

Document: #HT000030

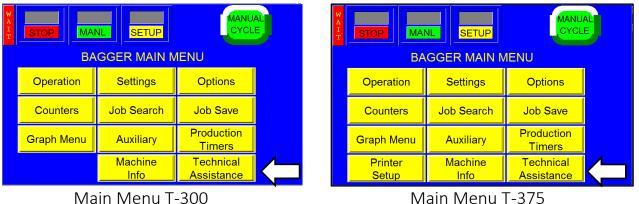
Document Title: Adjust Anti-Jam

Product(s): T-300/375

Procedure:

Turn Air Off and Main Power ON.

Press "Technical Assistance" from the Main Menu (the Main Menu is different for T-300 & T-375. Both versions shown below)



MANUAL CYCLE

EXIT

1234

1234

SETUP

9

6

3

ENT

MANL

4

0

Enter Level 1 Pass Code

8

5

2

CLR

PLC Ver:		GHI J KLMNO							
For technical assistance contact our service department: Advanced Poly-Packaging Inc. 1331 Emmitt Road Akron, OH 44306, USA Phone: (330) 785-4000									
Auxiliary	\mathbb{Z}	Bagger	Bagger	Printer					
Setup		PassCode	Factory	Status					
License	PLC IO	Option	Scale	APPI					
	Status	PassCode	Factory	Factory					

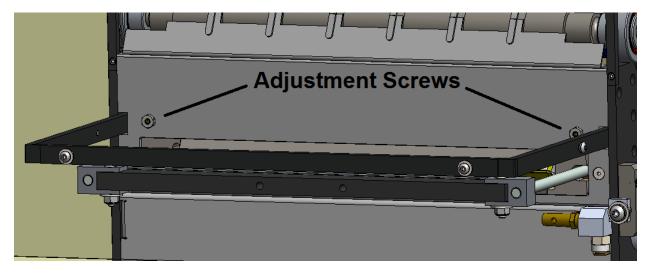
Enter Pass Code "1001", and press ENT. PLC I/O Screen.

Press "PLC Info". This will bring up the

Main Menu T-300

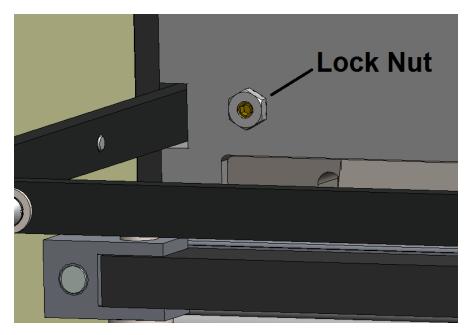
T ISTO		MA	NL	S	ETU				MAN	
	BA	GGE	R P	LC N	AIN	11/0)			
Inputs	•	•	•	•	•	•	•	•		PC Link
	X0	X1	X2	X3	X4	X5	X6	X7		
		•	•	•	•	•	•	•		TIZ I/O
	X8	X9	XA	XB	XC	XD	XE	XF		Technical
Outputs	- 60	0		-	-	-	0	-		Assistance
Bagger	Y0	¥1	¥2	¥3	¥4	¥5	¥6	¥77		Expansion I/O
Ready	¥8	¥9	YA	YB	YC	YD	YE	YF		Main
Hours: 12	3hhh	: mm	C	ycle	s: 1	2345	678	9		Menu

PLC I/O Screen



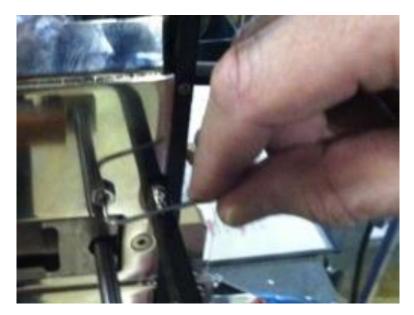
Locate the two adjustment screws on the Face Plate.

Note: Adjustment Screws can be located below the Gripper Plate if the unit is a Standard Frame model.

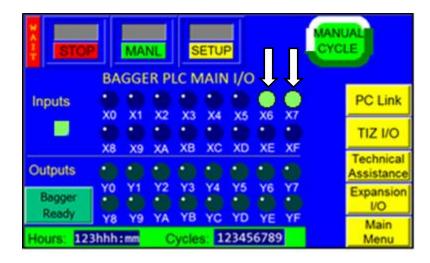


(Left Side shown above)

Loosen the Lock Nut.



Using an Allen Wrench, adjust the Plunger until input X6 or X7 just turns on.

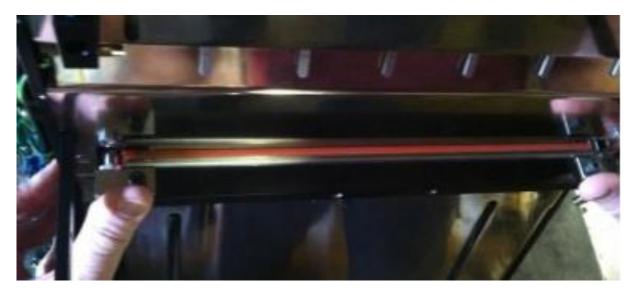


(GREEN indicates ON)

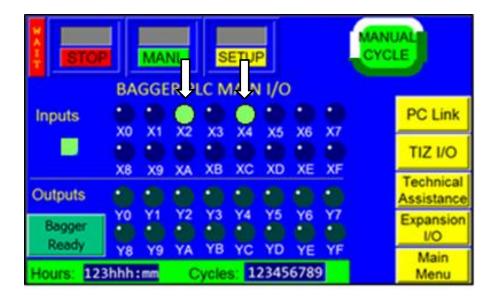
Repeat on left side, both X6 and X7 should be on (GREEN).

