



How To

Service Documents from APPI

Document: #HT000037

Document Title: Adjust Anti-Jam

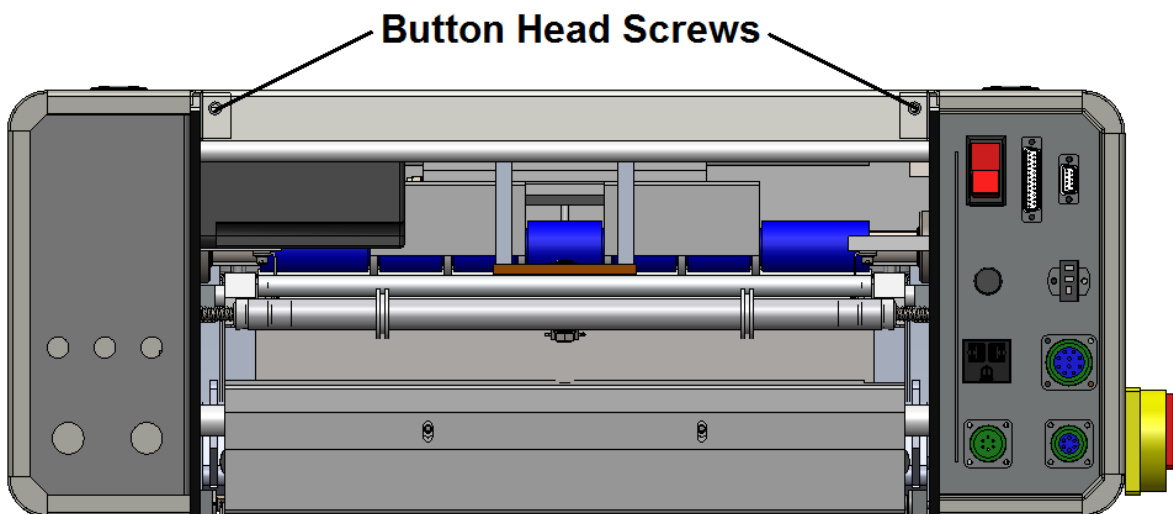
Product(s): T-1000

Procedure:

Disconnect Main Air Supply.



Remove button-head screws and slide back the cover.



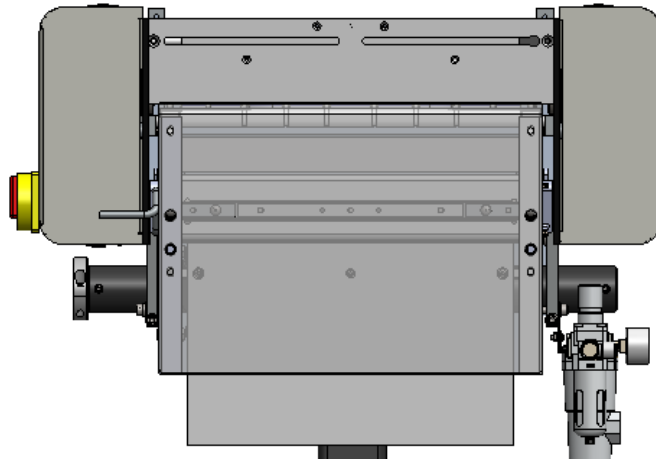
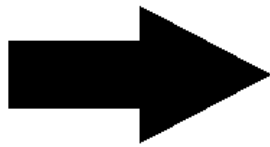


