNDIS driver:

**Step 1:** After the device is connected to the development PC, OS will automatically search for the RNDIS driver. After it fails to find the driver, the following message will be shown:

**Step 2:** Right click on Computer and select Manage. From System Tools, select Device Manager. It will show a list of devices currently connected with the development PC. In the list, RNDIS Kitl can be seen with an exclamation mark implying that driver has not been installed.

**Step 3:** Right click on it and select Update Driver Software. When prompted, choose Browse my computer for driver software to search for device driver software.

**Step 4:** Browse for driver software on your computer will come up. Select Let me pick from a list of device drivers on my computer.

**Step 5:** A window will come up asking to select the device type. Select Network Adapters as RNDIS emulates a network connection.

**Step 6:** In the Select Network Adapter window, select Microsoft Corporation from the Manufacturer list. Under the list of Network Adapter, select Remote NDIS Compatible Device.

**Step 7:** The RNDIS Kitl device is now installed and ready for use.
Issue: DC Bus High Voltage Warning when using an HT Tool

Solution: Adding a Brake Stop of 0.5 to 1.0 Second stage to the end of the rundown should eliminate this issue.
15. AIMCO Warranty

NEW TOOL AND ACCESSORY WARRANTY
Any new tool or accessory branded with the AIMCO, Uryu, AcraDyne or Eagle Group name, and purchased from AIMCO, or through one of its authorized distributors or agents, is warranted to the original buyer against defects in materials and workmanship for a period of one (1) year* from date of delivery. Under the terms of this warranty, AIMCO agrees, without charge, to repair or replace, at its option and Ex-Works (EXW) its authorized service centers, any product or accessory warranted hereunder proving to AIMCO’s satisfaction to be defective as a result of defective workmanship or material. In order to qualify for this warranty, written notice to AIMCO must be given immediately upon discovery of such defect, at which time AIMCO will issue an authorization to return the tool. The defective item must be promptly returned to an authorized AIMCO service center with all freight charges prepaid.

REPAIRED TOOL WARRANTY
Once a tool is beyond the new product warranty period as detailed above, AIMCO will provide repair subject to the following warranty periods: pneumatic tools: 90 days*; electric tools and Acra-Feed: 90 days; battery tools: 30 days*; DC Electric tools: 90 days*

EXCLUSION FROM WARRANTY
This warranty is valid only on products purchased from AIMCO, or through its authorized distributors or agents. AIMCO shall have no obligation pursuant to the AIMCO Warranty with respect to any tools or accessories which in AIMCO’s sole judgment have been altered damaged, misused, abused, badly worn, lost or improperly maintained. This Warranty is null and void if the customer, or any other person other than an authorized representative of AIMCO, has made any attempt to service or modify the tool or accessory prior to its return to AIMCO under this Warranty.

The warranty provision with respect to each such product may be amended by AIMCO from time to time in its sole discretion. The liability of AIMCO hereunder shall be limited to replacing or repairing, at its option, any defective products which are returned freight pre-paid to AIMCO or, at AIMCO’s option, refunding the purchase price of such products.

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