



How To

Service Documents from APPI

Document: #HT000130

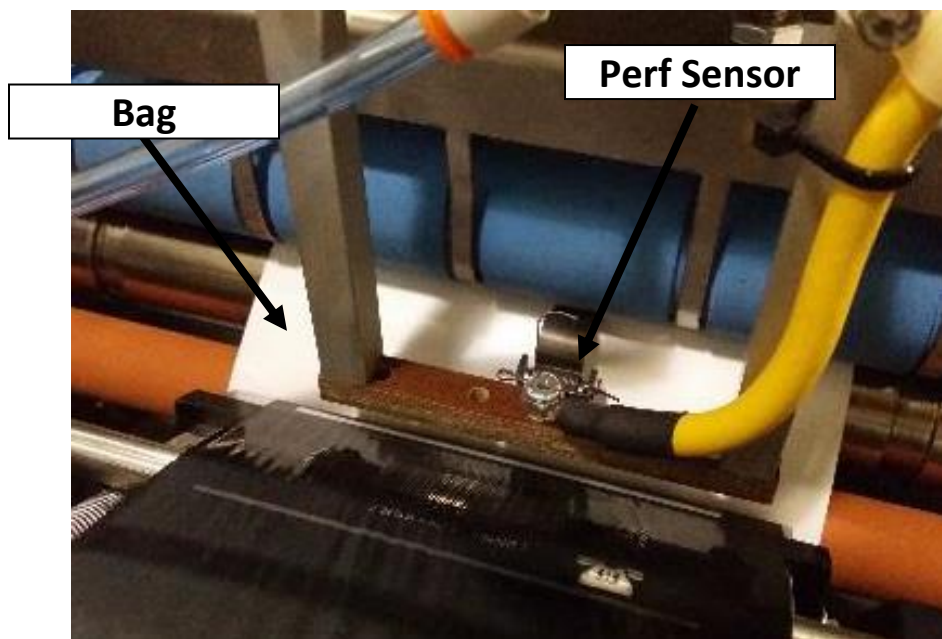
Document Title: Perforation Registration for Bags Smaller than 6"

Product(s): T-1000 Drop Frame

Procedure:

When using bags smaller than 6" on a T-1000 Drop Frame Bagger, it is necessary to slightly modify the standard Perf Registration procedure as follows.

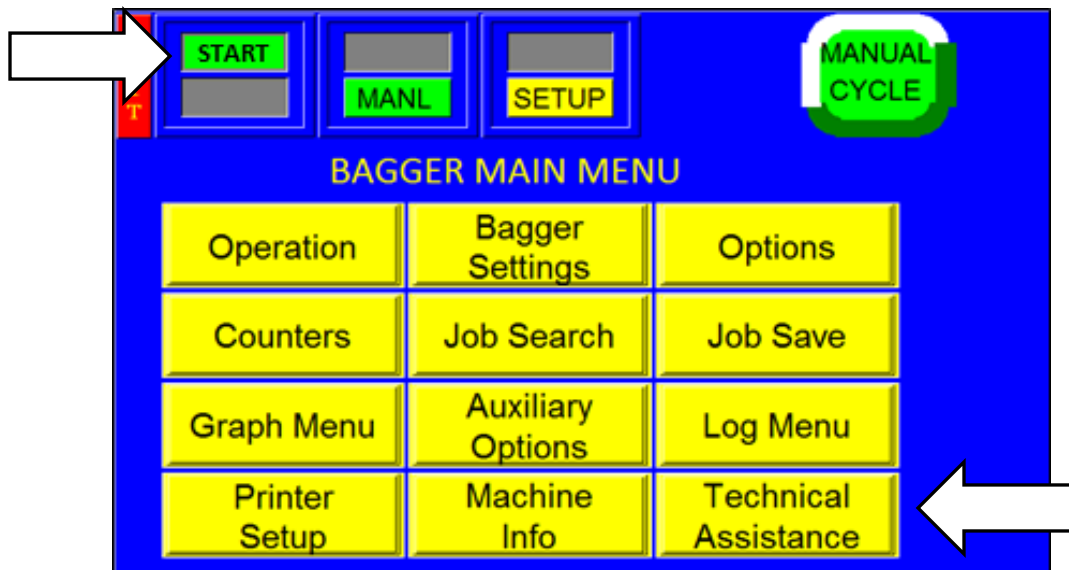
Position the Perf Sensor such that it is sitting on the bag, not a perforation.





