Document: #HT000051

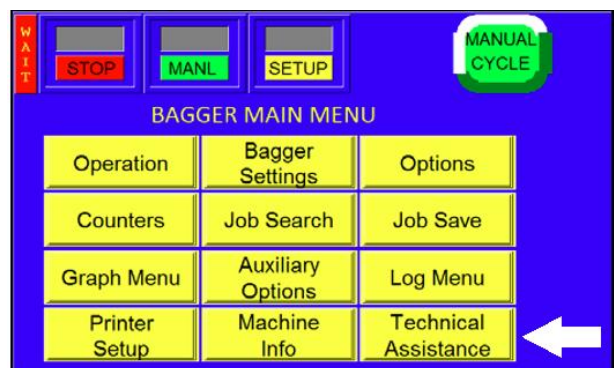**Document Title: Remove and Replace PLC**

Product(s): T-1000

Procedure:

Before removing PLC, you will need to record the TS and PLC versions.

Press **Main Menu**

Select **"Technical Assistance"**

Enter Pass Code "**1001**" & Press **Enter**

Write down TS and PLC Versions

Note: This information will be required on the PLC Return form.

Turn power OFF with Lock-Out Switch. If there is no Lock-Out Switch, unplug the Bagger.
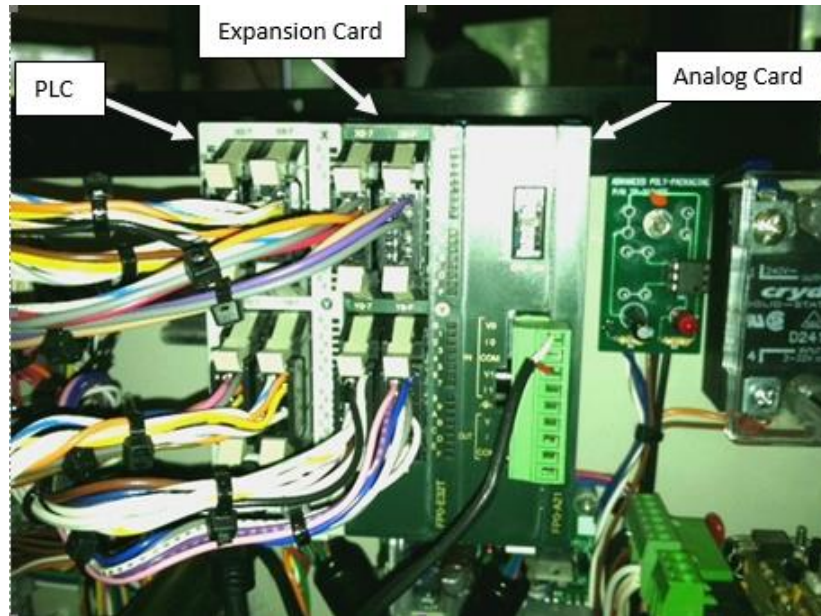

Remove the Button Head Screw.

Pull top of Cover out first, then bottom.

Locate the PLC, Expansion Card, and the Analog Card. Note the positions of these components; they must be re-assembled in the same positions.
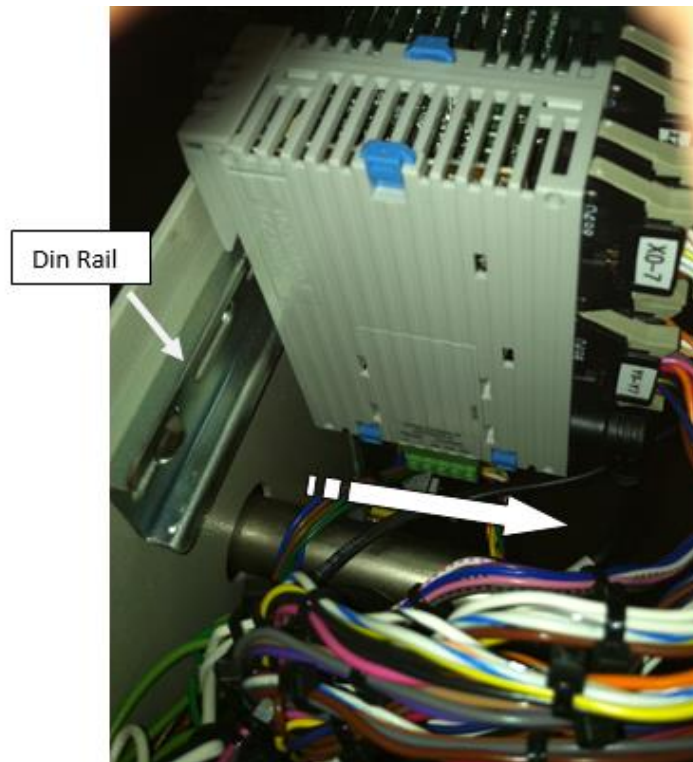

