

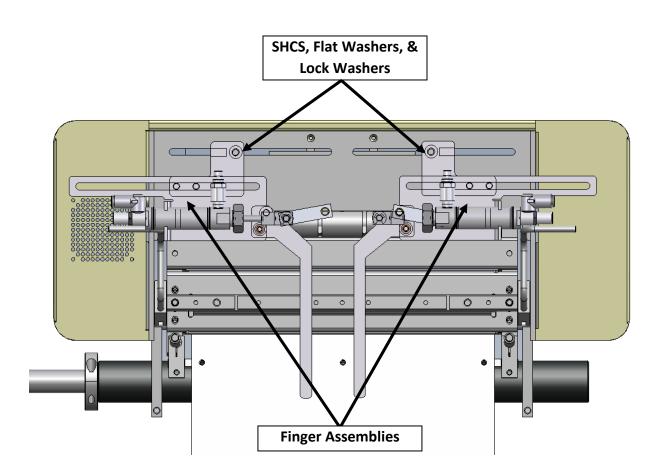
#### Document: #HT000145

#### Document Title: Mounting the FS-10 Flat Seal Kit

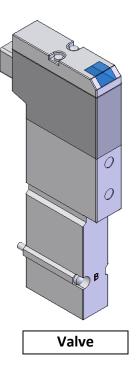
#### Product(s): T-1000

#### Procedure:

Mount Fingers to Base Plate with the included  $\frac{1}{4} \times 20 \times \frac{5}{8}$ " SHCS with Flat Washer and Lock Washer.

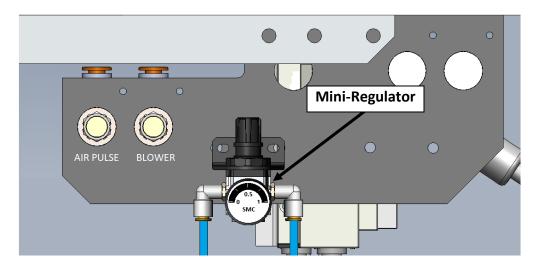


Using the provided hardware, mount Valve to an open station in the Manifold, #5-#10 (#1-#4 are a preassigned). Unscrew the existing blank valve from the existing manifold and screw the NEW valve with gasket to the existing Manifold.

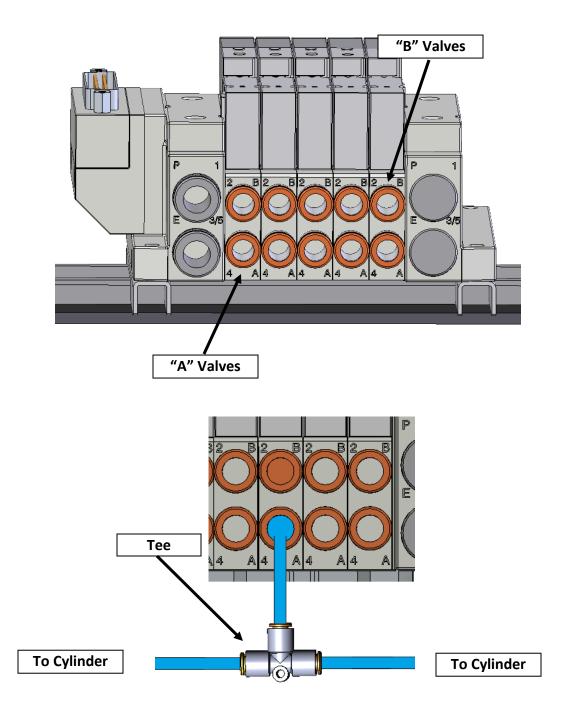


Mount the Mini-Regulator onto the Side Plate, using the included hardware.

