



How To

Service Documents from APPI

Document: #HT000225

**Document Title: Plug and Play Installation of a Light Curtain on
T-375**

Product(s): T-375

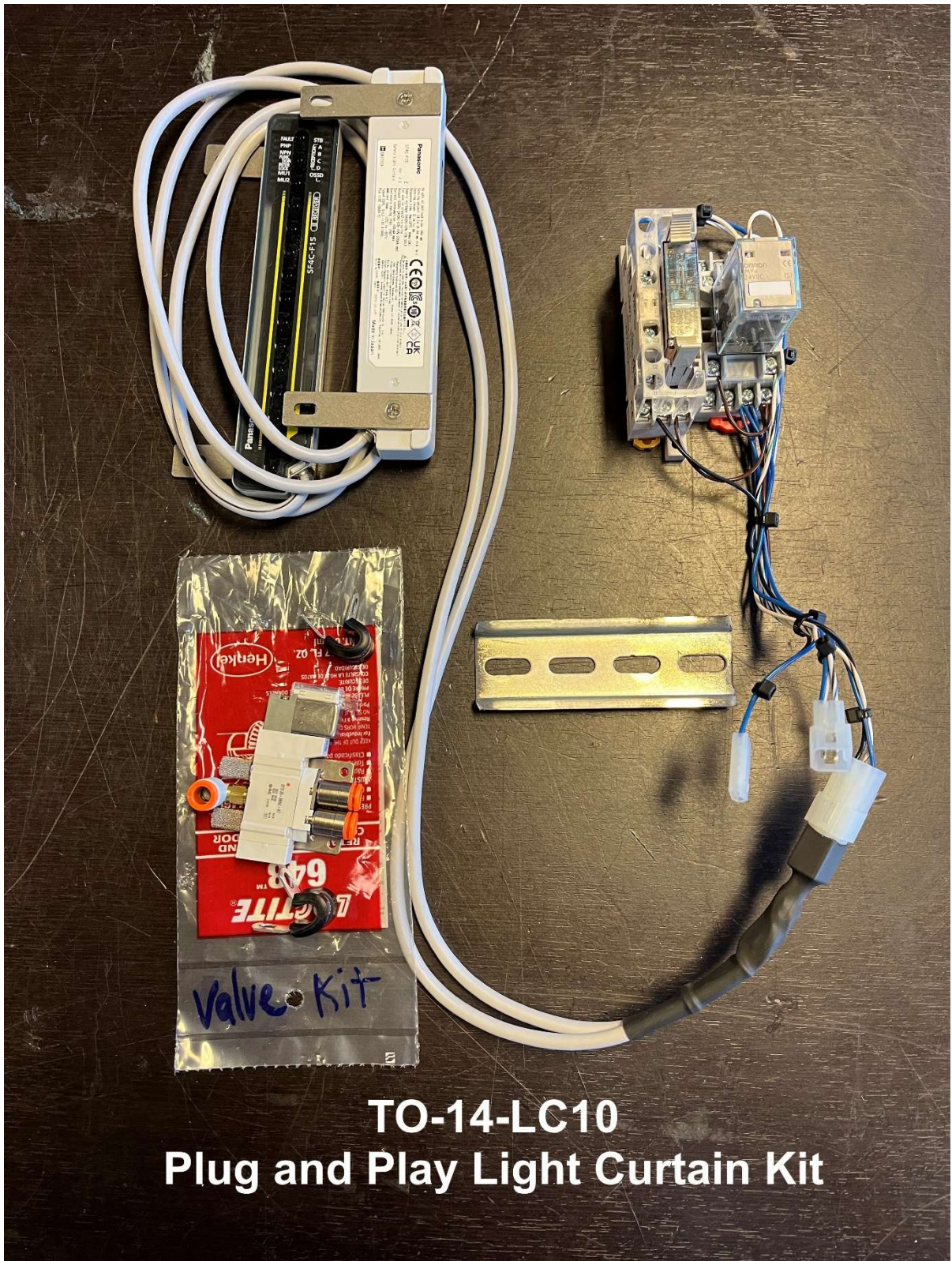
Procedure:

The following instructions are provided to assist in mounting a Light Curtain Assembly to APPI model T-375 Tabletop Bagger/Printer.

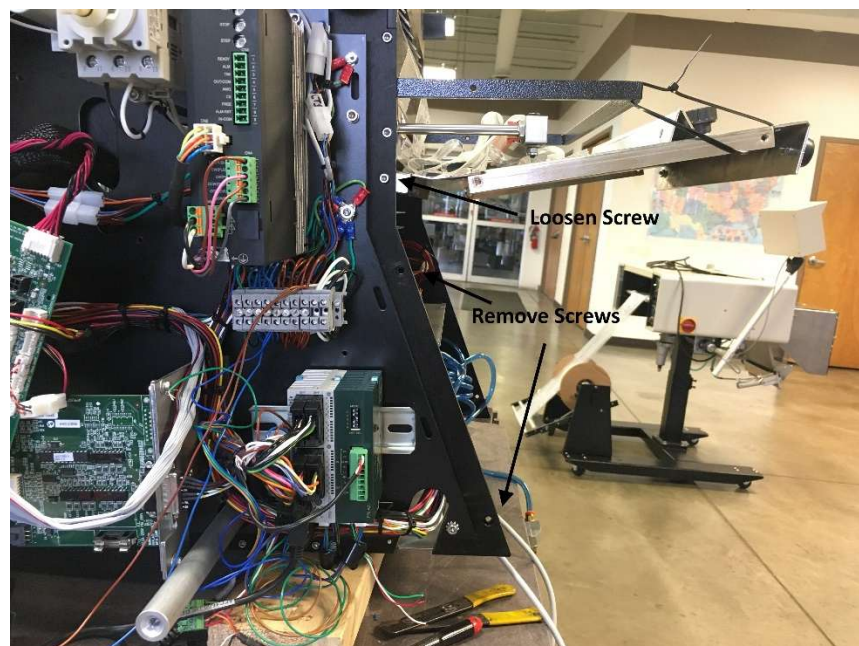
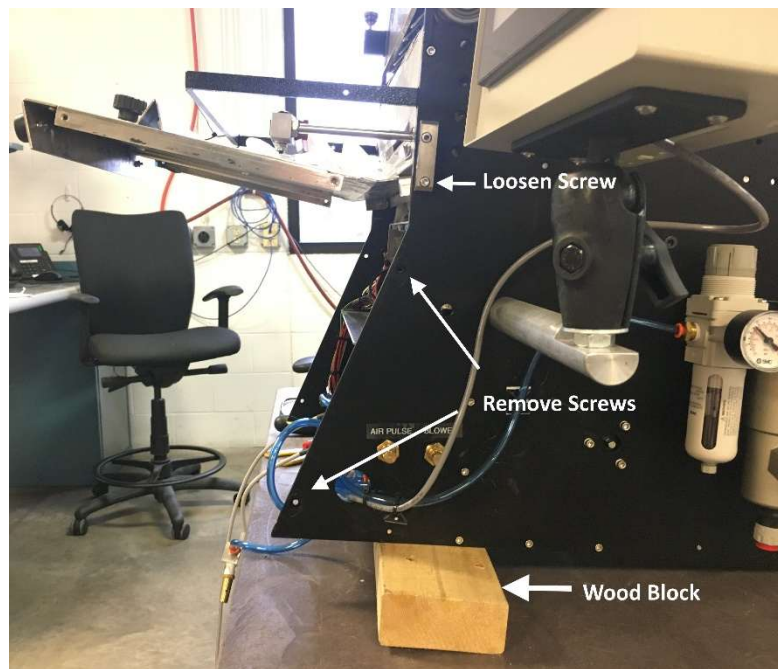
CAUTION: *This procedure should be performed by quality technicians. Ensure power has been removed by unplugging the unit. The Air Line should also be removed. Ensure power cannot be replaced while performing this work. Attempting to perform this work with power attached can result in injury or death. If you are not qualified to perform this work, APPI recommends returning the unit for APPI factory personnel to add the option.*

If you have any questions while performing this work, please contact APPI Service.

