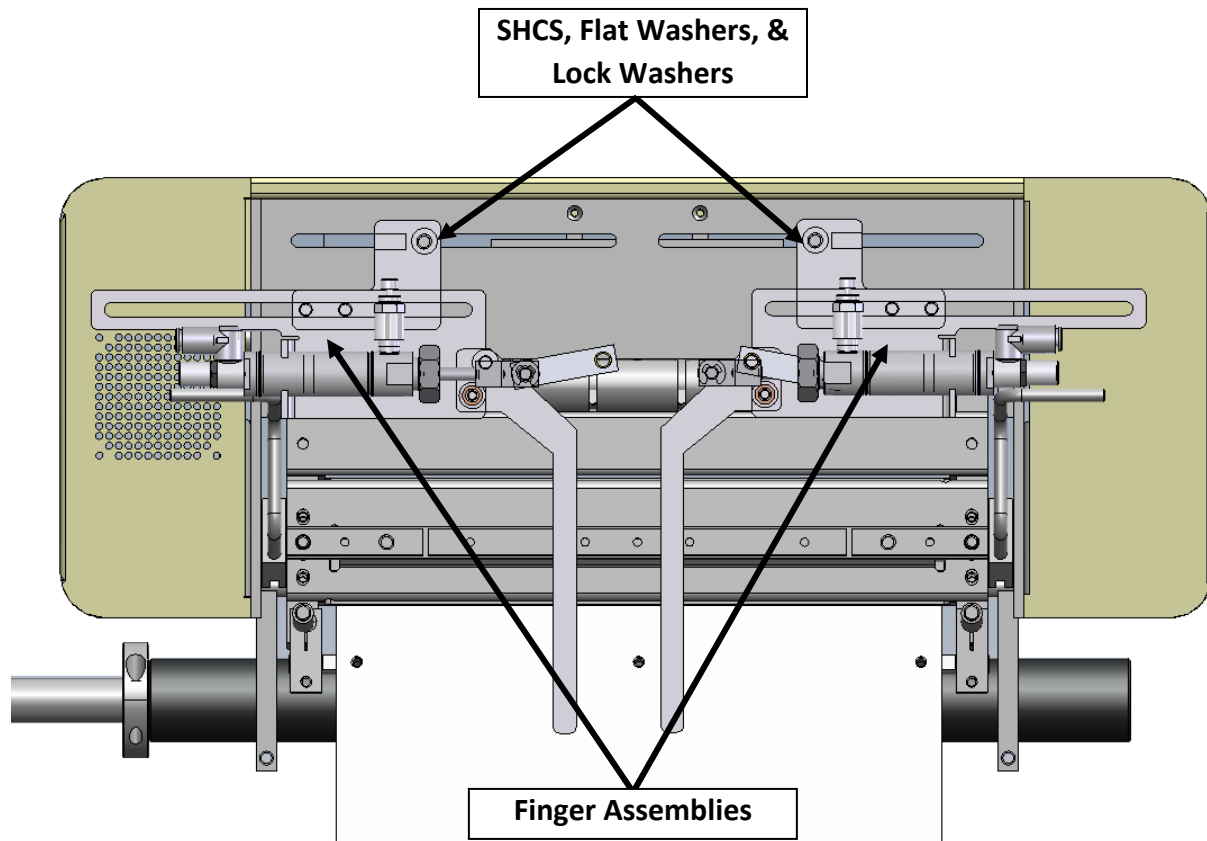**Document: #HT000145**

Document Title: Mounting the FS-10 Flat Seal Kit

Product(s): T-1000

Procedure:

Mount Fingers to Base Plate with the included ¼ x 20 x 5/8" SHCS with Flat Washer and Lock Washer.

