

How To

Service Documents from APPI

Document: #HT000030

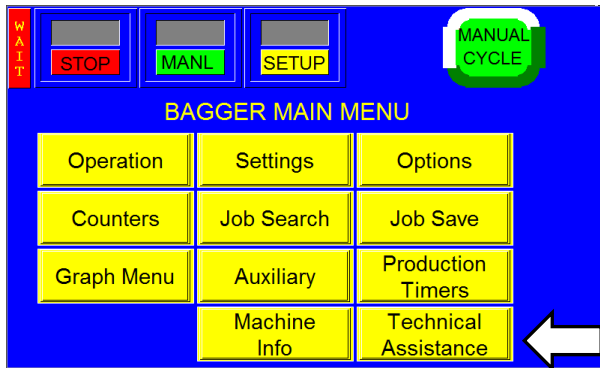
Document Title: Adjust Anti-Jam

Product(s): T-300/375

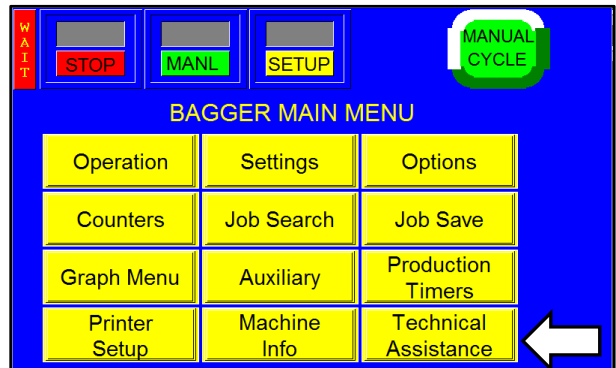
Procedure:

Turn Air **Off** and Main Power **ON**.

Press **“Technical Assistance”** from the **Main Menu** (the Main Menu is different for T-300 & T-375. Both versions shown below)



Main Menu T-300



Main Menu T-375



Enter Pass Code **“1001”**, and press **ENT**. Press **“PLC Info”**. This will bring up the PLC I/O Screen.

