



How To

Service Documents from APPI

Document: #HT000124

Document Title: Interfacing APPI Baggers to Third Party Equipment

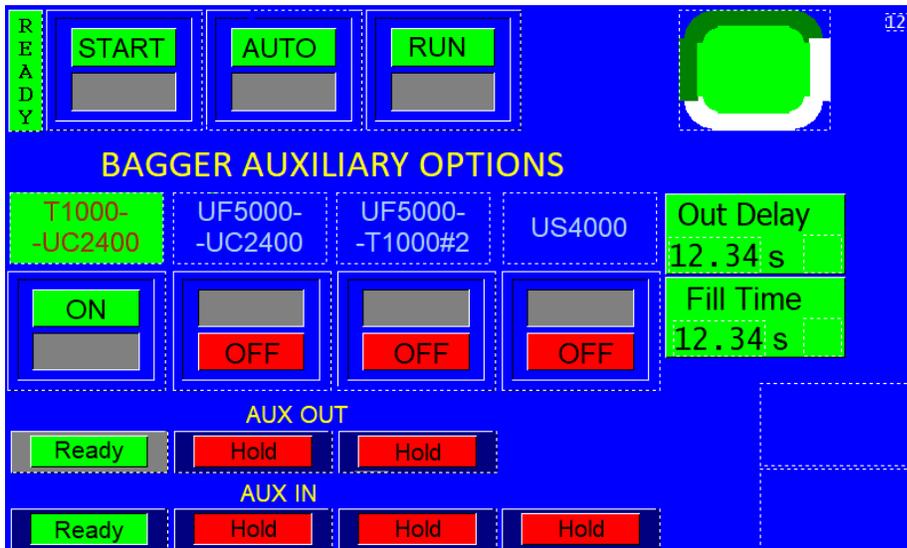
Product(s): T-1000

Procedure:

This document is for a T-1000 connected to a Feeder.

This document assumes that any startup procedure has been performed, and that both Bagger and Feeder are ready to run. The Bagger must be in START AUTO RUN, and have T-1000-UC2400 option selected.

This shows the sequence of events with printing. If there is no printing to be done, or no printer is attached, the steps are identical, except the Bagger will index a bag without printing.



When the Bagger is ready it will continuously be in AUX Out Ready mode.

The customer's equipment will only temporarily activate AUX In Ready to trigger bagger cycle.