SHCS, Flat Washers, & Lock Washers

Finger Assemblies

Using the provided hardware, mount Valve to an open station in the Manifold, #5-#10 (#1-#4 are a pre-assigned). Unscrew the existing blank valve from the existing manifold and screw the NEW valve with gasket to the existing Manifold.
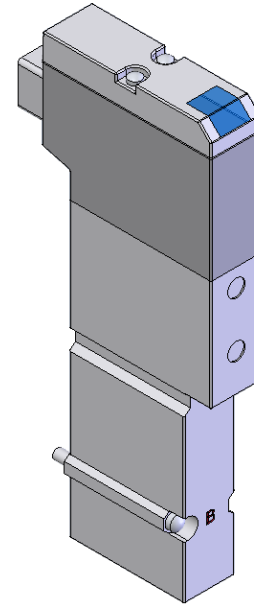
Valve

Mount the Mini-Regulator onto the Side Plate, using the included hardware.

Note: Tubing may need to be disconnected during the installation process. If this is the case, please refer to the included pneumatic diagram for the following instructions.
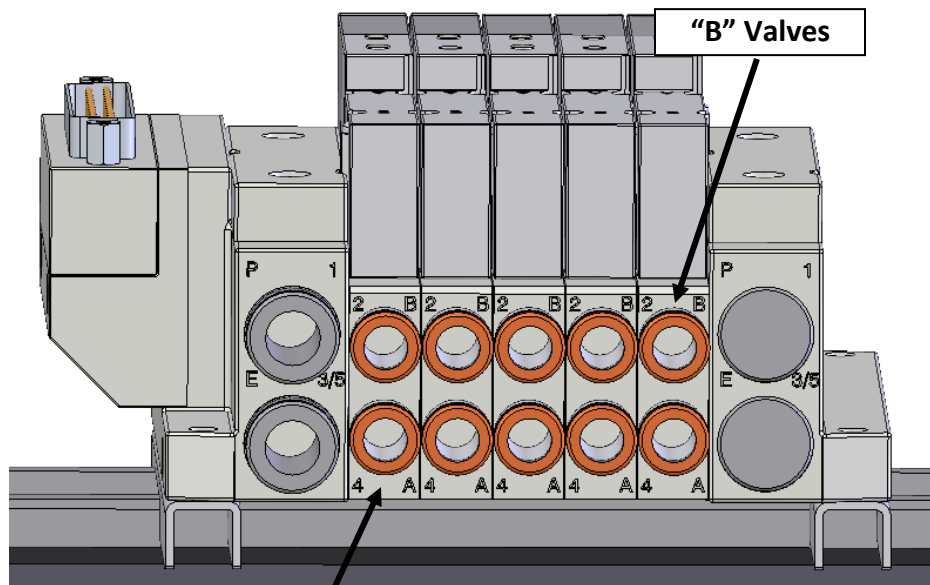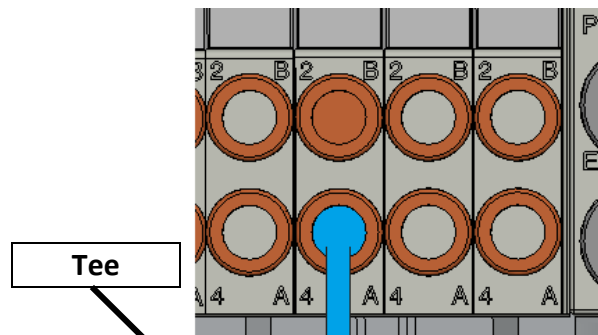

AIR PULSE   BLOWER

Mini-Regulator

0.5
0   1
SMC
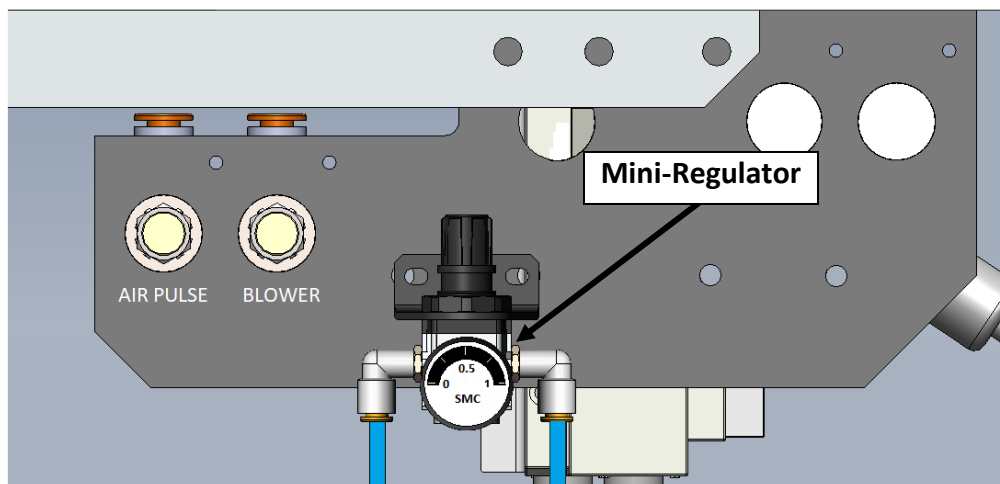
From the Mini-Regulator (TP-406247), attach the top tube to the "B" Valve (added station TP-402266). From the "A" Valve, run the tubing to the Air Tee. From this Air Tee, run each line of tubing to the top part of the cylinder, short tube goes to the left finger and the longer tube goes to the right finger.
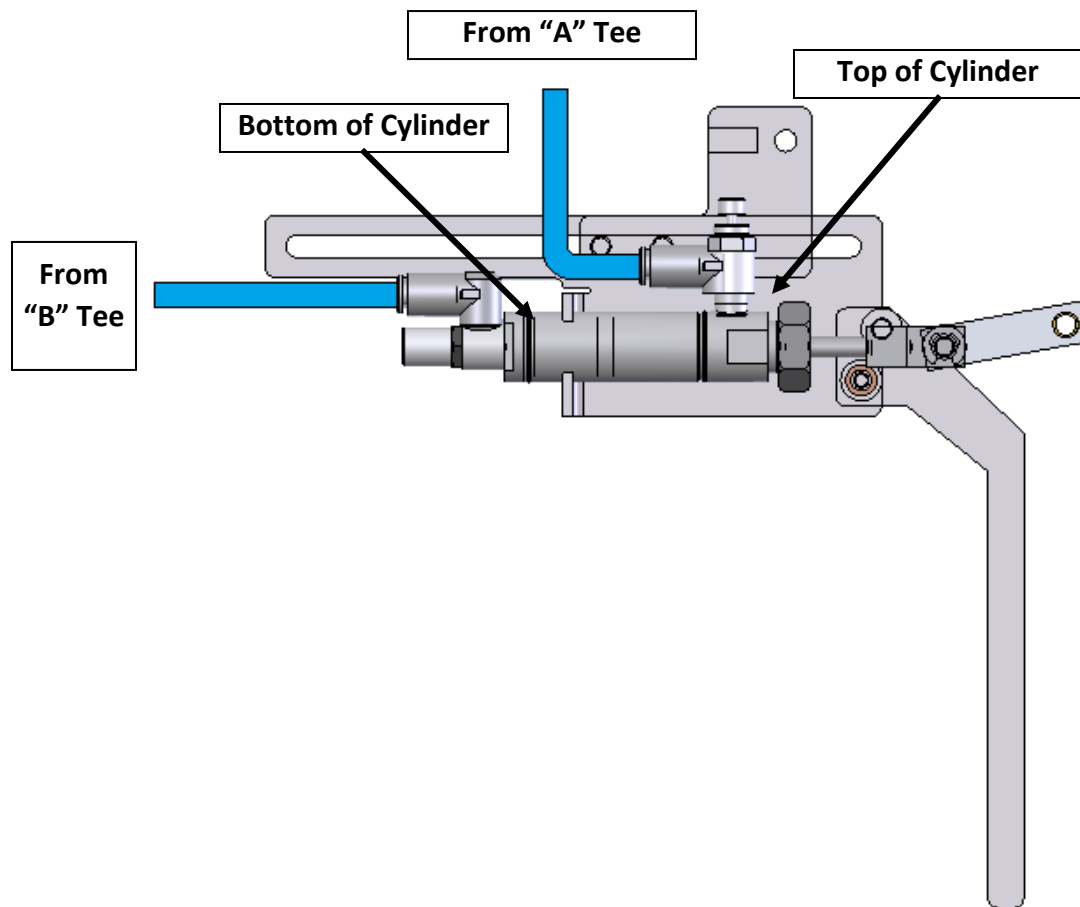
"B" Valves

