



# AcraDyne iAC4EGV-T Assignable I O Gen IV ACE iAC Controller Instructions

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AcraDyne iAC4EGV-T Assignable I O Gen IV ACE iAC Controller



Assignable I/O

The Gen IV controller supports assignable I/O.  
Buses: The controller is divided up into buses. Each bus has a set of inputs and a set of outputs. Currently the controller supports the following buses.

Bus Number	Bus
1	Physical I/O
2	Fieldbus (Anybus module) I/O
3	Modbus TCP
4	Ethernet/IP

All assignments have a bus, element, and bit configuration to define its location in the system. The bus value needs to be set from the list above. The element and bit define the location in the bus. The first element on the bus is 0 and goes up the last legal element for the given bus. The bits in each element is referenced from 0(LSB) to 31(MSB).

Inputs

All input assignments have a Bus, Element, and Bit configuration to define its location in the system. Along with the basic configuration many also have other configuration(s) that allow its behavior to be modified to suit the application.

			Supported Feature				Controllers	

	Bus	Element	Bit 0-31	Polarity N.O./N.C.	Width	Offset	iEC	iAC	iPC	iBC	iBC-Z
Do Nothing	√	√	√				√	√	√	√	√
Start	√	√	√	√			√				
Stop	√	√	√	√			√	√	√	√	
Reverse	√	√	√	√			√				
Disable	√	√	√	√			√	√	√		
Reset Job	√	√	√	√			√	√	√	√	√
Select PSet	√	√	√		√	√	√	√	√	√	
Select Job	√	√	√		√	√	√	√	√	√	√
Select Job Sequence	√	√	√		√	√	√	√	√	√	√
Disable Assembly	√	√	√	√			√				
Set ID	√	√	√		√		√	√	√	√	√
Set ID (word swap)	√	√	√		√		√	√	√	√	√
Set Date/Time	√	√	√		√		√	√	√	√	√
Set Date/Time (word swap)	√	√	√		√		√	√	√	√	√
Verify PSet	√	√	√		√	√	√	√	√	√	√

Clear Results	√	√	√	√			√	√	√	√	√
Log Change	√	√	√		√	√	√	√	√	√	√
Decrement Batch	√	√	√	√			√	√	√	√	√
Increment Batch	√	√	√	√			√	√	√	√	√
Click Wrench	√	√	√	√			√	√	√	√	√
Bypass Stops	√	√	√	√			√	√	√	√	√
Verify Job Sequence	√	√	√		√	√	√	√	√	√	√
ASCII ID	√	√					√	√	√	√	√
Abort Job	√	√	√	√			√	√	√	√	
Remote Start	√	√	√	√			√				
Remove Lock on Reject	√	√	√	√			√	√	√	√	
Dual Start Interlocked	√	√	√	√			√				
Decrement Job	√	√	√	√			√	√	√	√	√
Increment Job	√	√	√	√			√	√	√	√	√
Decrement PSet	√	√	√	√			√	√	√	√	√
Increment PSet	√	√	√	√			√	√	√	√	√
Decrement Job Sequence	√	√	√	√			√	√	√	√	√

Increment Job Sequence	√	√	√	√			√	√	√	√	√
------------------------	---	---	---	---	--	--	---	---	---	---	---

## Polarity

When the polarity is set to N.O. the input is considered active high (24vdc for physical inputs and logic 1 for all network type buses). When the polarity is set to N.C. the input is considered active low (0vdc for physical inputs and logic 0 for all network type buses).

## Width and Offset

For multiple bit inputs (for example “Select PSet”) the width variable defines the number of bits the assignment will read for its input. This allows the input size to be restricted to a few bits saving space for other assignments.

The offset variable allows a fixed value to be added to the read value.

For example to use bits 4 & 5 of the physical inputs to select parameter sets 1-4 the assignment would look like...