On the bottom of the PLC there are 3 Blue Tabs. With a small screw driver, gently pull them down. This will un-lock the PLC, Expansion Card, and Analog Card from Din Rail.
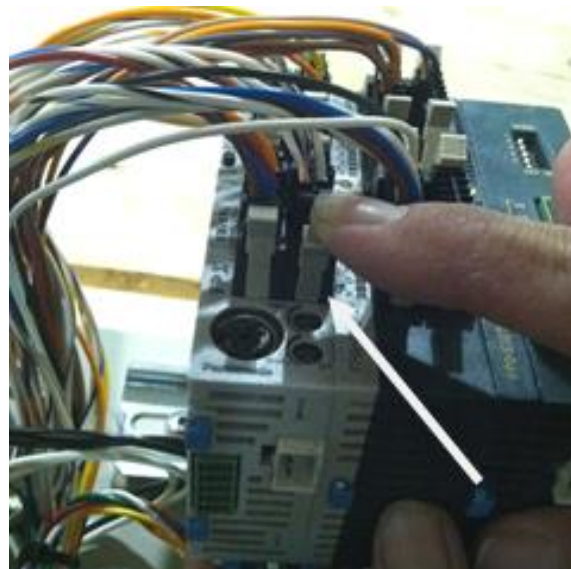
Din Rail
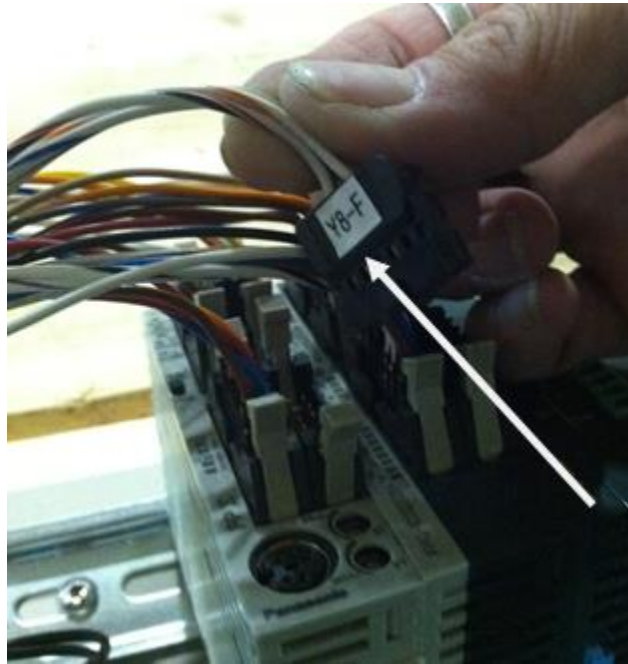
Gently pull bottom out first. Then lift off the Din Rail.

Pull back the Tabs that hold the Connectors in.

