

How To

Service Documents from APPI

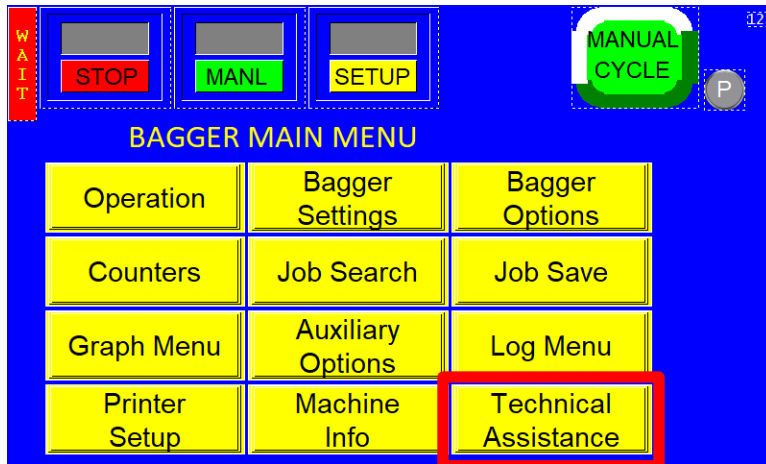
Document: #HT000190

Document Title: Activate the Accumulating Funnel

Product(s): T-1000

Procedure:

Go to Main Menu
Press Technical Assistance



Enter Code 1001
Press ENT



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Press Option Pass Codes

TS Version: 123(T7S)
 PLC Version: 123ABCDEF: ABCDEFGHIJKL
 TIZ Version: 123ABCDEFGHI: 123ABCD

For technical assistance contact our service department:
 Advanced Poly-Packaging Inc.
 1331 Emmitt Road
 Akron, OH 44306, USA
 Phone: (330) 785-4000

Main Menu	Bagger PassCode	Bagger Factory	Printer Status	License Status
PLC IO Status	Option PassCode	Scale Factory	APPI Factory	Temperature Calibration

Select Accumulating Funnel

WAIT STOP MANL SETUP MANUAL CYCLE P

Select option to enter password

NA Load Shelf	NA Flat Seal	NA Compartment Seal	NA Twin Seal
NA TI1000Z Printer	NA Counting Funnel	NA BO-30	NA Light Curtain
NA TIZ-RA	NA Accumulating Funnel	NA BO-20	Options Page 2
NA UF-5000	NA US-5000	SAV Station Set-Up	Tech Assist

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Press Activate

ACCUMULATING FUNNEL (AF-10)

Increase production by allowing a continuous in-feed of product into this funnel regardless of the operation of the T-1000. The Accumulating Funnel collects the product while the bag is sealing. Once another bag is in position, the funnel discharges its content without stopping flow of product.

