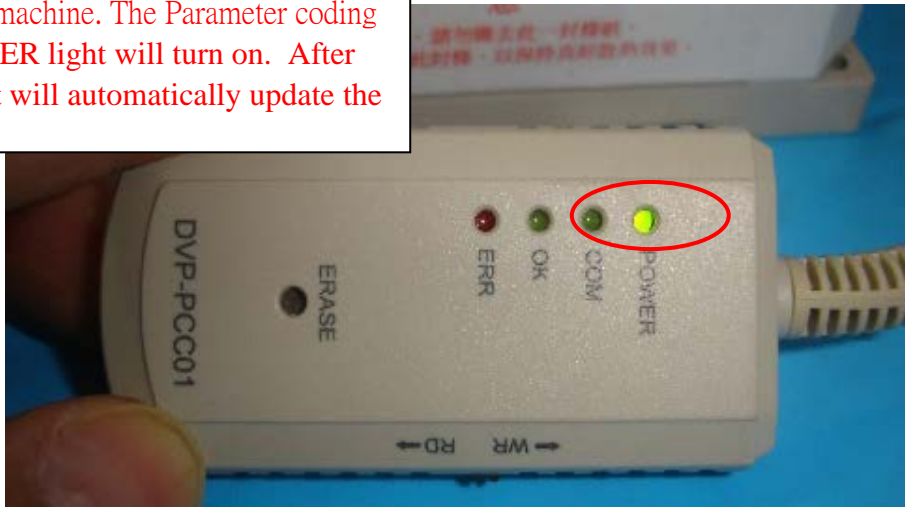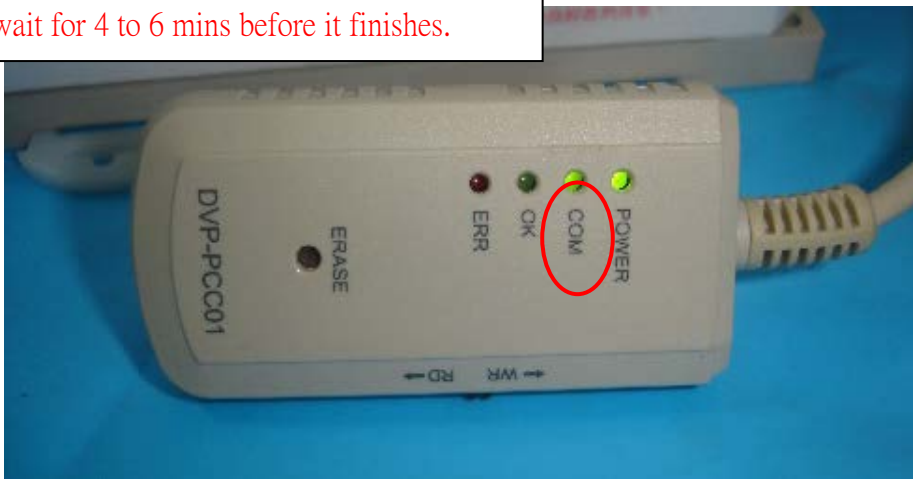| 故障原因	PLC paramenter replacement procedure

