



How To

Service Documents from APPI

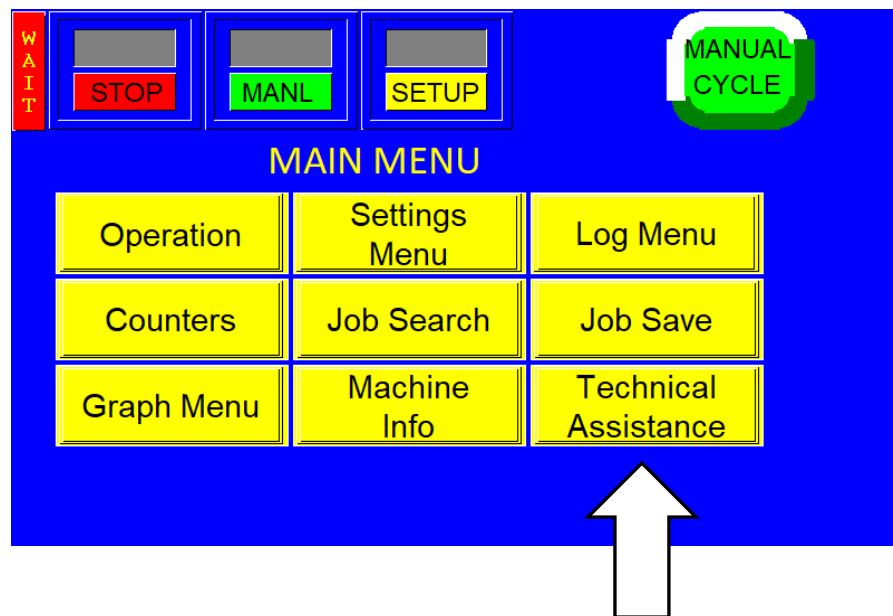
Document: #HT000173

Document Title: Set Up Towel Bagger Perf Registration

Product(s): ST-1000

Procedure:

Go to Main Menu. Press Technical Assistance



Enter Pass Code 1001 and press Enter.





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Press Bagger Factory

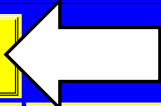
TS Version: 403(T7)
PLC Version: 123ABCDEF ABCDEFGHIJKL
 ABCDEF

STOP

For technical assistance contact our service department:

 Advanced Poly-Packaging Inc.
1331 Emmitt Road
Akron, OH 44306, USA
Phone: (330) 785-4000

Main Menu	Test	Bagger PassCode	Bagger Factory	
License Status	PLC IO Status	Scale Factory	APPI Factory	Solenoid Stations



Press Perf Registration

WAIT

STOP MANL SETUP

MANUAL CYCLE


BAGGER FACTORY SETTINGS

Heat Off 123 min	Seal Delay 12.34 s	Reverse Delay 12.34 s
Blower Off 123 min	Cool Time 12.34 s	ReverseSpeed 12.34 "/s
Temp Range 123 ° F	Index Delay 12.34 s	Twin Seal 1.23 "
Feed Dist. 12.34 "	Feed Error 12.34 "	AirPulse Delay 12.34 s

Brightness 1

Function Key

SAV Test
Temperature Calibration
Perf Registration
Bagger Settings
Tech Assistance