"A" Valves

Tee

To Cylinder

To Cylinder

Run the tubing from the bottom of the Mini-Regulator to the Air Tee. From this Air Tee, run the shorter tube to the Right Finger and the longer tube to the Left Finger. Connect each of these tubes to the back of the cylinders.

From "A" Tee

Top of Cylinder

Bottom of Cylinder

From "B" Tee

Once the fingers are connected, the Flat Seal Assembly must be activated, and the Valve must be assigned. See next section for Flat Seal activation and Valve Assignment Instructions.
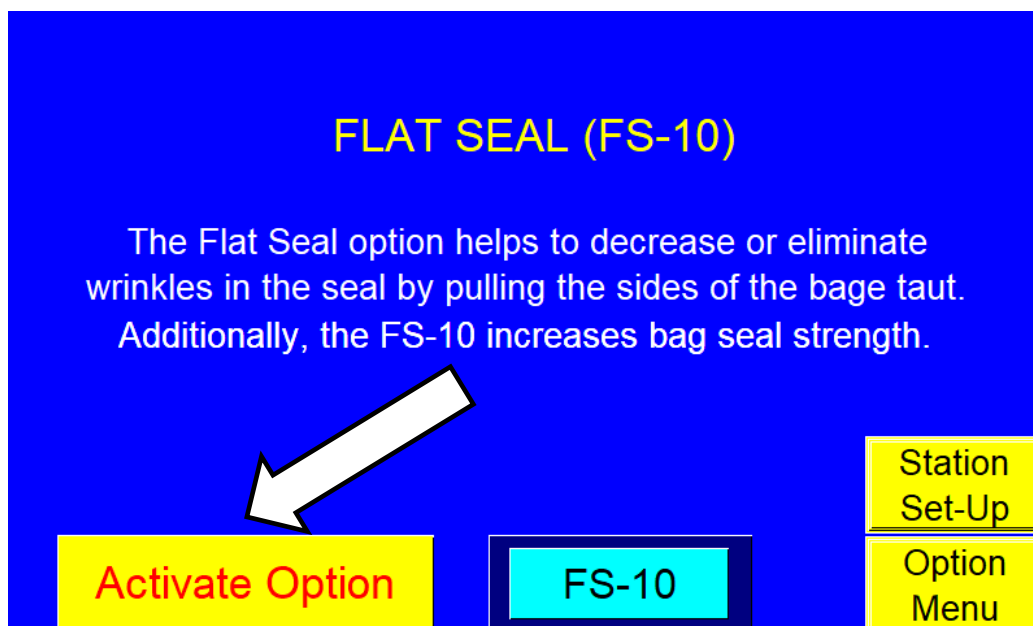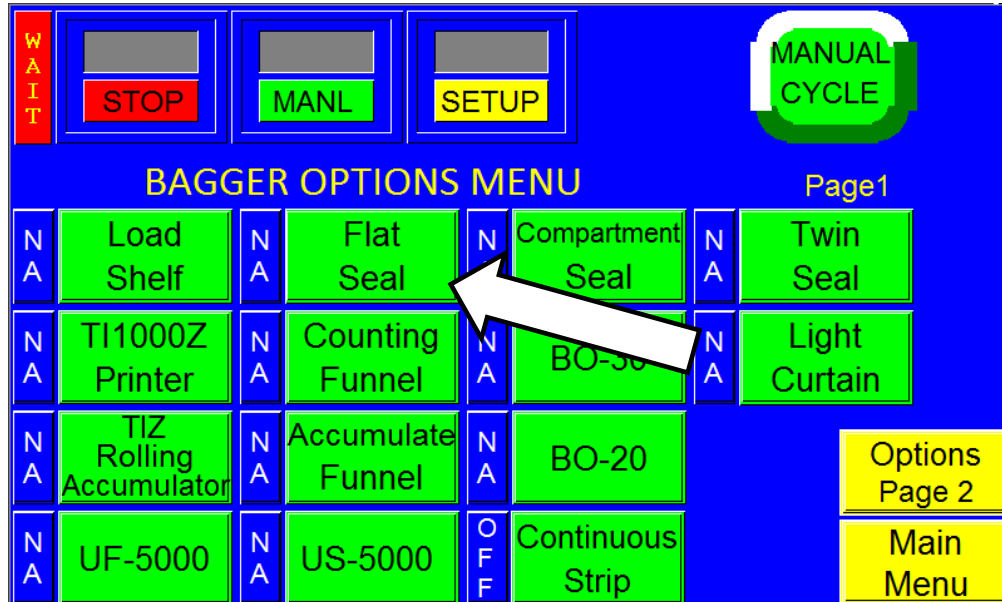
Flat Seal Activation