Select PSet		
Bus	1	For the physical bus
Element	0	For the first element on the bus
Bit	4	For the starting bit location
Width	2	To span the two bits 4 & 5
Offset	1	Adding 1 to the read input value so we get...  Binary 00 = 1  Binary 01 = 2  Binary 10 = 3  Binary 11 = 4

## Input Assignments

<b>Do Nothing</b>	Bus	Element	Bit 0-32	Polarity N.O./N.C.	Width	Offset
	√	√	√			

The “Do Nothing” assignment will run do nothing if it is active or inactive.

<b>Start</b>	Bus	Element	Bit 0-32	Polarity N.O./N.C.	Width	Offset
	√	√	√	√		

The “Start” assignment will run the tool while the input is active. Start is available for the Physical I/O bus only.

<b>Stop</b>	Bus	Element	Bit 0-32	Polarity N.O./N.C.	Width	Offset
	√	√	√	√		

The “Stop” assignment will stop the tool if it is running and prevent it from being started.

<b>Reverse</b>	Bus	Element	Bit 0-32	Polarity N.O./N.C.	Width	Offset
	√	√	√	√		

The “Reverse” will put the controller in disassembly mode while the input is active.

<b>Disable</b>	Bus	Element	Bit 0-32	Polarity N.O./N.C.	Width	Offset
	√	√	√	√		

The “Disable” will disable the tool while the input is active. It will not stop a fastening cycle that is progress.

<b>Reset Job</b>	Bus	Element	Bit 0-32	Polarity N.O./N.C.	Width	Offset
	√	√	√	√		

On the transition of inactive to active the “Reset Job” assignment will reset the active job.

<b>Select PSet</b>	Bus	Element	Bit 0-32	Polarity N.O./N.C.	Width	Offset
	√	√	√		√	√

The “Select PSET” input will select the parameter set according to the input value. Uses the width parameter limit the width of the input bits read. The minimum width is 1 and the maximum is 8.

After the input is read the offset parameter will be added to the value to get the actual parameter set number. Selecting an invalid parameter set number will disable the tool.

<b>Select Job</b>	Bus	Element	Bit 0-32	Polarity N.O./N.C.	Width	Offset
	√	√	√		√	√

The “Select Job” input will select the job number according to the input value. Uses the width parameter limit the width of the input bits read. The minimum width is 1 and the maximum is 8.

After the input is read the offset parameter will be added to the value to get the actual job number. Selecting an invalid job number will disable the tool.

<b>Select Job Sequence</b>	Bus	Element	Bit 0-32	Polarity N.O./N.C.	Width	Offset









	√	√				
The “ASCII ID” assignment will set the ID to the of the input (ASCII) value. This assignment consumes the entire element so the Bit is not used. It also has a length parameter to set the length of the input in bytes. The input value will be passed directly to the ID recognition system.						
<b>Abort Job</b>	B u s	E l e m e n t	B i t 0-3 2	P o l a r i t y N. O./N. C.	W i d t h	O f f s e t
	√	√	√	√		
The “Abort Job” assignment aborts the job and disables the tool. A job reset is required to enable the tool for the next job.						
<b>Remote Start</b>	B u s	E l e m e n t	B i t 0-3 2	P o l a r i t y N. O./N. C.	W i d t h	O f f s e t
	√	√	√	√		
The “Remote Start” assignment will run the tool while the input is active. Remote Start is available for non-physical I/O buses.						
<b>Remove Lock on Reject</b>	B u s	E l e m e n t	B i t 0-3 2	P o l a r i t y N. O./N. C.	W i d t h	O f f s e t
	√	√	√	√		
The “Remove Lock on Reject” assignment unlocks the tool if locked on reject, re-enabling the tool.						
<ul style="list-style-type: none"> <li>If the two second timer times out, both inputs must be deactivated to reset the timer.</li> <li>If either input is deactivated the tool stops.</li> <li>To restart the tool, both inputs must be deactivated then reactivated within two seconds of each other.</li> </ul> <p>Tubenut Tool Homing Exceptions for Dual Start Interlocked functionality</p> <ul style="list-style-type: none"> <li>If controller’s tubenut homing configuration is</li> </ul> <p>set to RELEASE:</p> <ul style="list-style-type: none"> <li>Deactivating either, or both, of the inputs will initiate the homing sequence.</li> <li>Homing will continue until sequence is complete.</li> <li>If controller’s tubenut homing configuration is</li> </ul> <p>set to RELEASE AND REPRESS:</p> <ul style="list-style-type: none"> <li>Deactivating either of the inputs, then activating both inputs will initiate the homing sequence.</li> <li>Homing will continue while both inputs are active.</li> <li>If either input is deactivated, before homing is complete, the tool will stop, and homing will pause until both inputs are reactivated.</li> <li>To restart tool, after homing is complete, both inputs must be deactivated, then reactivated within two seconds of each other.</li> </ul>						

