

How To

Service Documents from APPI

Document: #HT000125

Document Title: Sequence of events with AUX interface and NBO printing

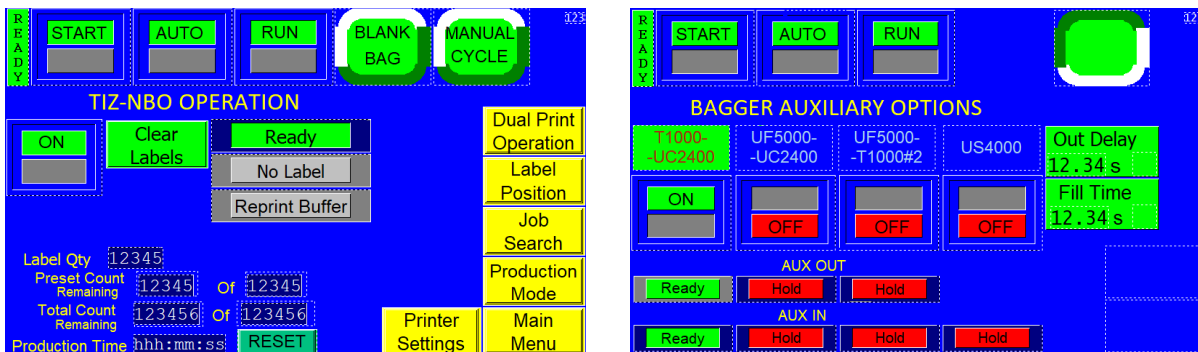
Product(s): T-1000

Procedure:

This document is for a T-1000NBO connected to a Feeder mechanism that sends a label to the T-1000 for every bag that is to be printed.

An NBO printer is used when every bag has to have the current weight or sample number and any other corresponding information printed on it.

This document assumes that any startup procedure has been performed, and that both Bagger and Feeder are ready to run. The Bagger must be in START AUTO RUN, and have T-1000-UC2400 option selected.



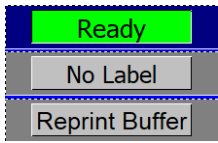
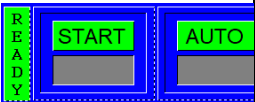
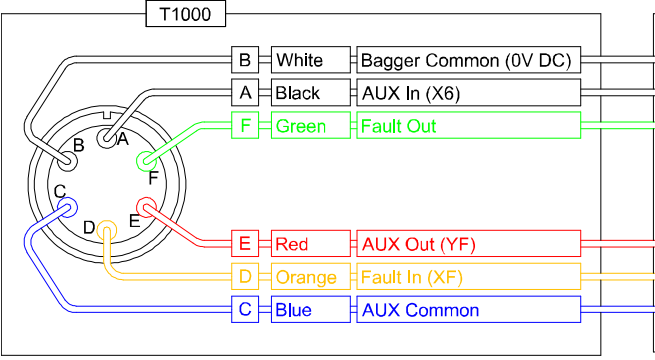
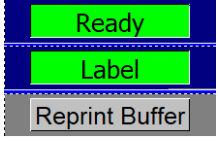
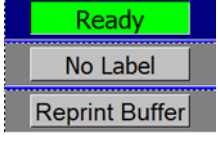
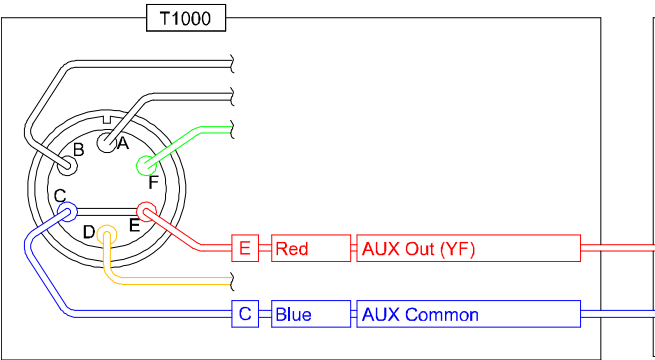
When the Bagger is ready it will continuously be in AUX Out Ready mode.

The customer's equipment will only temporarily activate AUX In Ready to trigger Bagger cycle.