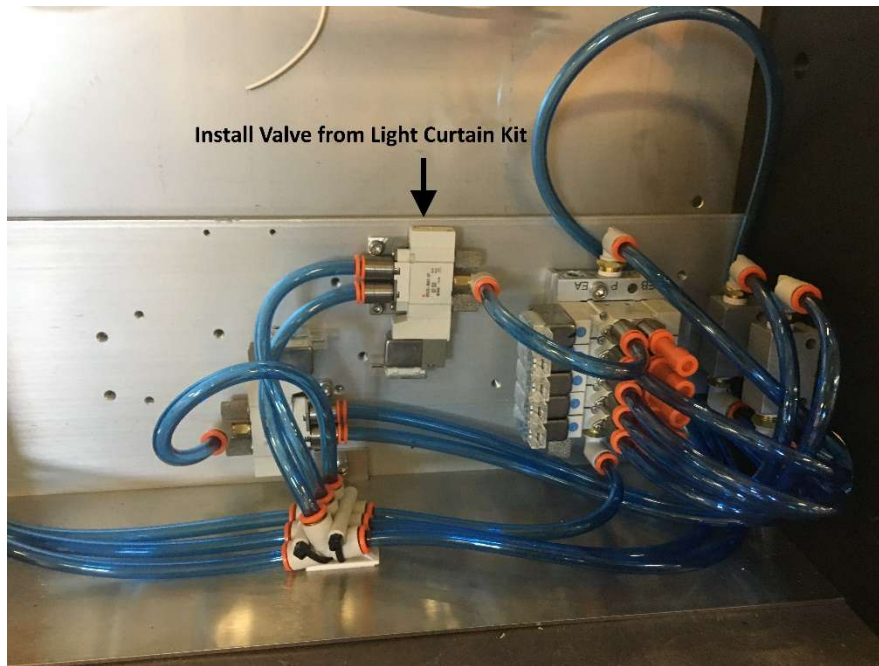
Note: If your T-375 does not have a PLC Expansion Card, then a PLC Expansion Card will have to be ordered separately. Part Number TP-220514



Place a block under the unit. Loosen the Top Socket Head Screws on both sides of the bagger. Remove the bottom 2 Socket Head Screws on each side of the Bagger and raise the Front Panel.

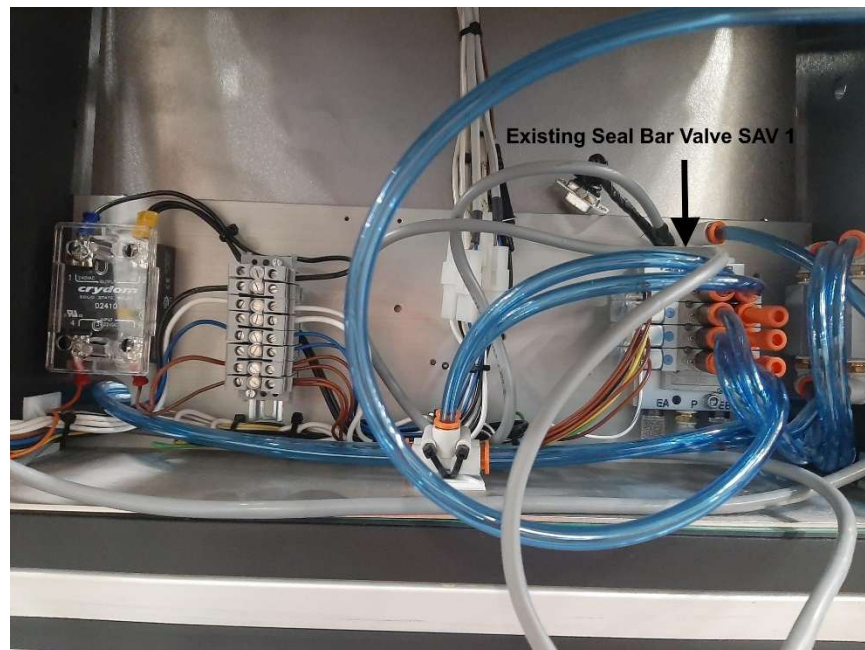


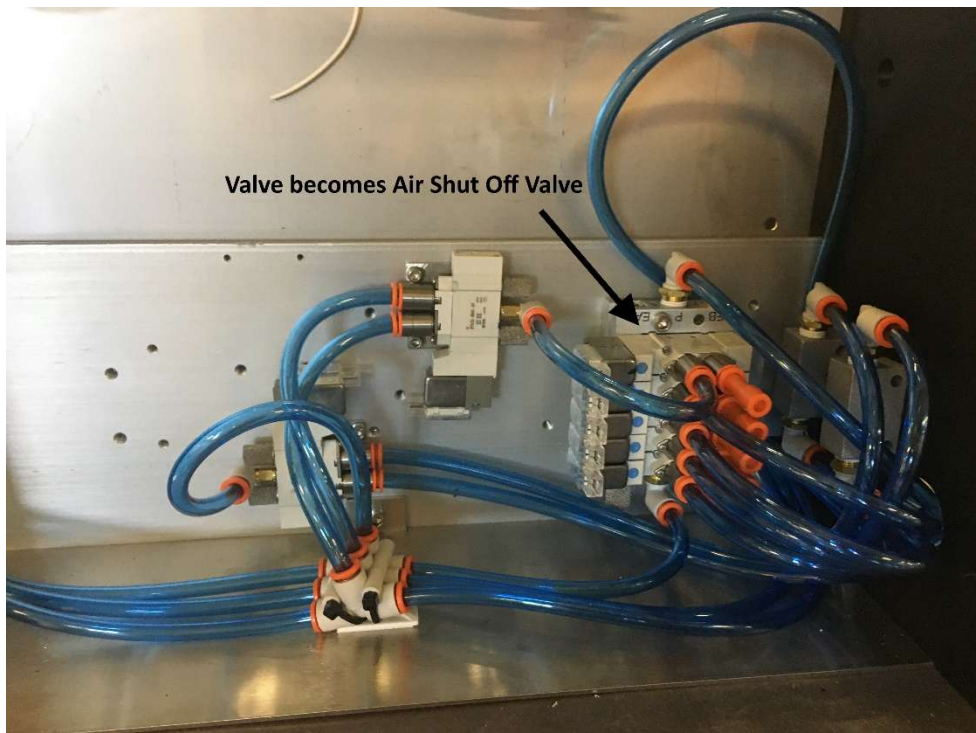
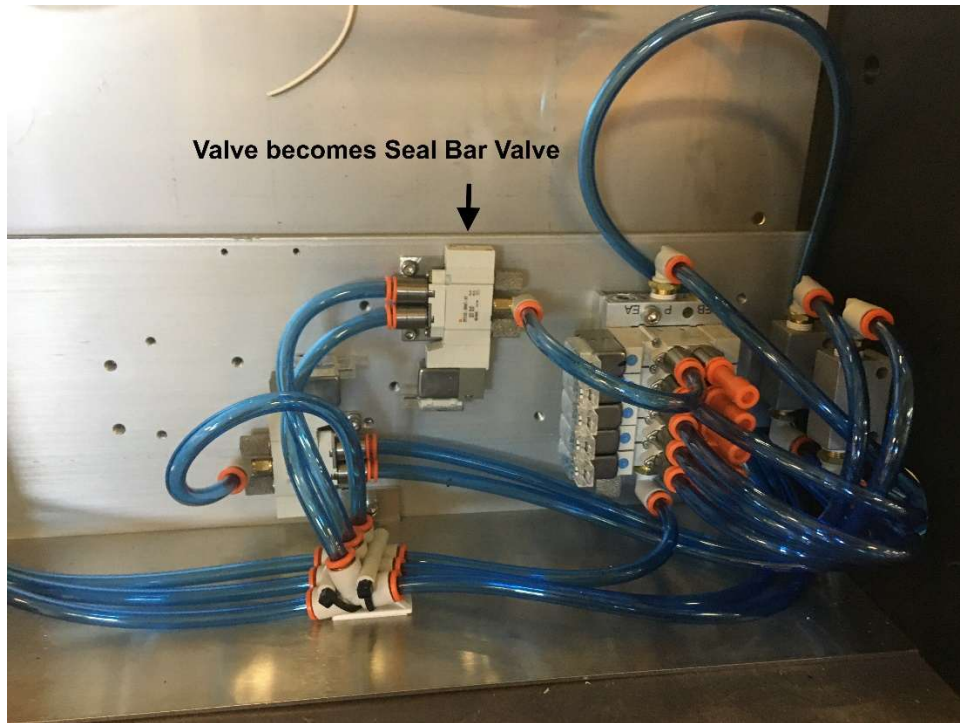
Install Valve from E-Light Curtain Kit



