



How To

Service Documents from APPI

Document: #HT000090

Document Title: Replace PTFE Anti-Stick Sheet

Product(s): T-200/275

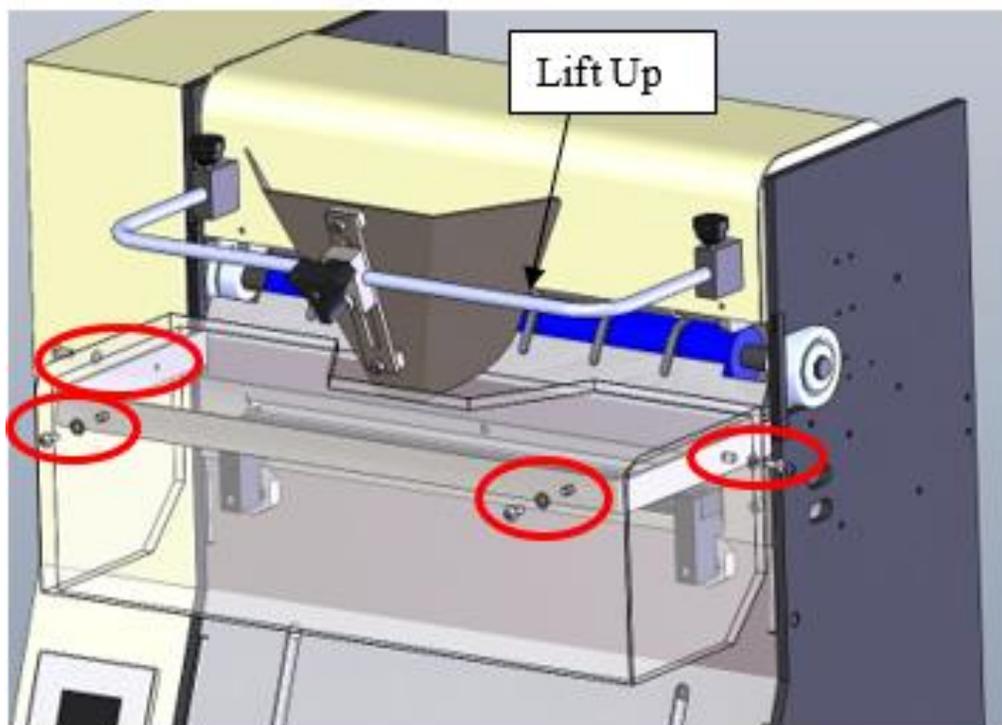
Procedure:

Turn **Main Power OFF**, unplug power cord, and disconnect air from unit.

Remove Stainless Steel Cover from back of machine.

Lift the funnel assembly and top cover upward.

Remove four screws from the guard assembly and remove the Lexan Guard.



Allow the sealer mechanism to cool for at least 30 minutes.