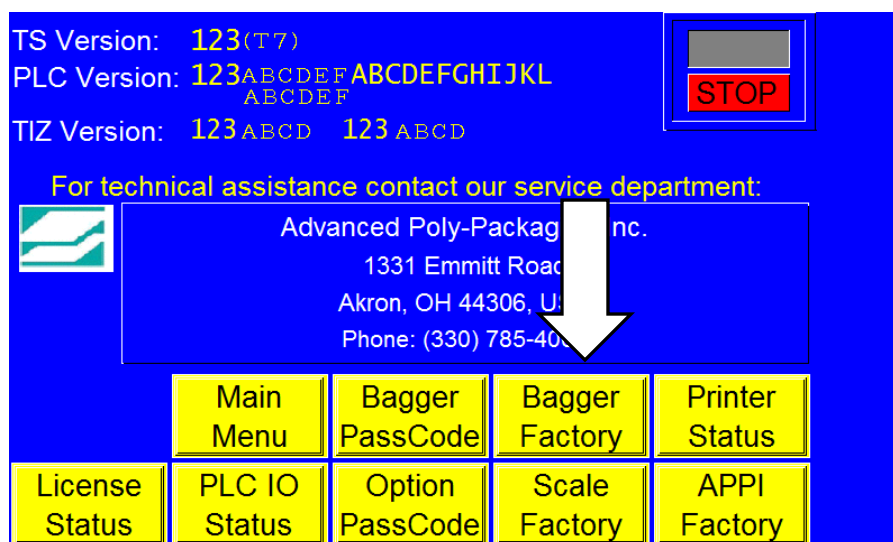
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The **START/STOP** button must be in the green **START** position. Press **Technical Assistance**. Enter passcode **1001** on the numeric keypad.

Note: The screens may differ slightly from these screenshots depending on your version.

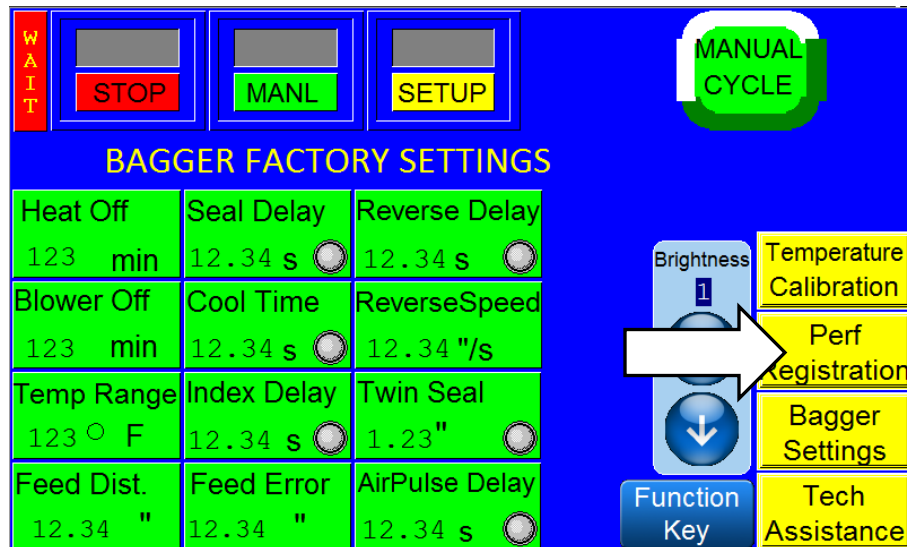


Press **Bagger Factory**.

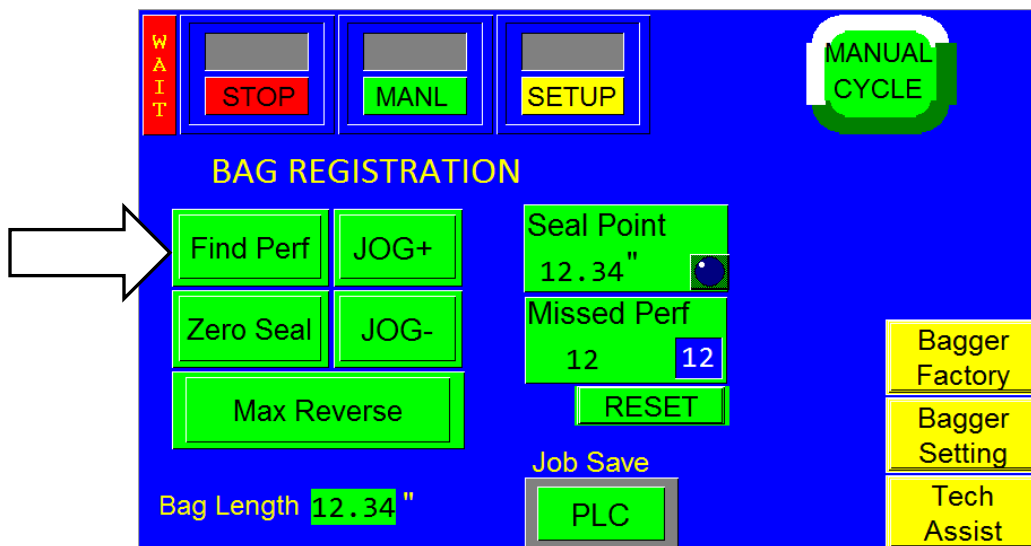


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On the **Bagger Factory Settings** screen, select **Perf Registration**.



