



How To

Service Documents from APPI

Document: #HT000207

Document Title: T-1000S14 Bagger Will Not Cycle

Product(s): T-1000

Procedure:

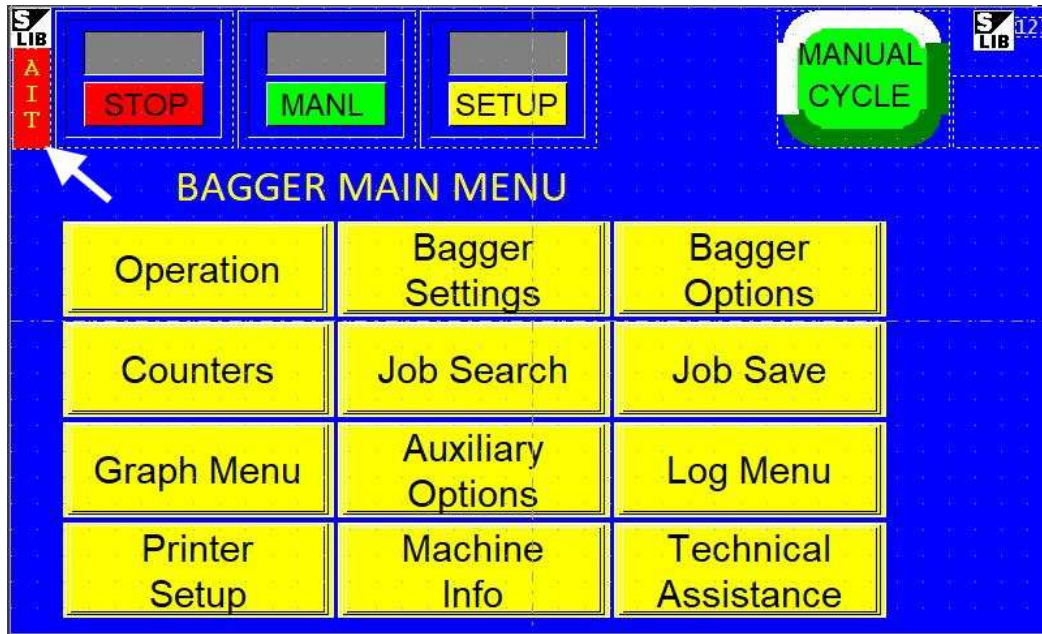
This document only assists with the T-1000 bagger itself. Below are the most common causes that has been found to prevent the T-1000 Bagger from cycling.

If product is placed by hand into the bag and a Foot Switch or pressing the Green Manual Cycle Button is used to cycle the bagger, place the bagger into Start / Manual / Set-Up and press the Green Manual Cycle Button. If the bagger cycles check the following.