Station Set-Up

Option Menu

Activate Option

Closed Mode

Enter Code 1201

Enter Password

7 8 9

4 5 6

1 2 3

CLR 0

ENT EXIT

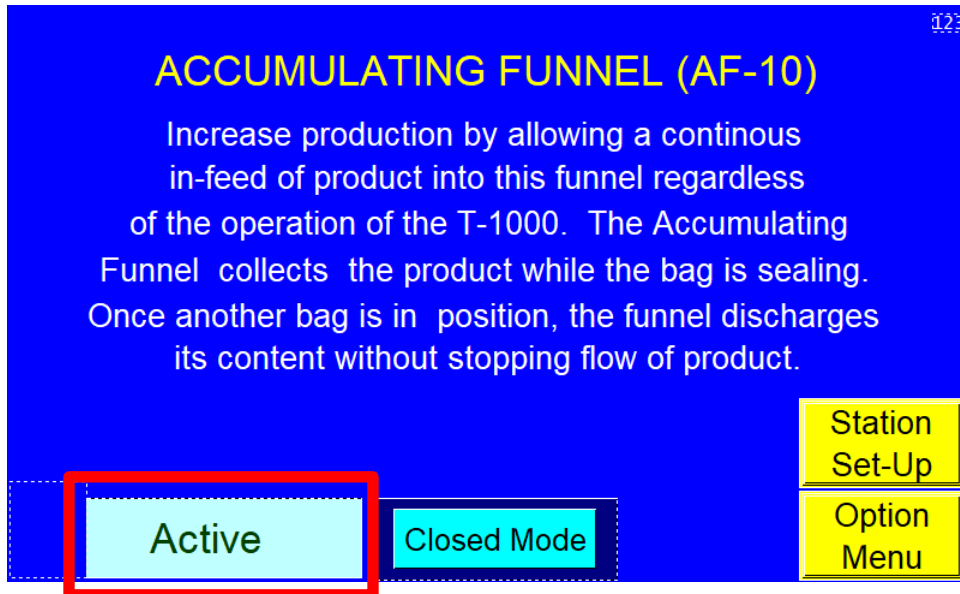
12345

Range 12345... 12345

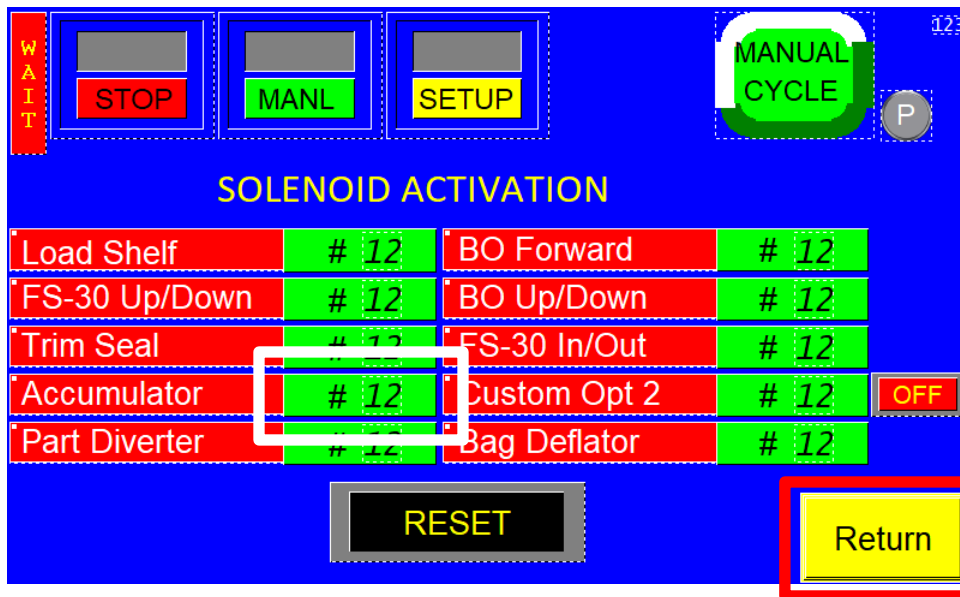
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The Yellow Button labeled Activate Option should now display Active.