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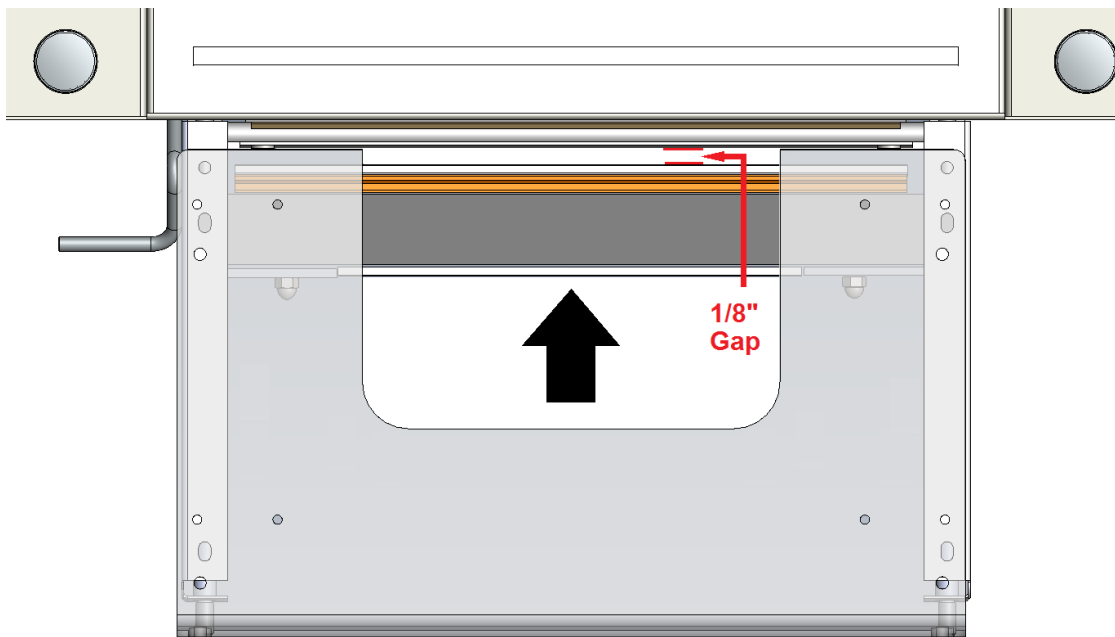
Locate the left side of the T-1000

Locate the Left Side of the T-1000



Move Pressure Bar in until it is approximately 1/8 inch from Heater Bar.

(Top View)