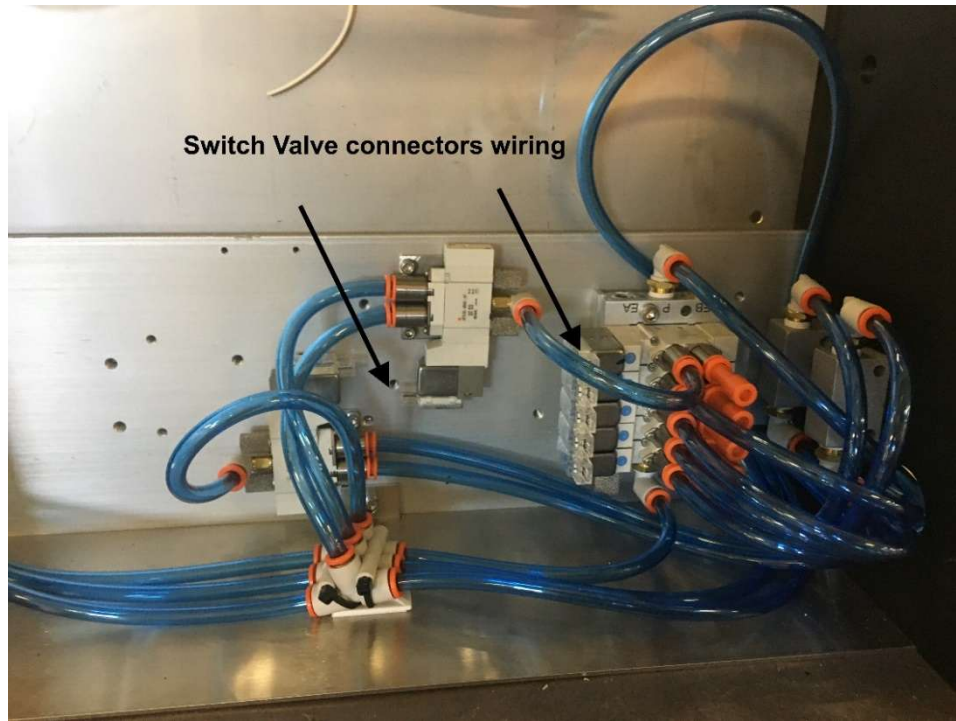
Change Airlines as shown in above picture.

Bottom Picture shows existing Airlines with without added valve.

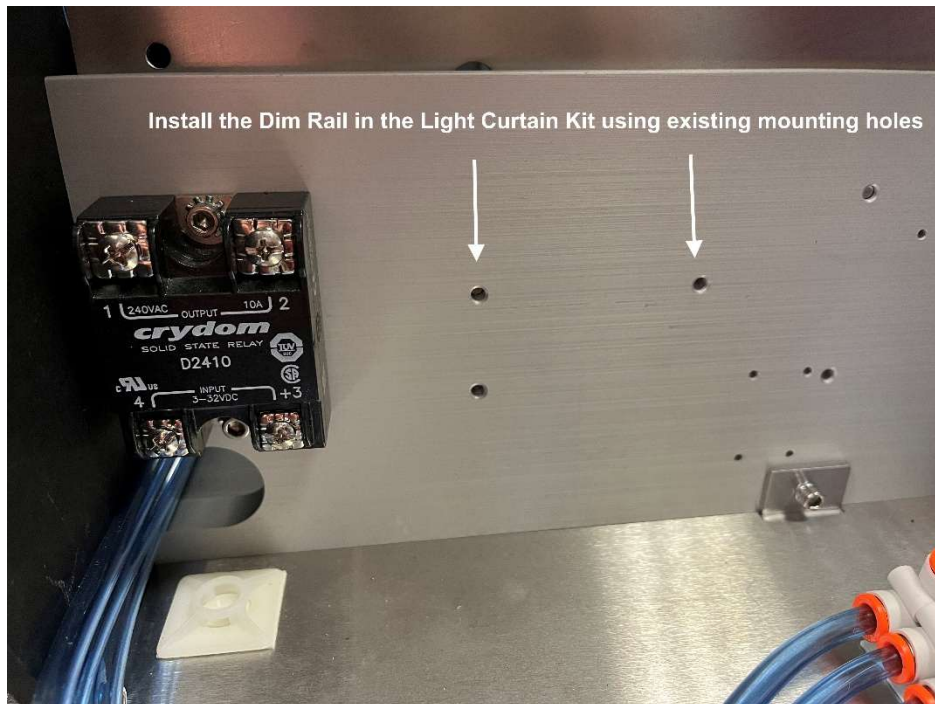


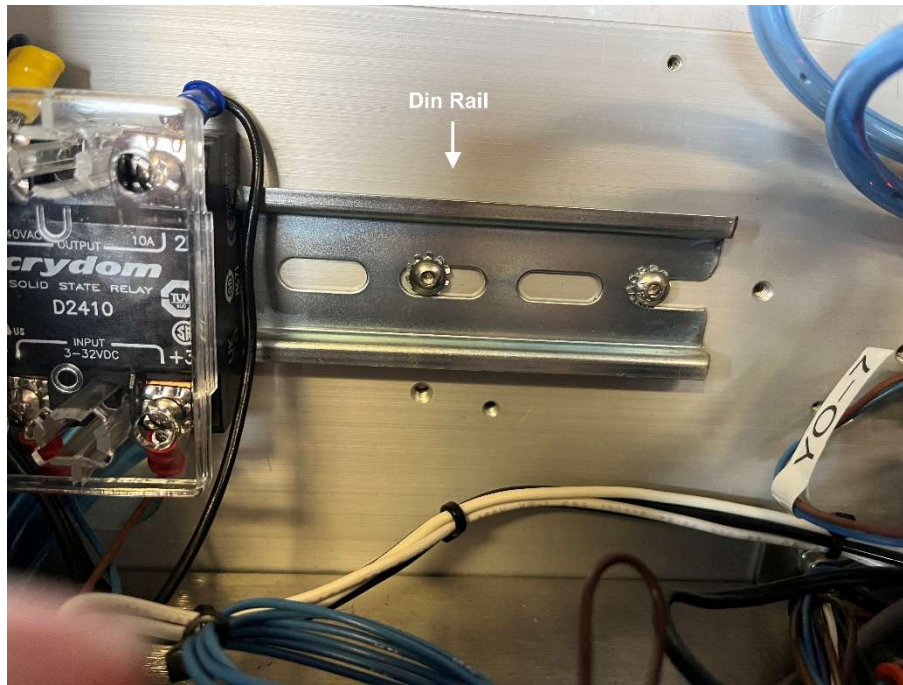


**Remove Valve Connector from Old Seal Bar Valve and connect to New Seal Bar Valve.
Install Light Curtain Valve Connector to the Air Shut-Off Valve**

