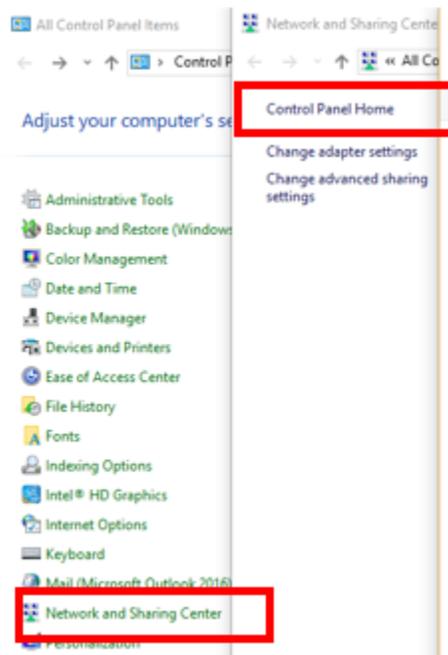


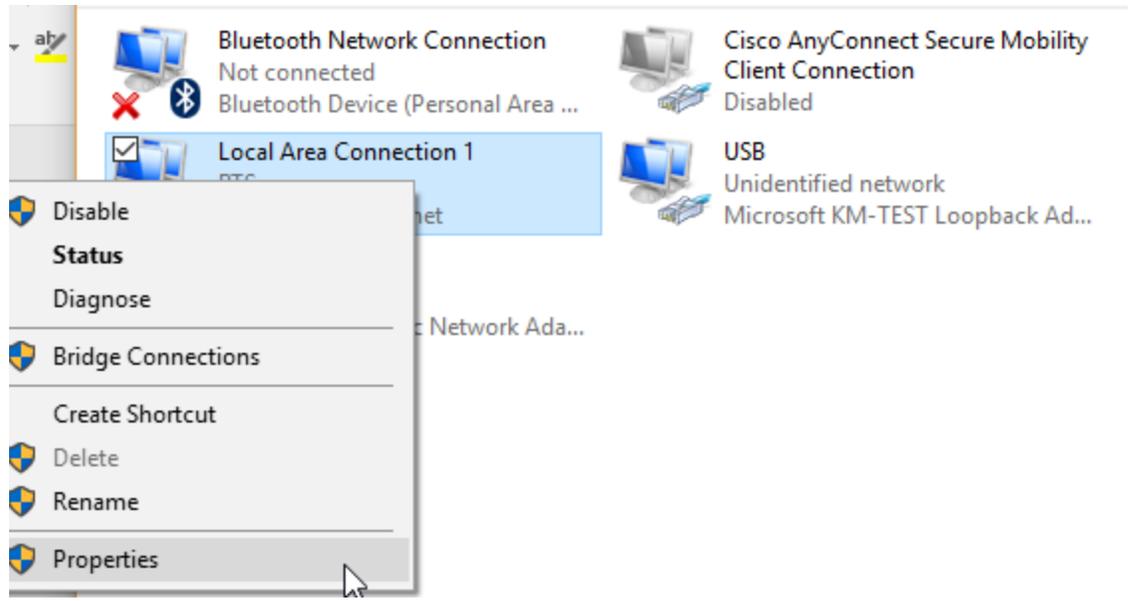
## Detailed Moxa Setup Guide

You will need to set your PC network adapter to the same network the Moxa is set to (either the default network or what you programmed it to) so that you can access the Moxa's web configuration page and program the unit. As you change the Moxa's settings, the IP address of the Moxa will change which will require you to adjust your network adapter's IP address settings in order to continue to make programming changes. The following steps will guide you through this process.

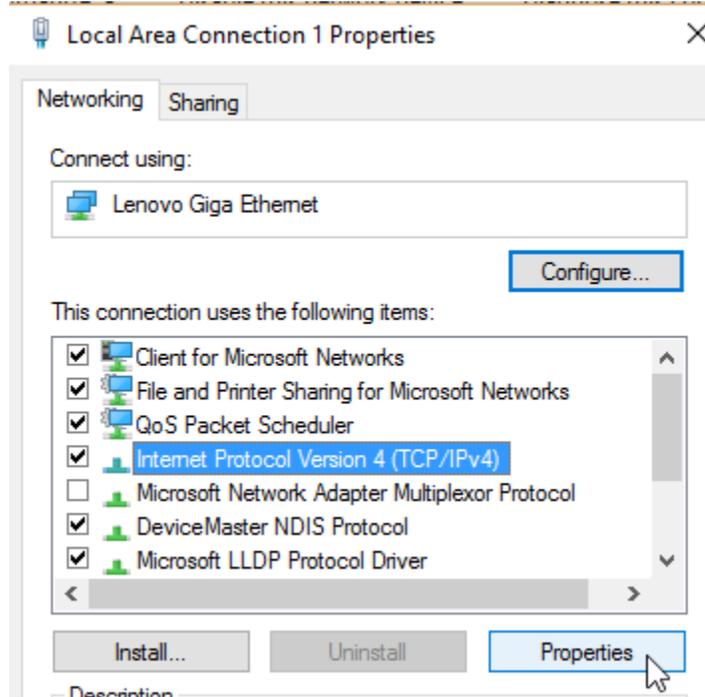
1. Go to Control Panel > Network and Sharing Center > Change adapter settings



