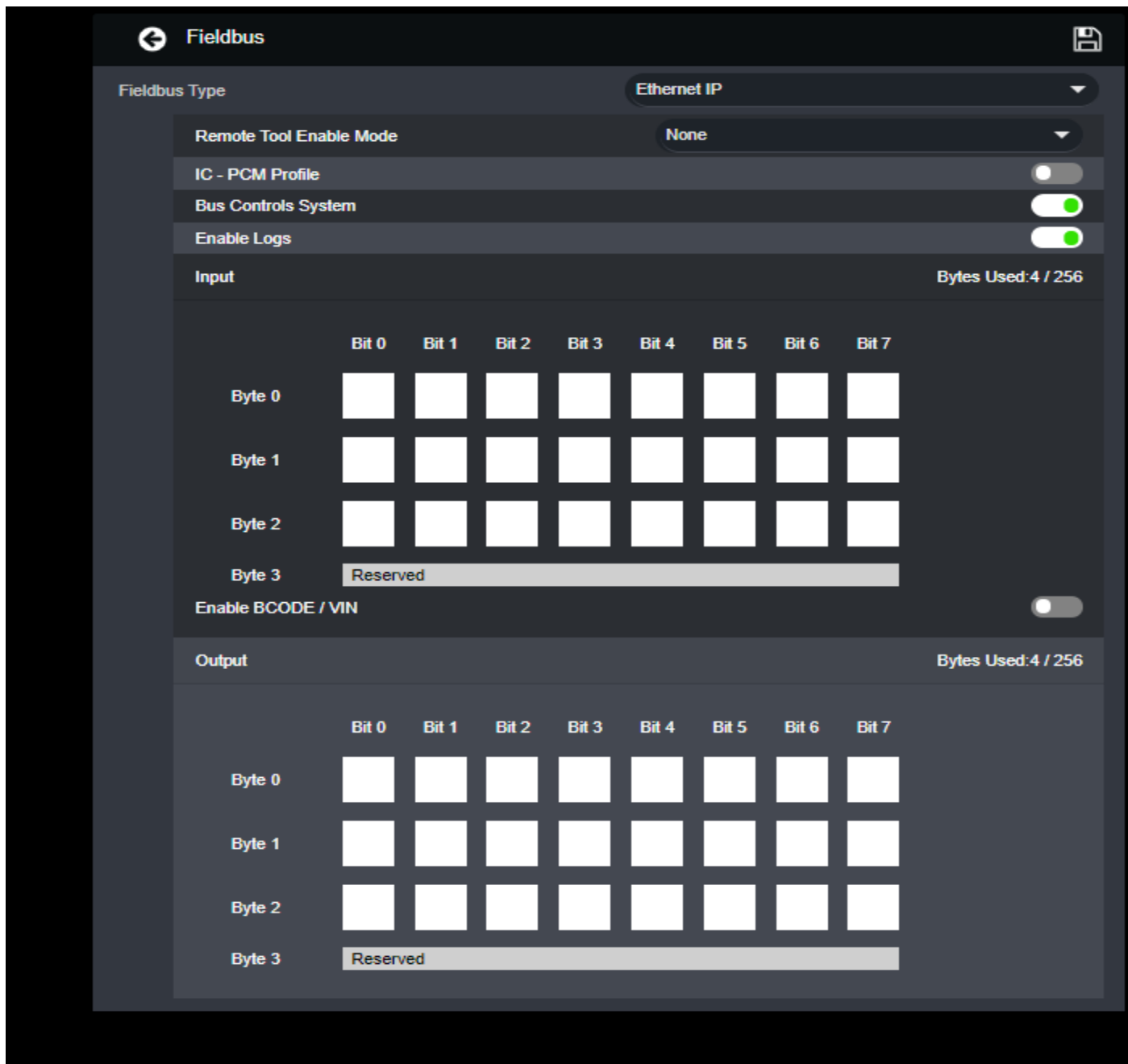


## Procedure

-From the Main Menu go to Settings-Fieldbus

-In the Type dropdown select Ethernet IP

-Enable Bus Control and Logs



-Under Input click on one of the Bits to open the Input Bit Assignment Screen.

Input Bit Assignment

Byte 0 ▲

Bit 0	None	Normally Open ▼
Bit 1	None	Normally Open ▼
Bit 2	None	Normally Open ▼
Bit 3	None	Normally Open ▼
Bit 4	None	Normally Open ▼
Bit 5	None	Normally Open ▼
Bit 6	None	Normally Open ▼
Bit 7	None	Normally Open ▼

Byte 1 ▲

Bit 0	None	Normally Open ▼
Bit 1	None	Normally Open ▼

-Select the required Data for each Bit and select Apply.