<b>Decrement Job</b>	Bus	Element	Bit 0-32	Polarity N.O./N.C.	Width	Offset
	√	√	√	√		

The “Decrement Job” assignment will decrement the Job Number, selecting the last job if decrementing past the first one.

<b>Increment Job</b>	Bus	Element	Bit 0-32	Polarity N.O./N.C.	Width	Offset
	√	√	√	√		

The “Increment Job” assignment will increment the Job Number, selecting the first job if incrementing past the last one.

<b>Decrement PSet</b>	Bus	Element	Bit 0-32	Polarity N.O./N.C.	Width	Offset
	√	√	√	√		

The “Decrement PSet” assignment will decrement the PSet Number, selecting the last PSet if decrementing past the first one.

<b>Increment PSet</b>	Bus	Element	Bit 0-32	Polarity N.O./N.C.	Width	Offset
	√	√	√	√		

The “Increment PSet” assignment will increment the PSet Number, selecting the first PSet if incrementing past the last one.

<b>Decrement Job Sequence</b>	Bus	Element	Bit 0-32	Polarity N.O./N.C.	Width	Offset

	√	√	√	√		
The “Decrement Job Sequence” assignment will decrement the Job sequence, selecting the last job sequence if decrementing past the first one.						
<b>Increment Job Sequence</b>	Bus	Element	Bit 0-32	Polarity N.O./N.C.	Width	Offset
	√	√	√	√		
The “Increment Job Sequence” assignment will increment the Job sequence, selecting the first job if incrementing past the last one.						

## Outputs

All output assignments have a Bus, Element, and Bit configuration to define its location in the system. Along with the basic configuration many also have other configuration(s) that allow its behavior to be modified to suit the application.

					Supported Feature							Controller				
					Mode Normal, Timed, Flashed	Time	Width	Offset	Input Bus	Input Element	Input Bit	iE C	iA C	iP C	iB C	iBC -Z
	Bus	Element	Bit 0-32	Polarity N.O./ N.C.												
Ok	√	√	√	√	√							√	√	√	√	√

Nok	√	√	√	√	√							√	√	√	√	√
Torque Ok	√	√	√	√	√							√	√	√	√	√
Torque Nok	√	√	√	√	√							√	√	√	√	√
Low Torque	√	√	√	√	√							√	√	√	√	√
High Torque	√	√	√	√	√							√	√	√	√	√
Angle Ok	√	√	√	√	√							√	√	√	√	√
Angle Nok	√	√	√	√	√							√	√	√	√	√
Low Angle	√	√	√	√	√							√	√	√	√	√
High Angle	√	√	√	√	√							√	√	√	√	√
Fastening Complete	√	√	√	√	√							√	√	√	√	√
In Cycle	√	√	√	√	√							√	√	√		
Fastening Aborted	√	√	√	√	√							√	√	√	√	√
Fastening Stopped	√	√	√	√	√							√	√	√	√	√
Batch Complete	√	√	√	√	√							√	√	√	√	√

Job Complete	√	√	√	√	√							√	√	√	√	√
Error	√	√	√	√	√							√	√	√	√	√
Tool Start Switch	√	√	√	√	√							√				
Tool Push to Start Switch	√	√	√	√	√							√				
Tool MFB	√	√	√	√	√							√				
Tool Enabled	√	√	√	√	√							√	√	√	√	√
Tool Running	√	√	√	√	√							√				
Service Indicator	√	√	√	√	√							√	√	√		√
ToolsNet Connected	√	√	√	√	√							√	√	√	√	√
Open Protocol Connected	√	√	√	√	√							√	√	√	√	√
PFCS Connected	√	√	√	√	√							√	√	√	√	√