To activate the Flat Seal Assembly, go to the **Bagger Options Menu** and select **Flat Seal**. When the **Flat Seal Screen** appears, select **Activate Option**.
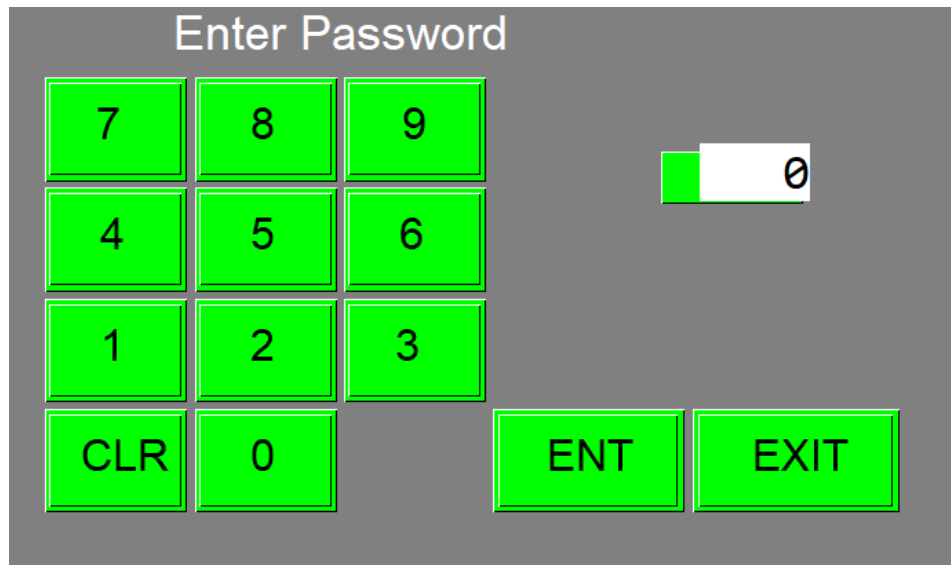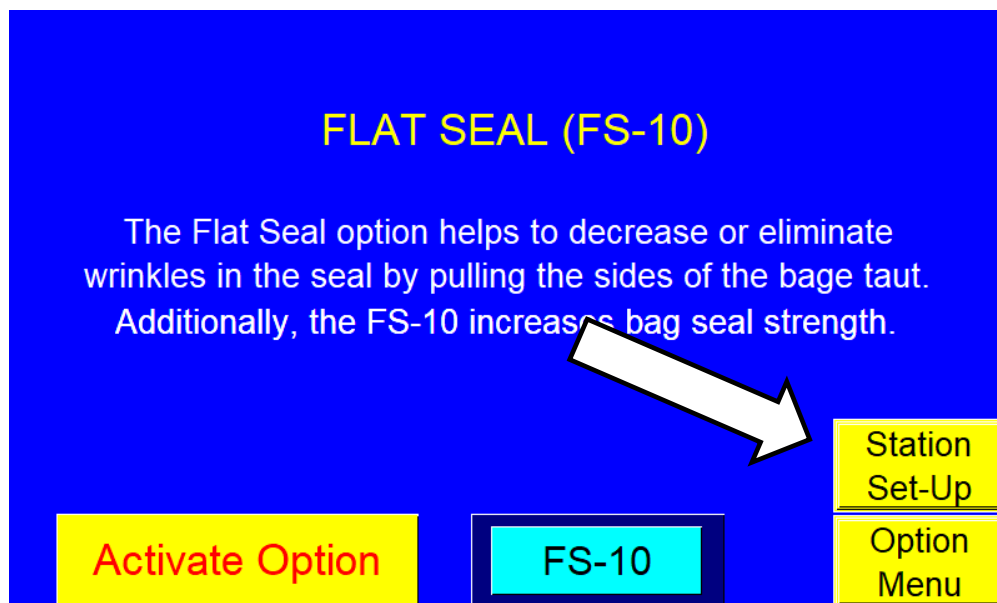
When prompted, use the **Numeric Keyboard** to enter the **Flat Seal Activation Code (0310)**.

