How To
Service Documents from APPI

Document: #HT000186

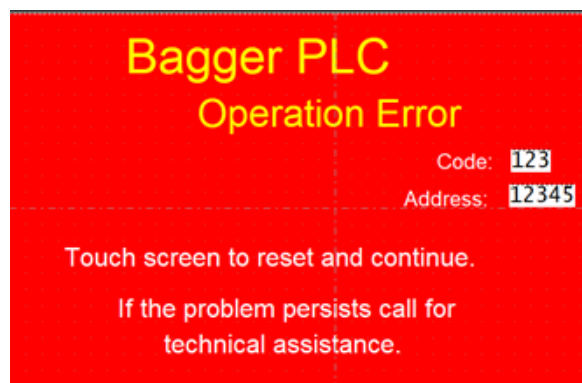**Document Title: How To Determine if Program in PLC is Corrupt**

Product(s): All Baggers

Procedure:

After replacing the PLC battery, the Red Error Light on the PLC should go out. If the Red Error Light stays ON the program is corrupt.

If the Red Error Light is OFF and the PLC is in RUN mode. The follow issues indicate that the program is corrupt
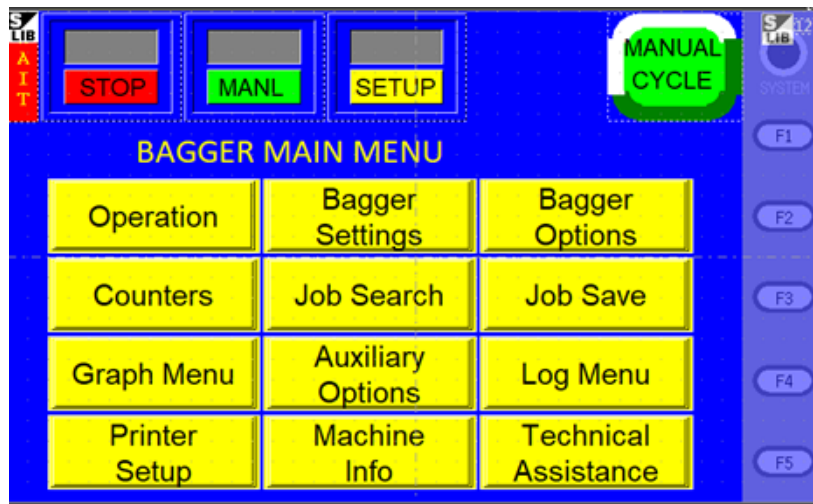
Turn Bagger OFF for 5 seconds. Then turn the Bagger ON. If the Bagger PLC Operation Error returns. The PLC program is corrupt.

If the Bagger PLC Operation Error Screen does not return. Go to Main Menu/ Technical Assistance. A screen with a Keypad will be Display asking for Level One passcode. Enter Code 1001 and press enter.

If a screen is displayed stating that the code is incorrect, then the program in the PLC is corrupt.

If the Passcode is accepted the following screen will be Displayed.

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Press the Yellow button PLC IO
Status.

The following screen will be
Displayed.

In the Hours and Cycles displays, number should be displayed. If dashes are
in either one of the display windows, the PLC program is corrupt.

Go to Main Menu/ Technical Assistance. A screen with a Keypad will be
Display asking for Level One passcode. Enter Code 1001 and press enter.

Press the Yellow button APPI Factory. A screen with a Keypad will be Display
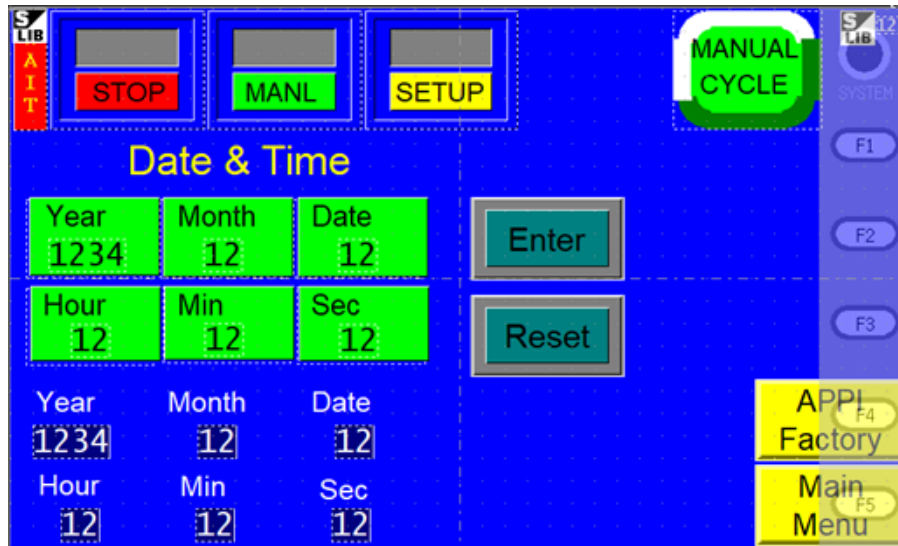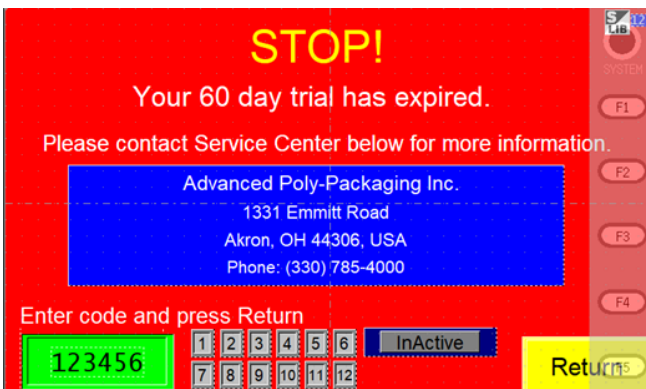asking for a passcode. Enter Code 9001 and press enter.

Press the Yellow Button labeled Date & Time.

If there are dashes in any of the display windows or the information is garbled, the PLC program is corrupt.

If any of the following Trial Period Screens are displayed the PLC program is corrupt.

Please remove the Bagger PLC and Printer PLC if the bagger has a Zebra Printer and ship to:

Advanced Poly-Packaging, Inc.
220 Ascot Parkway
Cuyahoga Falls, OH 44223

ATTN: Service and Technical Support

Additional Help Documents that can be found on our web page.

https://ecom.advancedpoly.com/documents

HOW TO (T-1000) Remove and Replace PLC: Help Doc 51
HOW TO (T-1000): Replace PLC Battery: Help Doc 17