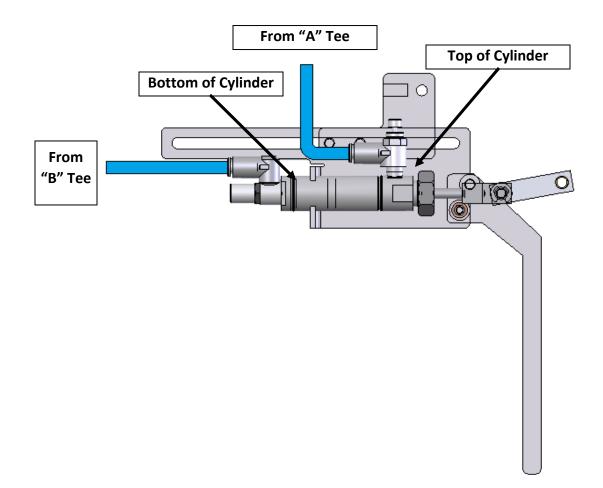
Note: Tubing may need to be disconnected during the installation process. If this is the case, please refer to the included pneumatic diagram for the following instructions.



From the Mini-Regulator (TP-406247), attach the top tube to the "B" Valve (added station TP-402266). From the "A" Valve, run the tubing to the Air Tee. From this Air Tee, run each line of tubing to the top part of the cylinder, short tube goes to the left finger and the longer tube goes to the right finger.



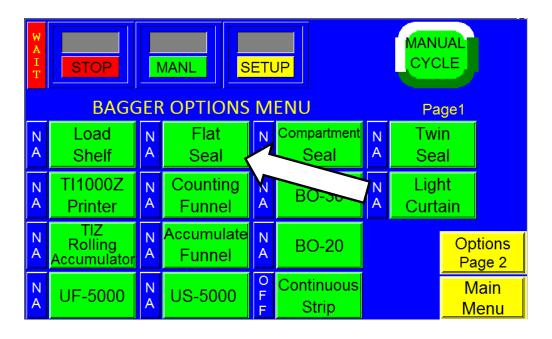
Run the tubing from the bottom of the Mini-Regulator to the Air Tee. From this Air Tee, run the shorter tube to the Right Finger and the longer tube to the Left Finger. Connect each of these tubes to the back of the cylinders.



Once the fingers are connected, the Flat Seal Assembly must be activated, and the Valve must be assigned. See next section for Flat Seal activation and Valve Assignment Instructions.

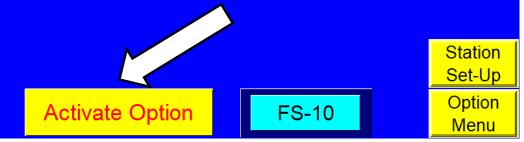
#### Flat Seal Activation

To activate the Flat Seal Assembly, go to the **Bagger Options Menu** and select **Flat Seal**. When the **Flat Seal Screen** appears, select **Activate Option**.

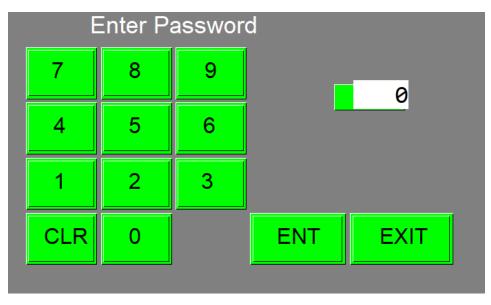


### FLAT SEAL (FS-10)

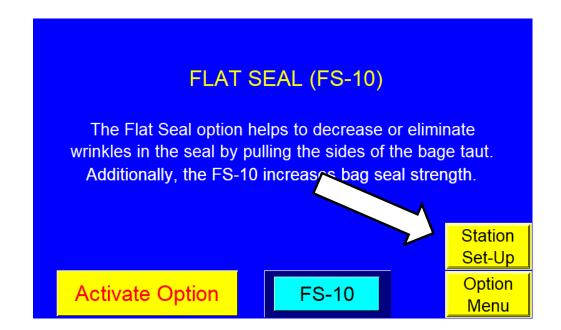
The Flat Seal option helps to decrease or eliminate wrinkles in the seal by pulling the sides of the bage taut. Additionally, the FS-10 increases bag seal strength.