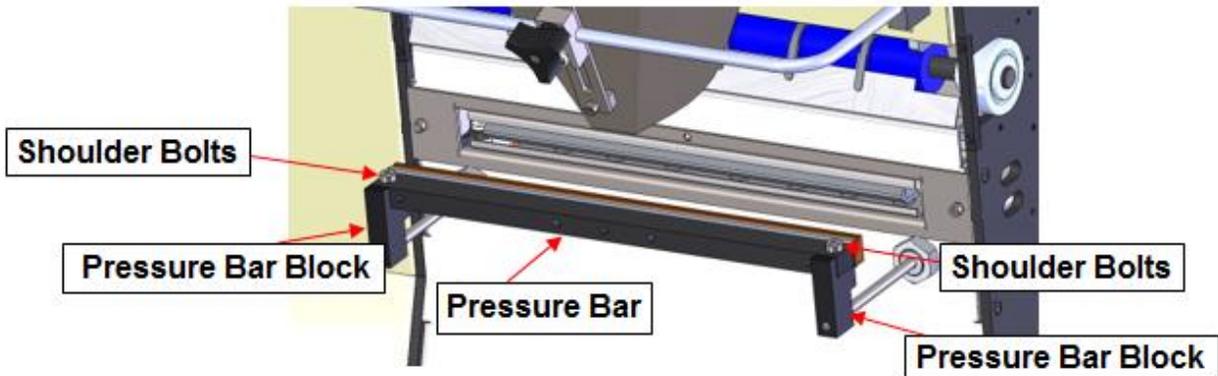


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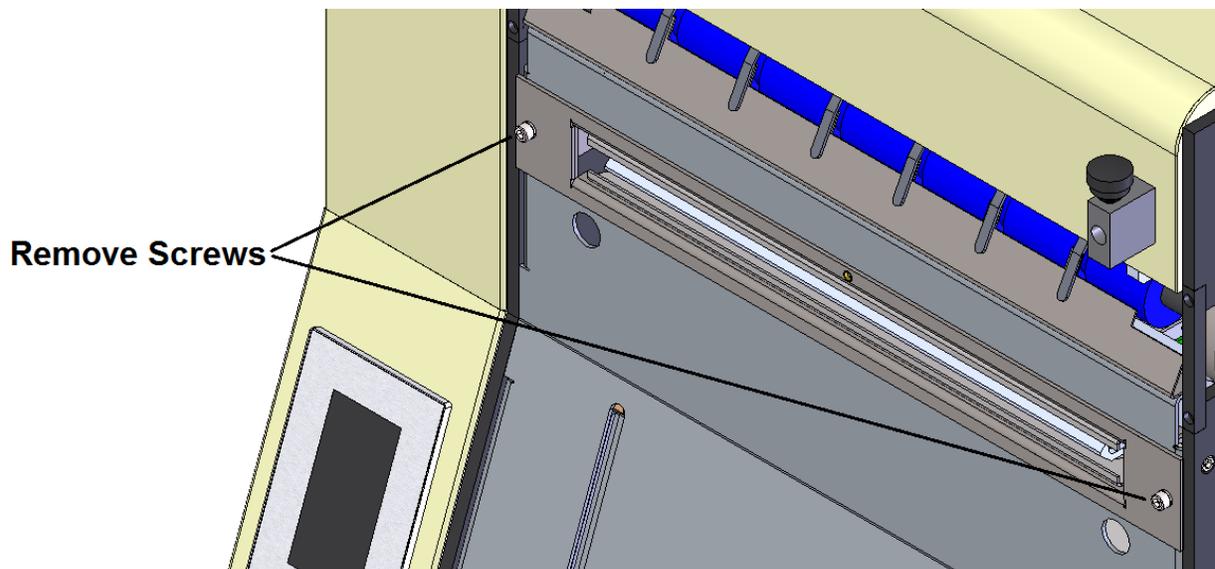
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Remove the two shoulder bolts from the **Pressure Bar**.

Remove the **Pressure Bar** and turn down the black **Pressure Bar Blocks**.



Remove the two screws located on the right and left side of the **Seal Bar** which hold the **Seal Assembly Mechanism** in place.

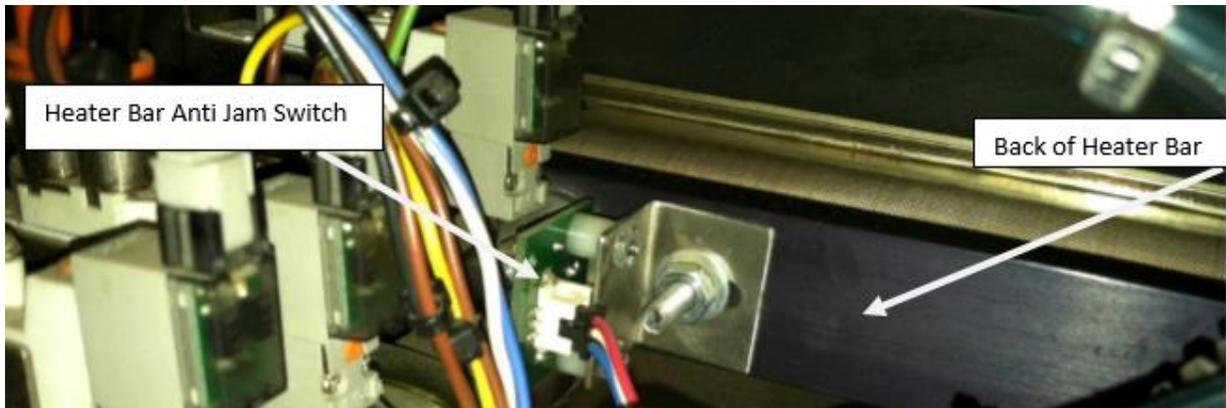


From the back, unplug the left and right side **Anti-Jam Sensors**, disconnect the **Thermal-Couple**, and the left and right **Heater Cartridge** connectors.