Fieldbus

### Input Bit Assignment

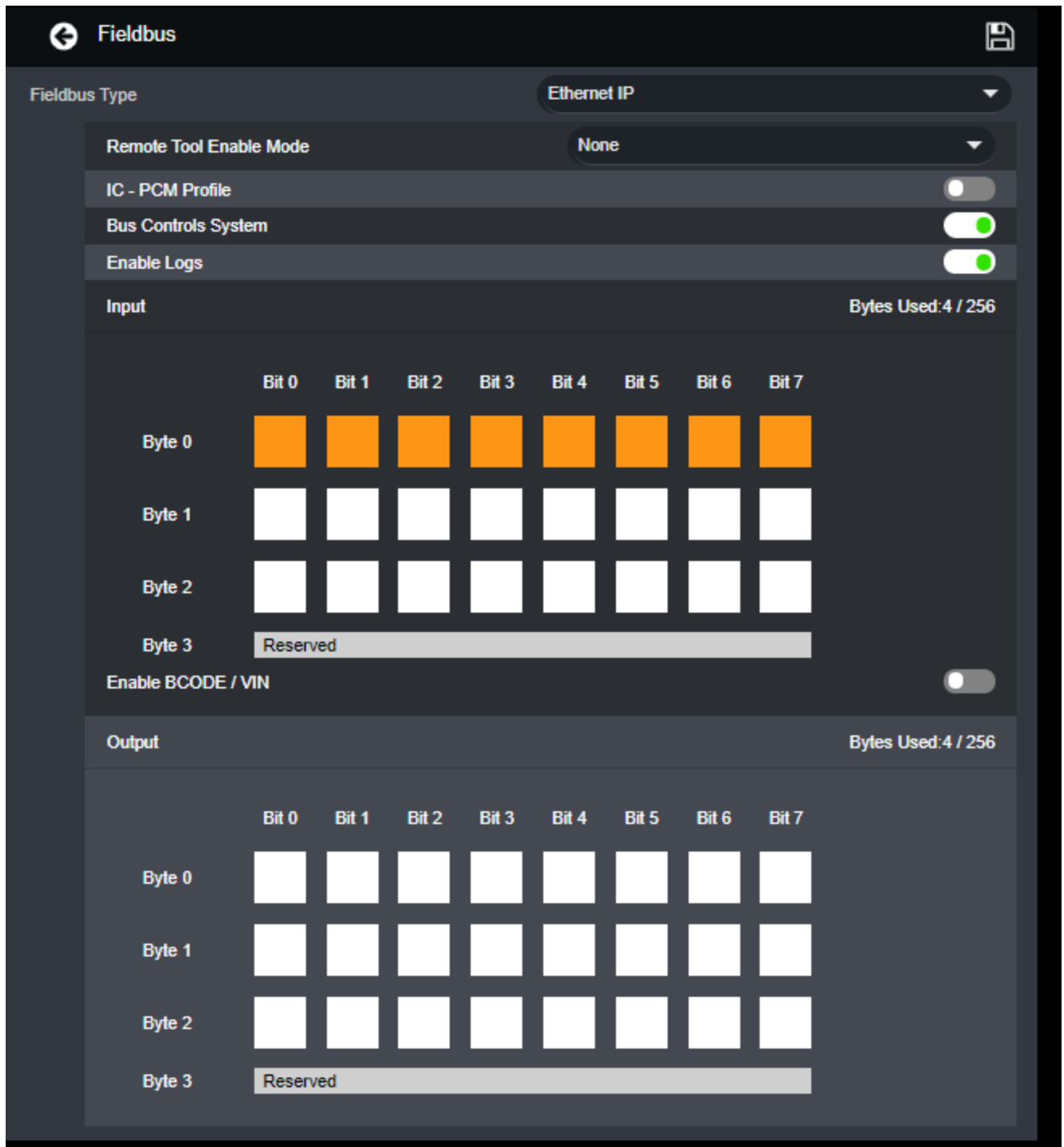
Byte 0

Bit 0	Job 1	Normally Open
Bit 1	Job 2	Normally Open
Bit 2	Job 3	Normally Open
Bit 3	Job 4	Normally Open
Bit 4	Tool Enable	Normally Open
Bit 5	Tool Disable	Normally Open
Bit 6	Disable Reverse	Normally Open
Bit 7	Batch Advance	Normally Open