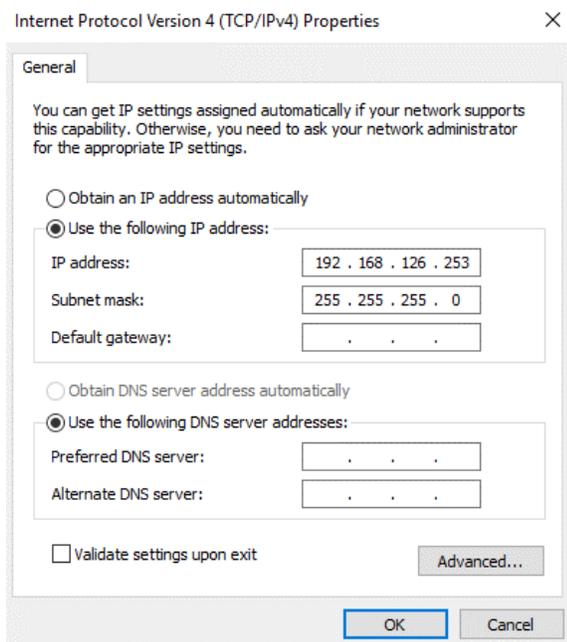
- a.
  2. Right click the network adapter you will be using and select properties.
    - a. If a Diamond USB-Ethernet adapter will be used, plug the adapter in at this time and wait for it to appear as a connection option. In this example I will be using my laptops built-in network adapter.



- b.
- 3. Highlight "Internet Protocol Version 4" and select properties.



- a.
- 4. Click "Use the following IP address:" and set the following values:
  - a. IP address: 192.168.126.253 (or any available address on the .126 network)
  - b. Subnet mask: 255.255.255.0



c.

NOTE: The moxa default wired IP address is 192.168.126.254. By setting you PC to “.253” you will be on the same subnet and allow your network interface to talk to the moxa when it is defaulted.

5. Plug the provided blue Ethernet cross over cable into the Ethernet port of the moxa unit
6. Plug the other end of the Moxa crossover cable in to you network adapter you set the static address to.
7. Now plug the power cable into the wall outlet and screw the other end into the moxa. This will power on the unit.  
**Note: Step 6 MUST be done before step 7 for process to work properly!!! The Moxa unit will only enable the wireless or the wired connection at any given time. This process takes place during boot time and if a network cable is plugged in, it will boot to wired mode. If no cable is plugged in to the Ethernet port, it will boot to wireless mode. To switch between modes, a power cycle is required so it can go through this process again.**
8. Using a small object such as a paper clip, insert it into the “reset” hole on top of the Moxa unit. The “ready” light will blink green a few times; hold the small object into the hole until a solid red light is displayed.
9. After a few short moments, the “ready” light will turn green and a beeping sound will be heard. The Moxa unit is now defaulted and you are ready to proceed. This is best practice even if the unit is brand new or an RMA unit.
10. Open a web browser, type the wired default IP address of 192.168.126.254 into the address bar at the top of the screen, then hit enter.