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From the front, pull one side (right or left side) of the **Seal Assembly** out from the front plate. Since the **Seal Assembly** is tight, some maneuvering may be required to remove the assembly from the machine. To avoid damage to components or wiring, do not force the assembly.





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Refer to the following Heater Bar Bill of Materials and diagram.

C. T-200 Heater Bar Assembly

PN: TA-T8-2000

ITEM NO.	QTY.	PART NO	DESCRIPTION
1	1	TP-T8MA00121-5	HEATER PLATE & BRACKET SUB-ASM.
2	1	TP-T8MA00112-1	BRACE
3	2	TP-T8MA00226	PHOTO EYE BRACKET
4	1	TP-T8MA00199	ANTI-JAM
5	1	TP-T8MA00202	SEAL BAR
6	2	TP-T8ME0161	ANTI JAM SENSOR BOARD ASM.
7	2	TP-T8MA00227	HEATER BAR SLIDE
8	2	TP-109210	THUMB SCREW
9	4	TP-104135	STANDOFF, NYLON SPACER
10	2	TP-T8MA00124	TEFLON SHAFT
11	2	TP-101103	SAE NUTS
12	2	TP- T8MA00231	ROUND UNIT SPACER
13	2	TP- 108099	COMPRESSION SPRING, .040 GUAGE, .359 OD.
14	2	TP-108153	EXTENSION SPRING
15	1	TP-T8MA00225	BLOW OFF TUBE
16	1	TP-221416	THERMAL-COUPLE WIRE

*Note: This assembly is used in both the T-200 and T-275 table-top baggers. Part No. TP-T8MA0025
Blow Off tube (item 15) is only used when the assembly is made for the T-275 model.*