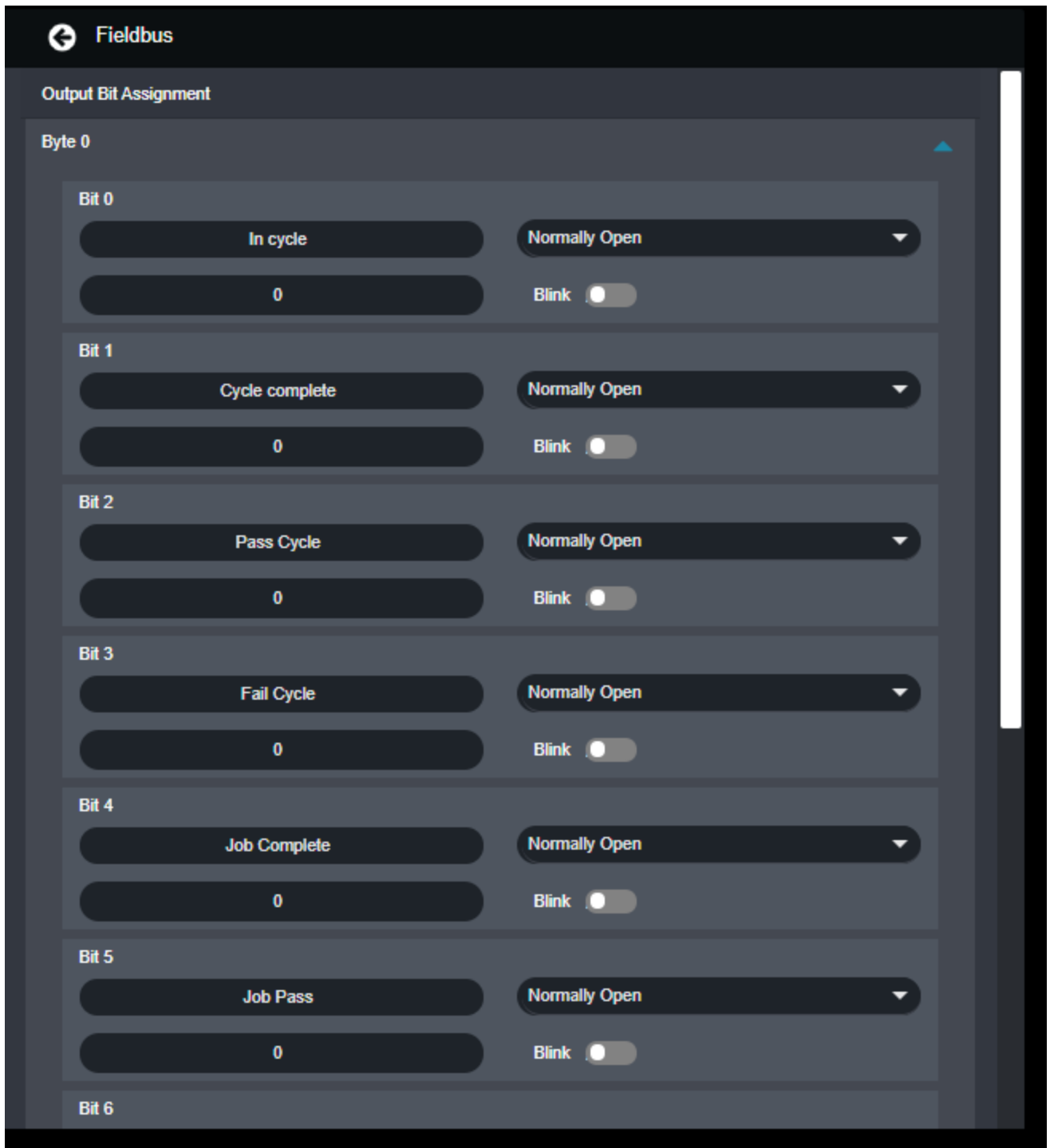
Byte 1

Bit 0	None	Normally Open
Bit 1	None	Normally Open

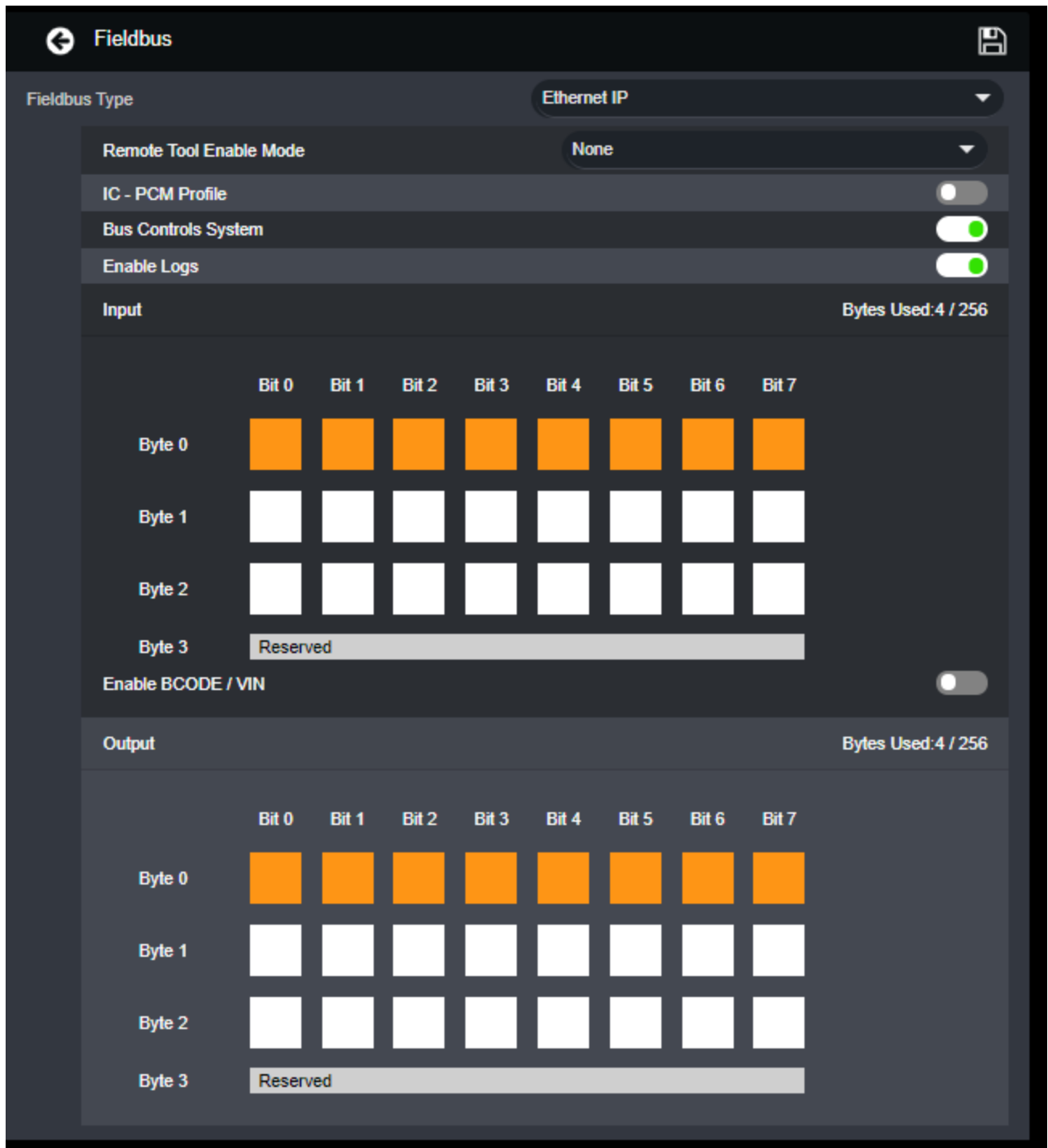
-When all Bits are assigned select OK at the bottom of the screen.



-Follow the same procedure to assign the Output Bytes.



-After the Input and Output Assignments are programmed select the Save icon in the top right corner.




-From the Main Menu go to Settings->Ethernet Settings.



-Assign the appropriate network settings for Port 2 to communicate with the PLC and select the Save icon in the top right corner..