Google Search

I'm Feeling Lucky

11. Click "Login" (No password needed to logon by default)

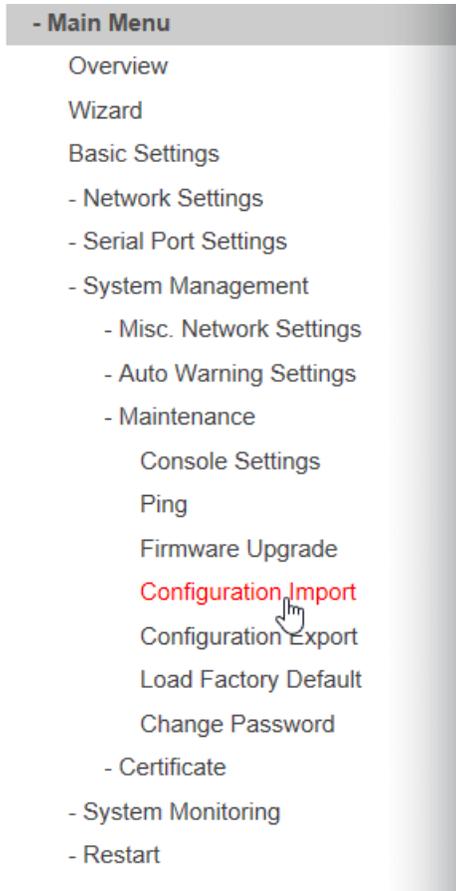
Account

admin ▾

Password

Login

12. On the left side's drop down menu, select System Management > Maintenance > Configuration Import.



13. On the Configuration Import screen, check the box saying “Import all configurations including IP configurations”. Select “Browse” and choose the provided ***text file if used***. If changes are made to the wireless network, a simple export configuration of a working unit on your network will provide the updated parameters.

NOTE: Profiles contain the IP address of the unit they were obtained from. Putting the configured unit on the network without completing this guide and updating the IP address to one that’s not currently used on your network will result in duplicate IP addresses on the network and cause issues with the duplicate devices. For new units, a new address will need to be obtained. For replacement of a Moxa unit, make sure the old unit is turned off.

## ❖ Configuration Import

Configuration Import

Select configuration file

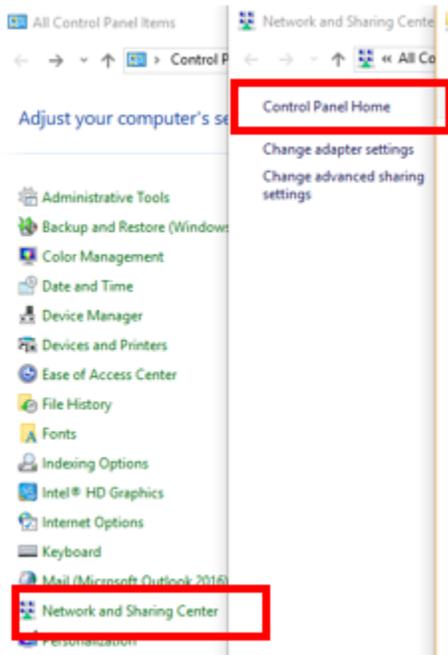
IP configuration

Browse

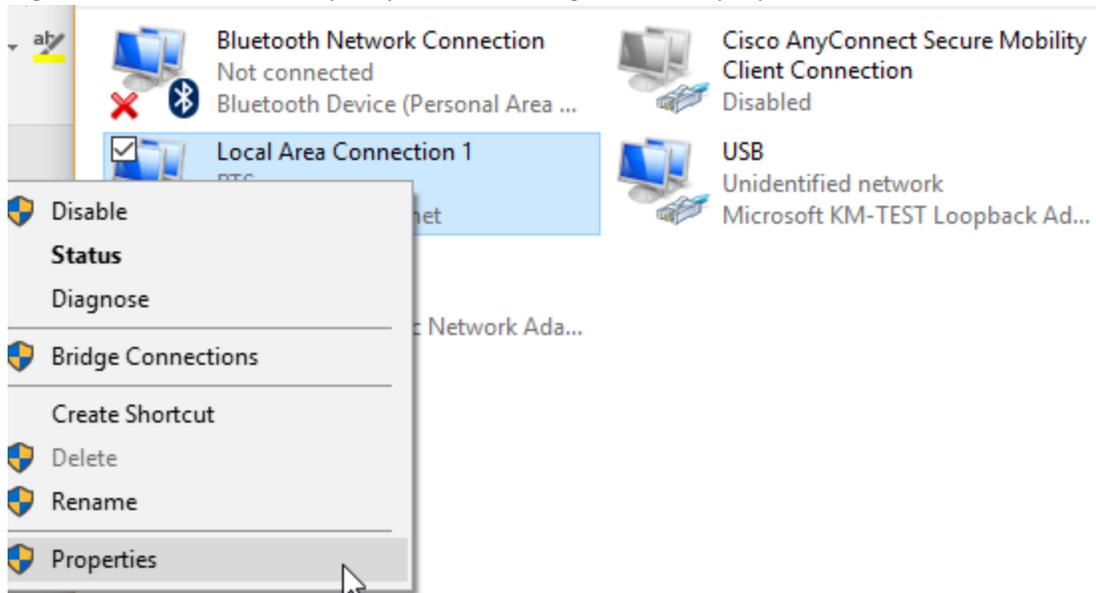
Import all configurations including IP configurations.