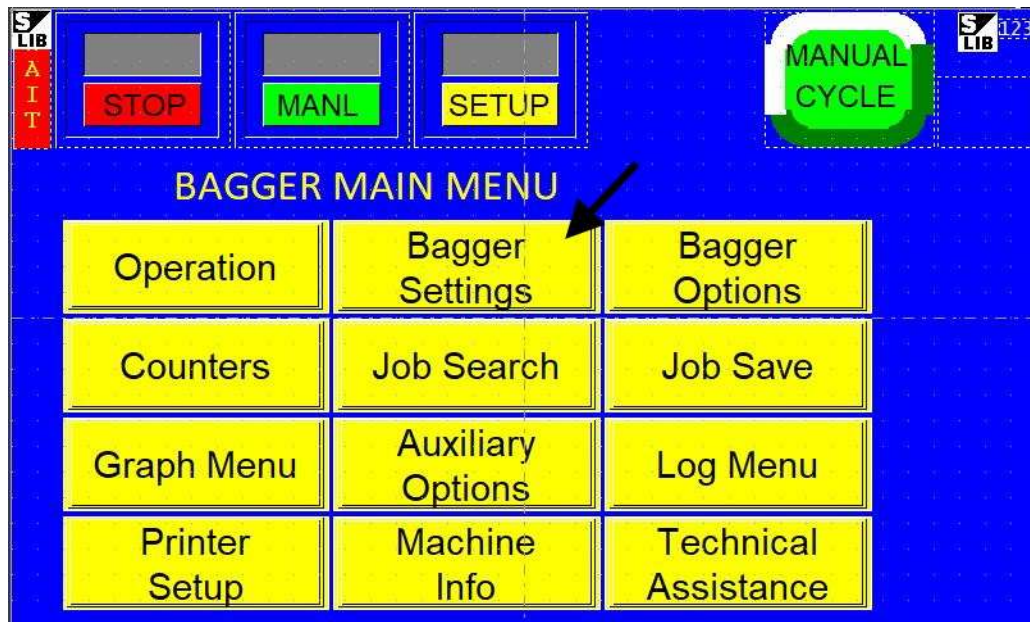
Cause #1

Seal Temperature not in acceptable range

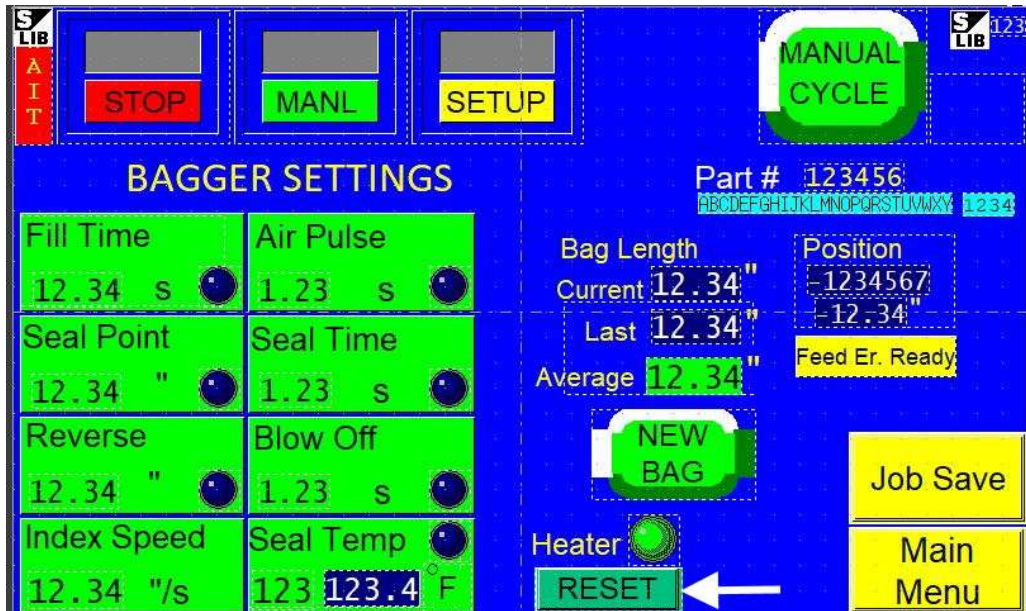
The display button to the left of the Stop/Start Button should be Green Ready.



If the display button to the left of the Stop/Start Button is Red Wait. Press the Yellow Bagger Settings Button.



Press The Heater Reset Button.

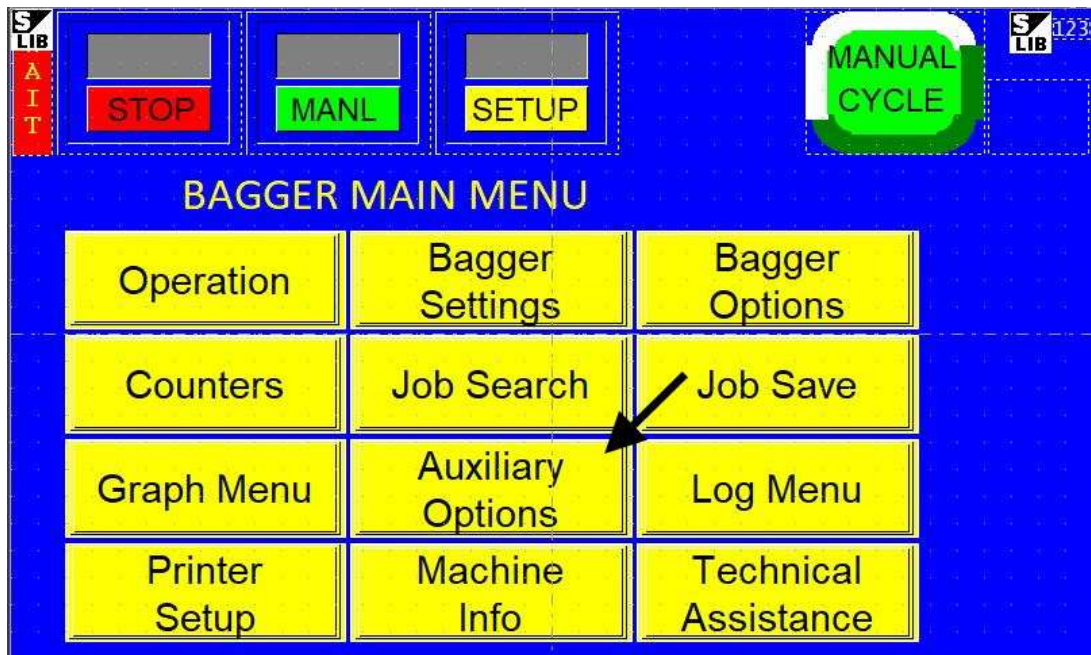


The Seal Temperature should begin to increase. When the Seal Temperature is in range the Red Wait indicator button will turn to Green Ready. Press the Yellow Set-Up Button to toggle to RUN. The bagger should now cycle.