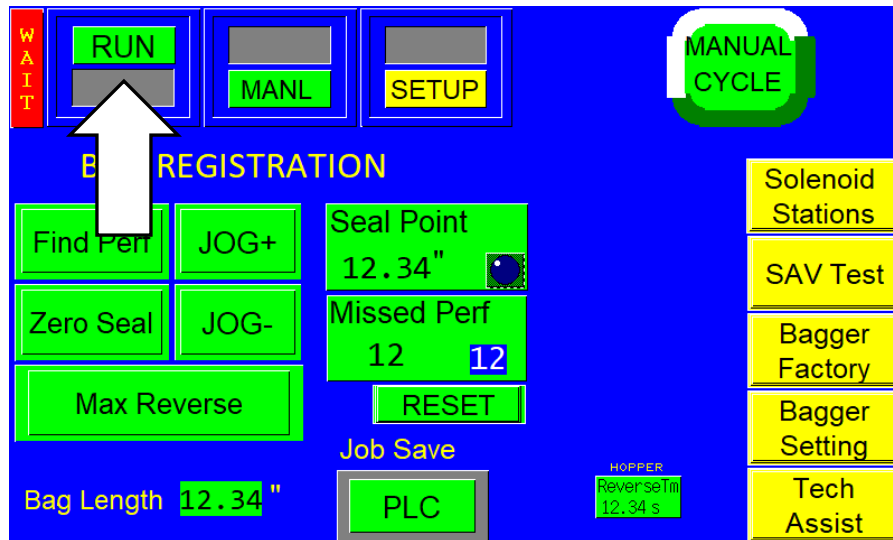




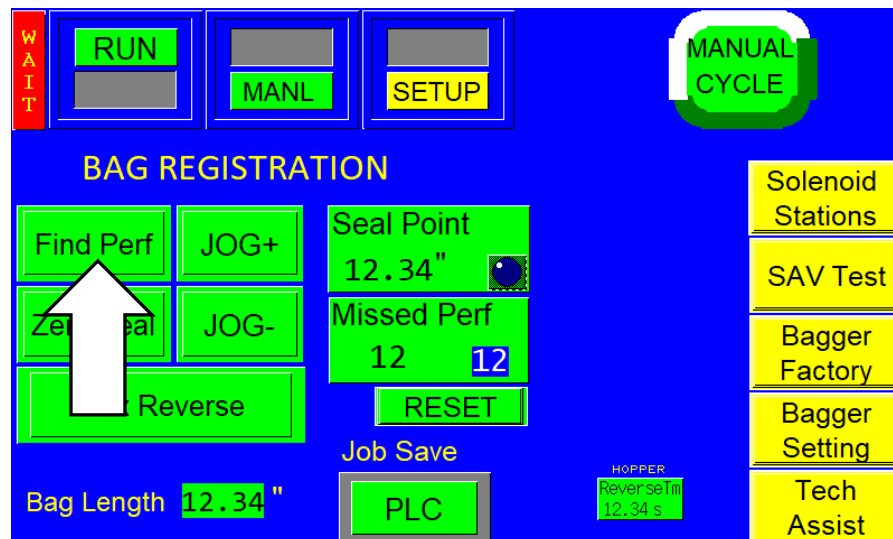
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Toggle Start/Stop Button to Start (Green).



Press Find Perf

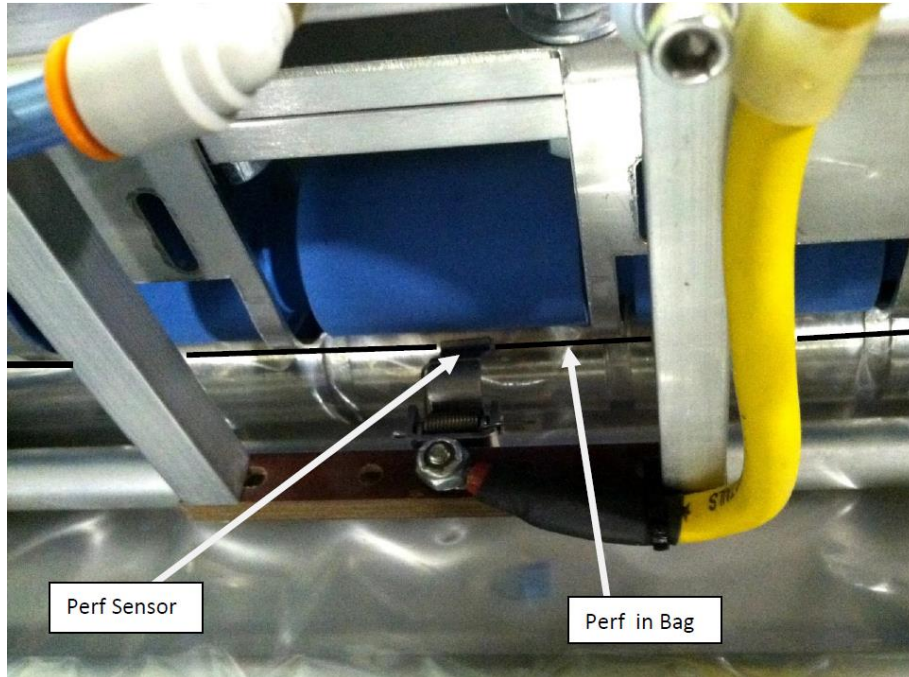




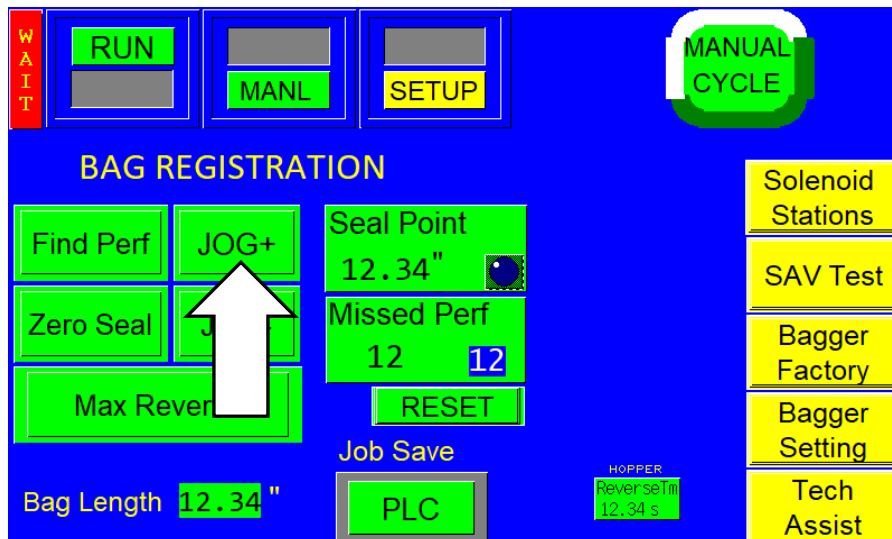
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Verify that the Perf stopped under the Perf Sensor



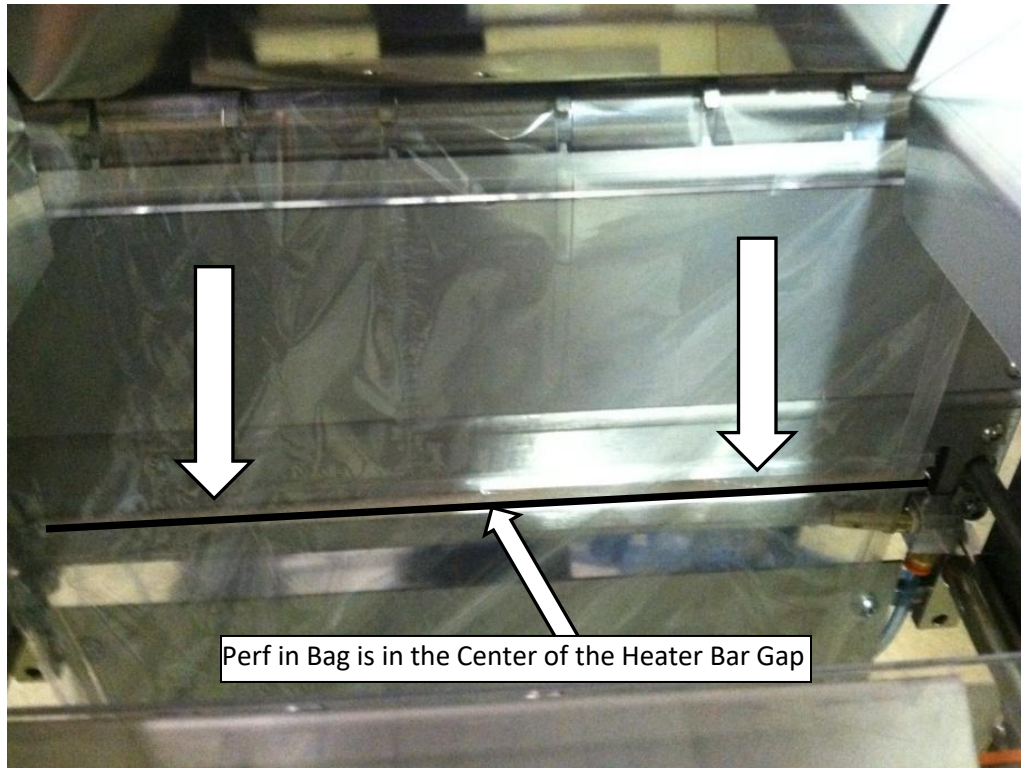
Press and hold **JOG+**. Until the Perf is Center in the Heater Bar Gap



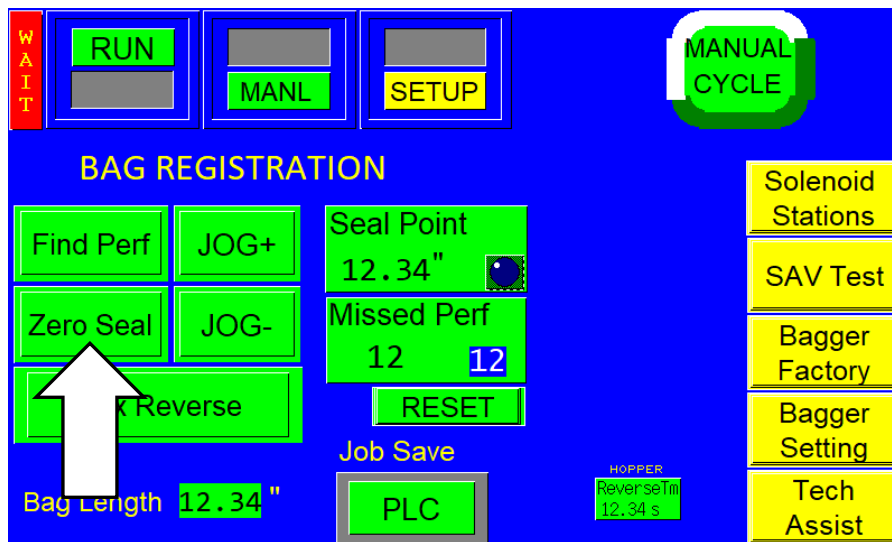


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Press Zero Seal.

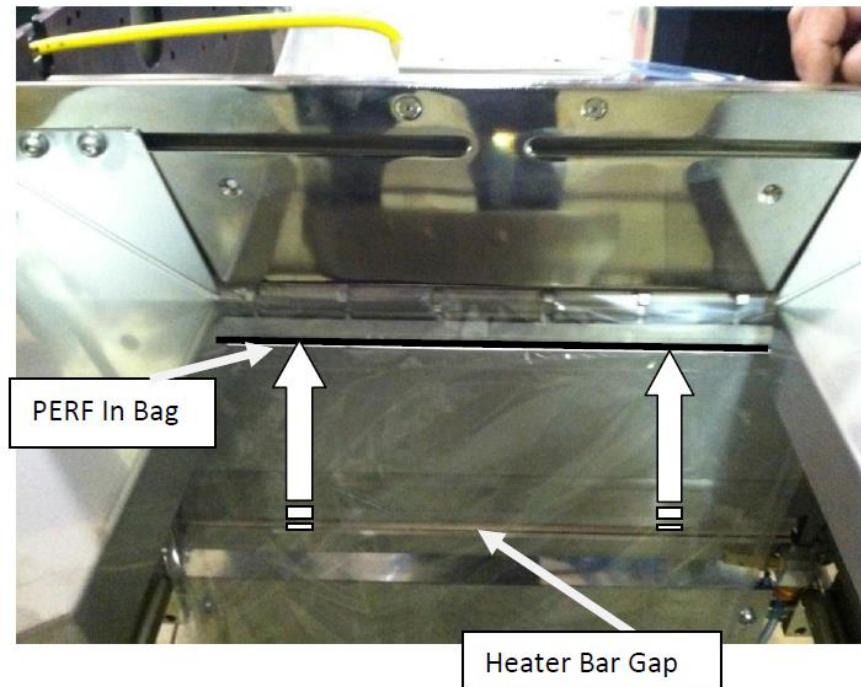
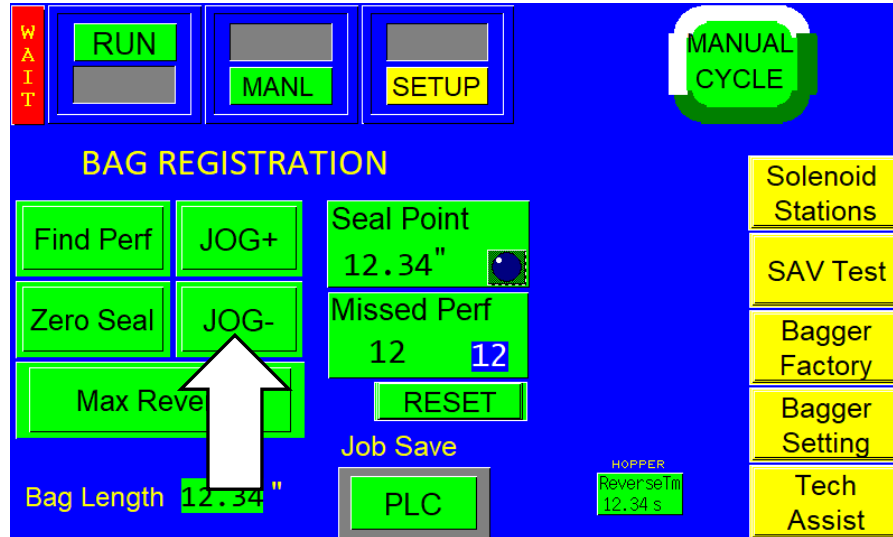




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Press and Hold **JOG-** until Perf in Bag is about 1-inch from **Rollers**.

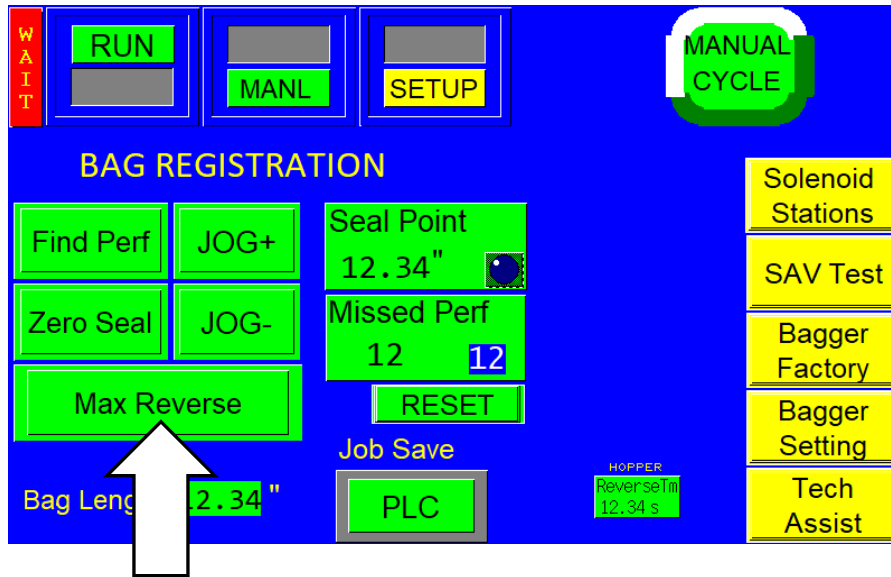




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Now Press **Max Reverse**



Perf Register is now complete.