Submit

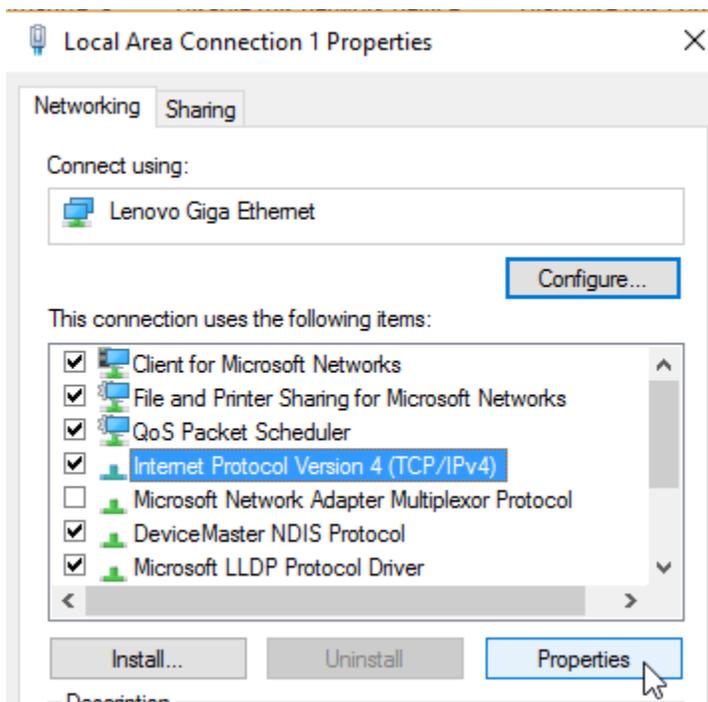
14. Click submit; the device is configured once a series of beeps is heard and the ready light is a steady green.
15. Go to Control Panel > Network and Sharing Center > Change adapter settings



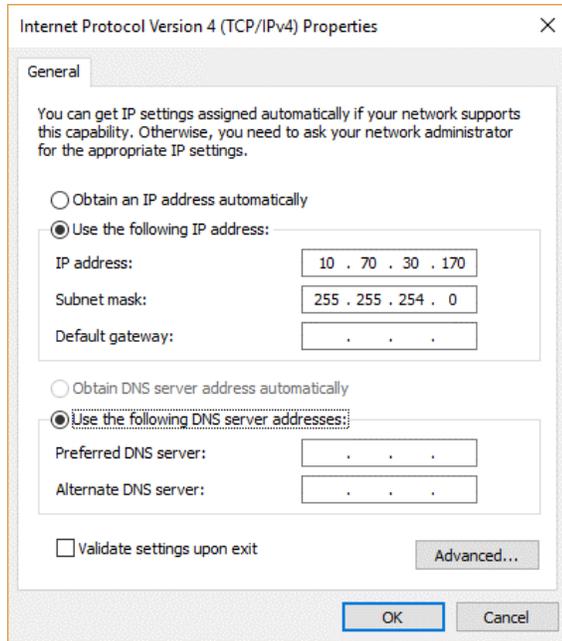
16. Right click the network adapter you will be using and select properties



17. Highlight “Internet Protocol Version 4” and select properties.



18. Click “Use the following IP address:” and set the following values:
- IP address: On same subnet as wired ip address
  - Subnet mask: **255.255.254.0**



19. Open a web browser, type the new Moxa IP address of 10.70.30.171 into the address bar at the top of the screen, then hit enter.



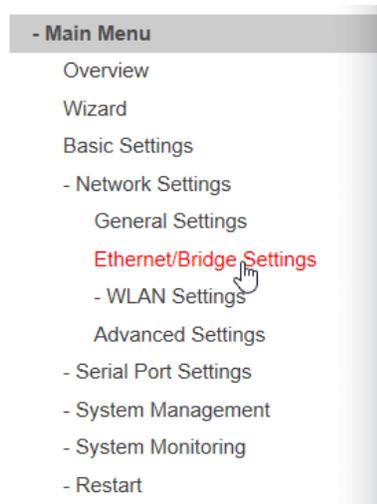
Google Search

I'm Feeling Lucky

20. Click "Login" (No password needed to logon)

Account    
Password

21. On the left side's drop down menu, click Network Settings > Ethernet/Bridge Settings



22. In the IP address bar, change the last set of numbers to correlate with your Moxa unit (171 in this example), and click "submit".