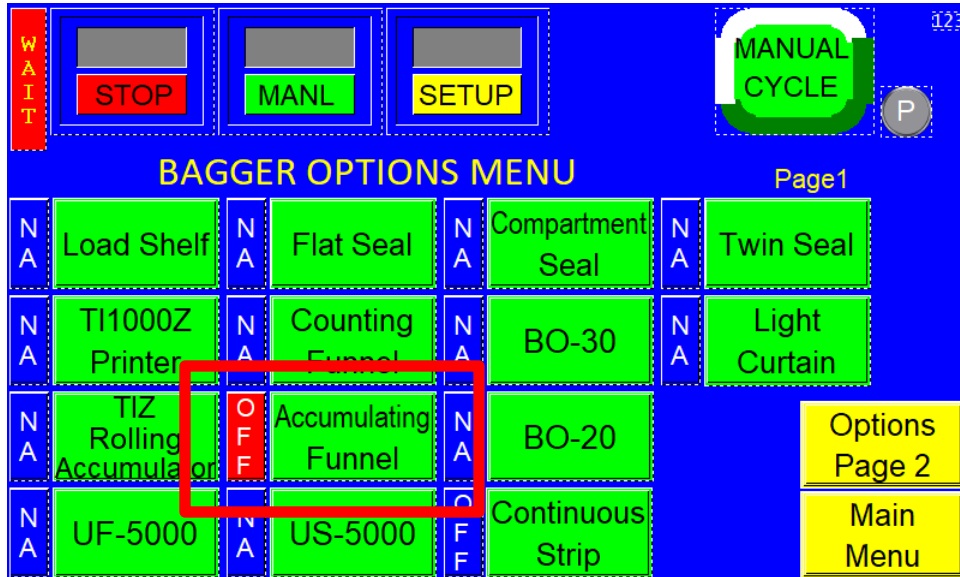
Press Yellow Button Station Set-Up



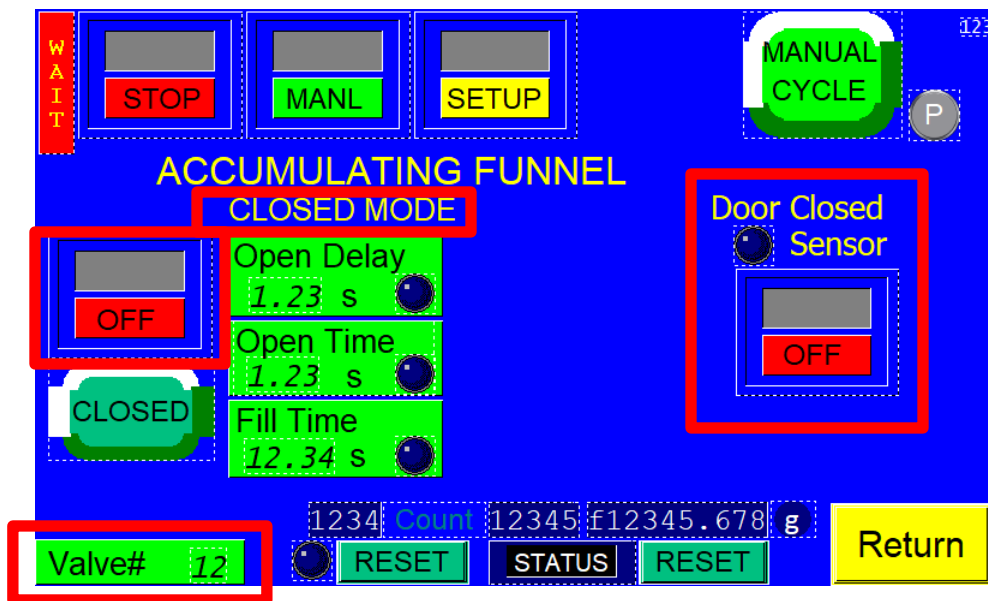
Press the Green Button next to Accumulator and assign a valve number for the Accumulator.
Call Advanced-Poly for assistance with valve assignments.
Press the Yellow Button labeled Return.

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The Green Accumulating Button should display Red OFF to the left side of the button.
Press the Green Accumulating Funnel Button



Accumulating Screen should say CLOSED MODE

Press the Red OFF Button to turn the Green Accumulating ON (Green)

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Press the Door Closed Sensor Red OFF Button to turn the Door Closed Sensor ON (Green)