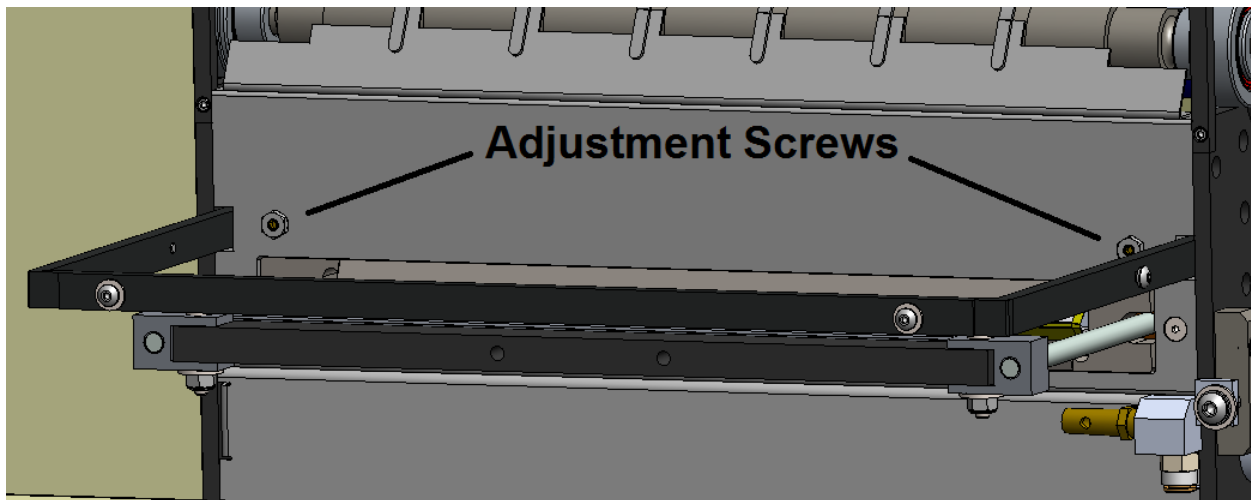


How To

Service Documents from APPI



PLC I/O Screen



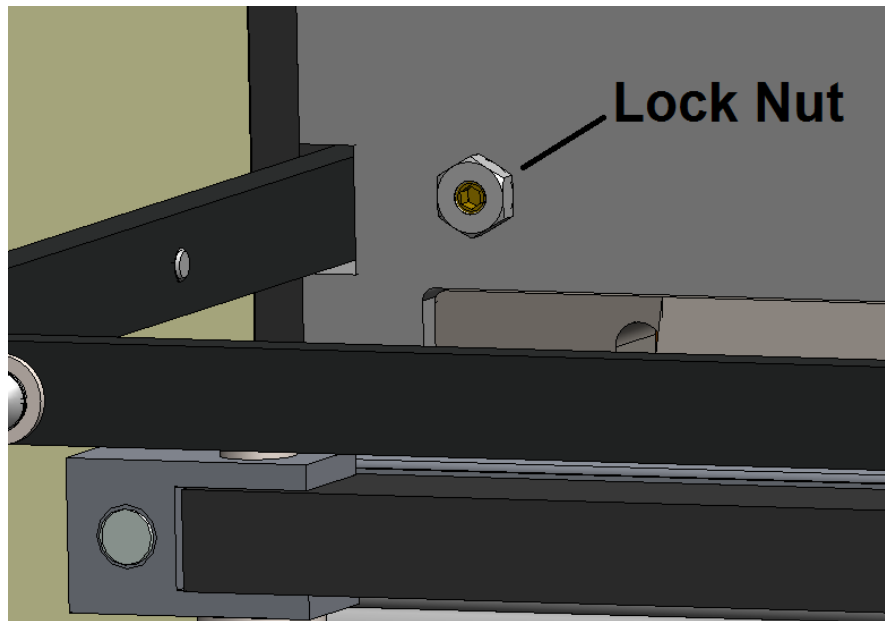
Locate the two adjustment screws on the Face Plate.

Note: Adjustment Screws can be located below the Gripper Plate if the unit is a Standard Frame model.



How To

Service Documents from APPI



(Left Side shown above)

Loosen the Lock Nut.



Using an Allen Wrench, adjust the Plunger until input **X6** or **X7** just turns on.



How To

Service Documents from APPI



(GREEN indicates ON)

Repeat on left side, both **X6** and **X7** should be on (GREEN).

Gently tighten Lock Nuts. **Do Not Over-Tighten**; it may break the Plunger Screw.

(Plunger Screw, TP-108220)

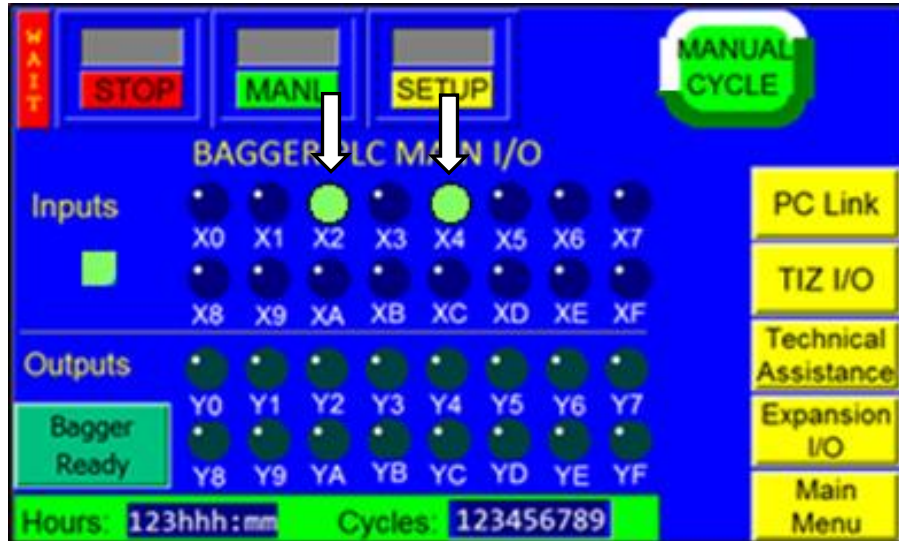


Have someone push the Pressure Bar all the way in.