Cause #2

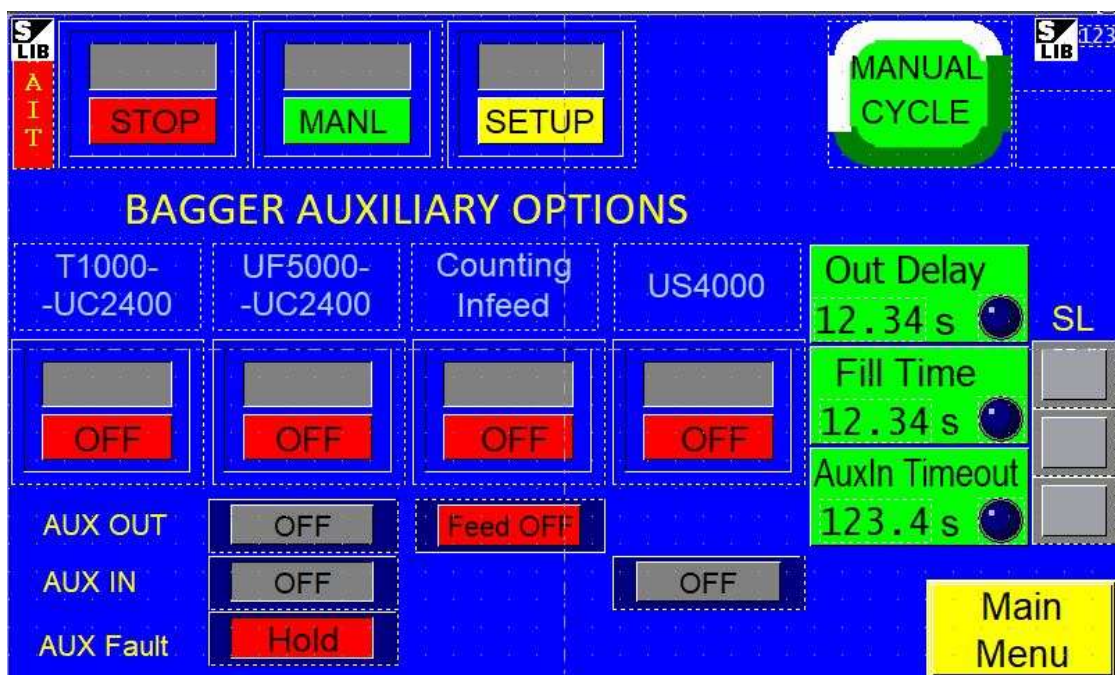
An Auxiliary Option may be ON

If the bagger will not cycle press the Yellow Auxiliary Button.



All Auxiliary Option should be Red OFF. If any Auxiliary Option is Green ON press the Green ON Button to toggle to Red OFF.

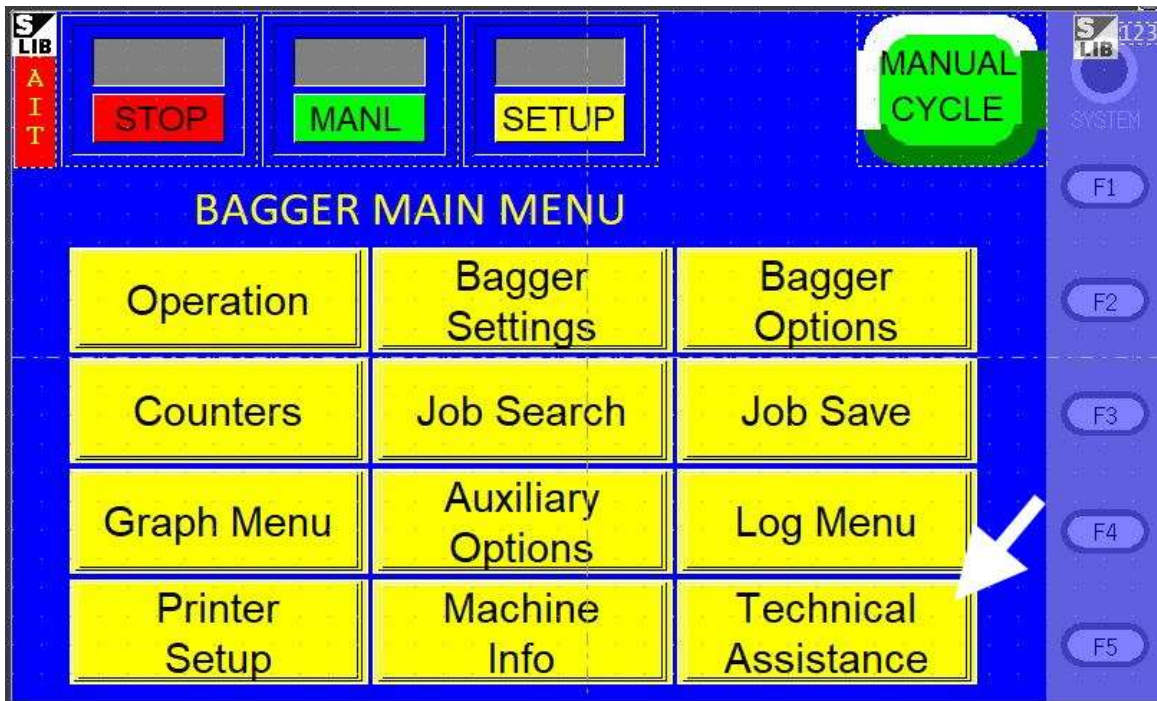
The bagger should now cycle in RUN Mode.