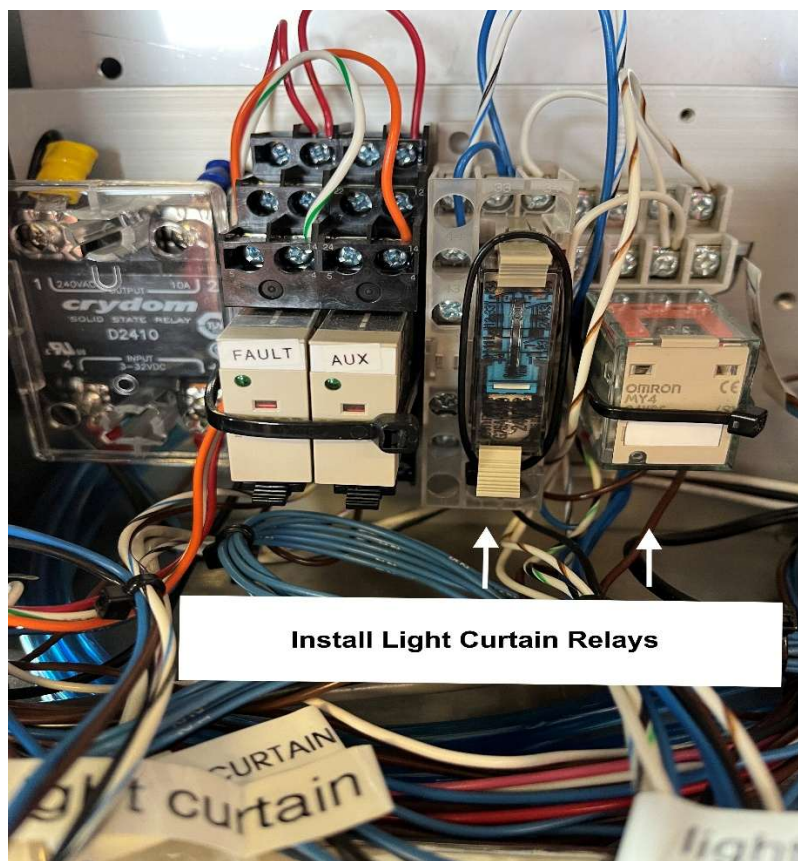


Install the Dim Rail in the Light Curtain Kit using existing mounting holes

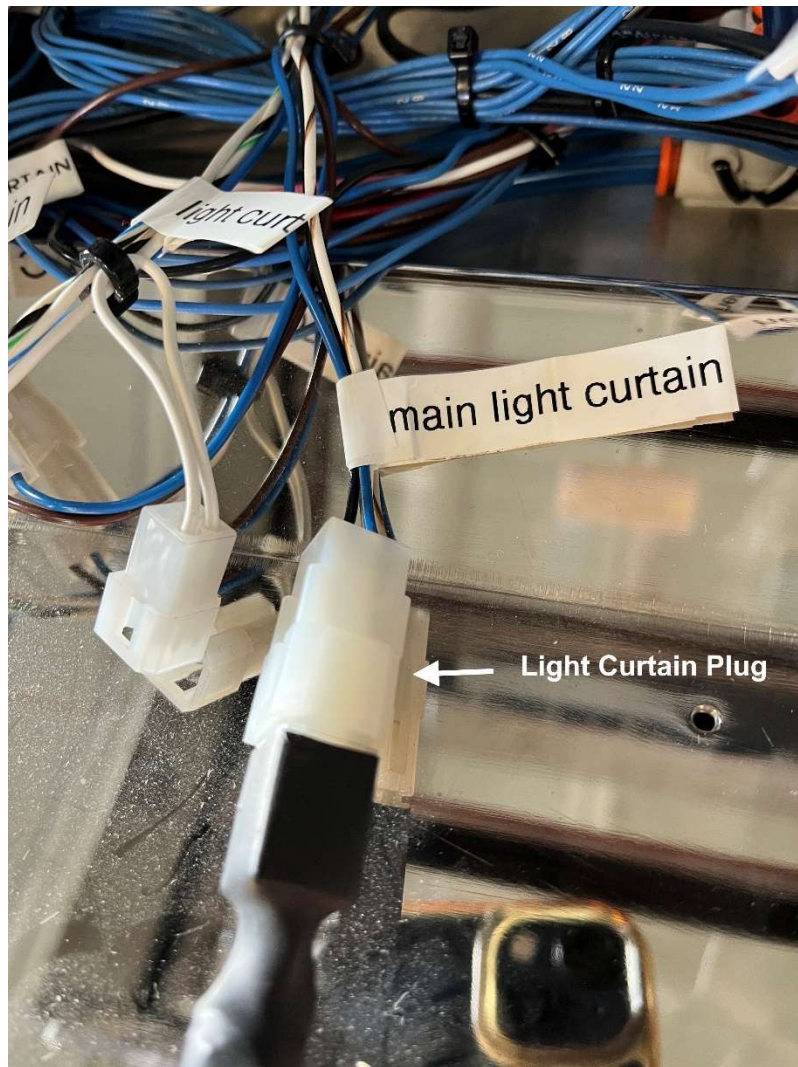




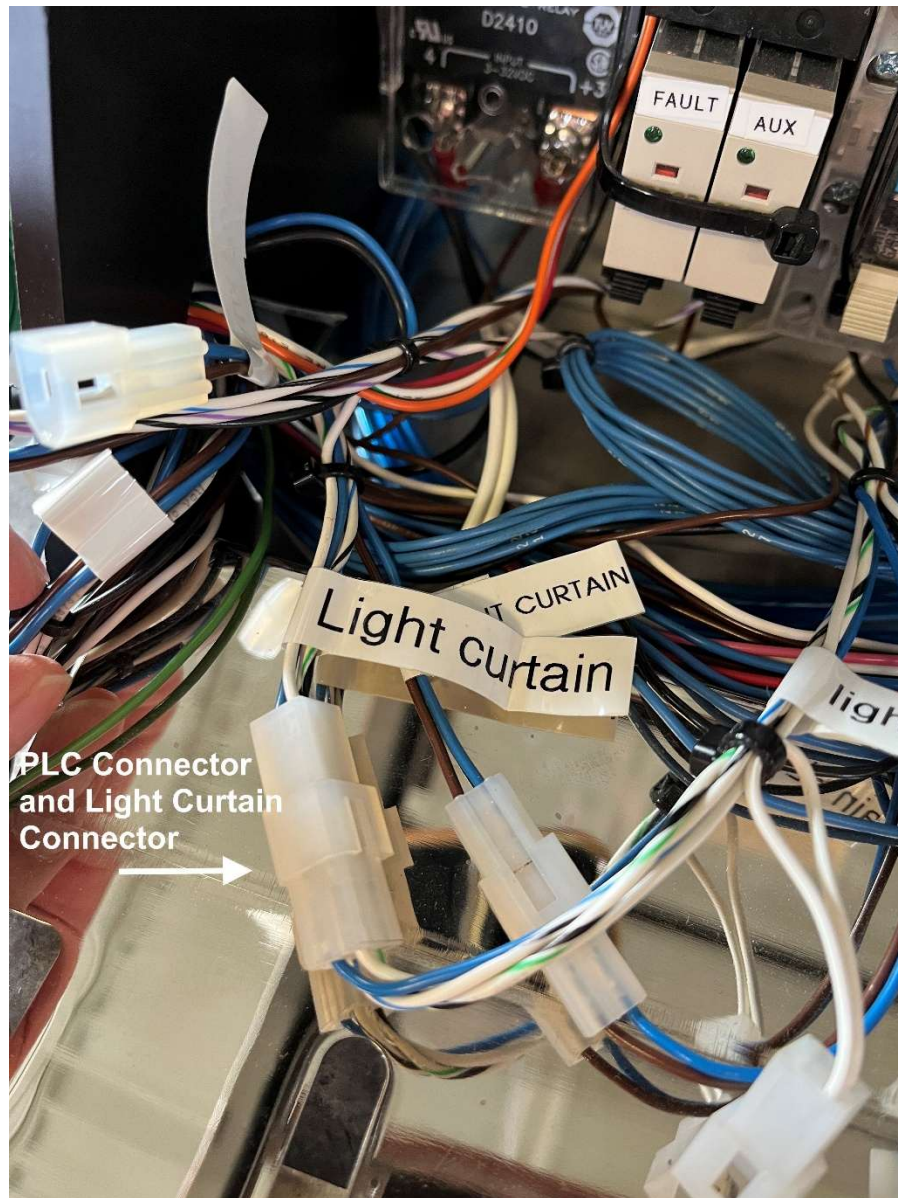