Gently tighten Lock Nuts. **Do Not Over-Tighten**; it may break the Plunger Screw.

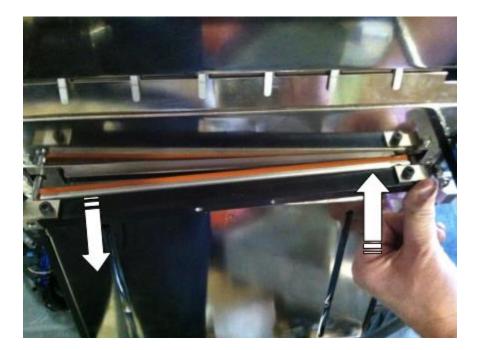
(Plunger Screw, TP-108220)



Have someone push the Pressure Bar all the way in.

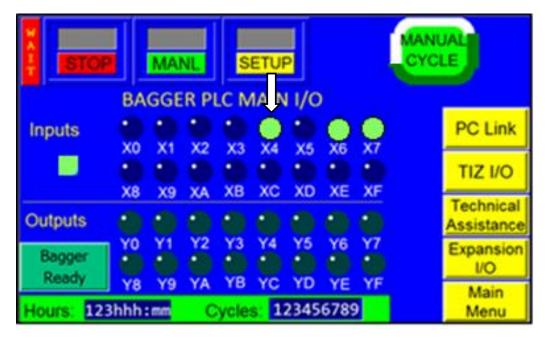


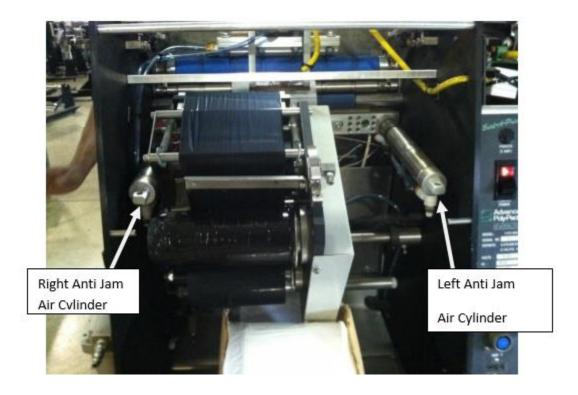
While pushing the Pressure Bar in completely, **X2** and **X4** should be **ON** (**GREEN**). If not, go to the next step.



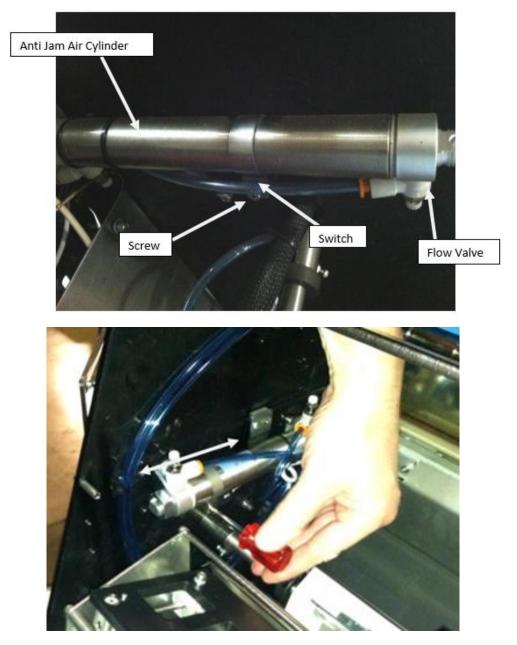
Push one side of the Pressure Bar all the way in. Note whether **X2** or **X4** turns on.

In this case, **X4** turns on (below), so **X4** is the Right Side.





Anti-Jam Air Cylinders (above)



While the Pressure Bar is pushed in all the way, loosen the Phillips Head Screw, and move the Switch until **X2** or **X4** lights.

Repeat procedure on the other cylinder.

With Both sides of the Pressure Bar pushed in all the way, **X2** and **X4** should be on.

STO		MA	NL	s	ETU				MAN	UAL
	BA	GGE	R P	LC N	1AIN	1/0				
Inputs	- 10	•		•	0	•	•	•		PC Link
-	X0	X1	X2	X3	X4	X5	X6	X7		
		•	•	•	•	•	•	•		TIZ I/O
	X8	X9	XA	XB	XC	XD	XE	XF		Technical
Outputs	- 20	-	-	-	8		80	-		Assistance
Reamer	Y0	Y1	¥2	¥3	¥4	Y5	¥6	¥7		Expansion
Bagger		0	-		0		-			I/O
Ready	Y8	¥9	YA	YB	YC	YD	YE	YF		Main
Hours: 12	3hhh	: mm	C	ycle	s: 1	2345	6789	9		Menu