Press **Find Perf**. The Bagger will advance until it stops on a perforation.



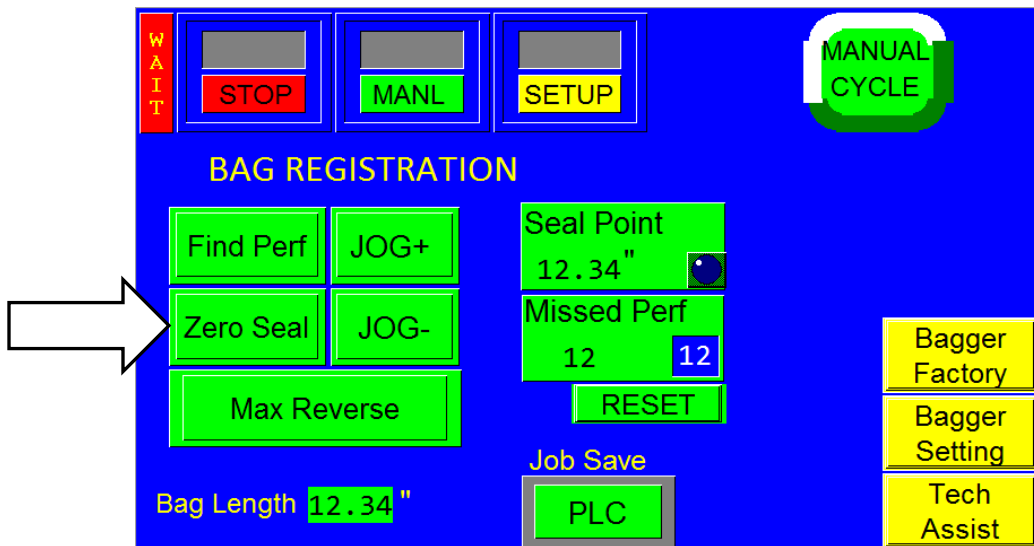
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Press and hold **JOG+** until the perforation that was under the **Perf Sensor** is above the opening for the **Heater Bar**. The actual distance above the opening will depend on the size of the bag; it should not be more than about an inch.

There is no set distance; you will have to do trial and error to see what works for you.

Note: It is normal for the bagger to advance the bag very slowly.

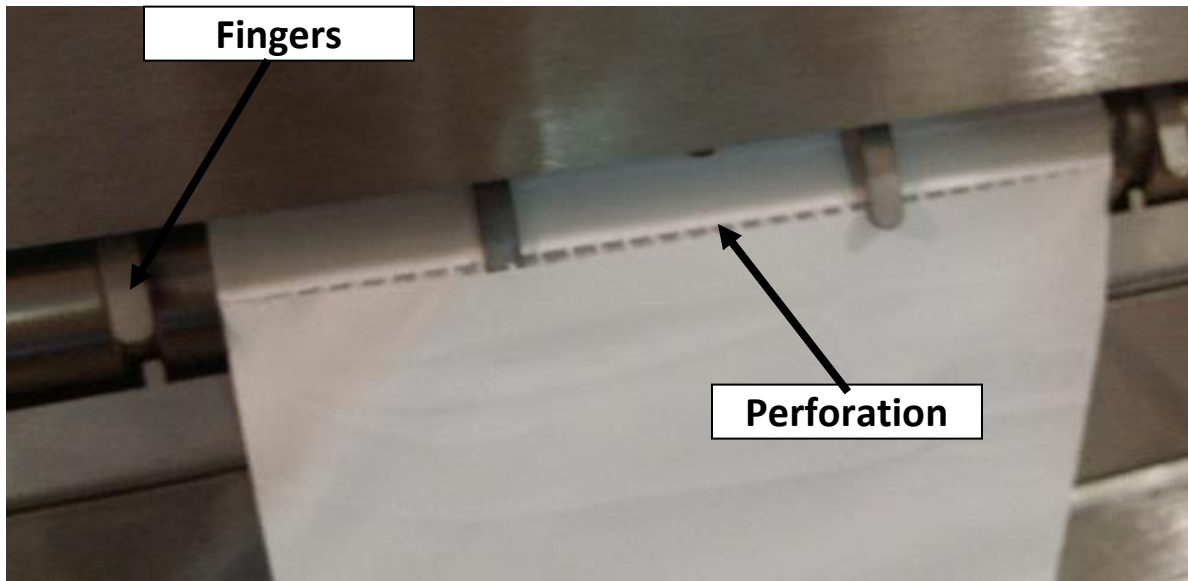


Press **Zero Seal**.

