




SD CARD RE-ETCHING INSTRUCTIONS

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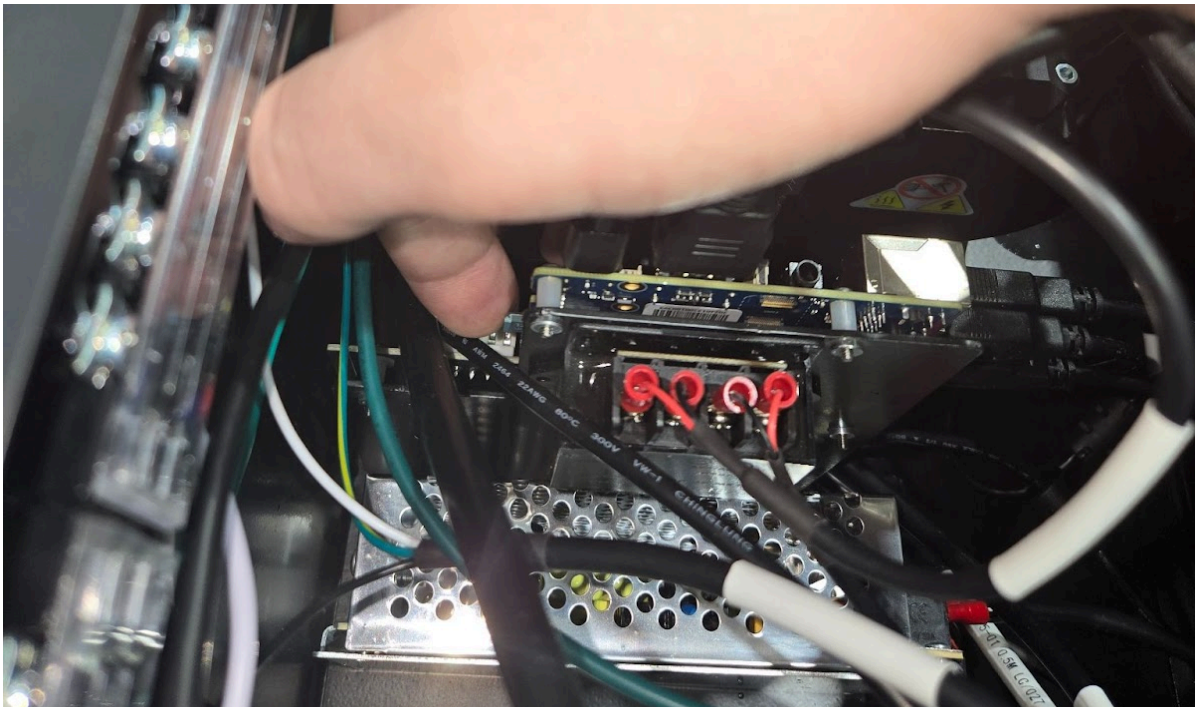
Preparatory Steps to Save Information on the SD Card:

There are two things you may want to save from your machine before re-etching the SD card. Any bends/programs you have made, and the ram-to-table opening distance.

1. To save your Ram-to-Table Opening Distance calibration
 - a. Go to the Settings tab and write down the current calibrated value so you can type it into the machine after you re-etch the SD card.
 - b. Alternatively, you can just measure your own calibrated value and input it after re-etching the SD card. Bring the ram down to "Y =-3.000" using the MOVE TO (Safety Button Operated) command in the Manual Mode tab. Measure the opening distance with a caliper and add your machine position (+3.000") to get your total ram to table opening distance. This value can be fixed in the settings tab.
2. To Save your Custom Bends and Programs
 - a. Enter the Backup & Restore menu  by pressing the icon in the top right section of the header.
 - b. In the text box labeled "Enter custom name for a backup" enter some name for your backup file. Press the  button to create the backup file.
 - c. The new file should appear in the list. Select the  icon next to the new backup file.
 - d. A file explorer will open allowing you to choose your USB drive on the left side. Select the drive and choose "Open".
 - e. Once completed pull the USB from the unit and place it into a PC.
 - f. There should be a new zip file with a title representing the date and time along with the backup filename.

Removing Micro SD Card from Titan:

1. Power your unit down and pull the power cable from the back of your unit.
2. Open the top of your machine.
3. Pull the micro SD card out of the unit. The card must first be pushed inwards to unlock the card, then it may be removed. The card must be unlocked out of place. You will feel/hear a discernible click when the card is unlocked. This should take minimal force. It may be useful to use pliers to reach the micro SD card.