Running PSet Number	√	√	√				√	√				√	√	√	√	√
Running Job Number	√	√	√				√	√				√	√	√	√	√
External Control led	√	√	√						√	√	√	√	√	√	√	√
Tool In CCW	√	√	√	√	√							√				
Tool In CW	√	√	√	√	√							√				
Torque	√	√	√				√					√	√	√	√	√
Torque (x10)	√	√	√				√					√	√	√	√	√
Torque (x100)	√	√	√				√					√	√	√	√	√
Angle	√	√	√				√					√	√	√	√	√
Rundown Save d to FTP Server	√	√	√				√					√	√	√	√	√
Fastener Remo ved	√	√	√	√	√							√	√	√		
Spindle Ok	√	√	√	√	√							√				
Spindle NOk	√	√	√	√	√							√				



Spindle Fastening Complete	√	√	√	√	√							√				
Pulses	√	√	√				√						√	√		√
Pulses High	√	√	√	√	√								√	√		√
Pulses Low	√	√	√	√	√								√	√		√
Pulses NOk	√	√	√	√	√								√	√		√
Pulses Ok	√	√	√	√	√								√	√		√
ON	√	√	√	√	√							√	√	√	√	√
Job Aborted	√	√	√	√	√							√	√	√	√	
Tool In Use	√	√	√	√		√						√	√	√	√	√
Barcode Scanned	√	√	√	√								√	√	√	√	√
Start Trigger Active	√	√	√	√								√				

## Polarity

When the polarity is set to N.O. the output will be high when it is active (24vdc for physical outputs and logic 1 for all network type buses). When the polarity is set to N.C. the output will be low for active (0vdc for physical inputs and logic 0 for all network type buses).

## Mode

### Normal

In the “Normal” mode the output will track the state of the assignment (while still observing the polarity setting). If the polarity is set N.O. and the assignment has an active output the output will be on and stay on till the assignment goes to inactive.

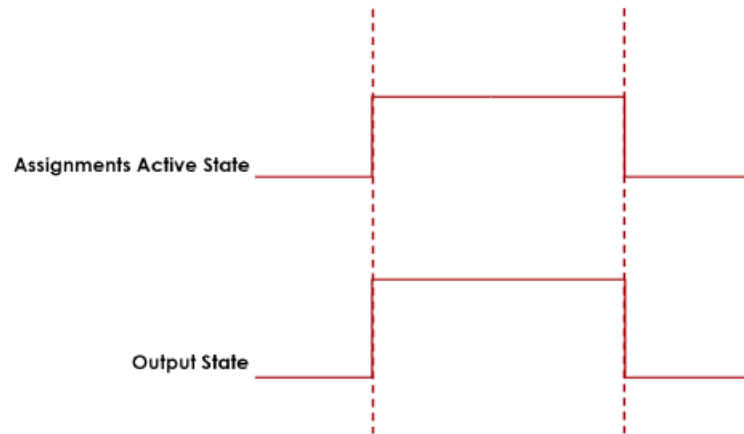


Figure 1: Normal Mode

### Timed

In the “Timed” mode the output will come on when the assignments state goes active and go off based on the time value or the assignment state going inactive (while still observing the polarity setting).

