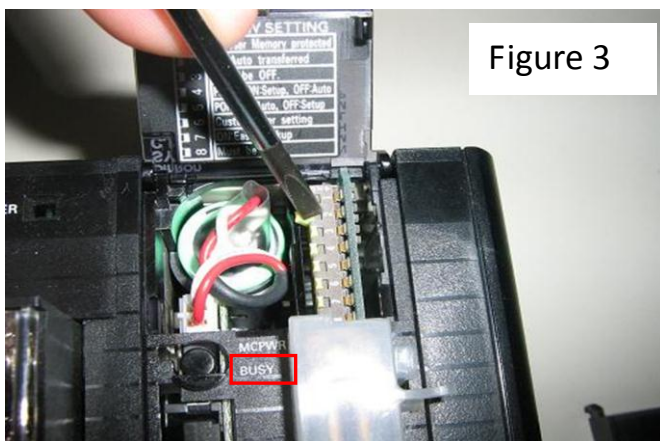
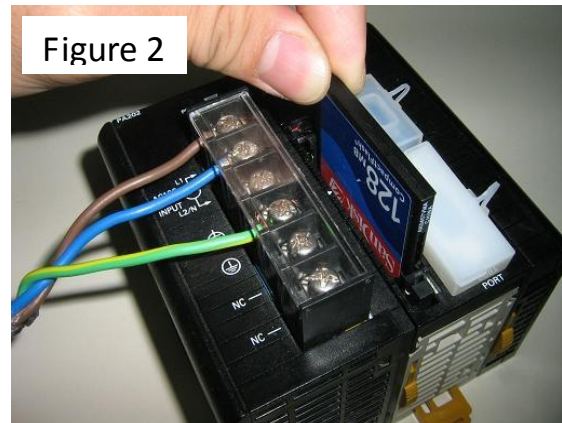


## Update PLC Software with REPLACE.OBJ Only:

1. Update PLC Software with REPLACE.OBJ Only
2. Copy only REPLACE.OBJ to CF Card
3. Switch Off PLC power (Picture 1)
4. Insert CF Card to PLC (Figure 2)
5. Turn ON DIP pin2 (Figure 3)
6. Power On the PLC
7. Busy LED will flash when program is transferring (Figure 3)
8. Wait for Busy LED to Stop, Power Off PLC,
9. Turn Off DIP pin2 and remove CF card
10. Update Completed

**Note: This procedures does NOT overwrite USER SETTING**



## Update Program from SD Card to Touch Panel:

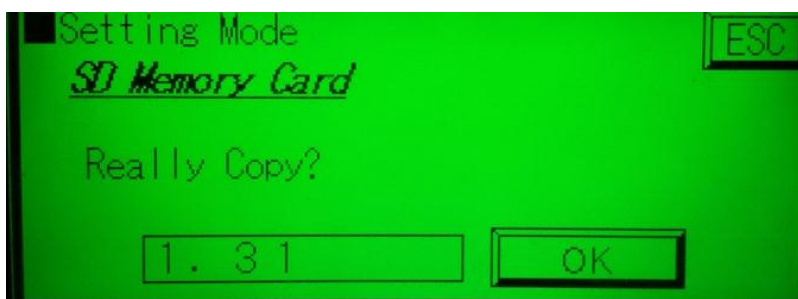
1. Copy all the "\*.gsd" files to SD Card (<=16GB). Format as follow: (gt\_data/1\_46/\*.gsd)
2. Without Power off Touch Panel, insert the SD card (<=16GB) into the touch panel card slot.
3. Touch Panel displays "Reading SD Memory Card" automatically.
4. Then, "Setting Mode" appears.
5. Select SD--> GT button (Figure 4)
6. Then, select desired file name, press "COPY" button to update. (Figure 5)
7. Select "OK" to start copy (Figure 6) and once update completed, Press "OK" button.
8. Remove the SD Card and then press "ESC" will lead to Main screen
9. Update Completed.



**Figure 4**



**Figure 5**



**Figure 6**