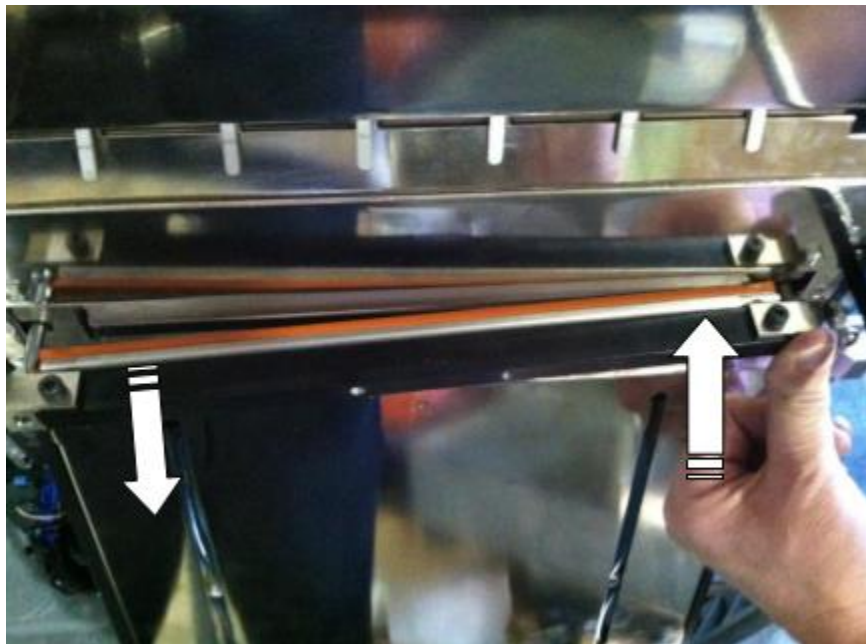


How To

Service Documents from APPI



While pushing the Pressure Bar in completely, **X2** and **X4** should be **ON (GREEN)**. If not, go to the next step.



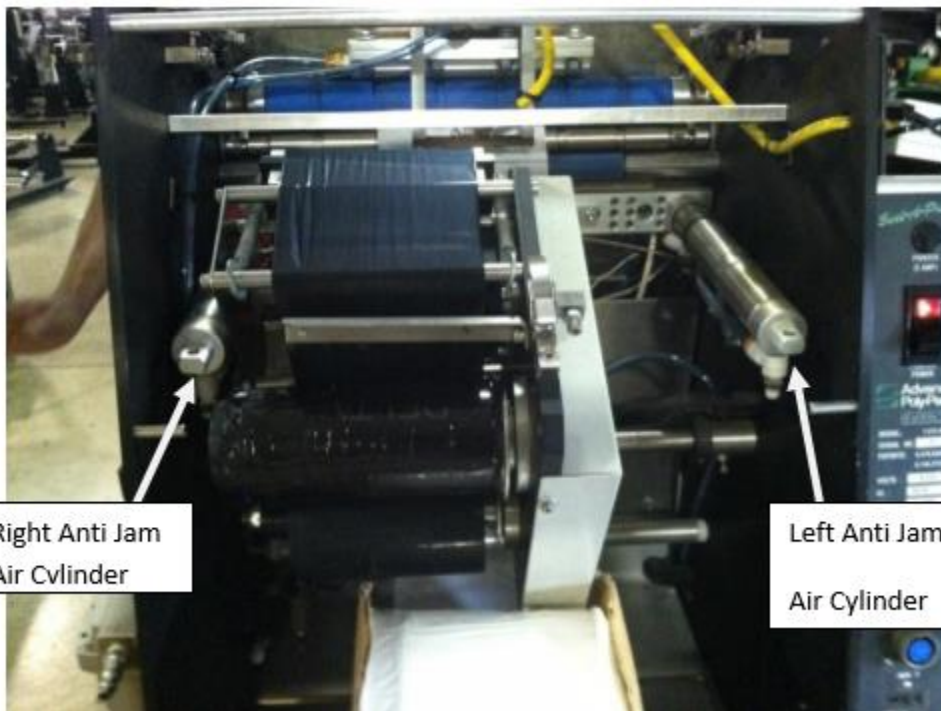
Push one side of the Pressure Bar all the way in. Note whether **X2** or **X4** turns on.



How To

Service Documents from APPI

In this case, **X4** turns on (below), so **X4** is the Right Side.

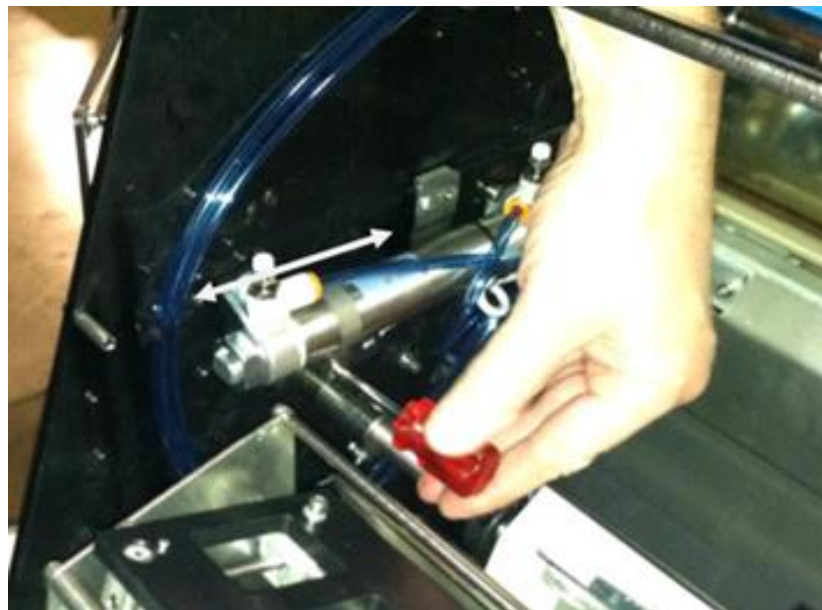
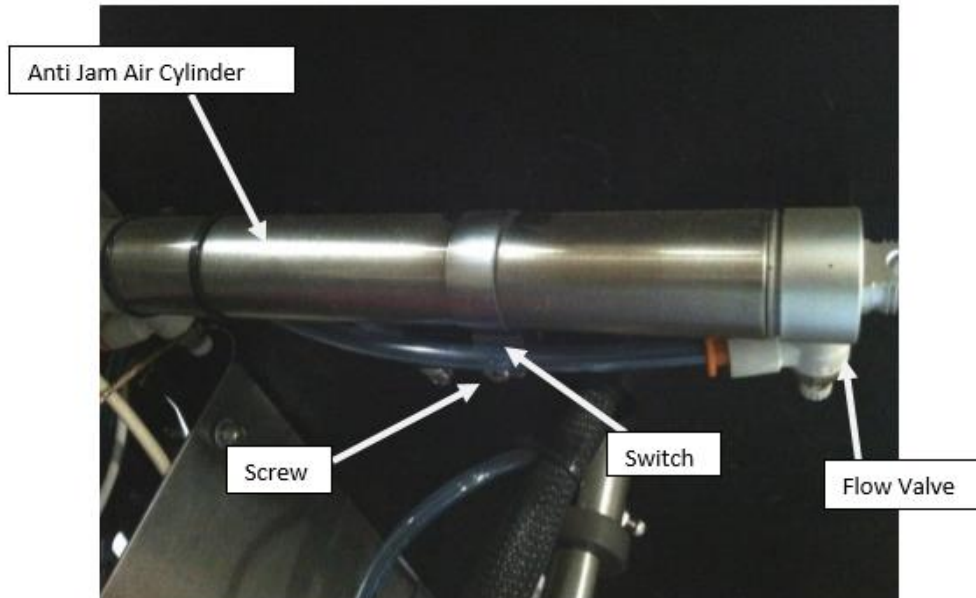




How To

Service Documents from APPI

Anti-Jam Air Cylinders (above)



While the Pressure Bar is pushed in all the way, loosen the Phillips Head Screw, and move the Switch until **X2** or **X4** lights.

Repeat procedure on the other cylinder.



How To

Service Documents from APPI

With Both sides of the Pressure Bar pushed in all the way, **X2** and **X4** should be on.