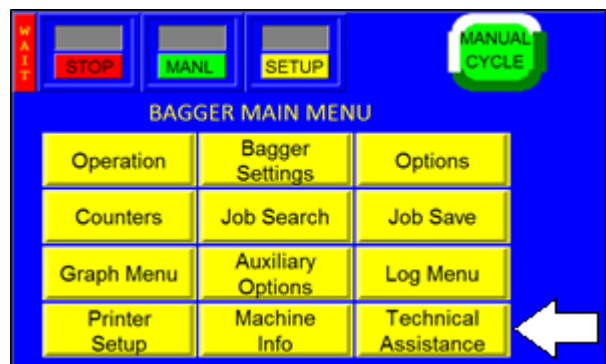
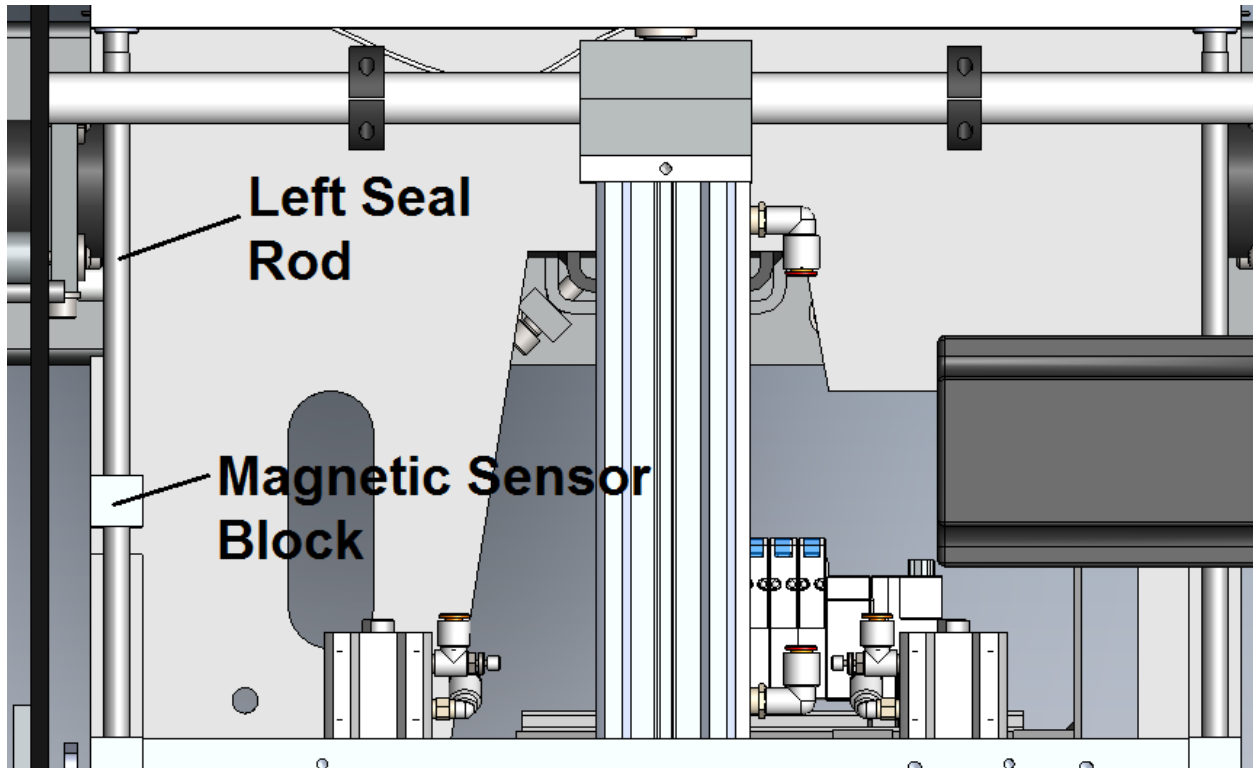




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Locate the Left Seal Rod and Magnetic Sensor Block (Top View)

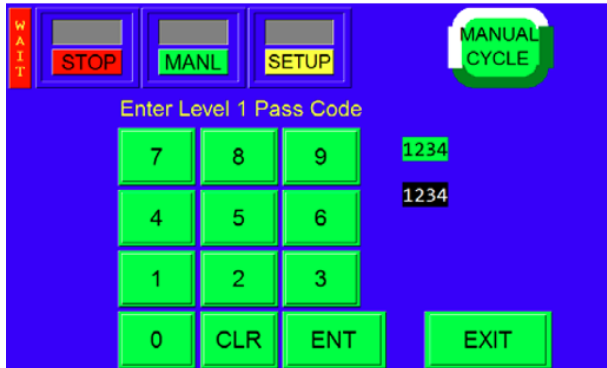


With Power ON, go to the "Main Menu" on your Touch Screen. Then Press Technical Assistance