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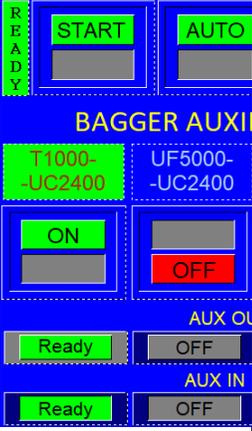
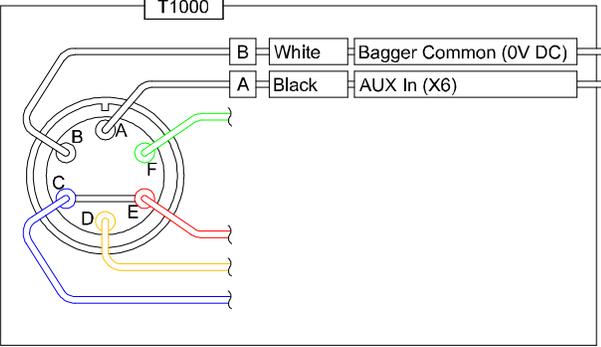
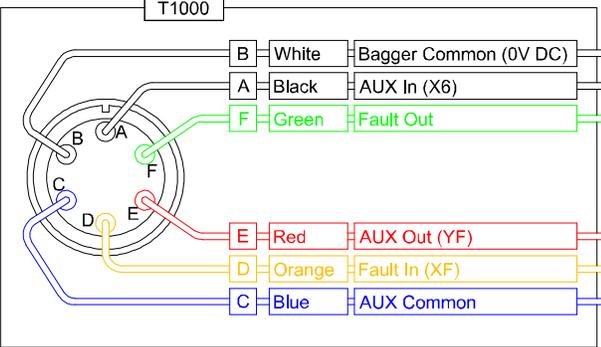
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Step	Bagger	Feeder	AUX
2	<div style="border: 1px solid black; padding: 5px; margin-bottom: 10px;"> <div style="background-color: green; color: white; text-align: center; padding: 2px;">Ready</div> <div style="background-color: green; color: white; text-align: center; padding: 2px;">Label</div> <div style="background-color: gray; color: white; text-align: center; padding: 2px;">Reprint Buffer</div> </div> <p>The bagger prints a bag, and indexes it into position.</p> <p>Bagger ready.</p> <div style="border: 1px solid black; padding: 5px;"> <div style="display: flex; justify-content: space-between;"> <div style="text-align: center;"> <div style="background-color: green; color: white; padding: 2px;">START</div> <div style="background-color: gray; color: white; padding: 2px;">[]</div> </div> <div style="text-align: center;"> <div style="background-color: green; color: white; padding: 2px;">AUTO</div> <div style="background-color: gray; color: white; padding: 2px;">[]</div> </div> </div> <p style="text-align: center; color: blue; font-weight: bold;">BAGGER AUXILIARY</p> <div style="display: flex; justify-content: space-between;"> <div style="text-align: center;"> <div style="background-color: green; color: white; padding: 2px;">T1000-UC2400</div> <div style="background-color: gray; color: white; padding: 2px;">[]</div> </div> <div style="text-align: center;"> <div style="background-color: gray; color: white; padding: 2px;">UF5000-UC2400</div> <div style="background-color: red; color: white; padding: 2px;">OFF</div> </div> </div> <div style="display: flex; justify-content: space-between; margin-top: 5px;"> <div style="text-align: center;"> <div style="background-color: green; color: white; padding: 2px;">ON</div> <div style="background-color: gray; color: white; padding: 2px;">[]</div> </div> <div style="text-align: center;"> <div style="background-color: red; color: white; padding: 2px;">OFF</div> <div style="background-color: gray; color: white; padding: 2px;">[]</div> </div> </div> <p style="text-align: center; color: blue; font-weight: bold;">AUX OUTPUT</p> <div style="display: flex; justify-content: space-between;"> <div style="text-align: center;"> <div style="background-color: green; color: white; padding: 2px;">Ready</div> <div style="background-color: gray; color: white; padding: 2px;">OFF</div> </div> <div style="text-align: center;"> <div style="background-color: gray; color: white; padding: 2px;">[]</div> </div> </div> <p style="text-align: center; color: blue; font-weight: bold;">AUX INPUT</p> <div style="display: flex; justify-content: space-between;"> <div style="text-align: center;"> <div style="background-color: red; color: white; padding: 2px;">Hold</div> <div style="background-color: gray; color: white; padding: 2px;">OFF</div> </div> <div style="text-align: center;"> <div style="background-color: gray; color: white; padding: 2px;">[]</div> </div> </div> </div>	<p>The feeder waits for Ready signal.</p>	<p>The diagram shows a circular terminal block with terminals A through F. Terminal A is connected to a green wire. Terminal B is connected to a gray wire. Terminal C is connected to a blue wire. Terminal D is connected to a yellow wire. Terminal E is connected to a red wire. Terminal F is connected to a green wire. The red wire (E) is connected to a terminal labeled 'E-Red' which is further connected to 'AUX Out (YF)'. The blue wire (C) is connected to a terminal labeled 'C-Blue' which is further connected to 'AUX Common'. A timer T1000 is shown at the top of the diagram.</p> <p>YF is activated on the bagger PLC and closes pin C and E.</p>
3	<p>Bagger ready.</p> <div style="border: 1px solid black; padding: 5px;"> <div style="display: flex; justify-content: space-between;"> <div style="text-align: center;"> <div style="background-color: green; color: white; padding: 2px;">START</div> <div style="background-color: gray; color: white; padding: 2px;">[]</div> </div> <div style="text-align: center;"> <div style="background-color: green; color: white; padding: 2px;">AUTO</div> <div style="background-color: gray; color: white; padding: 2px;">[]</div> </div> </div> <p style="text-align: center; color: blue; font-weight: bold;">BAGGER AUXILIARY</p> <div style="display: flex; justify-content: space-between;"> <div style="text-align: center;"> <div style="background-color: green; color: white; padding: 2px;">T1000-UC2400</div> <div style="background-color: gray; color: white; padding: 2px;">[]</div> </div> <div style="text-align: center;"> <div style="background-color: gray; color: white; padding: 2px;">UF5000-UC2400</div> <div style="background-color: red; color: white; padding: 2px;">OFF</div> </div> </div> <div style="display: flex; justify-content: space-between; margin-top: 5px;"> <div style="text-align: center;"> <div style="background-color: green; color: white; padding: 2px;">ON</div> <div style="background-color: gray; color: white; padding: 2px;">[]</div> </div> <div style="text-align: center;"> <div style="background-color: red; color: white; padding: 2px;">OFF</div> <div style="background-color: gray; color: white; padding: 2px;">[]</div> </div> </div> <p style="text-align: center; color: blue; font-weight: bold;">AUX OUTPUT</p> <div style="display: flex; justify-content: space-between;"> <div style="text-align: center;"> <div style="background-color: green; color: white; padding: 2px;">Ready</div> <div style="background-color: gray; color: white; padding: 2px;">OFF</div> </div> <div style="text-align: center;"> <div style="background-color: gray; color: white; padding: 2px;">[]</div> </div> </div> <p style="text-align: center; color: blue; font-weight: bold;">AUX INPUT</p> <div style="display: flex; justify-content: space-between;"> <div style="text-align: center;"> <div style="background-color: red; color: white; padding: 2px;">Hold</div> <div style="background-color: gray; color: white; padding: 2px;">OFF</div> </div> <div style="text-align: center;"> <div style="background-color: gray; color: white; padding: 2px;">[]</div> </div> </div> </div>	<p>The feeder fills the bag.</p>	<p>The diagram is identical to the one in Step 2, showing terminals A-F and connections to E (Red) and C (Blue). The red wire (E) is connected to 'E-Red' and 'AUX Out (YF)'. The blue wire (C) is connected to 'C-Blue' and 'AUX Common'. A timer T1000 is shown at the top.</p> <p>Bagger ready, feeder not ready. YF is active on the bagger PLC.</p>