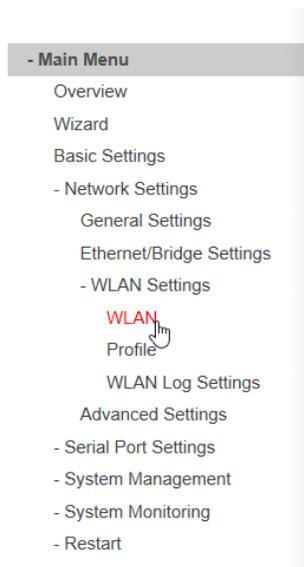
NOTE: "10.70.30", in this example, should be consistent for all moxa units and thus we will only need to change the last set to a unique, unused number for network communication. If the IP address the unit will be set to is not known, contact Don Barns or IT. Assuming you will only be changing the last 3 numbers, no adjustments to your network connection will be needed at this time.

## ⚙️ Network Setting - Ethernet/Bridge

Network Setting - Ethernet/Bridge

Ethernet bridge	<input type="text" value="Disable"/>
IP configuration	<input type="text" value="Static"/>
IP address	<input type="text" value="10.70.30.171"/>
Netmask	<input type="text" value="255.255.254.0"/>
Gateway	<input type="text" value="10.70.30.2"/>

23. Once the network settings for the Ethernet port are submitted, we will change the wireless network settings. Since the moxa only boots to one mode at a time (wired/wireless) we can set the IP addresses the same. This will allow you to switch between wired and wireless by simply power cycling the unit. To do this, Click on Network Settings > WLAN Settings > WLAN



24. In the IP address bar, change the last set of numbers to correlate with your Moxa unit (171 in this example), and click "submit".

**WLAN Settings**

WLAN Settings

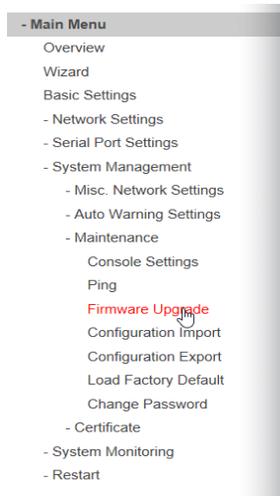
IP configuration Static

IP address	10.70.30.171
Netmask	255.255.254.0
Gateway	10.70.30.2

Submit

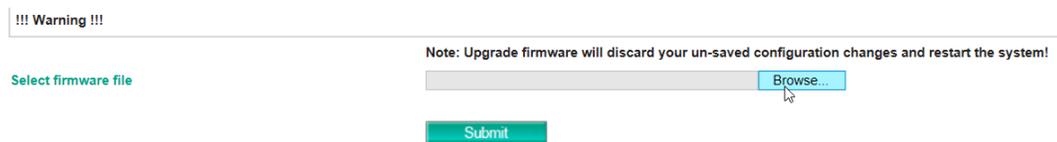
At this point the Moxa unit should be fully functional on your wireless network. If it is plugged into a shop floor switch with the wired or using the shop floor wireless, you can then access the web interface at any time using its IP address. The next steps will show you how to upgrade the moxa's firmware which is recommended. Firmware version can be seen at the top of the Moxa's web page and currently has the newest version. Units showing a version prior or equal to 1.8 should be upgraded immediately.

25. To update the firmware, click on the left side's drop down menu, System Management > Maintenance > Firmware Upgrade

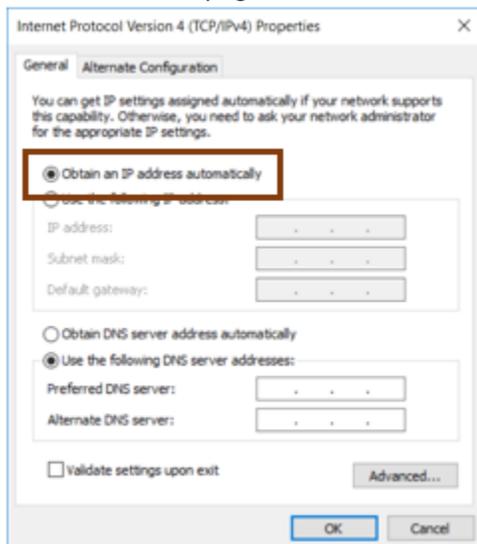


26. On the Firmware Upgrade screen, select “Browse”. Choose the provided ***firmware upgrade file***, and click “submit”. A series of beeps indicates that the firmware has been upgraded.

## ⚙️ Firmware Upgrade



27. If you used the Diamond USB-Ethernet adapter, you can leave the settings as they are. If you used your PC's built-in network interface card, you will need to complete steps 13-15 once more.
28. Once at the IPv4 page, Click the bubble saying “Obtain an IP address automatically, then click ok.



29. The Moxa device has now been configured to your network requirements and upgraded from previous firmware. It is now safe to unplug all connections to the device and plug it in where it will reside.