Install Light Curtain Relays



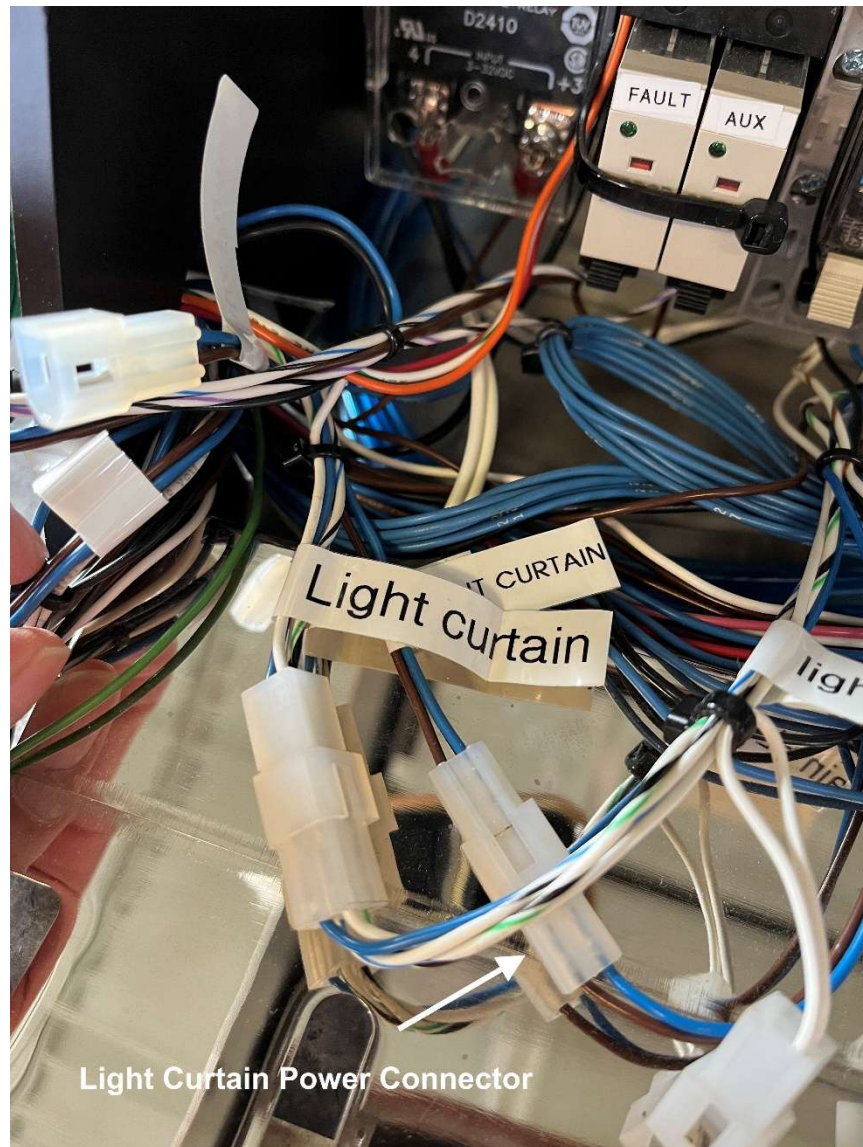
Connect the Main Light Curtain Plug



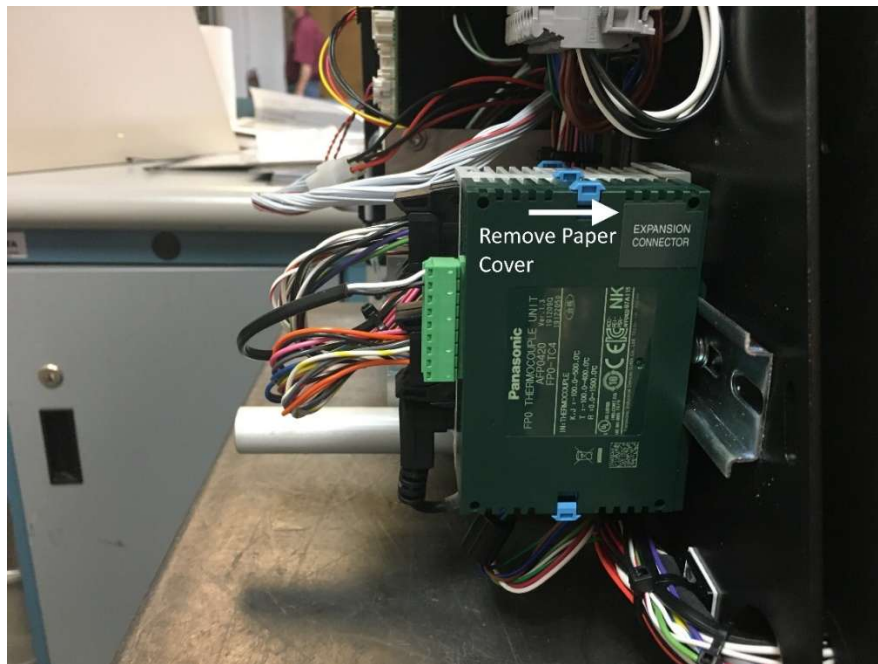
Connect the Plug from the PLC to the Plug from the Light Curtain