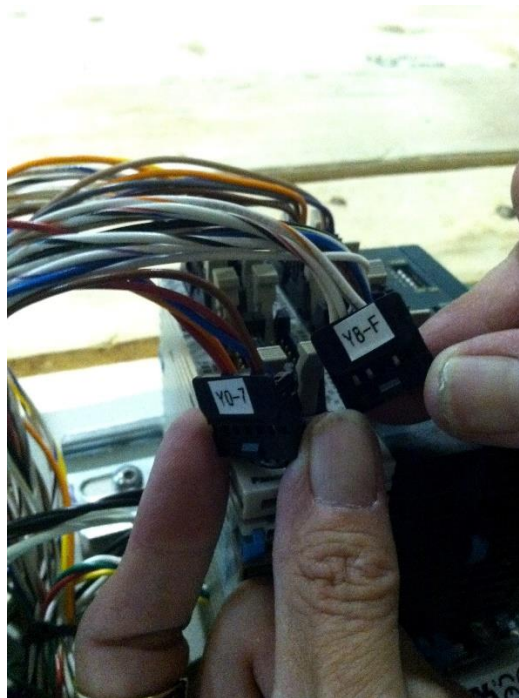Notice this connector is labeled **Y8-F**. If your connectors are not labeled, mark each one as you take them out. This will help you when you put PLC back in.
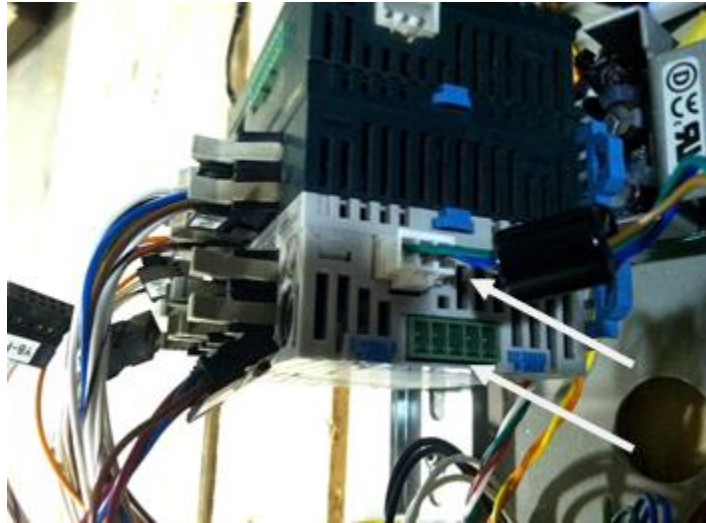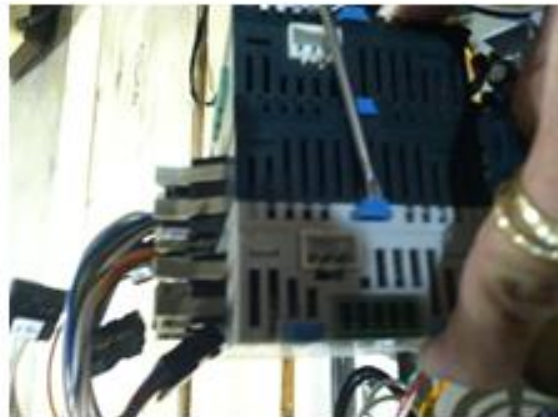