When prompted, use the Numeric Keyboard to enter the Flat Seal Activation Code (0310).



After the code is entered, the Flat Seal Screen will return. Press the Station Set-Up button, and proceed to assign a Valve Station.





#### Valve Station Assignments, S14

The T-1000 S14 has Valve Station Assignments, Valves 1 thru 4 are Default in the PLC Program. If there are additional Options on the T-1000 S14 you will need to assign it a Valve Station.

If you are sending in a PLC for programing it is recommended that you write down or take a picture of the Valve Assignments. You may want to take pictures of all your bag settings also. This will help you get your machine up and running more quickly.

W A I T	STOP MAI	SETUP		
	Operation	Bagger Settings	Options	
	Counters	Job Search	Job Save	
	Graph Menu	Auxiliary Options	Log Menu	
	Printer Setup	Machine Info	Technical Assistance	

From the Main Menu press **Technical Assistance**.

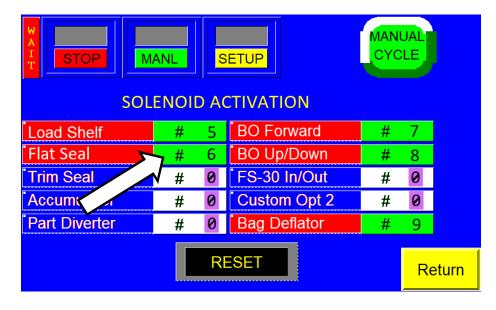
T STOP MANL SETUP MANUAL Enter Level 1 Pass Code									
	7	8	9	1234					
	4	5	6	1234					
	1	2	3						
	0	CLR	ENT	EXIT					

Enter the Pass Code 1001, then press ENT.

TS Version: 123(T7) PLC Version: 123ABCDEFABCDEFGHIJKL ABCDEF										
TIZ Version:										
For technical assistance contact our service department:										
Advanced Poly-Packaging Inc. 1331 Emmitt Road Akron, OH 44306, USA Phone: (330) 785-4000										
	Main Menu	Bagger PassCode	Bagger Factory	Printer Status						
License	PLC IO	Option	Scale	APPI						
Status	Status	Pase Sode	Factory	Factory						
sC										

Press Option PassC

WA HT ING	OPTION ENABLE Select option to enter password								
N A	Load Shelf	N A	Flat Seal	N A	Compartmen Seal	t N A	Twin S		
A	TI1000Z Printer	N / A	Counting Funnel	N / A	BO-30	N / A	Light Curtain		
N / A	TIZ-RA	N / A	Accumulating Funnel	N / A	BO-20				tions age2
NA	UF-5000	N / A	US-5000						ech ssist
Press SAV Station Set-Up									

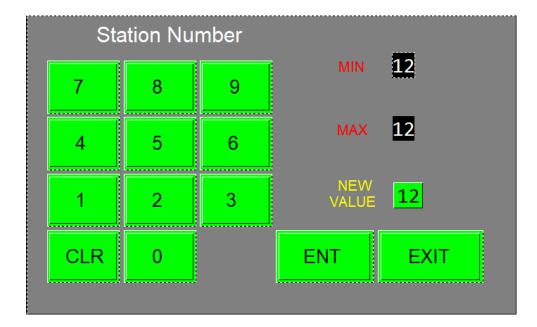


This screen shows the Station Assignments for the Options that are on the Bagger. This is what you want to document. Notice Flat Seal has been assigned to **Valve #6**.

#### Assign a Valve Station

MANUAL       STOP       MANL       SETUP									
SOLENOID ACTIVATION									
Load Shelf	#	5	BO Forward	#	7				
Flat Seal	#	6	BO Up/Down	#	8				
Trim Seal	<i>#</i> ר	0	FS-30 In/Out	#	0				
Accumulator	<b>√</b> #	0	Custom Opt 2	#	0				
Part Div # 0 Bag Deflator				#	9				
RESET						eturn			

Select the option and press the **#**.



Enter the Valve Station the press ENT.