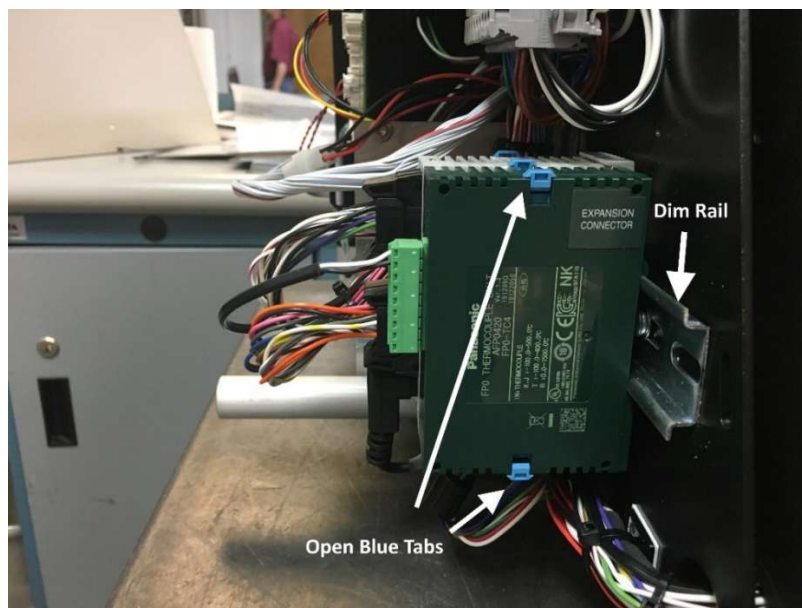
Connect Light Curtain Power Plugs



Remove Paper Coving Over Connector on Analog Card



Open Blue Tabs



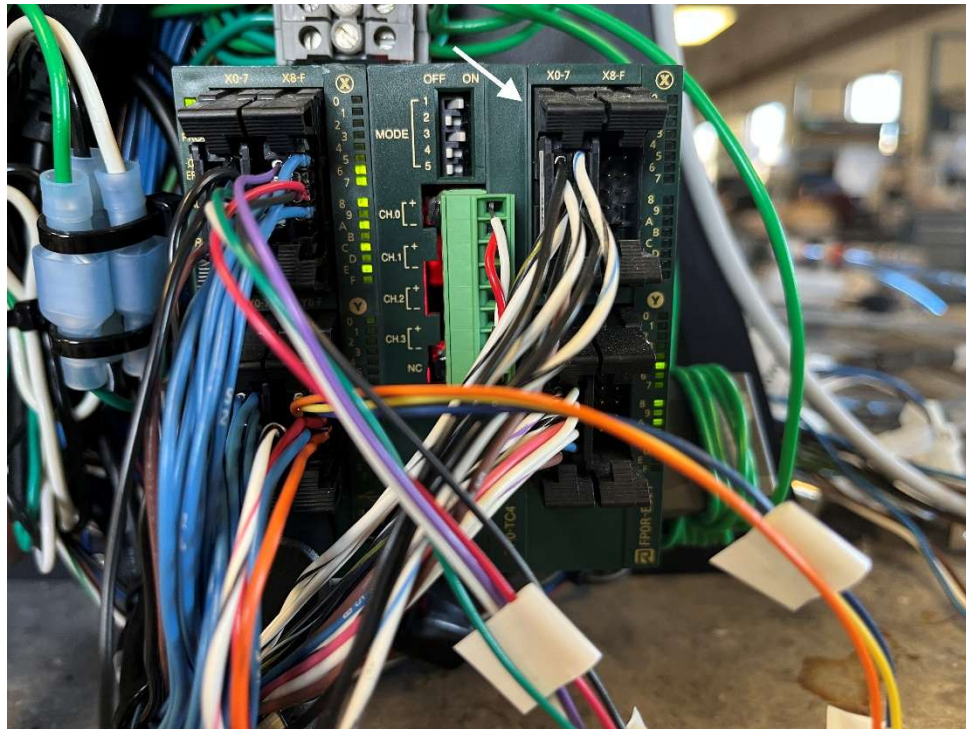
Pull Blue Tab down at bottom of Expansion Card and mount on Dim Rail



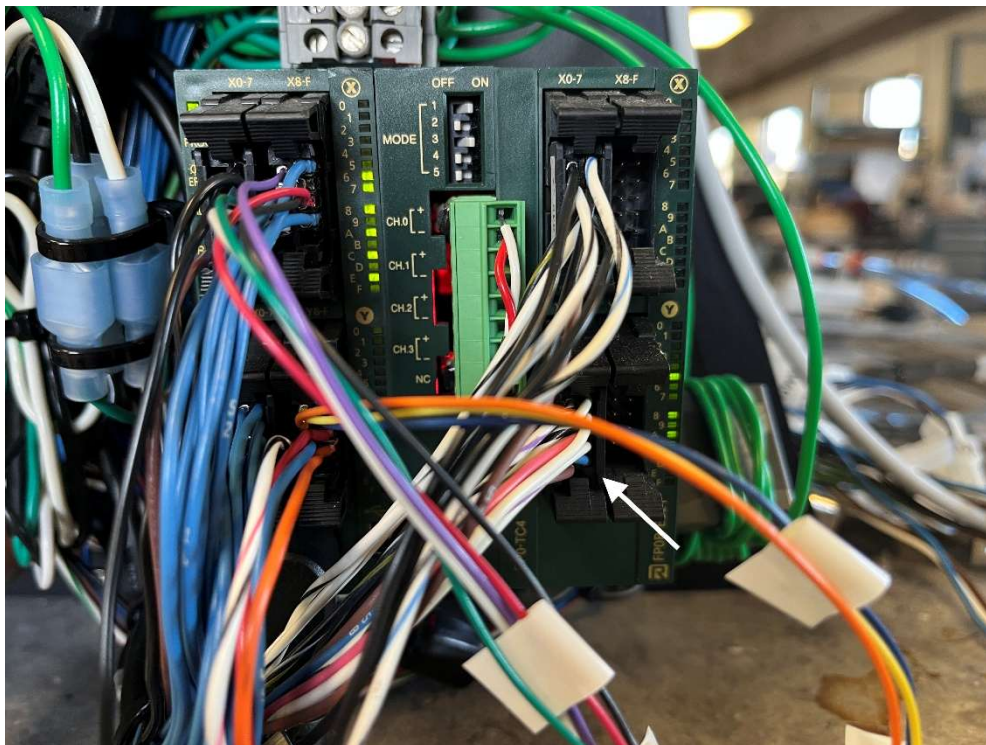
After Mounting Expansion Card on Dim Rail, Plug the Expansion Card from Light Curtain kit into Analog Card and Push the small Blue tabs down to lock into place.

Push the Large Blue Tab up to lock on to Dim Rail

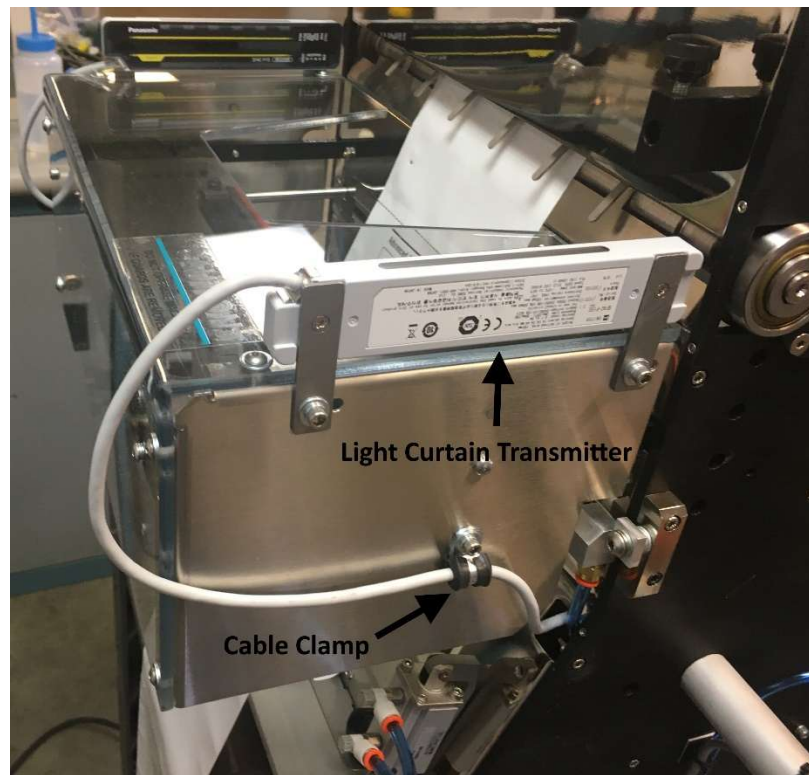
Plug PLC connector X40-X47 into the upper left-hand connector of the Expansion Card



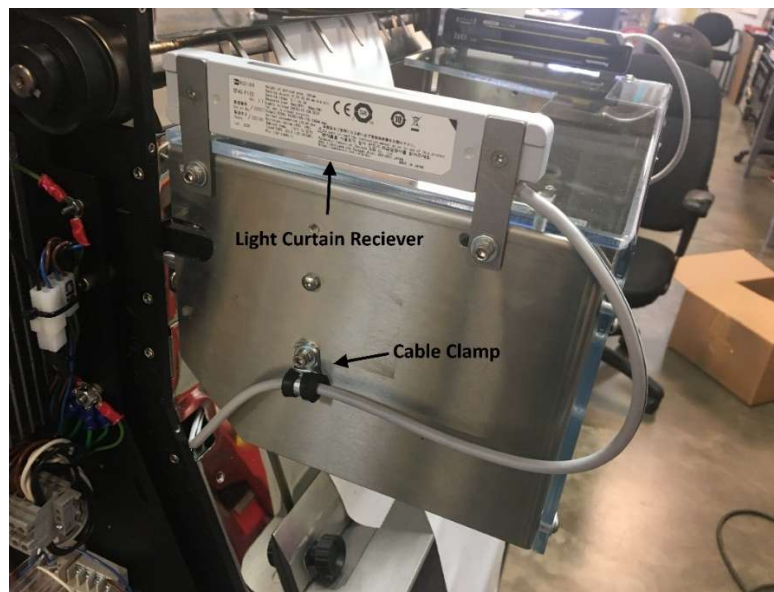
Plug PLC connector Y40-Y47 into the Lower left-hand connector of the Expansion Card



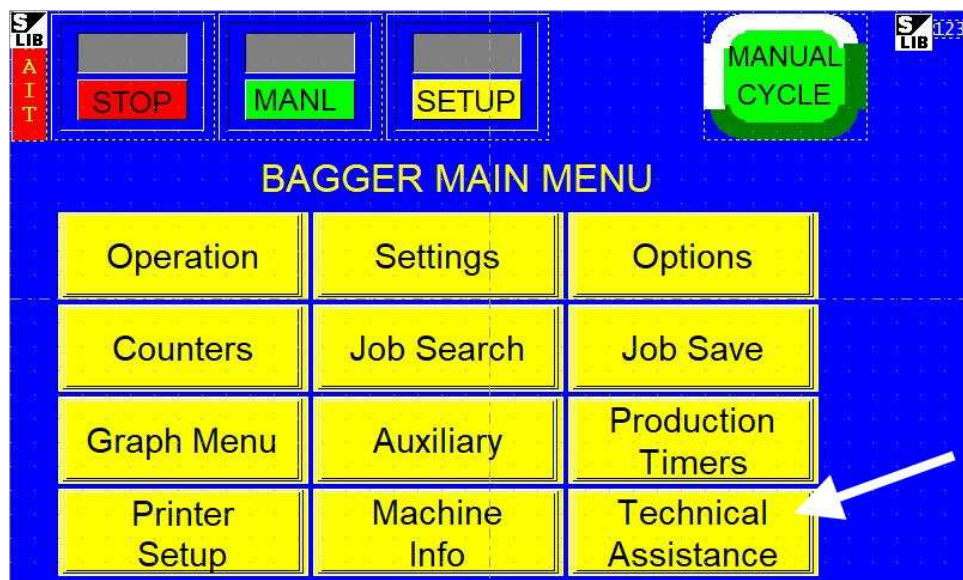
**Mount Light Curtain Transmitter on the Right Side of the Lexan Guard.
The Transmitter and Receiver are labeled.**



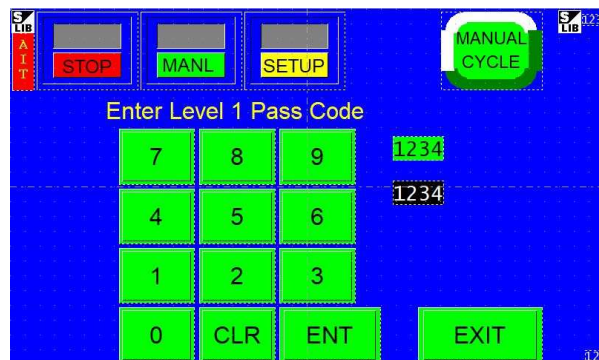
Mount Light Curtain Receiver on the Left Side of the Lexan Guard



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



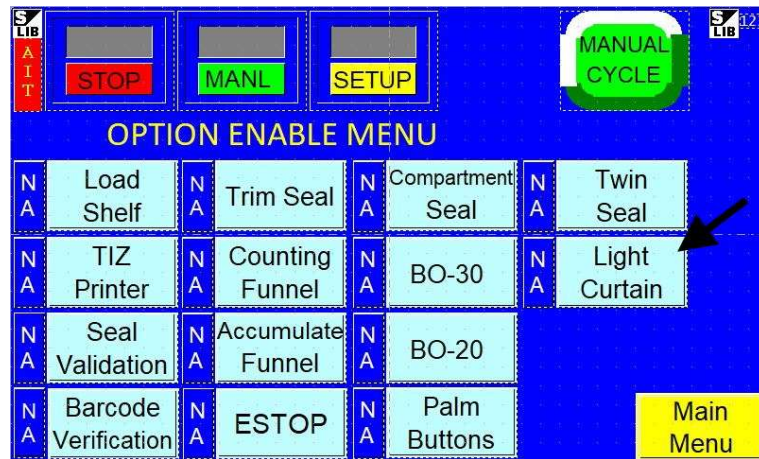
Enter Factory Set Code 1001
If Factory Code 1001 does not work call APPI for Assistance



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



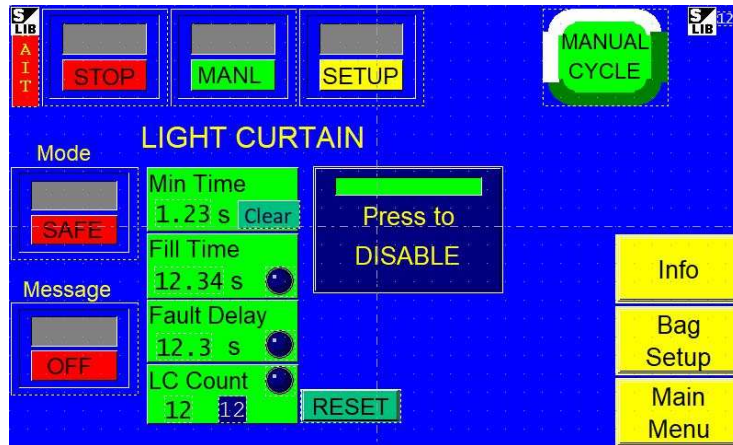
Min Time 0.3

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**



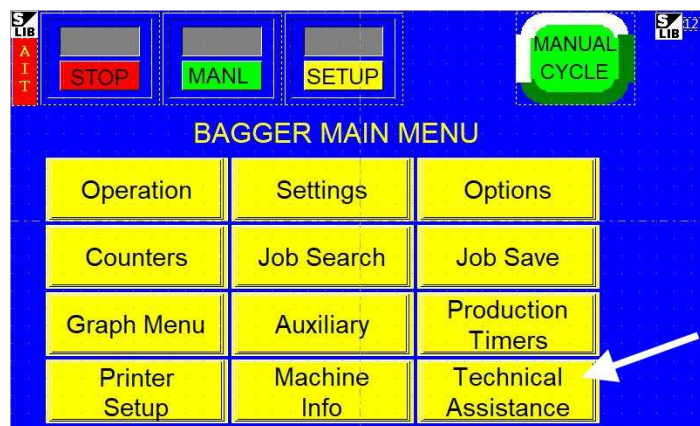
In Auto Mode breaking the Light Curtain circuit 1 time will cause the bagger to cycle. If LC Count is changed to 2 then breaking the Light Curtain circuit twice will cause the bagger to cycle.