Cause #3

An open in the Anti-Jam Circuit

If the bagger will not cycle press the Yellow Technical Assistance Button.



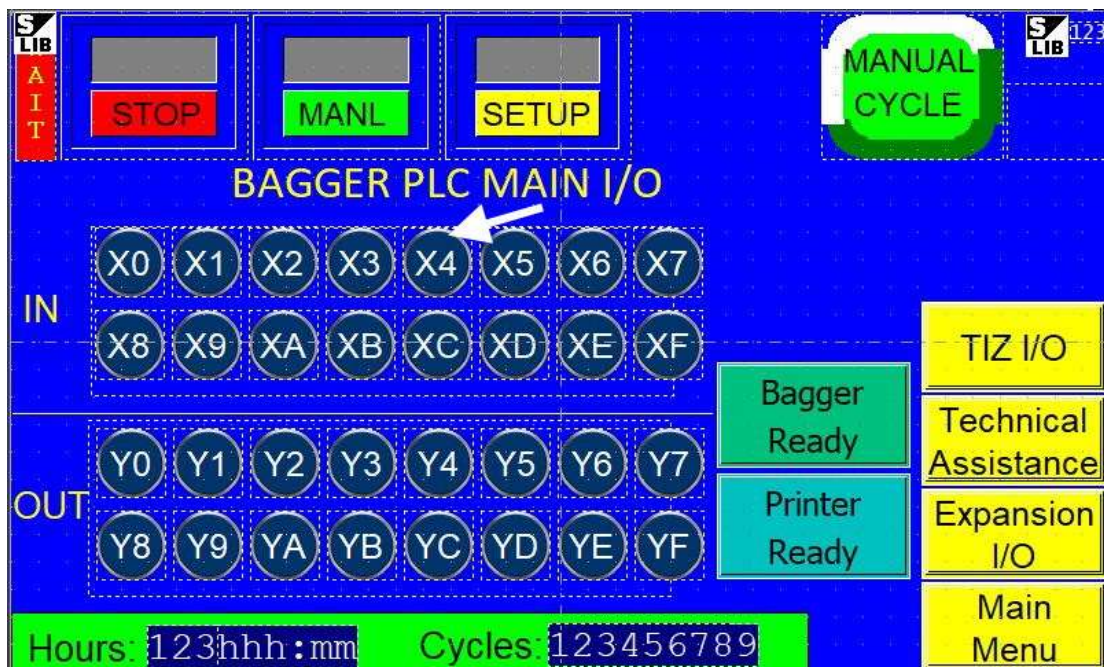
A Keypad will be displayed. Enter the Code 1001 and press Enter on the Keypad.



Press the Yellow PLC I/O Button.



The PLC Input X4 should be lit. If X4 is not lit the bagger will not cycle.



If X4 is not lit check the Anti-Jam Circuit.

The Anti-Jam Circuit is as follows:

Through the Black Seal Bar Coiled Cable connector, through the Black Seal Bar Coiled Cable to the back of the Seal Rods (White Wire) check for loose connection, through the Seal Rod to the Pressure Bar Assembly (check for loose connection), through the Pressure Bar Assembly (check the ¼-20 Acorn nuts for wear and loose connection), through the other Seal Rod to the other side of the Black Coiled Cable (Black Wire) check for loose connection.

See the following Anti-Jam Help Documents on our web page.

**HT000037 - Adjust Anti-Jam on T-1000
HT000038 - Check for Anti-Jam Problems (T-1000)
HT000096 - Replace Coiled Cable (T-1000)**

This document only assists with the bagger itself. Auxiliary infeed equipment, printing systems or other components may cause the bagger to not cycle. This document attempts to isolate the bagger from other options, auxiliary infeed, auxiliary outfeed or possible causes, but this document does not attempt to provide troubleshooting for those other possible causes. However, while attempting to isolate the bagger from other possible causes, the steps may focus your attention on those other system causes.