![Ingersoll-Rand Assembly Solutions logo]

Application Services (866) 284-5509

Purpose:
The purpose of this bulletin is to outline the steps required and timing for programming a PLC to operate an Insight DC Tool Controller with a Machine Mount tool or Handheld.

Programming Note:
If direction (FORWARD or REVERSE) or the configs are not going to change, these inputs may remain ON.
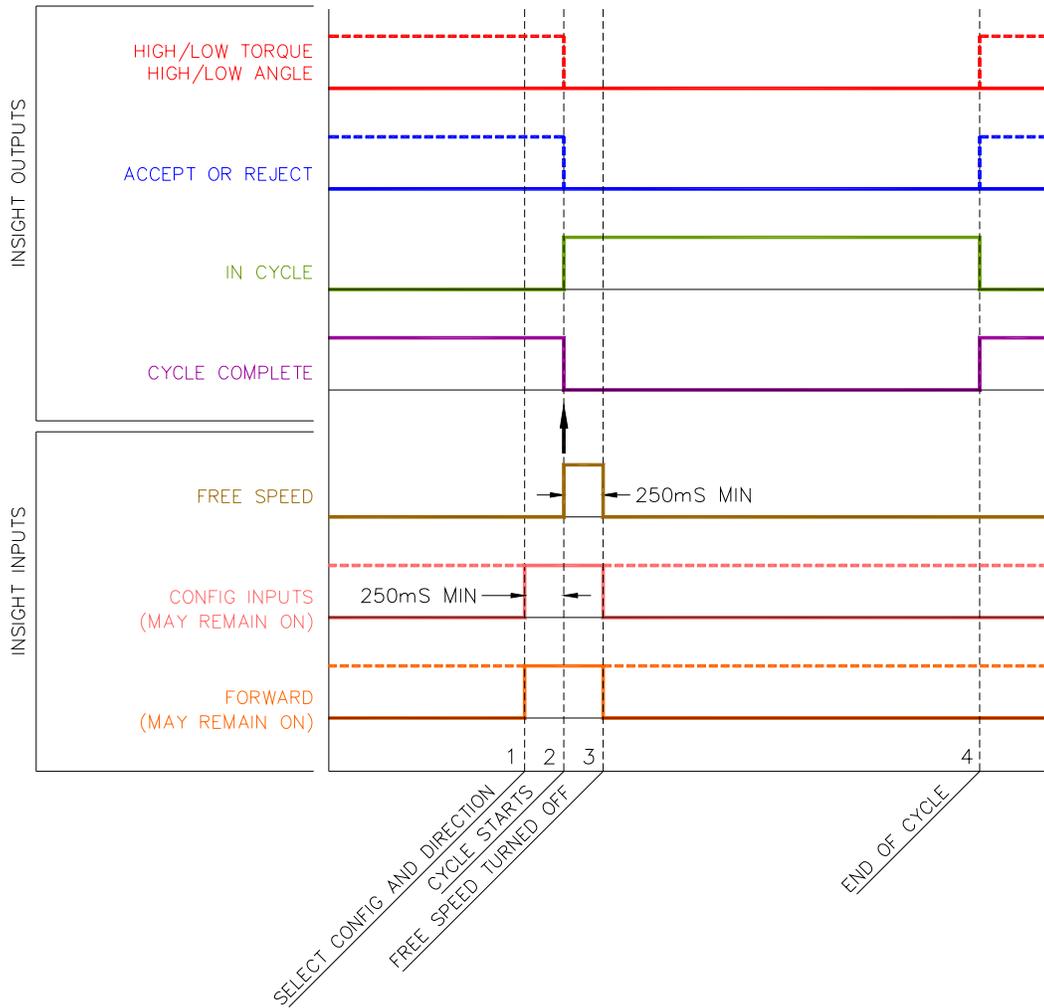
Handheld Tool with External Configuration Selection
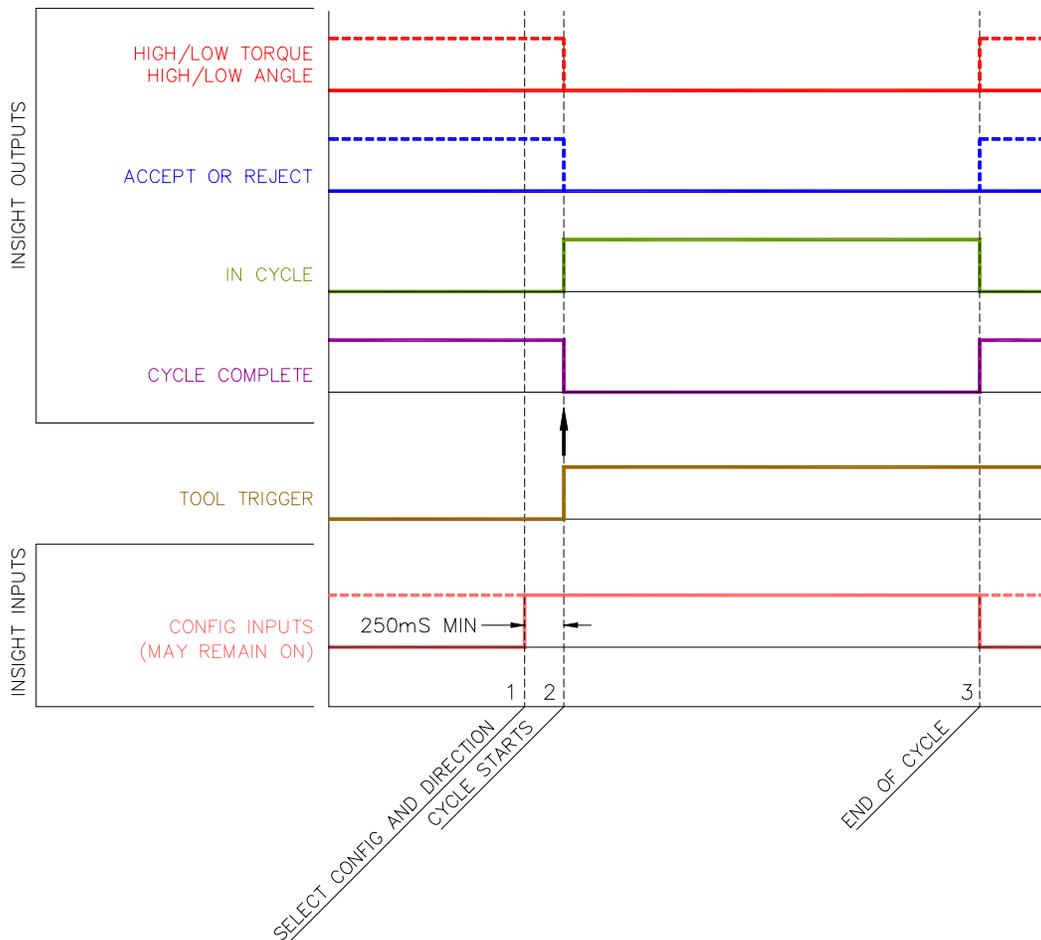
1)   Select configuration using the "CONFIG" inputs on the Insight.
2)   When the trigger is pulled, the configuration inputs are locked in and the cycle starts.
3)   The tool will stop at the end of the cycle and the trigger must be released and pulled again to start another cycle.