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4	<p>Bagger ready.</p> 	<p>The feeder temporarily closes AUX In, pin A and B.</p>	 <p>Input X6 on the bagger PLC is activated. YF is active on the bagger PLC.</p>
5	<p>The bagger opens pin C and E while cycling.</p> <p>The bagger cycles.</p> 	<p>The feeder pauses.</p>	 <p>Output YF on the bagger PLC not active while cycling. Pin C and E is open.</p>
6	Repeat from step 1		

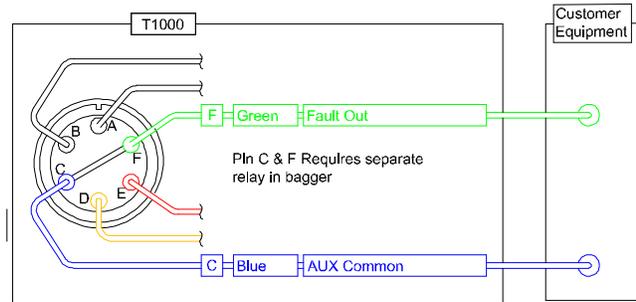


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AUX Fault Signals

AUX Fault Out from the bagger uses fault relays in the bagger. Auxiliary fault is signaled by any error message in the bagger that causes it to go into STOP mode.



AUX Fault In from customer equipment will cause the bagger to stop and display this error screen:

