

Document: #HT000130

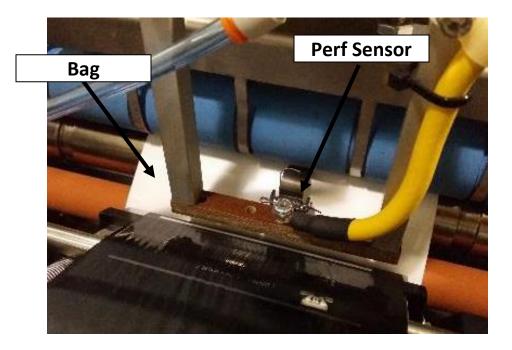
Document Title: Perforation Registration for Bags Smaller than 6"

Product(s): T-1000 Drop Frame

Procedure:

When using bags smaller than 6" on a T-1000 Drop Frame Bagger, it is necessary to slightly modify the standard Perf Registration procedure as follows.

Position the Perf Sensor such that it is sitting on the bag, not a perforation.



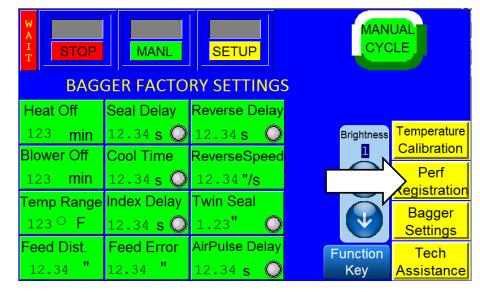
START MAI	SETUP		
Operation	Bagger Settings	Options	
Counters	Job Search	Job Save	
Graph Menu	Auxiliary Options	Log Menu	
Printer Setup	Machine Info	Technical Assistance	

The **START/STOP** button must be in the green **START** position. Press **Technical Assistance**. Enter passcode **1001** on the numeric keypad.

Note: The screens may differ slightly from these screenshots depending on your version.

TS Version: PLC Versior TIZ Version:	ABCDE	F ABCDEFGH	IJKL	STOP				
For technical assistance contact our service department: Advanced Poly-Packag nc. 1331 Emmitt Roac Akron, OH 44306, U: Phone: (330) 785-40								
	Main Menu	Bagger PassCode	Bagger Factory	Printer Status				
License Status	PLC IO Status	Option PassCode	Scale Factory	APPI Factory				

Press Bagger Factory.



On the Bagger Factory Settings screen, select Perf Registration.



Press Find Perf. The Bagger will advance until it stops on a perforation.

Press and hold **JOG+** until the perforation that was under the **Perf Sensor** is above the opening for the **Heater Bar**. The actual distance above the opening will depend on the size of the bag; it should not be more than about an inch.

There is no set distance; you will have to do trial and error to see what works for you.

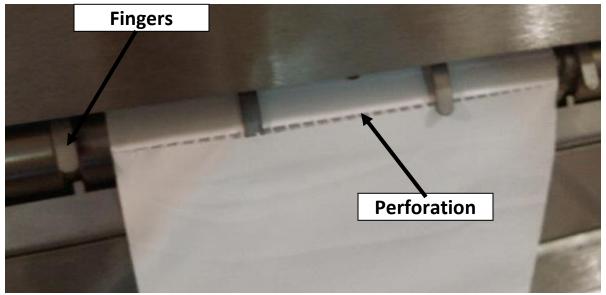


Note: It is normal for the bagger to advance the bag very slowly.



Press Zero Seal.





Press and hold **JOG**- until the perforation is under the fingers. You may need to go even further up, but not too close to the top of the metal roller. That will cause the bags to be pulled back too far, and fall back into the Bagger.



Press Max Reverse.

Press Bagger Setting.

Note: on older versions, you may have to go via Main Menu to Bag Settings.

WAI T	MANL	SETUP	MANUAL		
BAGGE	R SETTINGS	Part #	Part # 123456 ABCDEFGHIJKLMNOPORSTUWIXY 1234		
Fill Time	Air Pulse	Bag Length			
12.34 s 🕘	1.23 s	Current 12.34			
Seal Point	Seal Time	Last 12.34			
12.34 " 🎱	1.23 s 🕻	Average 12.34			
Reverse	Blow Off	BAG			
12.34 " 🕑	1.23 s 🕻	DAG	Job Save		
Index Speed	Seal Temp 🧕	🕨 Heater 🕗	Main		
12.34 "/s	123 123.4 F	RESET	Menu		

Press NEW BAG.

Since the bag now stops above the **Heater Bar** opening, you will have to adjust your **Seal Point** and **Reverse** to place the **Seal Point** where you need it, and to make sure **Reverse** doesn't pull your bags too far into the machine.

Since the bag now stops higher than normal, you may have to set a **Seal Point** that is very close to, or exactly 0.00

Press **MANUAL CYCLE** until Bag Length Current/Last/Average are about the same numbers. This usually takes 4 to 5 cycles.