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Machine Mount Tool with External Configuration Selection (Throttle or Maintained Start Mode)
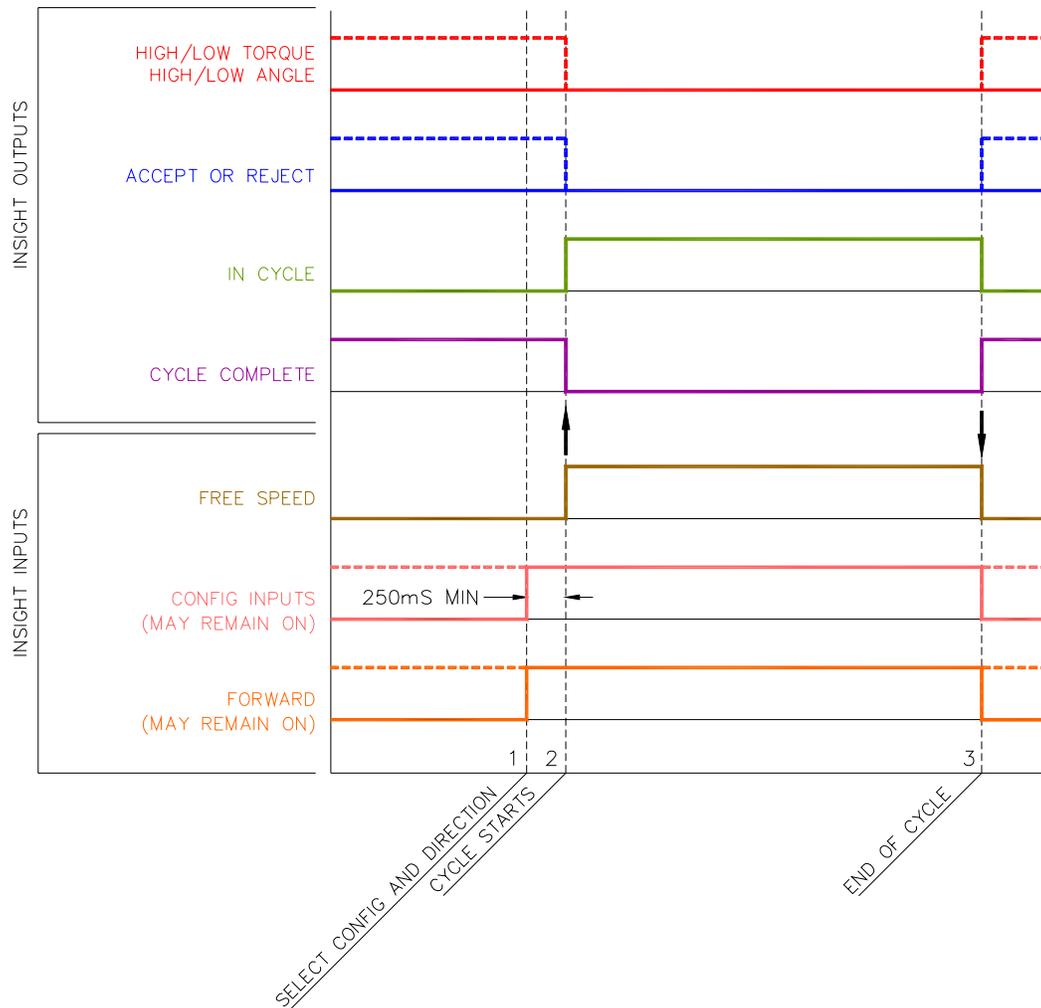
1) Select configuration using the "CONFIG" inputs on the Insight. Select the forward direction by activating the "FORWARD" input on the Insight.
2) When the "FREE SPEED" input is activated, the configuration inputs are locked in and the cycle starts.
3) The tool will stop at the end of the cycle. When the "CYCLE COMPLETE" output turns on, "FREE SPEED" should be dropped until the next cycle.

Machine Mount Tool with External Configuration Selection (Pulse or Momentary Start Mode)

1) Select configuration using the "CONFIG" inputs on the Insight. Select the forward direction by activating the "FORWARD" input on the Insight.
2) When the "FREE SPEED" input is activated, the configuration inputs are locked in and the cycle starts.
3) After 250 mS, "FREE SPEED", direction, and config inputs may be turned off.
4) The tool will continue to run and it will stop at the end of the cycle.