1. Please check and make sure the parameter coding switch's light is on, steps as follow:
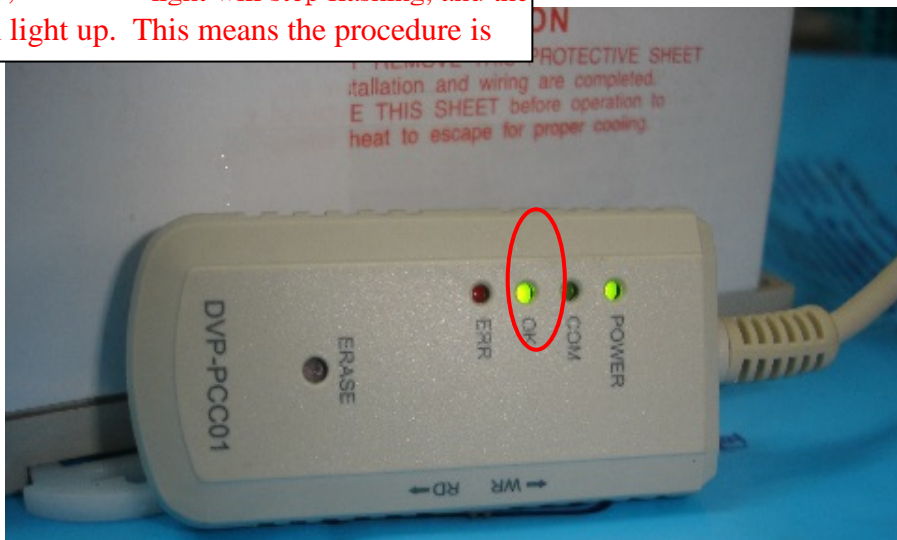
Power on the machine. The Parameter coding switch's **POWER** light will turn on. After about 5 sec, it will automatically update the PLC unit.
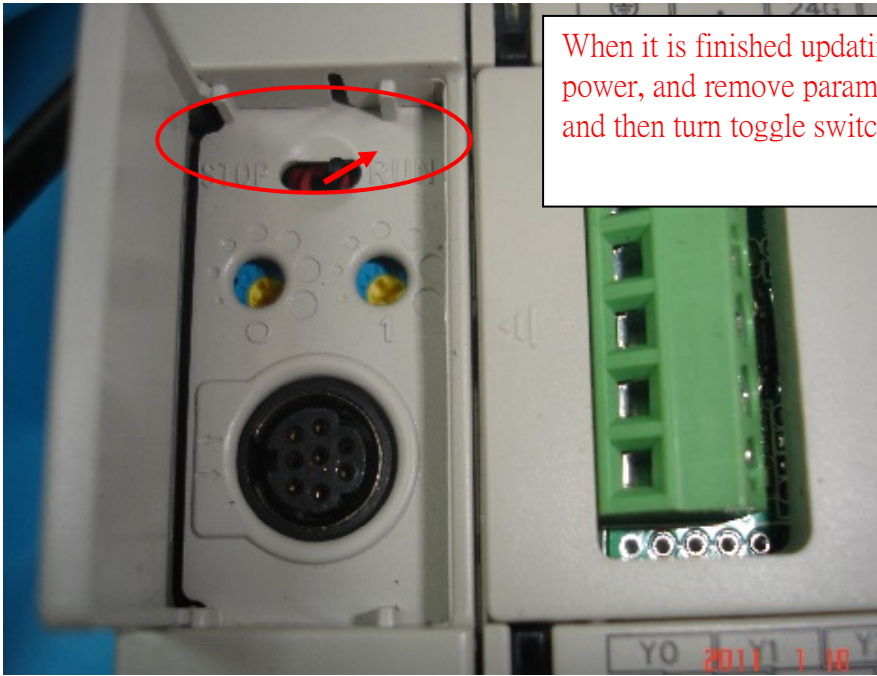

The "COM" light will flash to indicate the procedure is on-going. Please wait for 4 to 6 mins before it finishes.
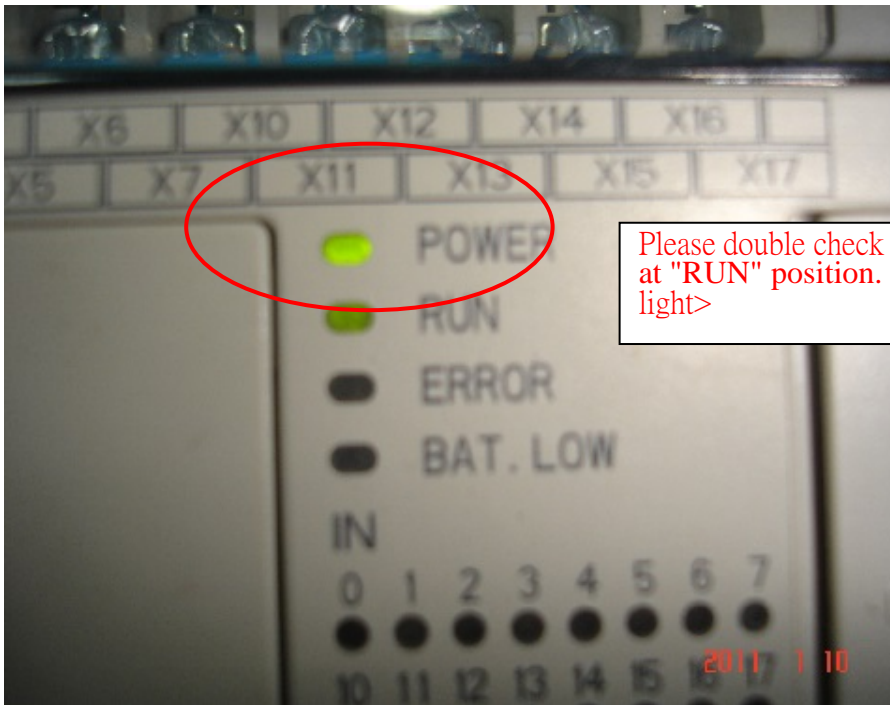

After the **update, the COM** light will stop flashing, and the "**OK**" light will light up. This means the procedure is

2. After updating, please check PLC's toggle is set at "RUN"!

When it is finished updating, please turn off the power, and remove parameter coding switch, and then turn toggle switch to "RUN" position.

Please double check PLC is at "RUN" position. <RUN light>