After the code is entered, the **Flat Seal Screen** will return. Press the **Station Set-Up** button, and proceed to assign a **Valve Station.**
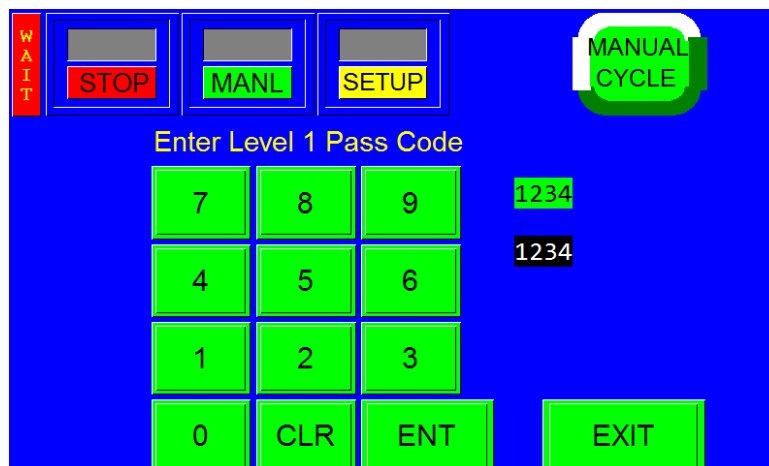
Valve Station Assignments, S14

The T-1000 S14 has Valve Station Assignments, Valves 1 thru 4 are Default in the PLC Program. If there are additional Options on the T-1000 S14 you will need to assign it a Valve Station.

If you are sending in a PLC for programing it is recommended that you write down or take a picture of the Valve Assignments. You may want to take pictures of all your bag settings also. This will help you get your machine up and running more quickly.
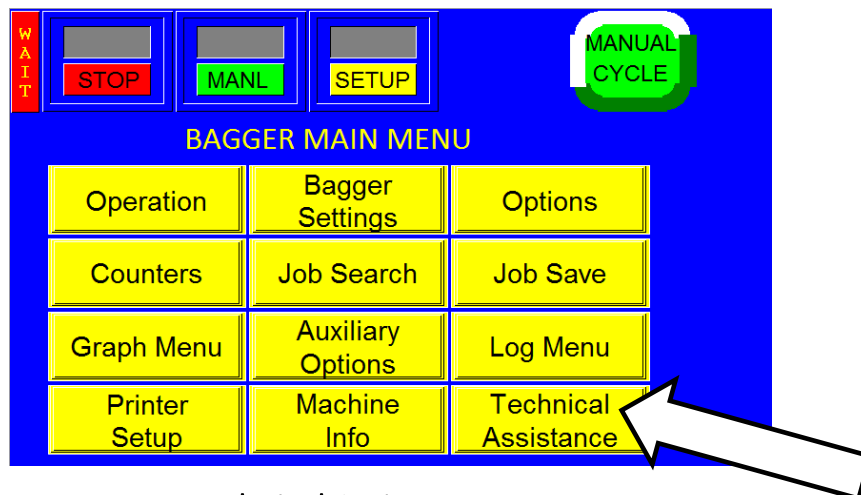
From the Main Menu press **Technical Assistance**.