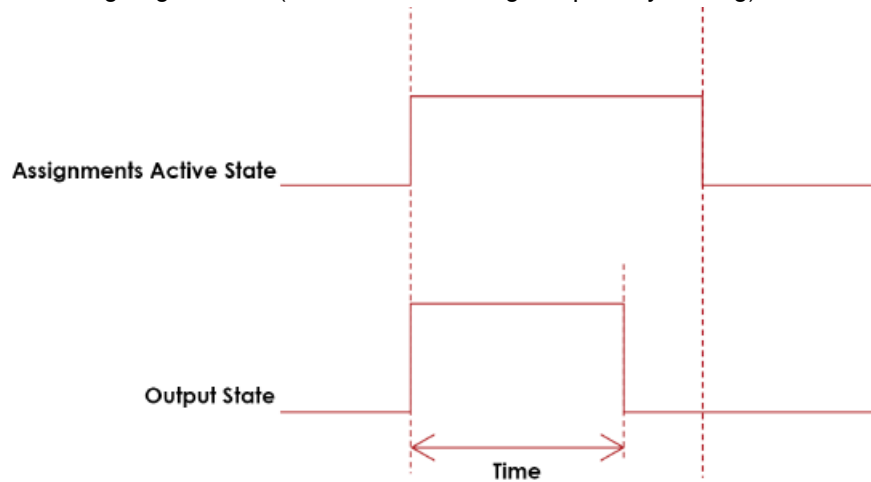


Figure 2 Timed Mode

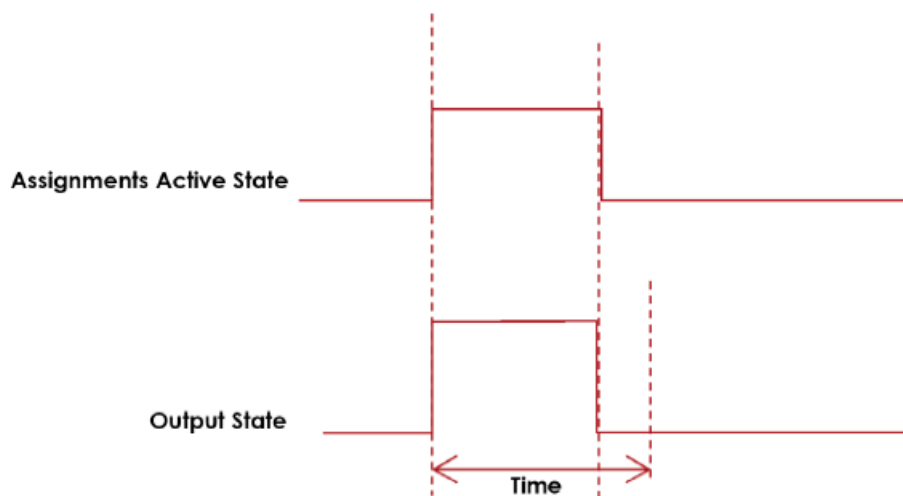


Figure 3: Timed Mode (assignment deactivates before time expires)

### Flash

In the “flash” mode the output will flash at the time rate while the assignments state is active (while still observing

the polarity setting).

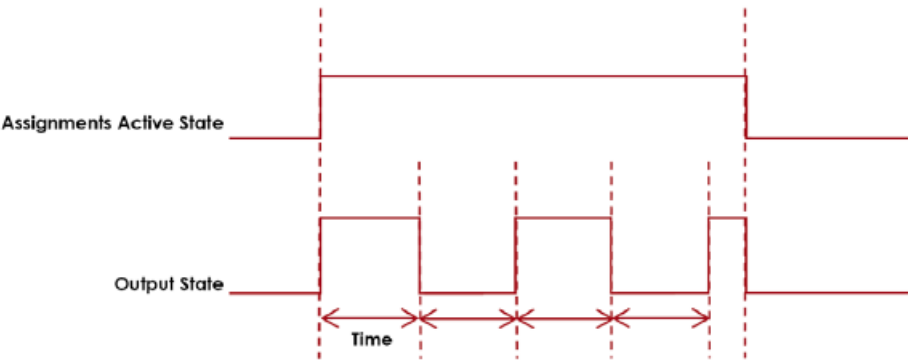


Figure 3 Flash Mode

Width and Offset

For multiple bit outputs (for example “Running PSet Number”) the width variable defines the number of bits the assignment will output. This allows the output size to be restricted to a few bits saving space for other assignments.

The offset variable allows a fixed value to be added to the value before it is output.

For example to use bits 4 & 5 of the physical outputs to indicate the selected parameter set number 1-4 as binary 0-3 the assignment would look like...