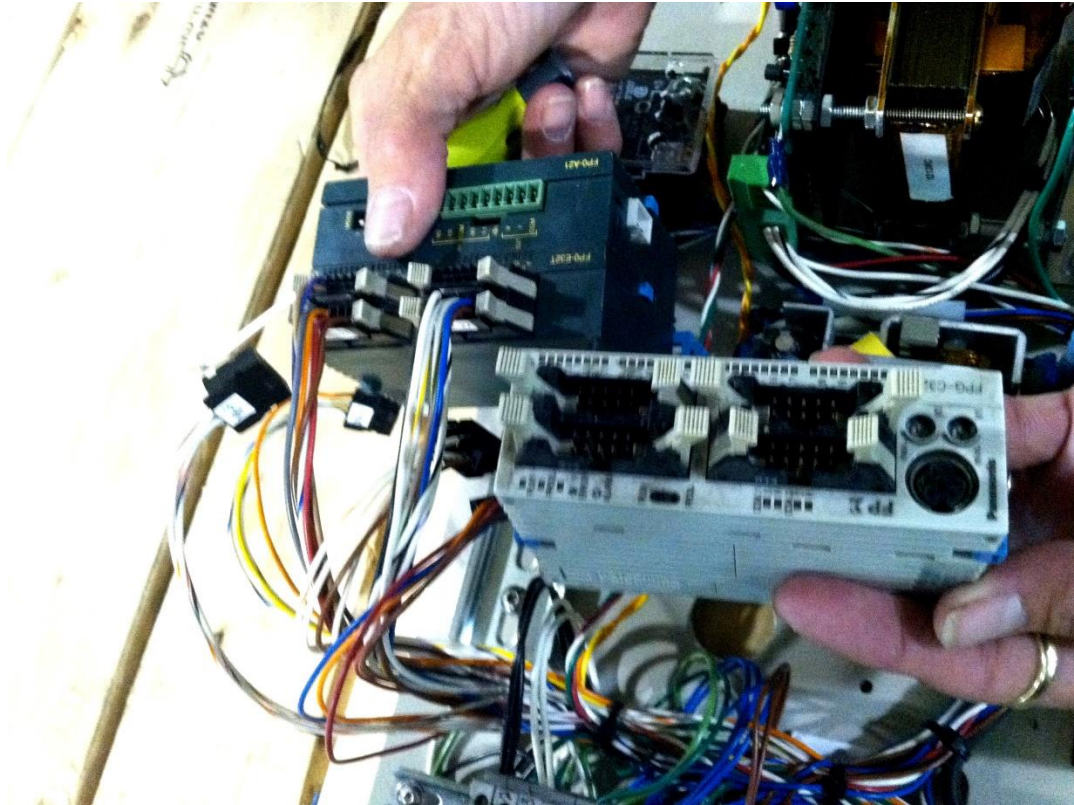Remove the other three Connectors.

Unplug the two bottom Connectors.

With a small screwdriver, gently pull the two Blue Tabs to unlock the PLC from the Expansion Card.

With all cables now disconnected, lift the PLC out of the Bagger.