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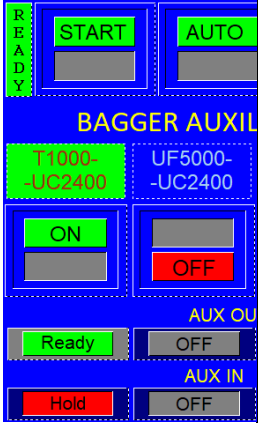
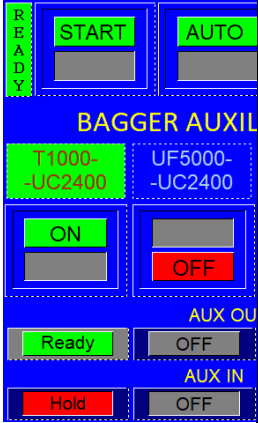
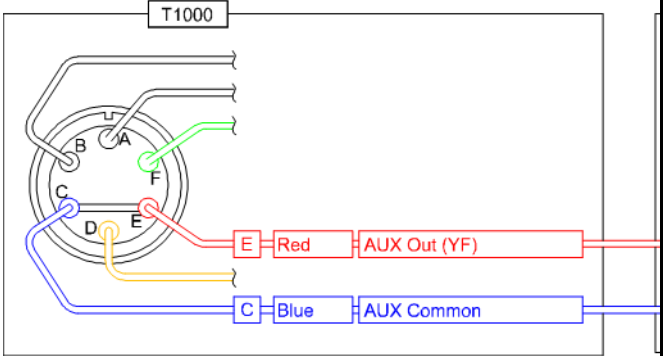
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Step	Bagger	Feeder	AUX
1	<p>Bagger ready to receive label. No bag in place.</p> <p>Bagger not ready.</p>   <p>BAGGER AUXILIARY</p> <p>T1000-UC2400 UF5000-UC2400</p> <p>ON OFF</p> <p>AUX OUT</p> <p>Hold OFF</p> <p>AUX IN</p> <p>Hold OFF</p>	<p>The feeder can send a label.</p>	 <p>No connections closed.</p>
2	<p>The bagger prints the bag, and indexes it into position.</p>  <p>The bag is printed, in place and open.</p> 	<p>The feeder has sent a label to the bagger.</p> <p>The feeder waits for Ready signal.</p>	 <p>YF is activated on the bagger PLC and closes pin C and E.</p>



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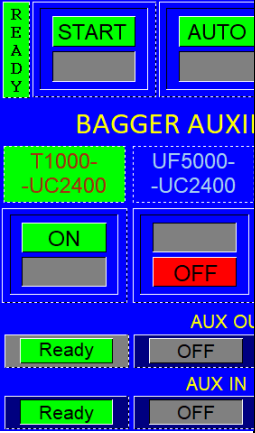
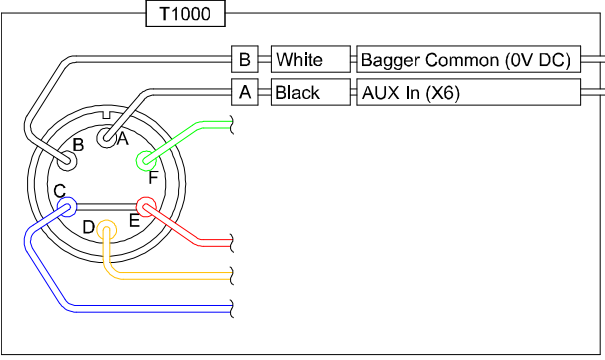

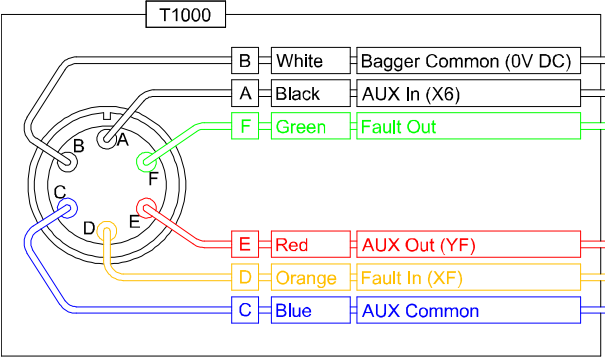
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	<p>The label is cleared.</p> <p>Bagger ready.</p> 		
3	<p>Bagger ready.</p> 	<p>The feeder fills the bag.</p>	 <p>Bagger ready, feeder not ready. YF is active on the bagger PLC.</p>



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<p>4</p>	<p>Bagger ready.</p> 	<p>The feeder temporarily closes AUX In, pin A and B.</p>	 <p>Input X6 on the bagger PLC is activated. YF is active on the bagger PLC.</p>
<p>5</p>	<p>The bagger opens pin C and E while cycling.</p> <p>The bagger cycles.</p> 	<p>The feeder pauses.</p>	 <p>Output YF on the bagger PLC not active while cycling. Pin C and E is open.</p>
<p>6</p>	<p>Repeat from step 1</p>		

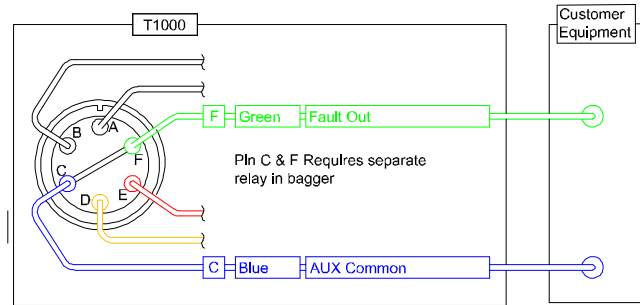


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AUX Fault Signals

AUX Fault Out from the bagger uses fault relays in the bagger. Auxiliary fault is signaled by any error message in the bagger that causes it to go into STOP mode.



AUX Fault In from customer equipment will cause the bagger to stop and display this error screen:

