

How To

Service Documents from APPI

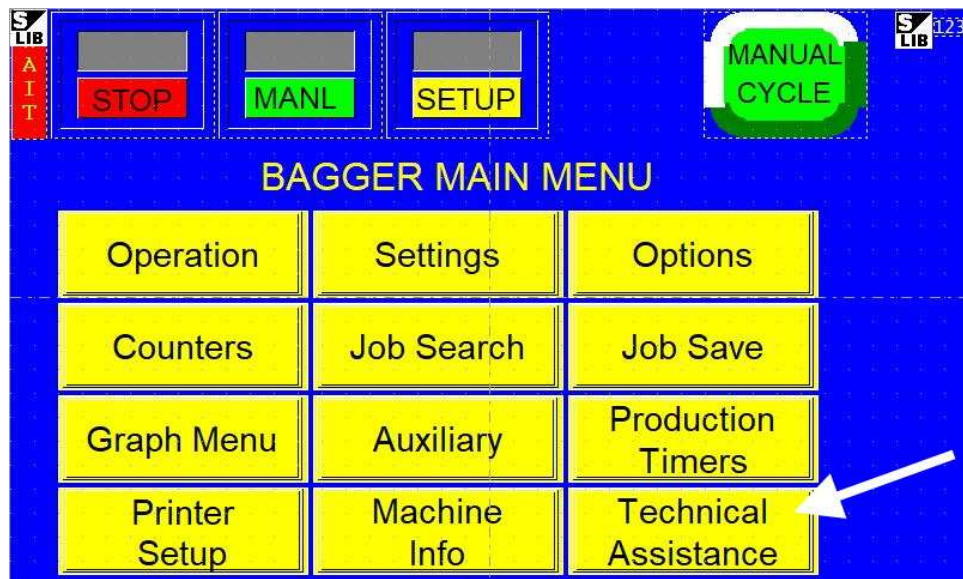
Document: #HT000209

Document Title: Active a Light Curtain

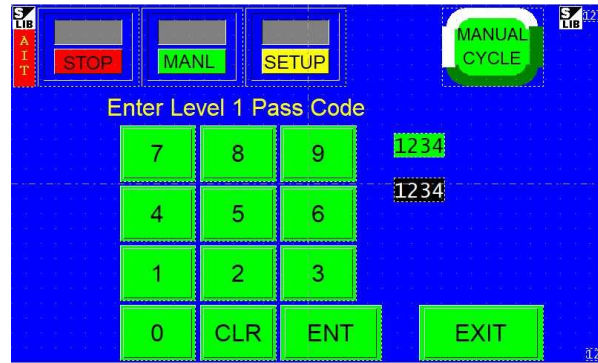
Product(s): T-1000S14

Procedure:

**To Active Light Curtain Option, Go to Main Menu and Press the Yellow Button
Technical Assistance**



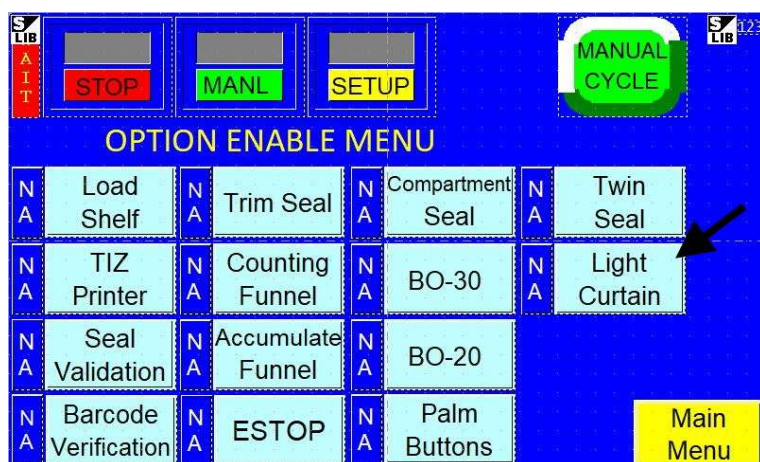
Enter Factory Set Code 1001
If Factory Code 1001 does not work call APPI for Assistance



Press the Yellow Button Option Activation



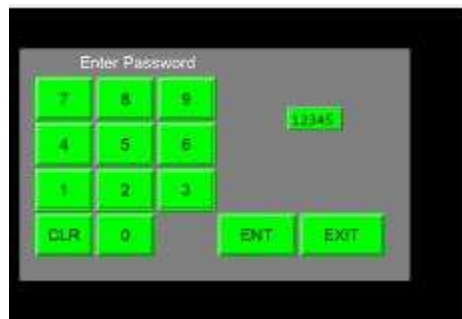
Press Light Curtain



Press the Yellow Active Option Button



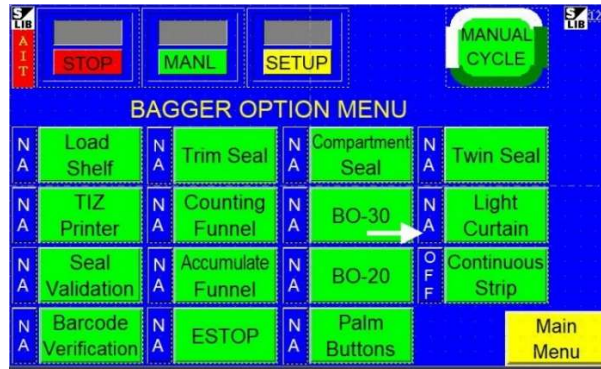
Enter the Code 508



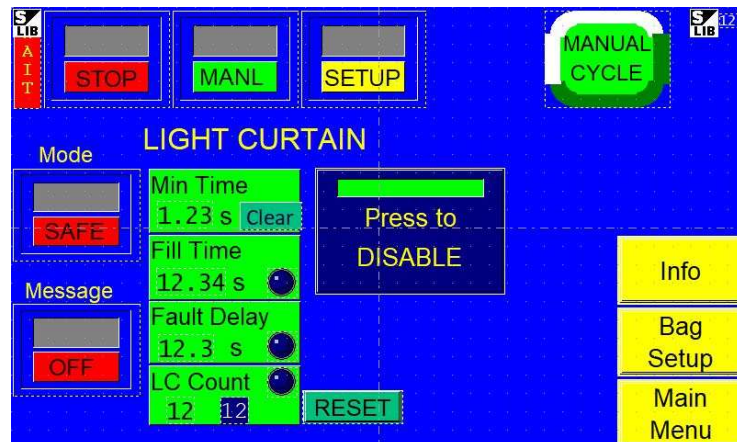
The Yellow Active Option Button should have turned Black and display Active.

Press the Yellow Option Menu Button

**Left of the Light Curtain Button the N/A in Blue should now display Green ON;
Press the Light Curtain Button**



Min Time 0.3
 Fill Time should have been set in Bagger Setting
 Fault Delay 9.9
 LC Count 1
 Press Red Safe Button; will toggle to Green Auto
 Message OFF



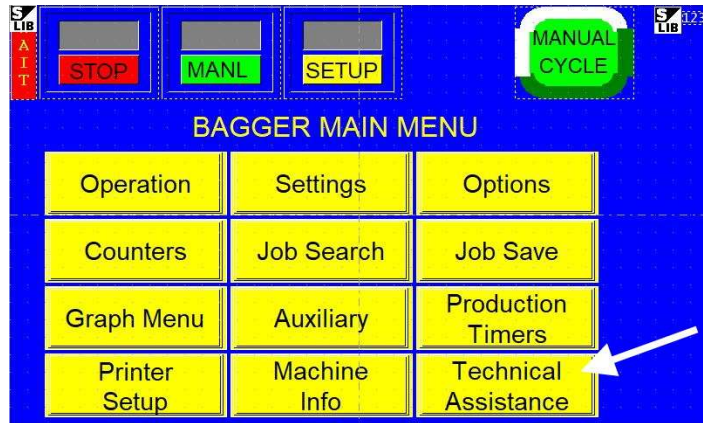
In Auto Mode breaking the Light Curtain circuit 1 time will cause the bagger to cycle. If LC Count is changed to 2 then breaking the Light Curtain circuit twice will cause the bagger to cycle.