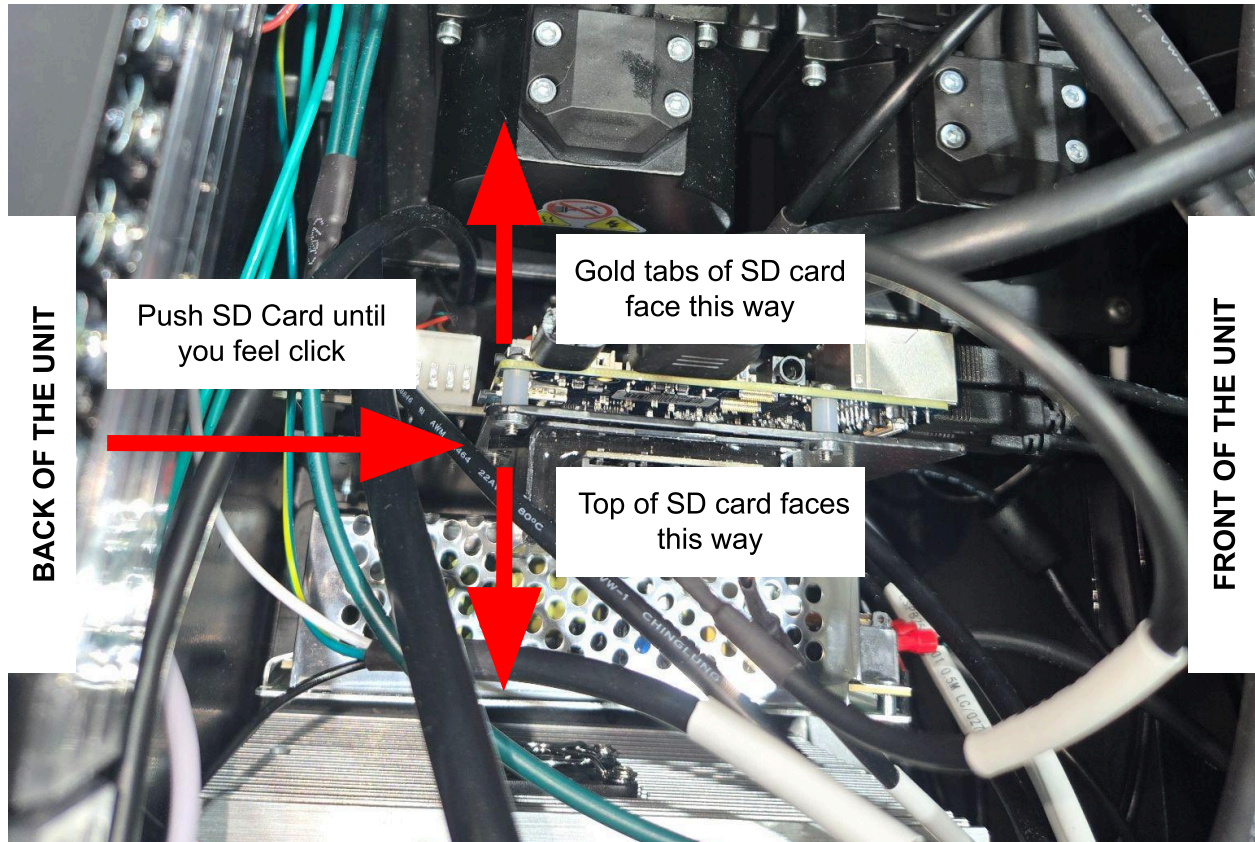


Etching Micro SD Card:

1. Download the [BendControl .img File](https://www.langmuirsystems.com/downloads) from:
<https://www.langmuirsystems.com/downloads>
2. Download BalenaEtcher from <https://etcher.balena.io/>.
 - a. Select “Download Etcher”. Select the correct version for your PC and click the “Download” button.
 - b. Once downloaded, run the installation.
3. Insert a micro SD card into the PC.
4. Once installed, open BalenaEtcher.
5. Select the image file and micro SD card that you wish to etch.
6. Select the “Flash!” button.
7. Once completed remove the micro SD card from the PC.

Installing Micro SD Card:

1. Power your unit down and pull the power cable from the back of your unit.
2. Open the top of your machine.



3. Install the updated micro SD card. If you are facing the back of the unit, the golden tabs of the micro SD card must face towards your left. The card must be locked into place. You will feel/hear a discernible click when the card is locked in.
4. Plug in the power cable and power the unit on.
5. The machine should boot straight into Bend Control.