Running PSet Number		
Bus	1	For the physical bus
Element	0	For the first element on the bus
Bit	4	For the starting bit location
Width	2	To span the two bits 4 & 5
Offset	-1	Adding -1 to the read input value so we get...  1 = Binary 00  2 = Binary 01  3 = Binary 10  4 = Binary 11

Output Assignments

OK	B u s	Elem ent	Bit 0-3 2	Polarity N.O. /N.C.	Mode: Normal, Time d, Flash	Ti me	Wi dth	Off set	Input Bus	Input Ele ment	Input Bit
	√	√	√	√	√						

The “Ok” output assignment will go active at the completion of an acceptable fastening. It will go inactive when the next fastening is started (the torque exceeds the threshold value) or a Job reset.

Nok	B u s	Elem ent	Bit 0-3 2	Polarity N.O. /N.C.	Mode: Normal, Time d, Flash	Ti me	Wi dth	Off set	Input Bus	Input Ele ment	Input Bit
	√	√	√	√	√						

The “Nok” output assignment will go active at the completion of an unacceptable fastening. It will go inactive when the next fastening is started (the torque exceeds the threshold value) or a Job reset.

Torque Ok	B u s	Elem ent	Bit 0-3 2	Polarity N.O. /N.C.	Mode: Normal, Time d, Flash	Ti me	Wi dth	Off set	Input Bus	Input Ele ment	Input Bit
	√	√	√	√	√						

The “Torque Ok” output assignment will go active at the completion of a fastening that has an acceptable torque value. It will go inactive when the next fastening is started (the torque exceeds the threshold value) or a Job reset.

Torque Nok	B u s	Elem ent	Bit 0-3 2	Polarity N.O. /N.C.	Mode: Normal, Time d, Flash	Ti me	Wi dth	Off set	Input Bus	Input Ele ment	Input Bit
	√	√	√	√	√						

The “Torque Nok” output assignment will go active at the completion of a fastening that has an unacceptable torque value. It will go inactive when the next fastening is started (the torque exceeds the threshold value) or a Job reset.

Low Torque	B u s	Elem ent	Bit 0-3 2	Polarity N.O. /N.C.	Mode: Normal, Time d, Flash	Ti me	Wi dth	Off set	Input Bus	Input Ele ment	Input Bit
	√	√	√	√	√						

The “Low Torque” output assignment will go active at the completion of a fastening that has a low torque results. It will go inactive when the next fastening is started (the torque exceeds the threshold value) or a Job reset.



High Angle	B u s	Elem ent	Bit 0-3 2	Polarity N.O. /N.C.	Mode: Normal, Time d, Flash	Ti me	Wi dth	Off set	Input Bus	Input Ele ment	Input Bit
	√	√	√	√	√						

The “High Angle” output assignment will go active at the completion of a fastening that has high angle results. It will go inactive when the next fastening is started (the torque exceeds the threshold value) or a Job reset.

Fastenin g Compl ete	B u s	Elem ent	Bit 0-3 2	Polarity N.O. /N.C.	Mode: Normal, Time d, Flash	Ti me	Wi dth	Off set	Input Bus	Input Ele ment	Input Bit
	√	√	√	√	√						

The “Fastening Complete” output assignment will go active at the completion of a fastening. It will go inactive when the next fastening is started (the torque exceeds the threshold value) or a Job reset.

In Cycle	B u s	Elem ent	Bit 0-3 2	Polarity N.O. /N.C.	Mode: Normal, Time d, Flash	Ti me	Wi dth	Off set	Input Bus	Input Ele ment	Input Bit
	√	√	√	√	√						

The “In Cycle” output assignment will go active at the start of the fastening cycle (the torque exceeds the threshold value). It will go inactive when the fastening cycle ends.

Fastenin g Aborte d	B u s	Elem ent	Bit 0-3 2	Polarity N.O. /N.C.	Mode: Normal, Time d, Flash	Ti me	Wi dth	Off set	Input Bus	Input Ele ment	Input Bit
	√	√	√	√	√						

The “Fastening Aborted” output assignment will go active at the completion of a fastening that was aborted by the system. It will go inactive when the next fastening is started (the torque exceeds the threshold value) or a Job reset.