Enter the **Pass Code 1001**, then press **ENT**.
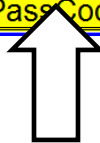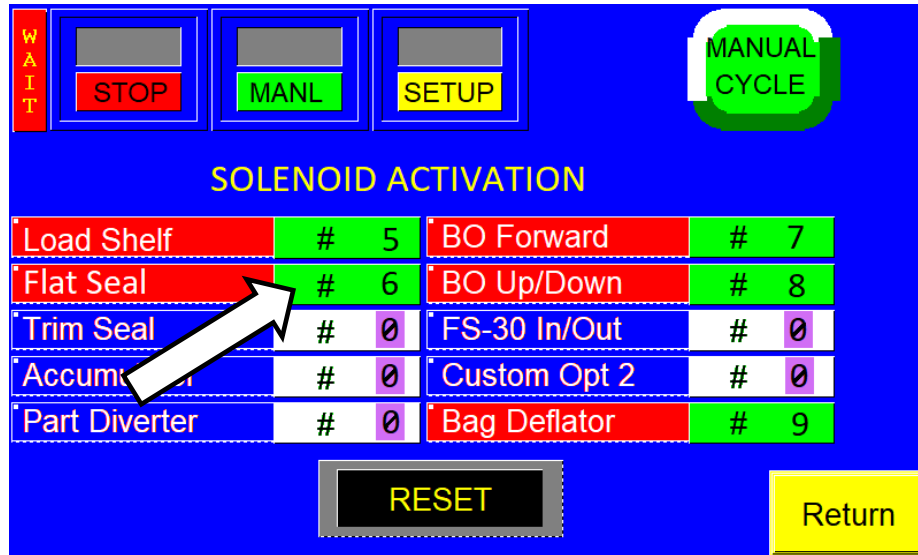
How To
Service Documents from APPI

Press **Option PassC**

Press **SAV Station Set-Up**
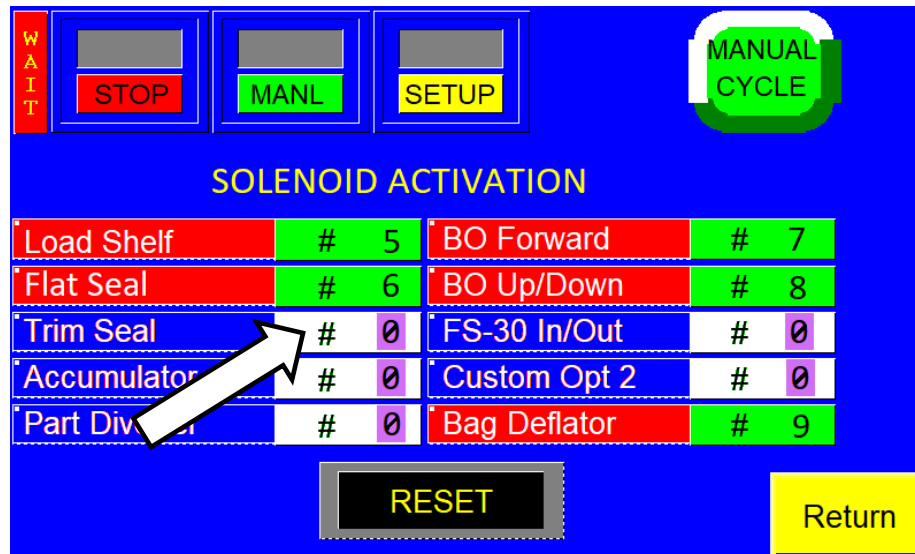
This screen shows the Station Assignments for the Options that are on the Bagger. This is what you want to document. Notice Flat Seal has been assigned to **Valve #6**.

Assign a Valve Station

Select the option and press the **#**.

How To
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Enter the Valve Station the press **ENT**.