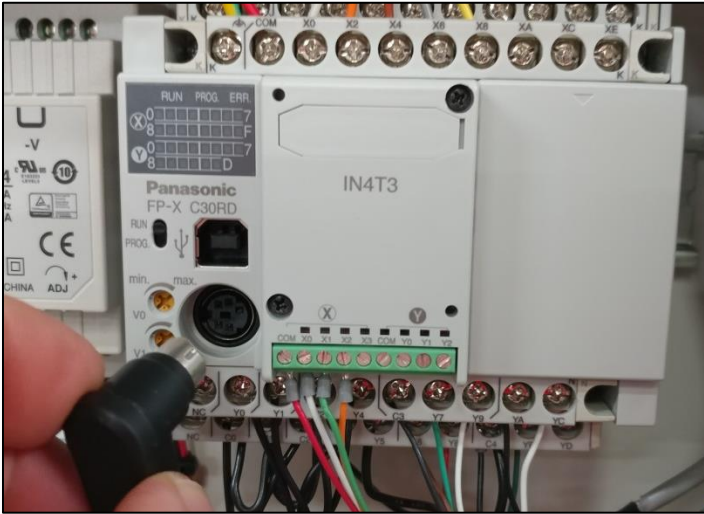


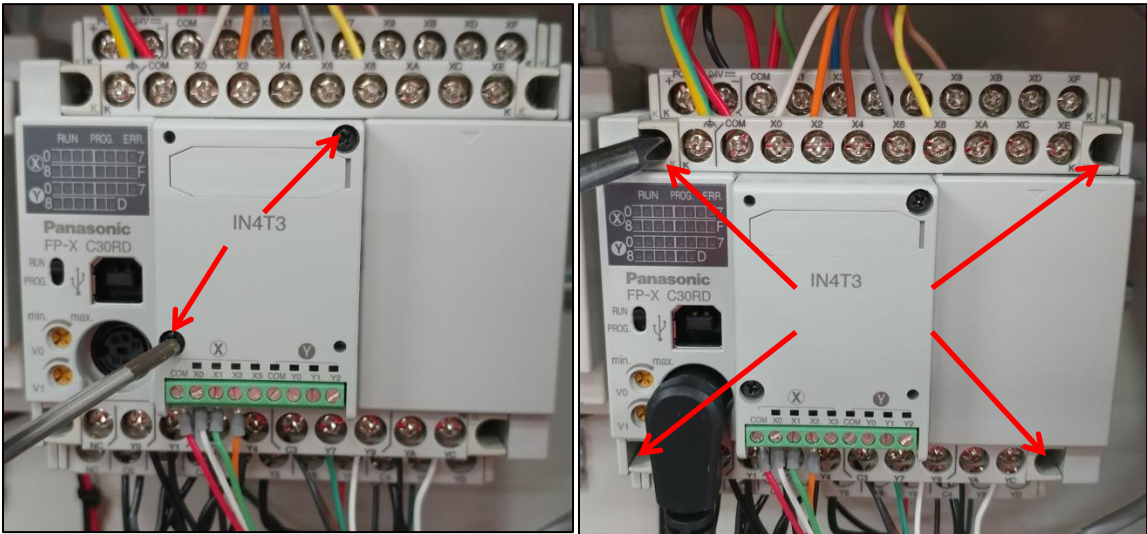
1335 PLC CONTROLLED RUFFLER

HOW TO CHANGE PLC IN 1335MGCA-SU OR 1335ETA:

- 1) **VERY IMPORTANT**: Record any machine settings on the settings pages (3 pages total)
- 2) Remove power from the machine
 - a) Turn off power to machine
 - b) Disconnect power plug at power source
- 3) Remove right angle connector for the touchscreen communications (see picture below)

