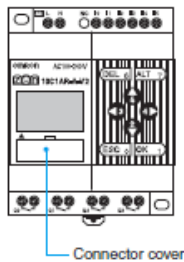


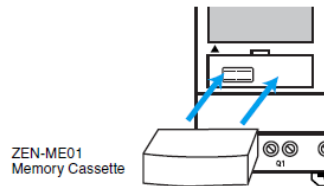
## TRANFERRING PROGRAMS USING MEMORY CASSETTE

Memory Cassettes are used to load new programs to ZEN CPU Units and to copy programs and settings from one CPU Unit to other CPU Units.

**Always turn OFF the power supply to the ZEN before removing or mounting Memory Cassettes**

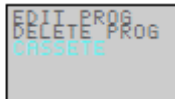


Remove the connector cover on the front of the ZEN

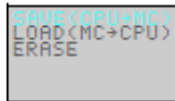


Mount the Memory Cassette

Turn power supply ON. Change the operation mode to STOP, see below



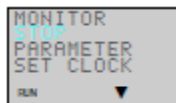
Select **CASSETTE**



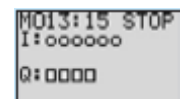
Use the **UP/DOWN** Buttons to move the flashing cursor and press the **OK** Button to select an operation

Use the **LOAD** operation when uploading a new program from a Memory Cassette (MC) to the ZEN CPU Unit. Remove Memory Cassette when finished loading the program, remember to turn OFF the power supply. Operation mode may have to be changed to RUN, see Section 1.

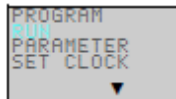
### Changing operation mode RUN/STOP



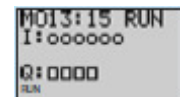
Press the **OK** Button to display the Menu Screen and press the **Down** Button to move the flashing cursor to **STOP**



Stop mode



Press the **OK** Button to switch from **STOP** to **RUN** mode



Run mode



Press the **ESC** Button to return to the **BB** Menu or Main Screen to observe input/output bit status.