

How To

Service Documents from APPI

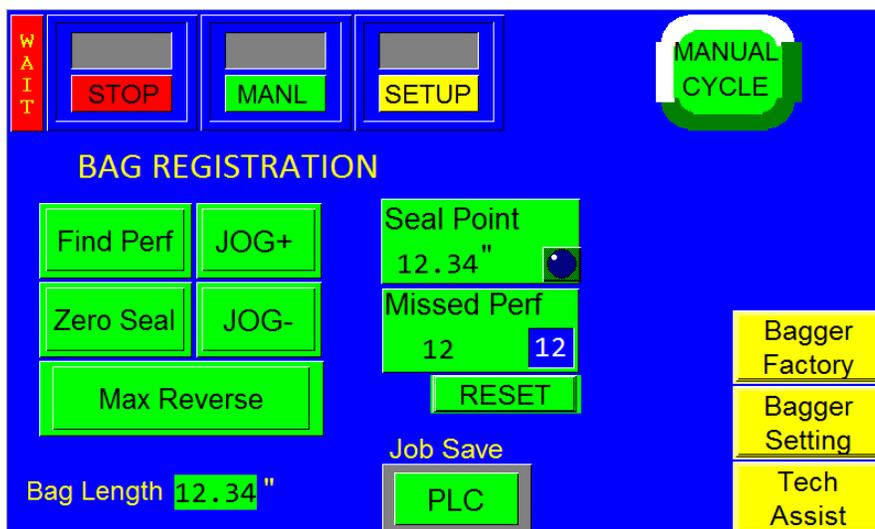
Document: #HT000089

Document Title: Bag Registration

Product(s): T-1000

Procedure:

Proceed from the “Main Menu”, through “Tech Assistance” and “Bagger Factory Settings”, to the “Bag Registration Screen”. This screen allows the operator to set up the perforation. *Note: the default Level One Pass Code is “1001”.*



To determine if the **Seal Point** is registered, set the **Seal Point** setting to the lowest possible setting. Then press the “Manl” cycle button or press the foot switch. The bag should move so that the perforation is approximately **1/8"** from the center of the heater bar. If the bag perforation is not approximately **1/8"** from the perforation, perform the following procedure carefully. If these steps are performed out of order, the bagger will not function properly.

Follow these steps to set up the perforation:



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1. Press the “**Perf Registration**” button on the “**Bagger Factory Settings**” screen. The “**Bag Registration Screen**” will be displayed.
2. Press the “**Find Perf**” button. The bagger will advance until the perforation sensor finds the perforation, and then the bag will stop.
3. Hold the “**JOG+**” button until the perforation moves down to the middle of the PTFE Anti-Stick sheet area at the heater bar.
4. Release the “**JOG+**” button.
5. Push the “**Zero Seal**” button once.
6. Hold the “**JOG-**” button until the perforation moves up to just in front of the nip rollers.
7. Push the “**Max Reverse**” button once.

Note: If these steps are performed incorrectly, repeat from Step 1. When complete, test the Seal Point setting by entering 0.1" and pressing the “Manual Cycle” button. The bag should feed so that the perforation is approximately 1/8" from the center of the heater bar.

Since the procedure set the maximum reverse value as well, enter **6"** in the **Max Reverse** setting. If equipped with a standard frame bagger, this setting will be approximately **1.8"** when the **Seal Point** setting is **0.1"**. On a drop frame machine, the maximum setting will be approximately **2.7"** when the **Seal Point** setting is **0.1"**. Press the **Manual Cycle** button and ensure that the bag does not reverse too far, to drop inside the machine. After successfully performing the above steps, the “**Bag Registration Screen**” is ready for bag indexing.

Missed Perf: The maximum number of perforations the sensor can miss before operation stops and an error message is displayed. To adjust this setting, press the “**Missed Perf**” button, enter the desired value on the numeric keypad and press the “**ENT**” button.