In Safe Mode breaking the Light Curtain will not cause the bagger to cause the bagger to cycle. A Footswitch will need to be used to cycle the bagger.

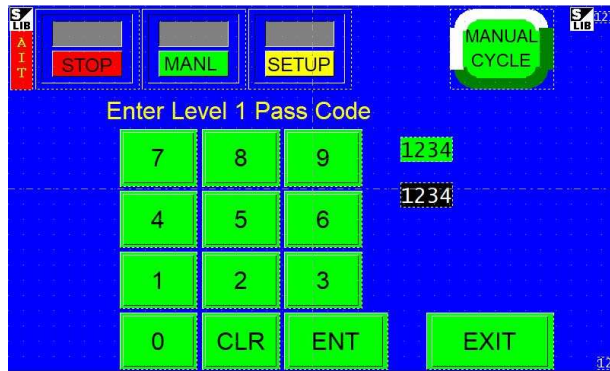
CAUTION: *Do not turn ON power until all covers are replaced.*

After the covers are replaced place the bagger in Start/Manual/Run to test the Light Curtain.

Go to Main Menu and Press the Yellow Button Technical Assistance



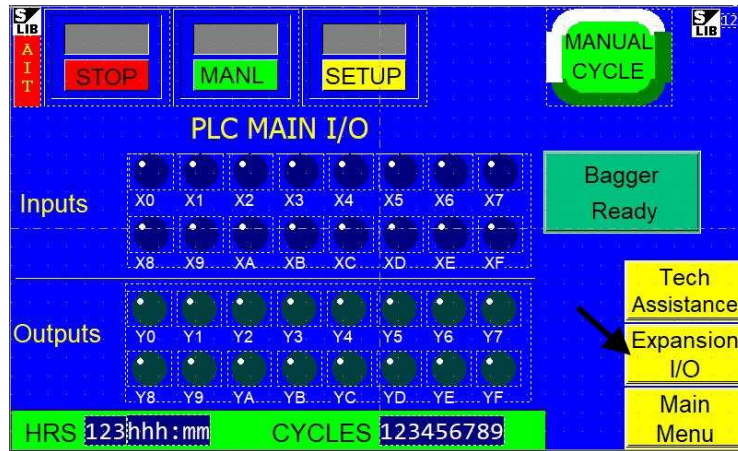
Enter Factory Set Code 1001
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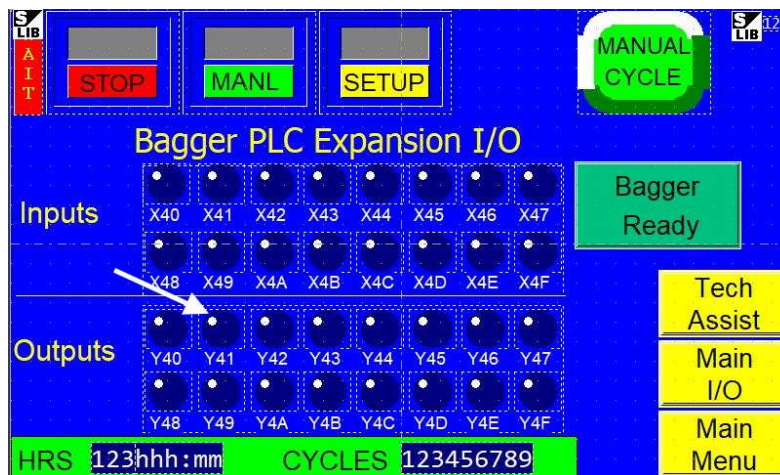
Press the Yellow Button PLC Info



Press the Yellow Button Expansion I/O



Y41 indicates Light Curtain Power is being applied and should be illuminated Green.



X41 should light up Green when the Light Curtain is Interrupted by placing hand between the Light Curtain Transmitter and Receiver; causing the bagger to cycle if the Mode in the Light Curtain Screen was toggled to Green Auto.



CAUTION: To avoid personal injury, do not attempt to disable the Light Curtain option unless a funnel is added that physically blocks the path to the heater bar and pressure bar.