	√	√	√	√	√							
The “Tool Running” output assignment will be active while the tool is running.												
Service I ndicator	B u s	Elem ent	Bit 0-3 2	Polarity N.O. /N.C.	Mode: Normal, Time d, Flash	Ti me	Wi dth	Off set	Input Bus	Input Ele ment	Input Bit	
	√	√	√	√	√							
The “Service Indicator” output assignment will be active if the system is in need of service.												
ToolsNet Connect ed	B u s	Elem ent	Bit 0-3 2	Polarity N.O. /N.C.	Mode: Normal, Time d, Flash	Ti me	Wi dth	Off set	Input Bus	Input Ele ment	Input Bit	
	√	√	√	√	√							
The “ToolsNet Connected” output assignment will be active if the controller has an active connection to a Tools Net server.												
Open Pr otocol C onnected	B u s	Elem ent	Bit 0-3 2	Polarity N.O. /N.C.	Mode: Normal, Time d, Flash	Ti me	Wi dth	Off set	Input Bus	Input Ele ment	Input Bit	
	√	√	√	√	√							
The “Open Protocol Connected” output assignment will be active if the controller has an active Open protocol c onnection.												
PFCS Connect ed	B u s	Elem ent	Bit 0-3 2	Polarity N.O. /N.C.	Mode: Normal, Time d, Flash	Ti me	Wi dth	Off set	Input Bus	Input Ele ment	Input Bit	
	√	√	√	√	√							
The “PFCS Connected” output assignment will be active if the controller has an active PFCS connection.												
Running PSet Nu mber	B u s	Elem ent	Bit 0-3 2	Polarity N.O. /N.C.	Mode: Normal, Time d, Flash	Ti me	Wi dth	Off set	Input Bus	Input Ele ment	Input Bit	

[illegible]



<b>Rundown Saved to FTP Server</b>	B u s	Elem ent	Bit 0-3 2	Polarity N.O. /N.C.	Mode: Normal, Time d, Flash	Ti m e	Wi dth	Off set	Input Bus	Input Ele ment	Input Bit
	√	√	√				√				

The “Rundown Saved to FTP Server” output assignment will output the ID of the last rundown that was saved to the FTP server.

<b>Fastener Removed</b>	B u s	Elem ent	Bit 0-3 2	Polarity N.O. /N.C.	Mode: Normal, Time d, Flash	Ti m e	Wi dth	Off set	Input Bus	Input Ele ment	Input Bit
	√	√	√	√	√						

The “Fastener Removed” output assignment will go active when a fastener is removed by the operator. The controller must be configured to report disassembly for this output to work. It will go inactive when the next fastening is started (the torque exceeds the threshold value) or a Job reset.

<b>Spindle OK</b>	B u s	Elem ent	Bit 0-3 2	Polarity N.O. /N.C.	Mode: Normal, Time d, Flash	Ti m e	Wi dth	Off set	Input Bus	Input Ele ment	Input Bit
	√	√	√	√	√						

The “Spindle Ok” output assignment will go active at the completion of multi-spindle fastening if all spindles have an OK. It will go inactive when the next fastening is started (the torque exceeds the threshold value) or a Job reset.

<b>Spindle NOK</b>	B u s	Elem ent	Bit 0-3 2	Polarity N.O. /N.C.	Mode: Normal, Time d, Flash	Ti m e	Wi dth	Off set	Input Bus	Input Ele ment	Input Bit
	√	√	√	√	√						

The “Spindle NOK” output assignment will go active at the completion of multi-spindle fastening if one or more of the spindles have an NOK. It will go inactive when the next fastening is started (the torque exceeds the threshold value) or a Job reset.

<b>Spindle Fastening Complete</b>	B u s	Elem ent	Bit 0-3 2	Polarity N.O. /N.C.	Mode: Normal, Time d, Flash	Ti m e	Wi dth	Off set	Input Bus	Input Ele ment	Input Bit
	√	√	√	√	√						

The “Spindle Fastening Complete” output assignment will go active at the completion of multi-spindle fastening. It will go inactive when the next fastening is started (the torque exceeds the threshold value) or a Job reset.

<b>Pulses</b>	B u s	Elem ent	Bit 0-3 2	Polarity N.O. /N.C.	Mode: Normal, Time d, Flash	Ti m e	Wi dth	Off set	Input Bus	Input Ele ment	Input Bit
	√	√	√				√				

The “Pulses” output assignment will output the pulse count value of the most recent rundown. The value will be cleared to 0 at the start of a new fastening cycle or a Job reset.

<b>Pulses High</b>	B u s	Elem ent	Bit 0-3 2	Polarity N.O. /N.C.	Mode: Normal, Time d, Flash	Ti m e	Wi dth	Off set	Input Bus	Input Ele ment	Input Bit
	√	√	√	√	√						

The “Pulses High” output assignment will go active at the completion of a fastening that has an pulse count that exceeds the high limit. It will go inactive when the next fastening is started (the torque exceeds the threshold value) or a Job reset.

<b>Pulses Low</b>	B u s	Elem ent	Bit 0-3 2	Polarity N.O. /N.C.	Mode: Normal, Time d, Flash	Ti m e	Wi dth	Off set	Input Bus	Input Ele ment	Input Bit
	√	√	√	√	√						

The “Pulses Low” output assignment will go active at the completion of a fastening that has an pulse count that falls below the low limit. It will go inactive when the next fastening is started (the torque exceeds the threshold value) or a Job reset.



	√	√	√	√		√						
<p>The “Tool In Use” output assignment will go active when the trigger is pressed, whereupon a timer will restart. It will go inactive when the specified time is reached without becoming active in between.</p>												
<b>Barcode Scanned</b>	B u s	Elem ent	Bit 0-3 2	Polarity N.O. /N.C.	Mode: Normal, Time d, Flash	Ti m e	Wi dth	Off set	Input Bus	Input Ele ment	Input Bit	
	√	√	√	√								
<p>The “Barcode Scanned” output assignment will go active when a barcode is scanned. The ID # (1-4) will activate the corresponding bit, if it is covered by the number of bits configured. The maximum size is 4 bits. All bits will go inactive when a tool reaches the InCycle threshold of a rundown or when they are reset.</p>												
<b>Start Trigger Active</b>	B u s	Elem ent	Bit 0-3 2	Polarity N.O. /N.C.	Mode: Normal, Time d, Flash	Ti m e	Wi dth	Off set	Input Bus	Input Ele ment	Input Bit	
	√	√	√	√								
<p>The ‘Start Trigger Active’ assignment will reflect the state of the active Start Input configured to run the tool.</p>												

The ‘Start Trigger Active’ assignment will reflect the state of the active Start Input configured to run the tool.

#### Possible Start Inputs include:



- Start from IO
  - Start
  - Dual Start Interlocked
- Start from Tool Buttons
  - Lever and/or PTS
  - Dual Levers Interlocked
  - Start from Master Tool
  - Start from Remote Start
  - Latched Throttle

Start Trigger Active is available for the iEC Controller Only.

Phone: (503) 254-6600  
Toll Free: 1-800-852-1368

AIMCO CORPORATION DE MEXICO SA DE CV Ave. Cristobal Colon 14529  
Chihuahua, Chihuahua. 31125  
Mexico  
Phone: (01-614) 380-1010

Documents / Resources

 Gen IV Controller  Assignable I/O Instructions   <small>AIMCO is a part of the AIMCO GROUP. For more information, visit <a href="http://www.aimco.com">www.aimco.com</a></small>	<a href="#">AcraDyne iAC4EGV-T Assignable I O Gen IV ACE iAC Controller</a> [pdf] Instructions iAC4EGV-T, Assignable I O Gen IV ACE iAC Controller, iAC4EGV-T Assignable I O Gen IV ACE iAC Controller, Gen IV ACE iAC Controller, ACE iAC Controller, Controller
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References

-  [Aimco-Global | Tough tools Made in the USA.](#)

[Manuals+](#)