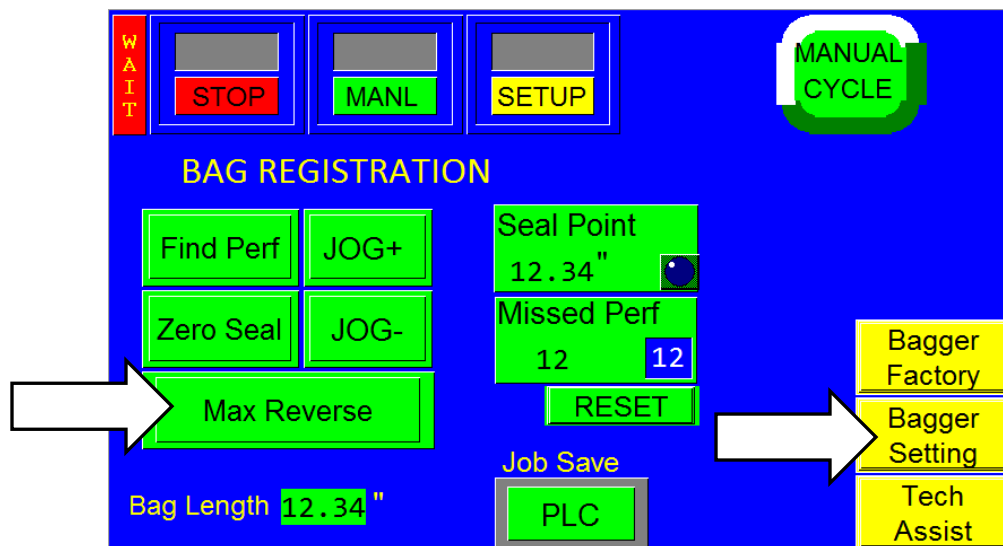


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Press and hold **JOG-** until the perforation is under the fingers. You may need to go even further up, but not too close to the top of the metal roller. That will cause the bags to be pulled back too far, and fall back into the Bagger.



Press **Max Reverse**.

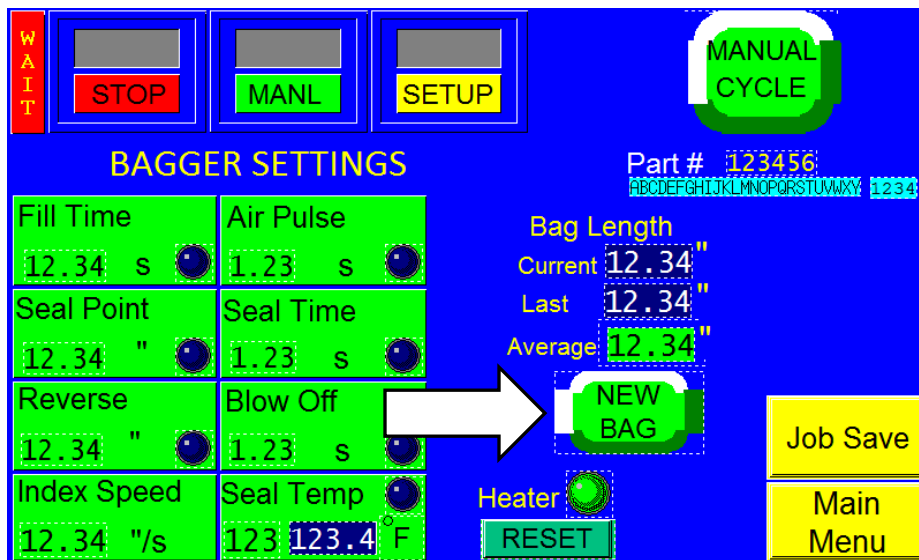
Press **Bagger Setting**.

Note: on older versions, you may have to go via Main Menu to Bag Settings.



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Press **NEW BAG**.

Since the bag now stops above the **Heater Bar** opening, you will have to adjust your **Seal Point** and **Reverse** to place the **Seal Point** where you need it, and to make sure **Reverse** doesn't pull your bags too far into the machine.

Since the bag now stops higher than normal, you may have to set a **Seal Point** that is very close to, or exactly 0.00

Press **MANUAL CYCLE** until Bag Length Current/Last/Average are about the same numbers. This usually takes 4 to 5 cycles.