### Ethernet Settings

#### Port 1 Settings

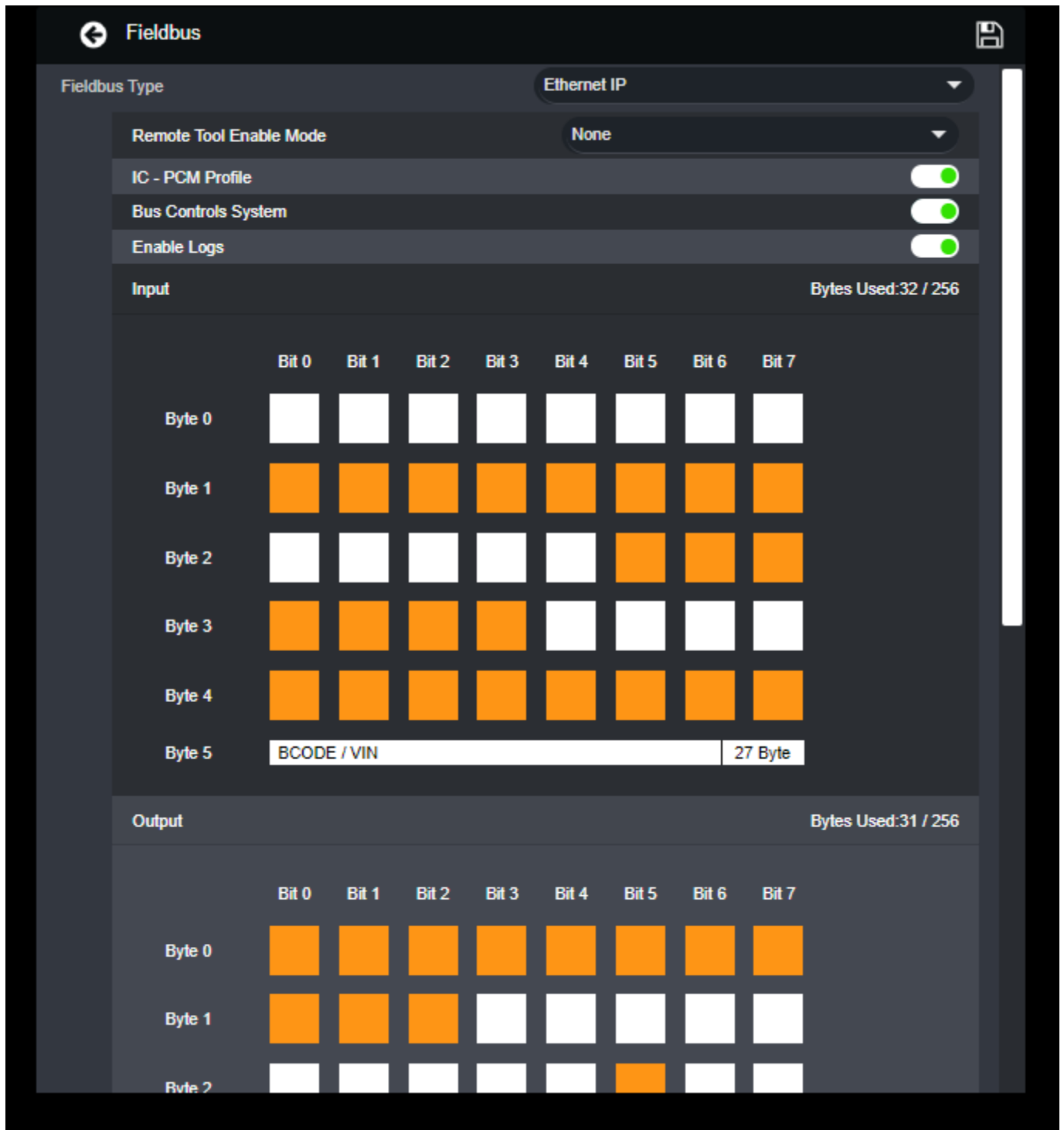
Link Status	
MAC Address	00:d0:69:50:c4:86
Speed	100 Mbps
Network Type	DHCP 
IP Address	10.52.6.1
Subnet Mask	255.255.252.0
Gateway	10.52.4.1
Primary DNS	10.52.4.100
Secondary DNS	10.86.8.30

#### Port 2 Settings

Link Status	
MAC Address	00:d0:69:50:c4:87
Speed	-
Network Type	Static 
IP Address	176.168.5.6
Subnet Mask	255.255.255.0
Gateway	176.168.5.1
Primary DNS	0.0.0.0
Secondary DNS	0.0.0.0

--Note: Port 1 is used for accessing the controller web browser and should be on a different subnet than Port 2.

--Note: There is an option on the Fieldbus Setup screen to select the PCM Profile. Enabling this will set the Input and Output Bits to the same mapping as the PCM controllers.



## Notes



**See the attached link for the appropriate EDS file. The controller should be updated to version 1.1.6 or greater before using the Ethernet IP option.**

**See the attached spreadsheet showing the PCM Bit Mapping.**

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