



# How To

## Service Documents from APPI

**Document: #HT000020**

**Document Title: Adjust Anti-Jam**

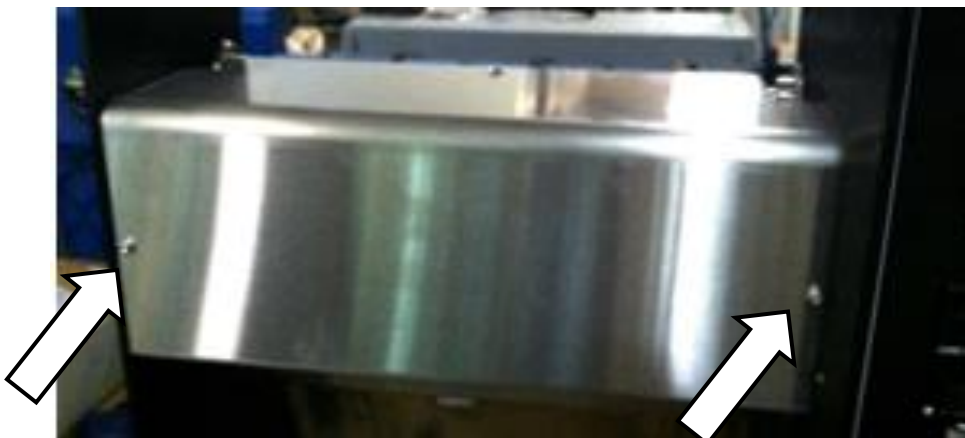
**Product(s): T-200/275**

**Procedure:**

Disconnect the Air Supply



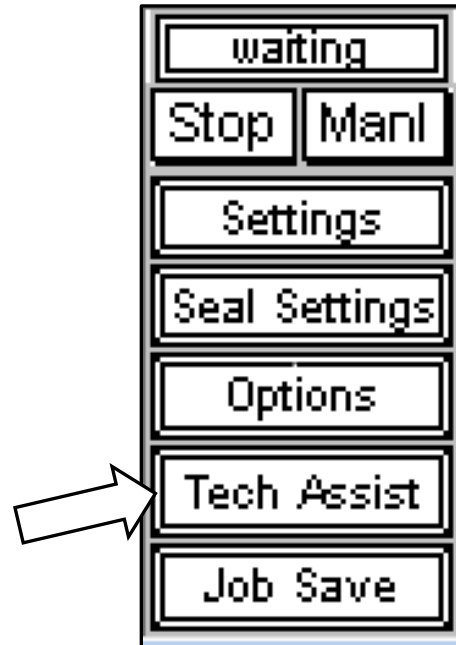
Remove the Stainless Back Cover by removing the Screw on each side.





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Go to the Main Menu and press Tech Assist



Press PLC I/O

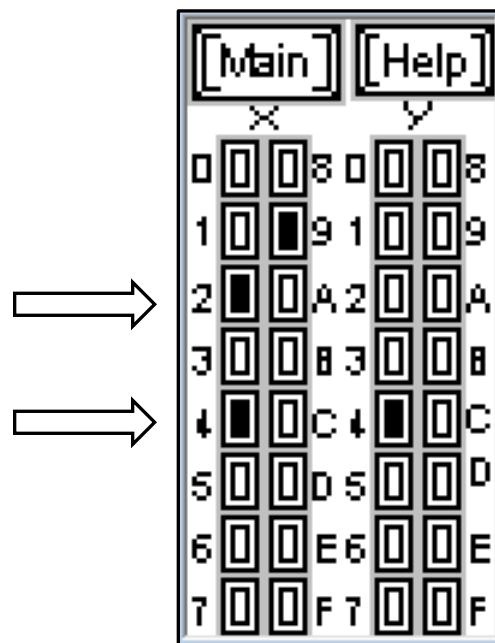


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Push the **Pressure Bar** in until it just touches

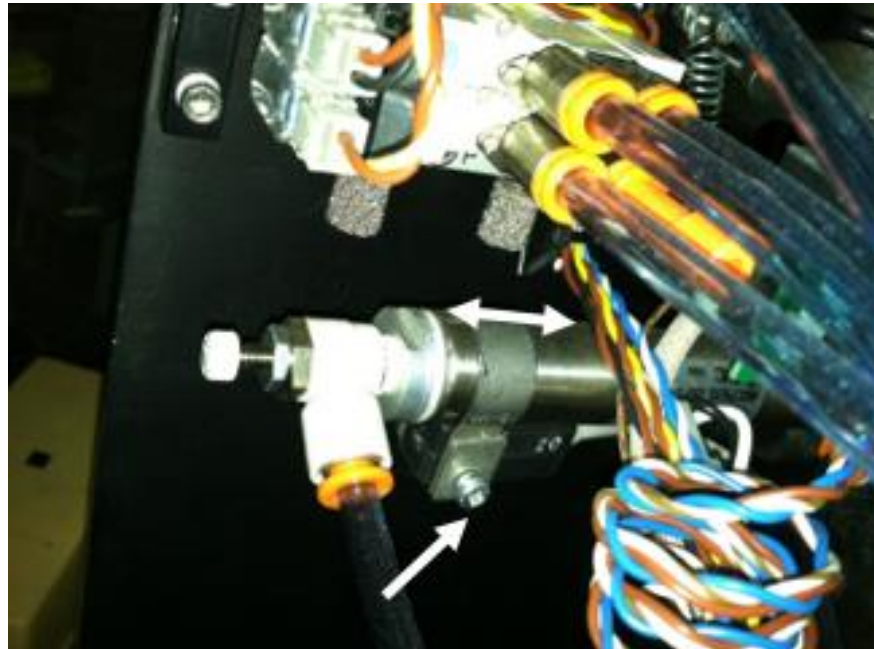


X2 and X4 should be on.

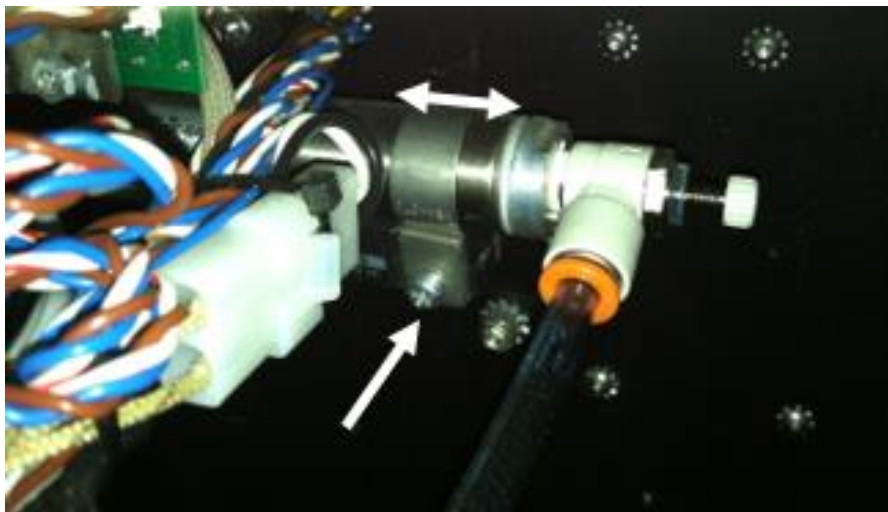


# How To

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Left Air Cylinder



Right Air Cylinder



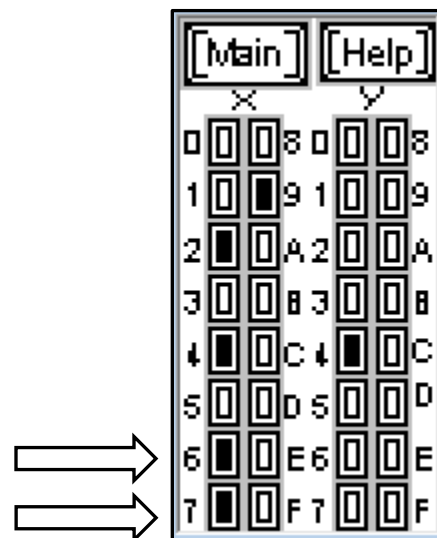
# How To

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Loosen the switch and move it forward and aft until X2 or X4 turn on. Adjust each side so both X2 and X4 are ON.



Now push the Pressure Bar all the way in.



X6 and X7 should now be ON.



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Push on the Left side of the **Heater Bar** all the way in, **X6** should be **ON**. When you push the Right side in all the way **X7** should be **ON**.

If one side does not turn on, you may have a bad connector, a bad Anti Jam Circuit Board, or the Sensor may need to be adjusted.





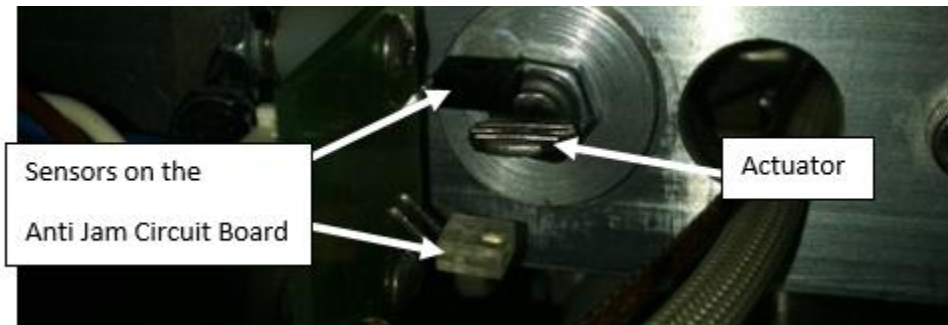
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One each on both Right and Left sides

Perform the following procedures to determine where the problem is.





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Place a small Screw driver between the two Sensors and see if **X6** or **X7** turn **ON**. If **X6** or **X7** does turn on when placing the Screw Driver between the Sensors, you need to adjust the Anti Jam Circuit Board.



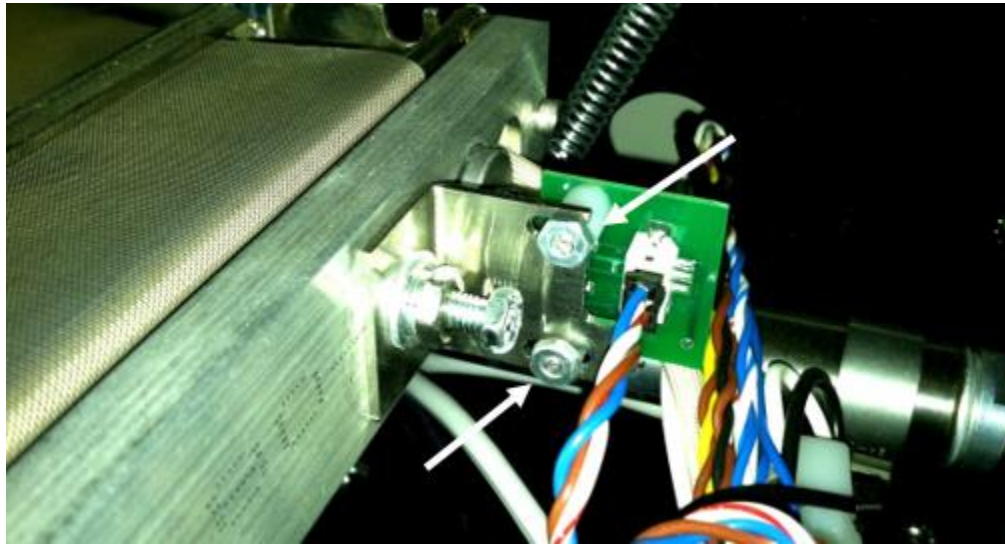
Have someone push the **Pressure Bar** all the way in.





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Loosen the two Lock Nuts holding the Circuit Board to the Anti Jam Mounting Bracket.



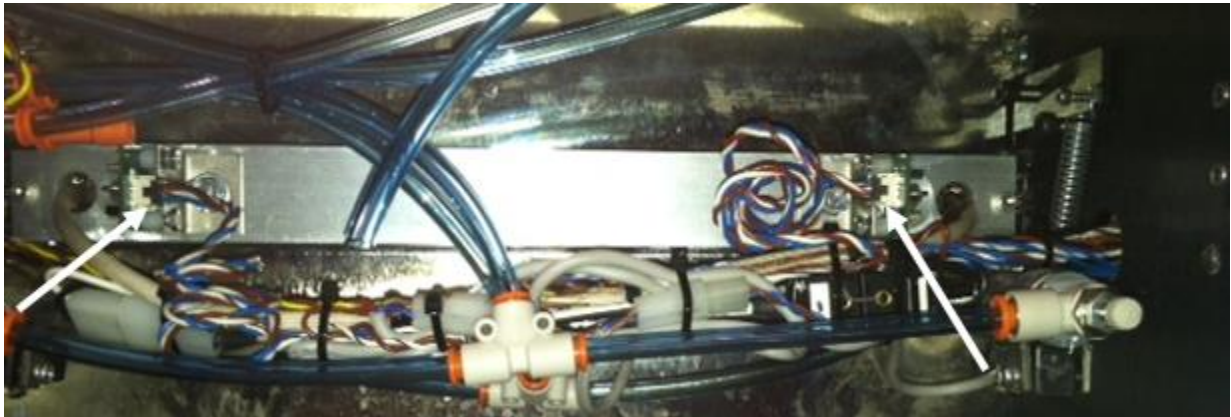
While holding the **Pressure Bar** all the way in, move the Anti Jam Circuit Board fore and aft until **X6** or **X7** turns **ON**. Tighten the two Lock Nuts holding Circuit Board to the Bracket.

If **X6** or **X7** did not turn on while doing this procedure, go to the next page.



# How To

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Unplug both Pig Tail Connectors, plug the Right Pig Tail into the Left Anti Jam Circuit Board and plug the Left Pig Tail into the Right Anti Jam Circuit Board.

Reconnect the air supply to the bagger, turn power on. Now cycle the bagger. Did the Heater Bar Sensor Error go to the other side?

### **Warning!**

Please check  
left Heat Bar  
sensor.

**Return**

If it did, then the Pig Tail is bad. Order a replacement part: Pig Tail, Anti Jam, part number TP-T8ME0161-1.

If the Error did not change sides then you need a new Anti-Jam Circuit Board, part number TP-T8ME0161.