X Inputs

X0-7 goes here

X8-F goes here

When reinstalling PLC make sure this switch is in run mode

Y Outputs

Y0-7 goes here

Y8-F goes here
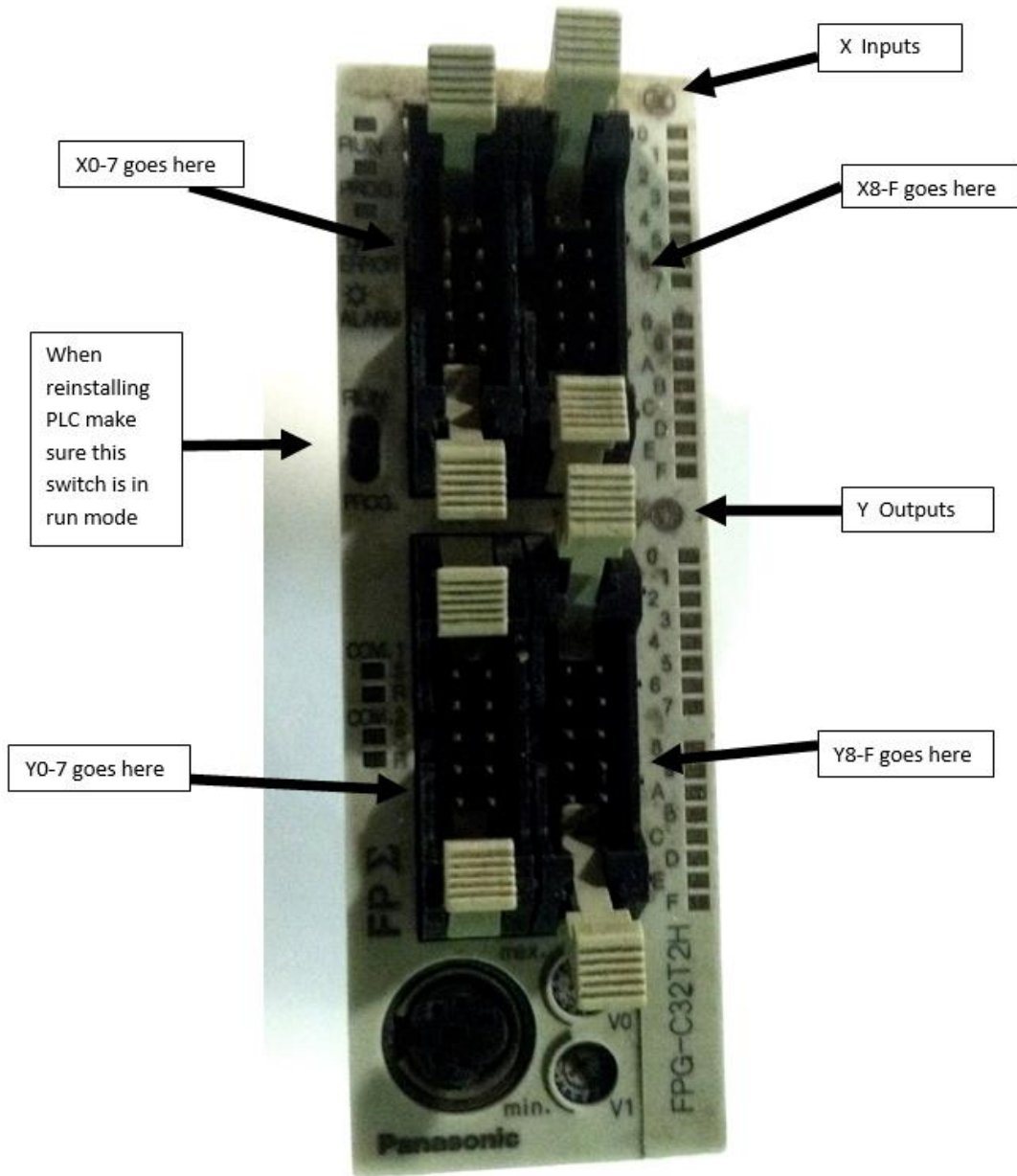
Save this for when you reinstall your PLC. *Note: make sure PLC is in RUN mode.*

