



# How To

Service Documents from APPI

**Document: #HT000129**

**Document Title: Calibrate Thermocouple**

**Product(s): T-375**

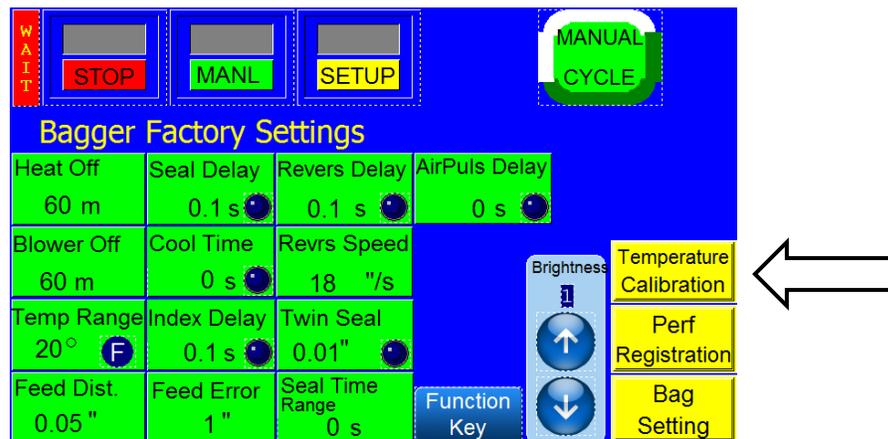
## Procedure:

To calibrate a thermocouple after replacement or repair, it is necessary to have exterior temperature sensor (Fluke Thermocouple Thermometer 51/52 Series II or equivalent) in order to compare and adjust the temperature readings.

Set the thermometer to the same scale as the Bagger (°F or °C).

Place the temperature sensor probe from the Fluke or equivalent thermometer in contact with the **Heater Bar** as close to the point of contact for the **Thermocouple Wire** as possible.

Access the **Temperature Calibration Screen**, by starting at the **Main Menu**, proceeding to the **Technical Assistance** and **Bagger Factory Screens**.



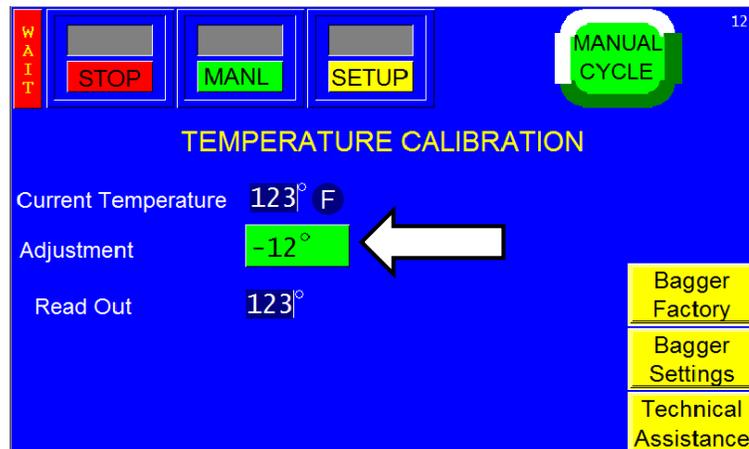
Press **“Temperature Calibration”** button on right side of **Bagger Factory Settings** screen.

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Follow these steps to calibrate the heater bar:

1. Using a controlled measurement device, clamp the measurement tip or pad to the heater bar surface as close to the thermocouple connection as possible.
2. Take the difference between the Current Temperature and the temperature measured in Step 1 and enter that number in the Adjustment field.
3. Return to the Temperature Calibration screen to confirm the Current Temperature matches the Read Out.



Note: If the PLC (Current) temperature is very different from the temperature that is measured, there may be a problem with the method of measuring the temperature, a problem with the thermocouple cable or connection, or a different problem. Please contact APPI Technical Support for assistance before making any manual temperature adjustments.

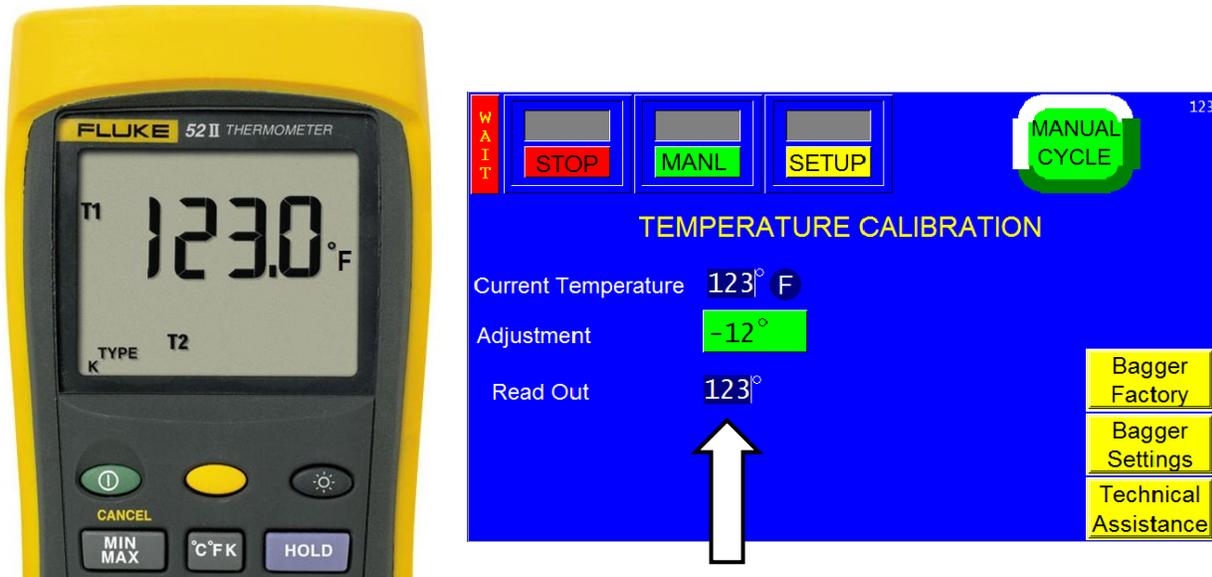
**Current Temperature** will display the current temperature. Compare this to the temperature displayed on the Fluke Thermometer.



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**Read Out:** This display shows the difference between the PLC temperature and the Adjusted Temperature that has been entered manually.



### Adjustment

If there is a discrepancy between the readings, press the **“Adjustment”** button and enter the correct temperature reading according to the Fluke Thermometer. For example, if the outside calibration equipment reads 123°F and the bagger shows 111°F, a value of -12° can be entered into **Adjustment**, allowing the variation to be known. By pressing the green **“Adjustment”** button, a numeric keypad is accessed where two digits, negative or positive can be entered into this field.