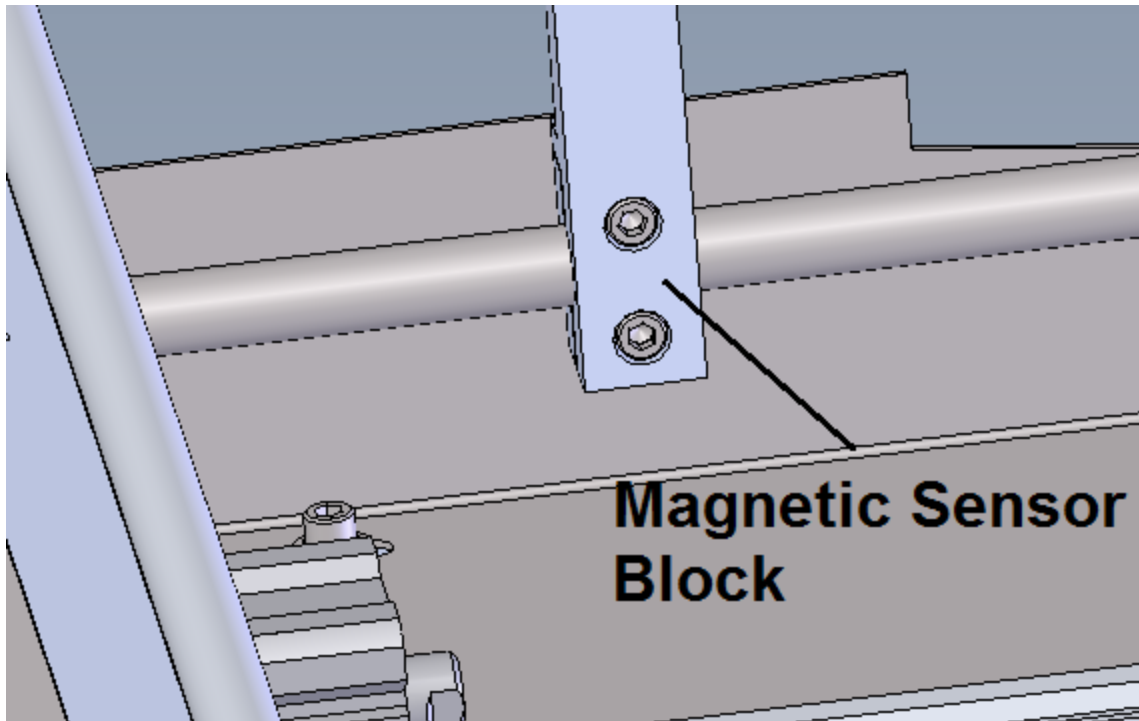
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Enter Pass Code “1001”, and press **ENT**. Press **PLC Info**. This will bring up the PLC I/O Screen.

With an Allen Wrench Loosen, the Magnetic Sensor Block.

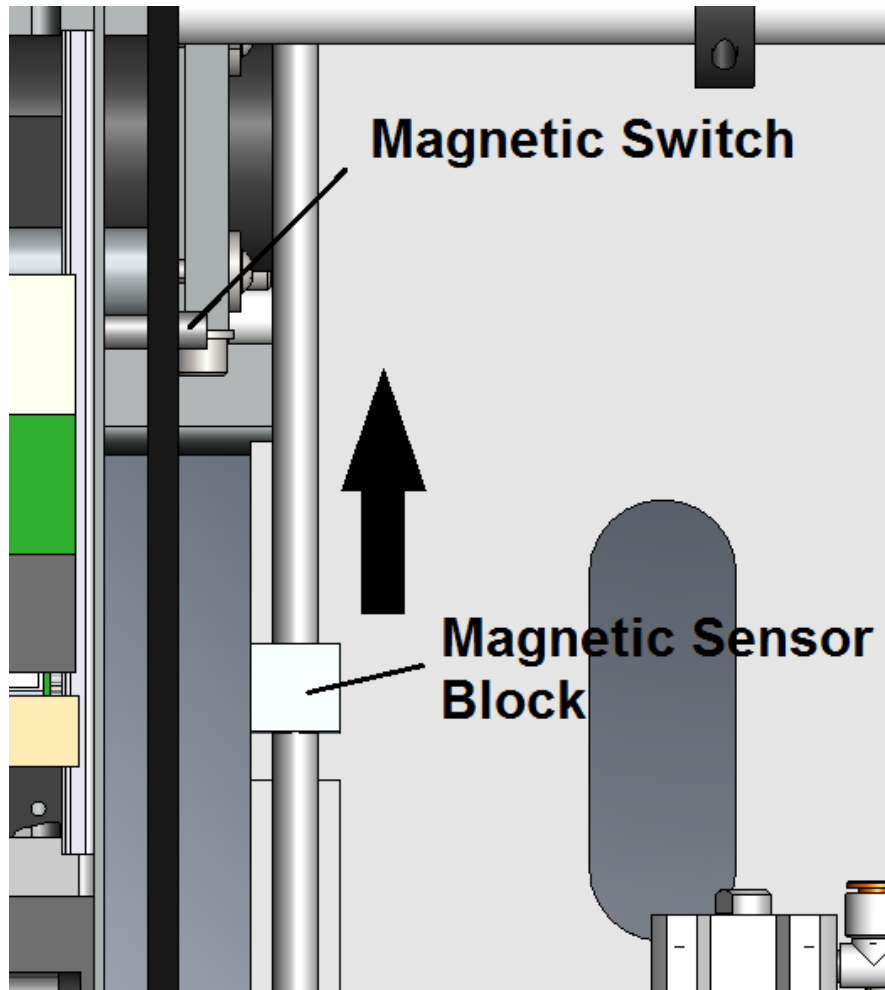




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Slide Magnetic Sensor Block towards Magnetic Switch until the X7 LED on the PLC I/O Screen just lights.

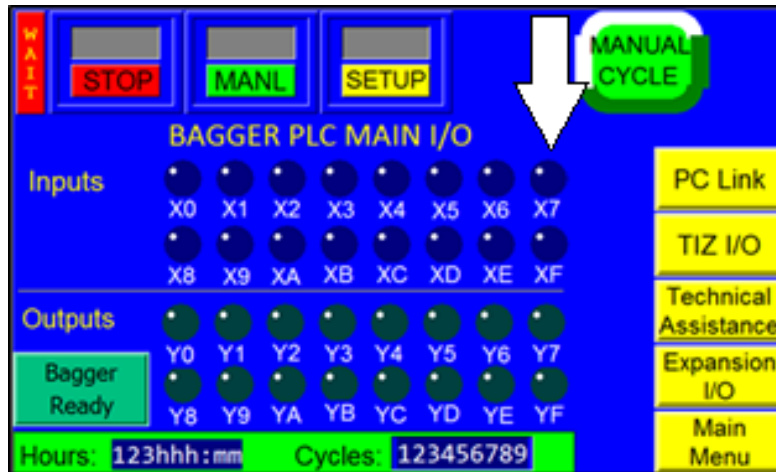




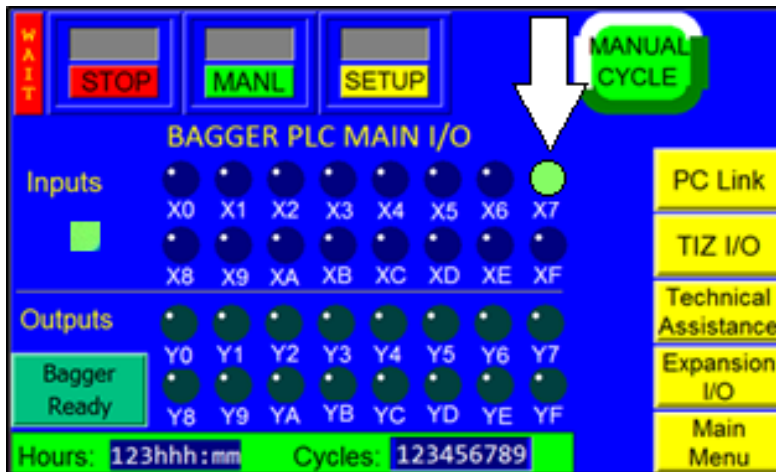
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X7 OFF



X7 ON

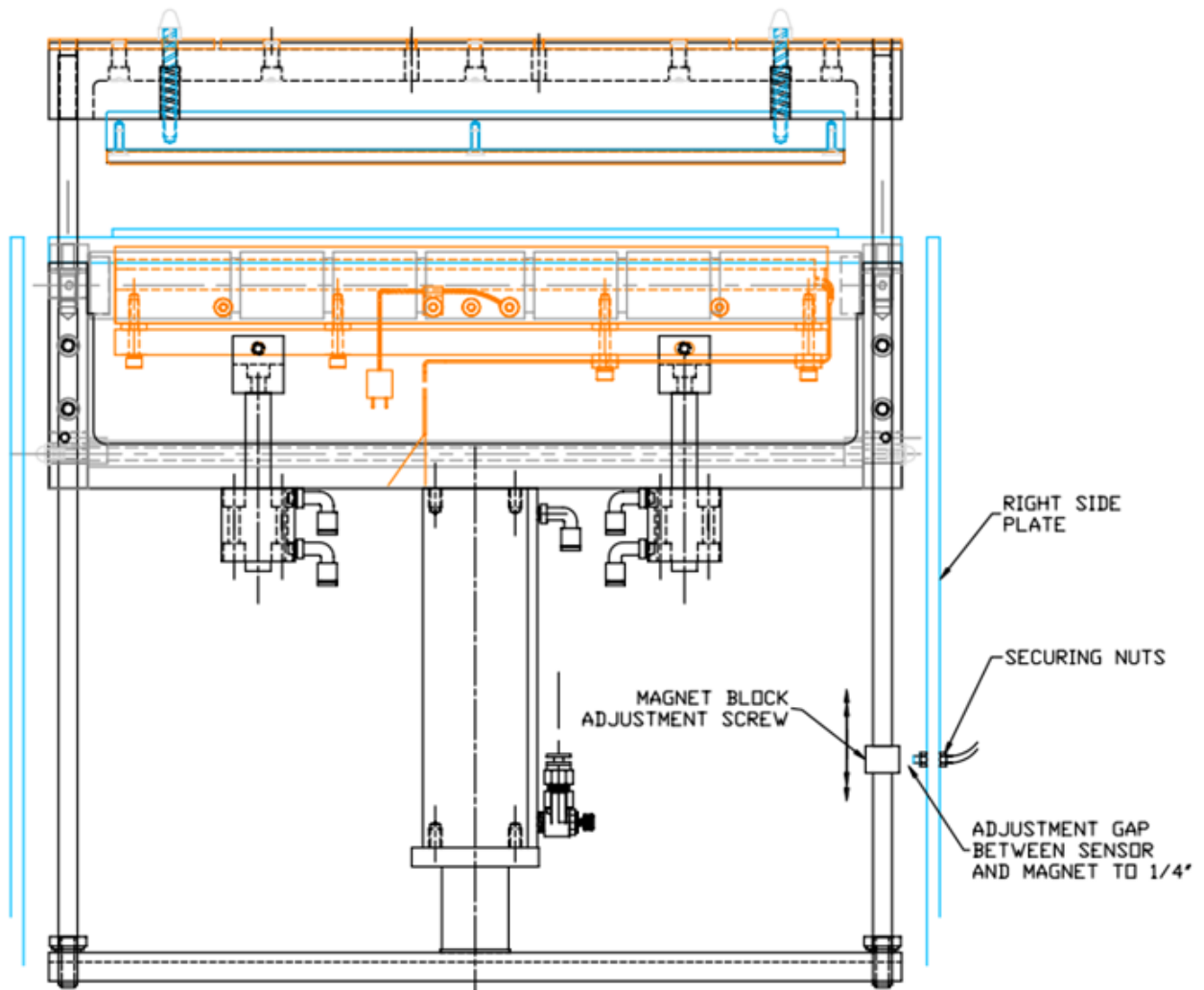




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Tighten the Magnetic Sensor Block. *Note: Be sure it is straight up and down and clears the Magnetic Switch.*





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Re-Attach Air Supply.

Anti-Jam should now be working. Put the T-1000 in Auto Run and allow the machine to cycle. While it is running, insert a piece of 3/8" tubing doubled over between Pressure Bar and Heat Bar as shown. The Pressure Bar should jump back and the Touch Screen should give an Anti-Jam error screen.