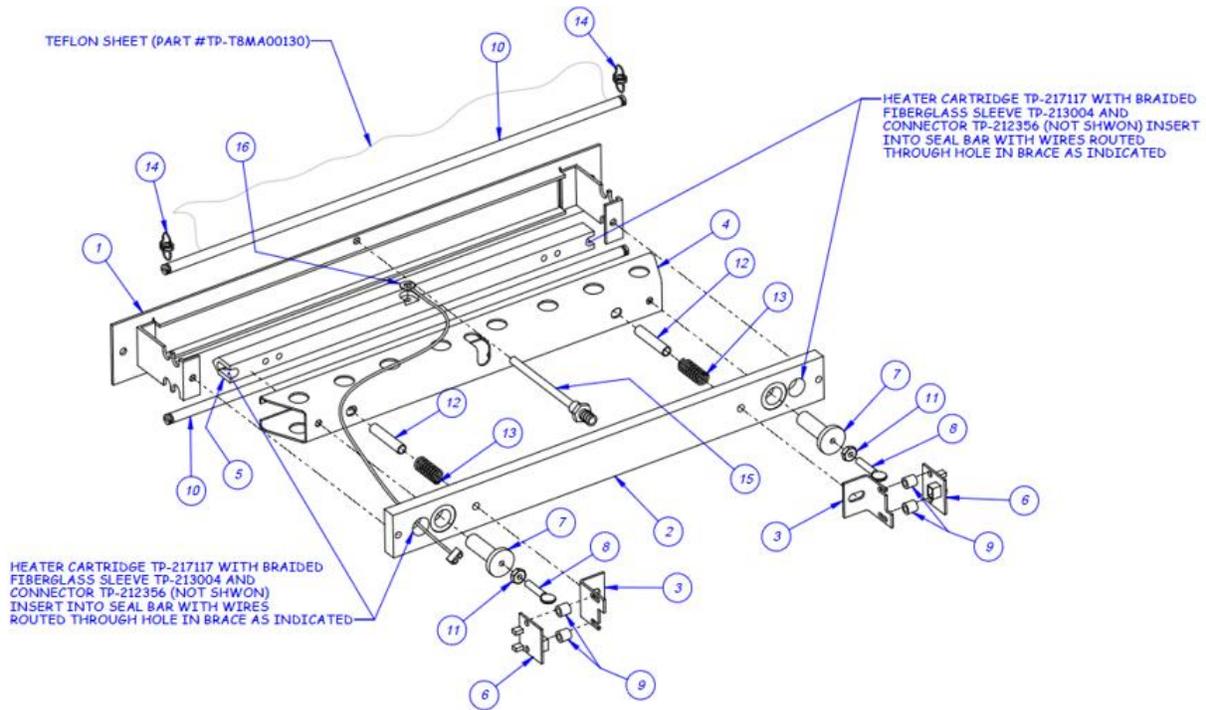


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T-200 Heater Bar Assembly

PN: TA-T8-2000



Remove the two extension springs holding the shafts together.

Remove the Socket Head Bolt and Nut on Each side of the **Heater Plate**.

Remove PTFE Shafts and PTFE Sheet.

Clean the adhesive from both shafts.

Separate the two shafts.

Lay one Shaft on the top of the PTFE Sheet and measure from the edge of the PTFE Sheet to the edge of the shaft. Ensure the PTFE Sheet is in the center of the Shaft.

Wrap a piece of tape on the shaft at the edge of the PTFE.

Take the second shaft, lay the first shaft next to it and wrap tape around the end of the second shaft in exactly the same place as the first. Keep the taped ends on the same side of the PTFE Sheet.



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Remove the adhesive backing from one end of the PTFE Sheet.

Align one shaft parallel to the PTFE Sheet with the taped end of the shaft meeting up with the edge of the PTFE Sheet. Once the shaft is in position, lower onto adhesive side of the PTFE Sheet.

Roll the shaft until you reach the end of the adhesive part. Repeat with the other shaft, ensuring the taped ends are on the same side. Once the PTFE Sheet has been rolled over the shafts, the tape may be removed.



Lay **Heater Plate** on a flat surface so the side plates stick up. Lay PTFE sheet over the Heater Plate so that the shafts are parallel to the plate and the PTFE will roll on the outside of the shaft when reattached.

Place the **Heater Bar** on top of the PTFE sheet so that it fits through the rectangle window through the Heater Plate. The PTFE will be between the **Heater Plate** and **Heater Bar**.

Replace the 2 socket head bolts and nuts.

Replace PTFE Shafts and springs.

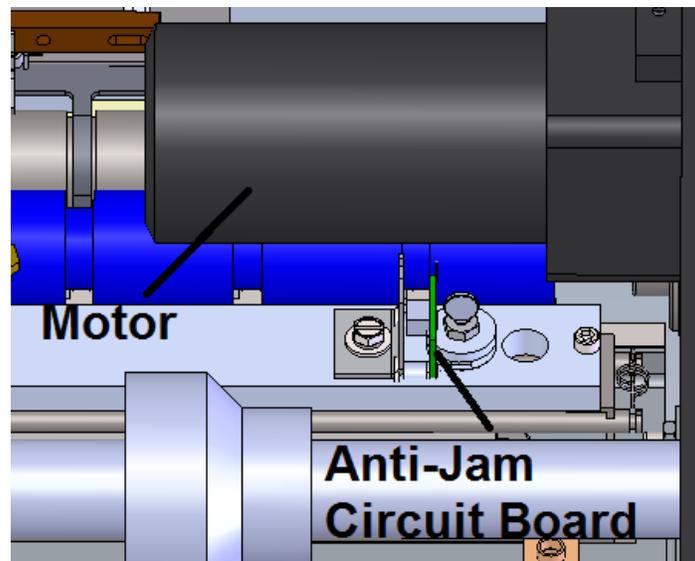
Slide **Heater Bar Assembly** back in.

CAUTION: *When facing the T-200, the motor is on the left side. When reinserting the Heater Bar Assembly use caution not to bump the motor as it will dislocate the Anti-Jam Circuit Board.*



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Replace and tighten socket head bolts.

Reinstall **Pressure Bar**.

Put a light film of grease on Shoulder Bolts and tighten. Attach Lexan Cover.

Connect Thermal Couple.

Reconnect right and left Heater Bar Connectors.

Reconnect both Heater Bar Sensors.

Replace Stainless Cover.