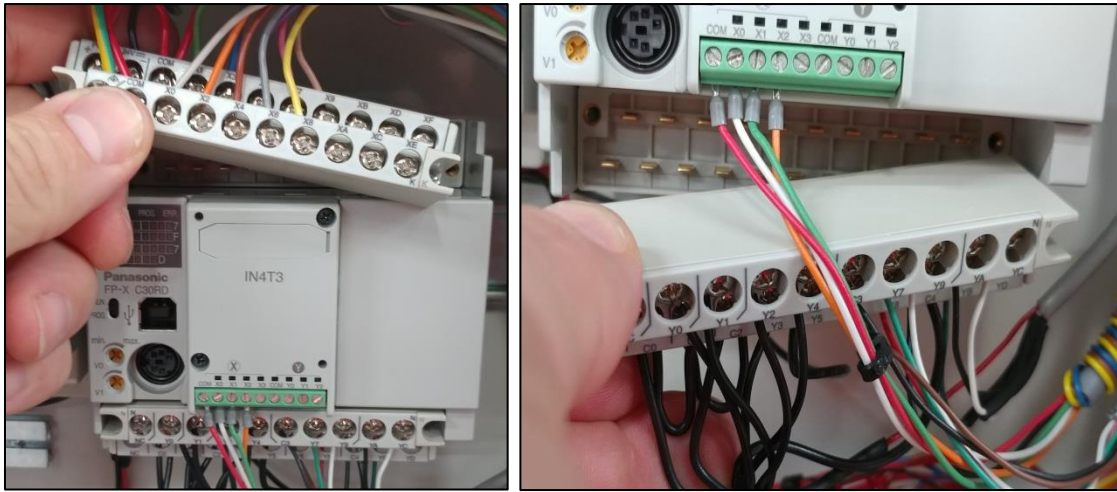


- 4) Remove the two screws with small Philips screw driver in the I/O cassette. (see left side picture below) **PLEASE TAKE CARE NOT TO LOOSE THE SMALL SCREWS**

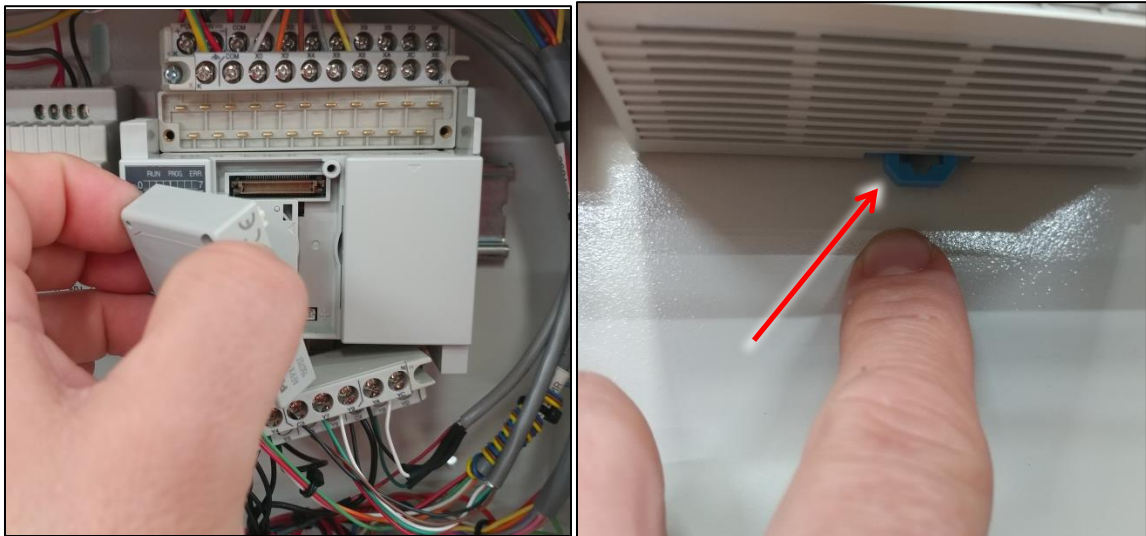


- 5) Loosen the two captive screws in the top terminal block on the PLC and then repeat for the bottom terminal block on the PLC. Note these are captive screws. (see right side picture above)

- 6) Carefully remove the top terminal block from the PLC base and then remove the bottom terminal block from the PLC base. (see pictures below)



- 7) Carefully remove cassette from PLC base (see left side picture below)



- 8) Pull down on the blue clip on the bottom side of the PLC base until it clicks. Raise up on the bottom side of the PLC base and pull outward away from the din rail.
- 9) Install the new PLC on the din rail and repeat steps 8 thru 1 in reverse order to reinstall the cassette and I/O terminals onto the PLC. Replace the right angle HMI communications cable into the round port below the USB socket. Make sure the RUN – PROG switch is in the RUN position.
- 10) Turn on the main power to the machine and go to the settings page to make sure the settings data has not changed. If the values are different, re-enter the values that were recorded before changing the PLC.