The Green Valve# Button should display the Valve # assigned in the previous step

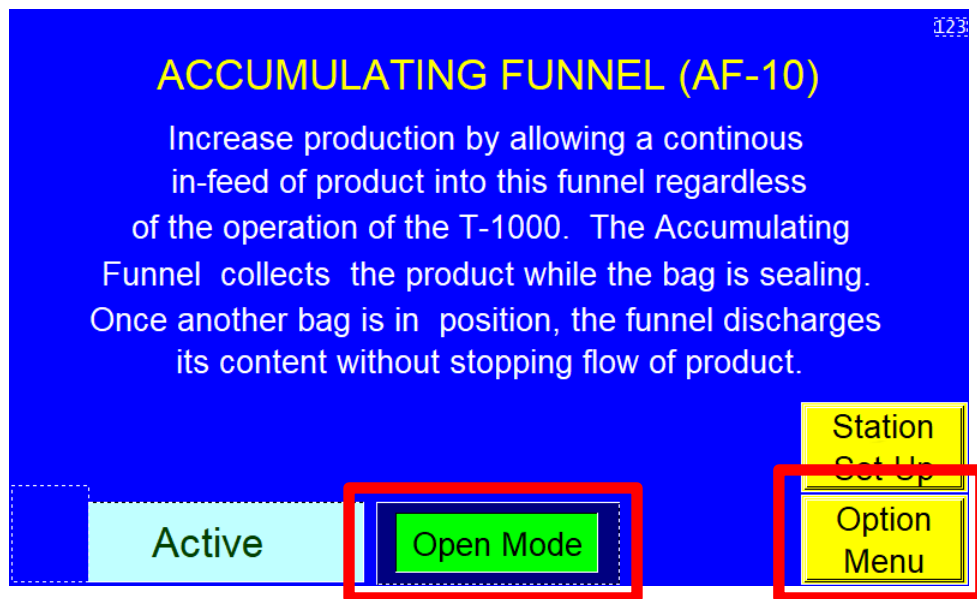
Press the Green Open Delay Button and enter .03

Press the Green Open Time Button and enter 0.75

The Green Fill Time Button should display the Fill Time already enter when setting-up the bagger

To switch the Accumulating Funnel to OPEN MODE

Repeat Steps 1 – 4



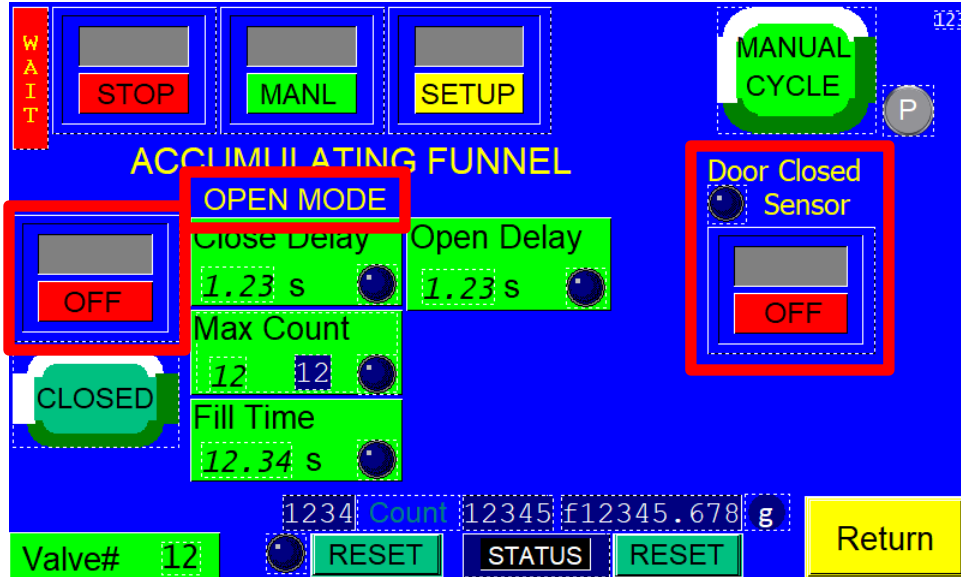
Press the Blue Closed Mode Button the switch to Open Mode

Press the Yellow Option Menu Button

Press the Green Accumulating Funnel Button

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Accumulating Screen should say OPEN MODE

Press the Red OFF Button to turn the Green Accumulating ON (Green)

If the Door Closed Sensor is ON press the Green ON Button to turn the Door Closed Sensor OFF (RED)

NOTE: The CLOSED DOOR SENSOR MUST be OFF in order for the bagger to Cycle when operating the Accumulating Funnel in OPEN MODE

The Green Valve# Button should display the Valve # assigned in the previous step

Press the Green Closed Delay Button and enter .03

Press the Green Open Delay Button and enter 0.5

The Green Fill Time Button should display the Fill Time already enter when setting-up the bagger

The Green Max Count Button is normally set to 0 unless using a Counting Funnel

Max Count is used to limit the number of pieces of product being held in the Accumulating Funnel to avoid the product bridging in the Accumulating Funnel.