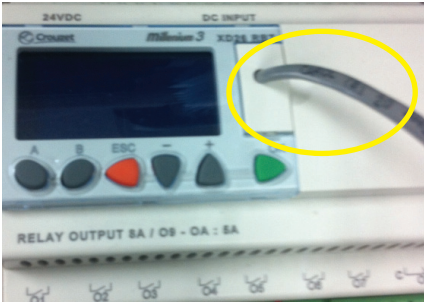


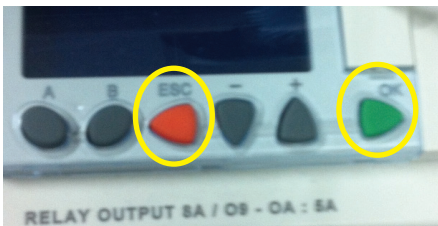
1. Power off the machine at the disconnect.
2. Remove the gray display cable from the PLC.



3. Gently insert the memory cartridge into the slot.



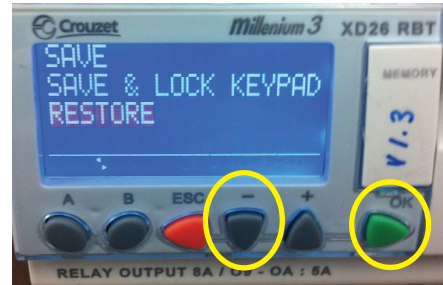
4. Power on at the disconnect (do not turn on the machine).
5. Press the "ESC" and "OK" buttons at the same time (the screen might be blank).



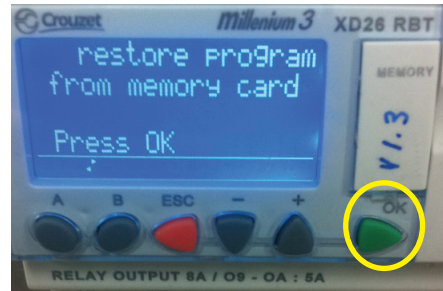
6. Use the "-" (minus) key to scroll down to "MEMORY CARD" and press "OK."



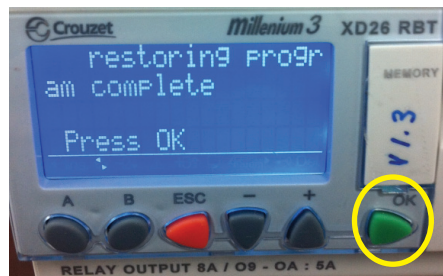
7. Use the "-" (minus) key to scroll down to "RESTORE" and press "OK."



8. Press "OK" at "restore program from memory card."



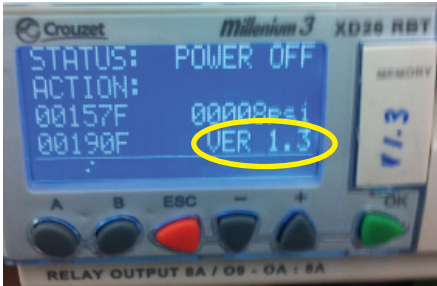
9. Press "OK" at "restoring program complete."



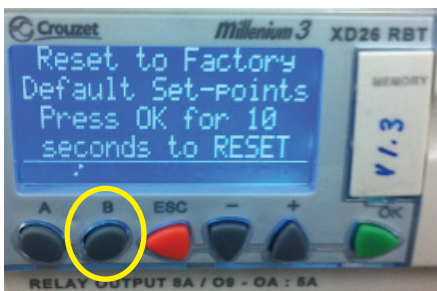
10. Power off the machine at the disconnect.
11. Power on at the disconnect (do not turn on the machine).
12. Press "OK" to power up the screen.



13. Verify the screen indicates “VER 1.3.”



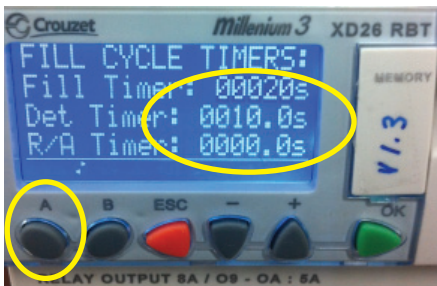
14. Press the “B” key to go to “Reset to Factory” screen.



15. Press and hold the “OK” key for 10+ seconds until the screen flashes “FACTORY RESET.”



16. Do a quick check: press the “A” key three times and there should be values in the parameters.



17. At this point the PLC is updated.

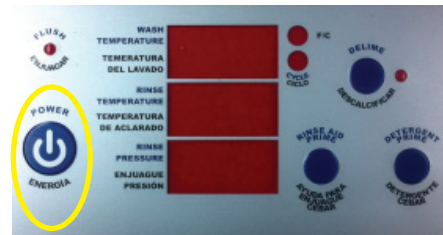
18. Power off the machine at the disconnect.

19. Remove the memory cartridge and gently insert the gray display cable.



20. Power on at the disconnect.

21. Press the “POWER” button on the machine and run through fill and cycle tests to verify the machine functions properly.



NOTE: this program change increases the drain time to 30 seconds and decreases the cycle start delay to 200 milliseconds.