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

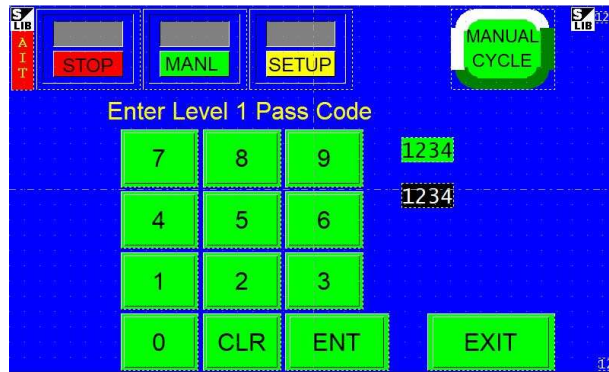
CAUTION: *Do not turn ON power until all covers are replaced.*

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.



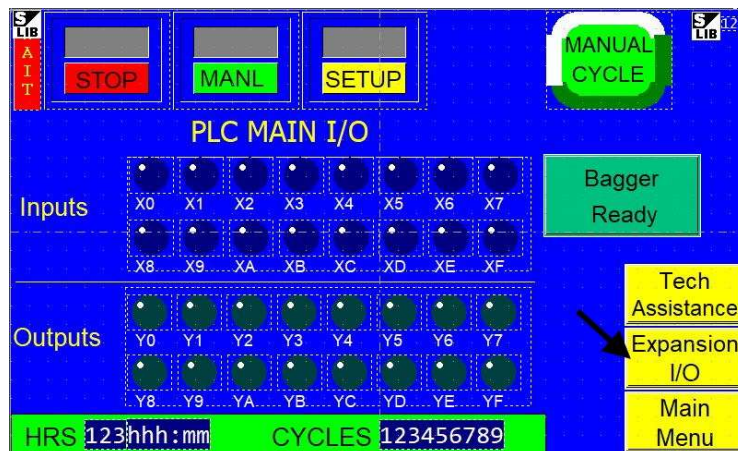
Enter Factory Set Code 1001
If Factory Code 1001 does not work call APPI for Assistance



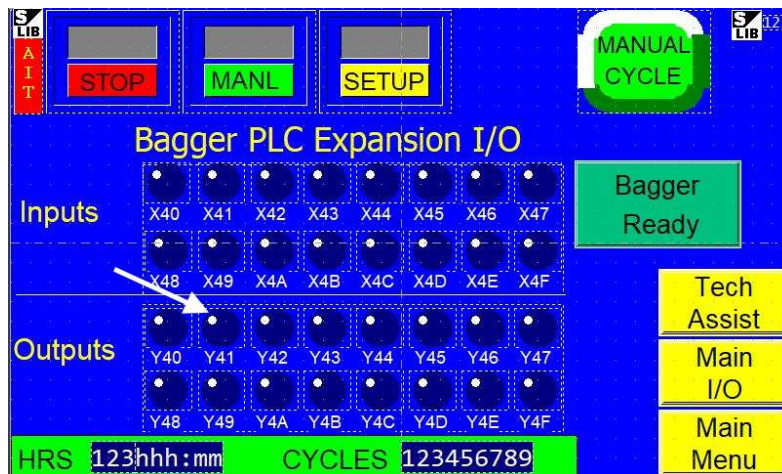
Press the Yellow Button PLC Info



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.

TO-T14-LC10 Light Curtain Bill of Materials

User: Charles

Bill of Material Report Advanced Poly-Packaging, Inc. Indented Level

Page: 1
Date: 10/18/2021
Time: 3:54:34:54:34 PM pm

Lvl Type	Seq Part Number	Revision	Alt	Description	Qty/Parent	Required Qty
	TO-T14-LC10	D		Light Curtain Safety Kit (T-30		1.000 EA
1 Asm	10 TO-T14-LC10-FA	A		Fasteners, LC10 Light Curtian,	1.000 EA	1.000 EA
2 Mtl	10 TP-101103			Nut, 8-32 Hex Mach Screw SS	6.000 EA	6.000 EA
2 Mtl	20 TP-102133			Washer,#8 SAE Flat	10.000 EA	10.000 EA
2 Mtl	30 TP-102152			Washer, #6 Med Split Lock	2.000 EA	2.000 EA
2 Mtl	40 TP-102153			Washer, #8 Med Split Lock	6.000 EA	6.000 EA
2 Mtl	50 TP-103182			Screw, BHCS 8-32 x 5/8 S.S.	6.000 EA	6.000 EA
2 Mtl	60 TP-103195			Screw, BHCS 8-32 x 5/16	2.000 EA	2.000 EA
2 Mtl	70 TP-103207			Screw, BHCS 6-32 x 3/8	2.000 EA	2.000 EA
2 Mtl	80 TP-103212			Screw, BHCS 8-32 x 1/2 S.S.	6.000 EA	6.000 EA
2 Mtl	100 TP-214259			Shrink Tubing, 1/16" ID; 2:1;	1.000 EA	1.000 EA
2 Mtl	110 TP-214260			Shrink Tubing, 1/8" ID; 2:1; B	1.000 EA	1.000 EA
2 Mtl	120 TP-214262			Shrink Tubing, 3/8" ID; 2:1; X	1.000 EA	1.000 EA
2 Mtl	130 TP-218020			Din-3 Rail, (Thick) 35mm x 7.5	1.000 EA	1.000 EA
1 Mtl	20 TP-208141			Small Terminal Clip, Gray Bloc	6.000 EA	6.000 EA
1 Mtl	30 TP-208374			Clamp, Rubber Cushion Steel Lo	2.000 EA	2.000 EA
1 Mtl	50 TP-215020			14-Pin MY4 Series Relay Socket	1.000 EA	1.000 EA
1 Mtl	60 TP-215021			Relay, 4PDT, 24VDC, General Pu	1.000 EA	1.000 EA
1 Mtl	70 TP-216153			Relay; Electro-Mechanical; Saf	1.000 EA	1.000 EA
1 Mtl	80 TP-216154			Relay, Socket, PCB, 4-Pole, 24	1.000 EA	1.000 EA
1 Mtl	90 TP-216188			Light Curtain, Panasonic (SF4C	1.000 EA	1.000 EA
1 Mtl	100 TP-401277			1/4" Elbow Air Fitting,10-32	1.000 EA	1.000 EA
1 Mtl	110 TP-401278			1/4" Orange Plug	1.000 EA	1.000 EA
1 Mtl	120 TP-401288			Grey 2-Pin, SY3120 Valve Conne	1.000 EA	1.000 EA
1 Mtl	130 TP-401289			Crimp Pins for TP-401288 Grey	2.000 EA	2.000 EA
1 Mtl	140 TP-402175			Air Valve Bracket, SX3000-16-1	1.000 EA	1.000 EA
1 Mtl	150 TP-402255			Valve, 5-Port Solenoid, w/ 1/4	1.000 EA	1.000 EA
1 Mtl	160 TP-404263			Muffler / Silencer for Pneumat	2.000 EA	2.000 EA
1 Mtl	170 TP-LC002	A		Light Curtain Eye Bracket, Pan	4.000 EA	4.000 EA