PLC Return Form

In order to ensure quick and accurate repair of your PLC, please provide the following information:

Company Name:		
Address:		
Contact Name:	Distributor (If Applicable):	
City:	State:	Zip:
Phone: ( )	Email:	
PO Number:	Preferred Shipping Method:	
Machine Model:	S/N:	
TS Version:	PLC Version:	

Reason for Return:	Comments:
☐ Repair ☐ Reprogram ☐ New Battery ☐ Other	

Please check all options currently on the Bagger:

☐ Accumulating Funnel	☐ Insert Funnel	☐ Counting Funnel
☐ Trim Seal	☐ UF-5000	☐ Load Shelf
☐ Part Diverter	☐ Flat Seal	☐ US-5000
☐ Printer	☐ Palm Buttons	☐ Twin Seal
☐ BO-20	☐ BO-30	☐ Light Curtain
☐ Compartment Seal	☐ E-Stop	☐ Barcode Reader
☐ Medical Validation	☐ Other	

When the form is completed, please send the PLC and form to:
Advanced Poly Packaging
220 Ascot Parkway – Shipping/Receiving
Akron, OH 44223
Attn: Gary Baker, Service Department

To Re-Install PLC on T-1000:

Turn Main Power **OFF.**
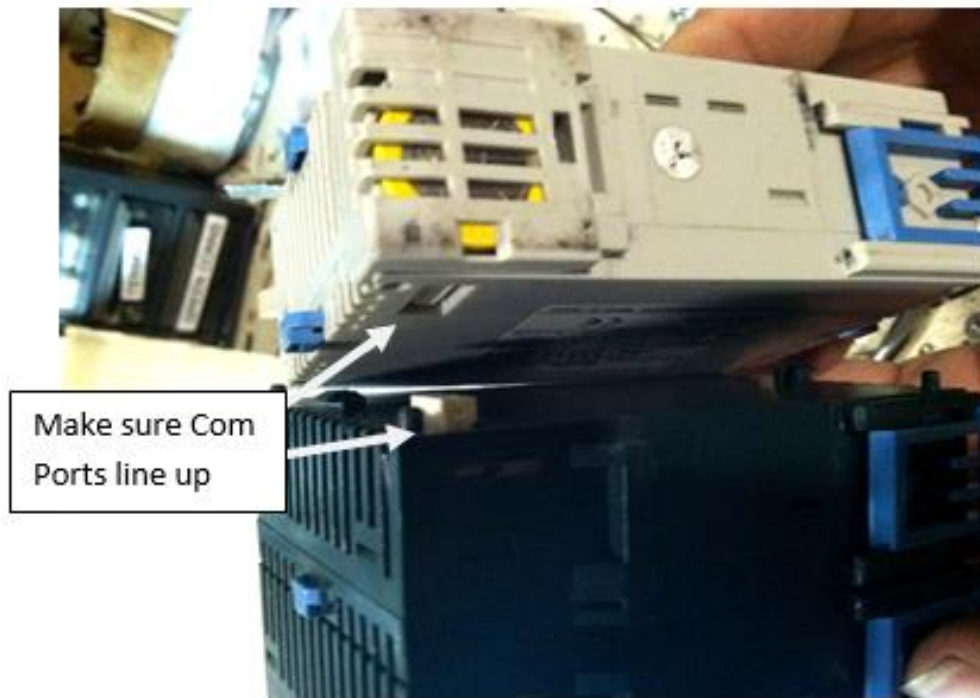

Gently pull Blue Lock Tabs out.

Make sure the Com Port is lined up and connect PLC to Expansion Card.

Push Blue Lock Tabs in to Lock PLC to Expansion Card.
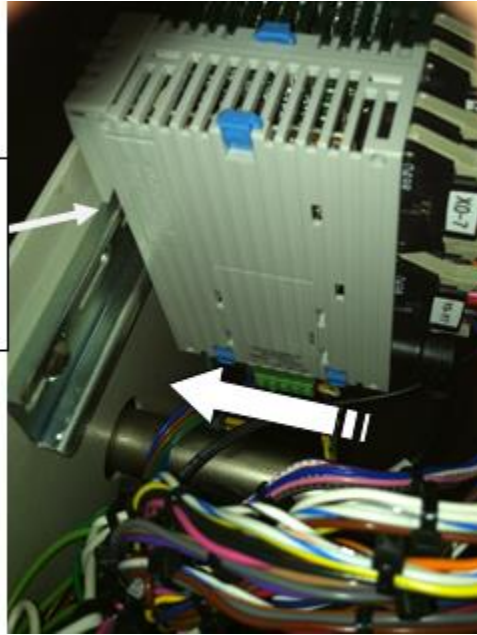
Plug in the Green and White Connectors.

Gently pull all three Blue Lock Tabs out.

Put the top of the PLC on Din Rail. Then push the bottom of PLC to touch Din Rail.

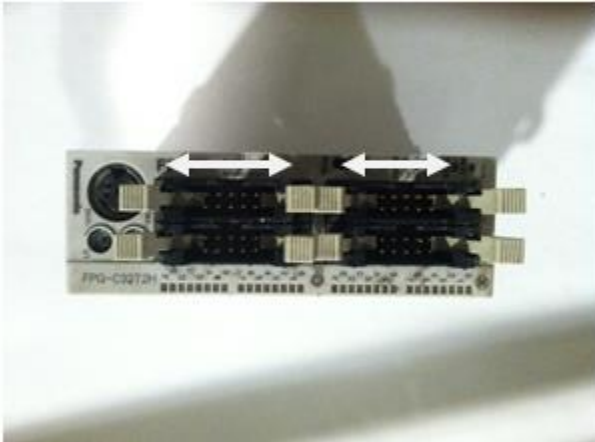Put the top of the PLC on Din Rail. Then, push the bottom of PLC to touch Din Rail.

Push up all three Blue Tabs to lock the PLC on to the Din Rail.

Carefully connect the X Input and Y output connectors to the PLC. Refer to the diagram on page 8 for help connecting.

Make sure connector Locks are Open.   Insert Connectors and Close Locks.

Make sure PLC is in RUN MODE.

When reinstalling PLC make sure this switch is in run mode