

How To

Service Documents from APPI

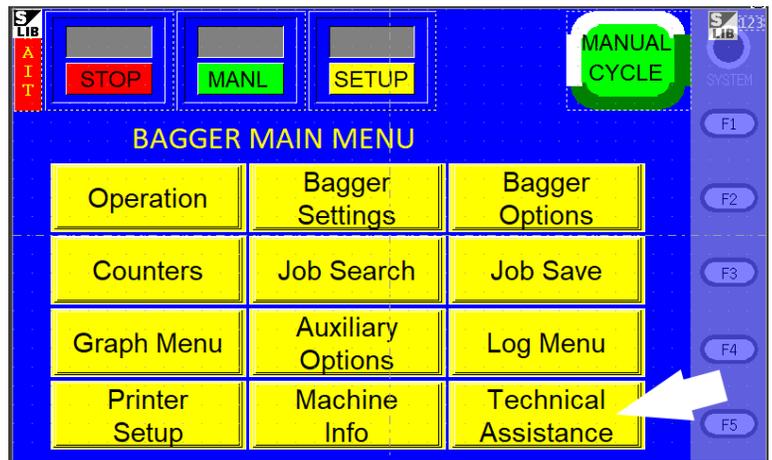
Document: #HT000200

Document Title: PC link PLCs

**Product(s): T-1000-S14, Ti-1000Z,
UCS-2400, US-9000, US-5000**

Procedure:

On the Touch Screen
go to Main Menu.
Press Yellow Technical
Assistance Button.



Enter Code 1001 on Keypad
and Press Enter. Press the
Yellow PLC IO Status Button.

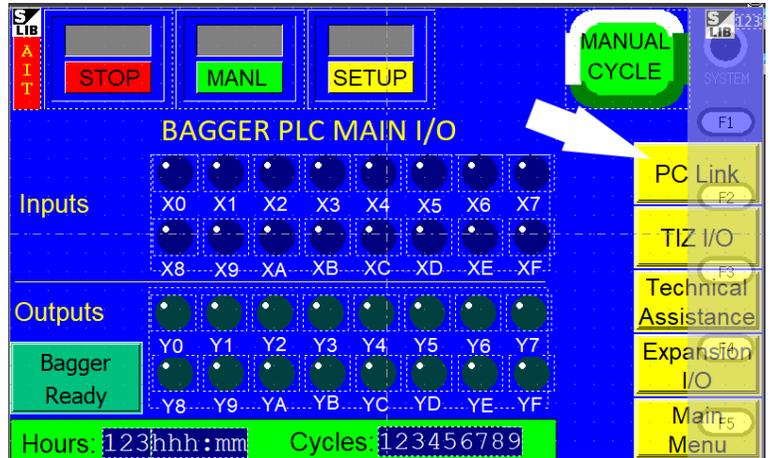




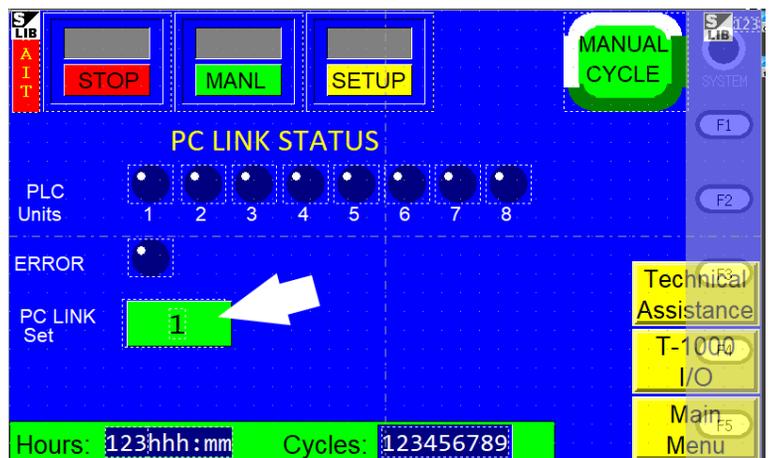
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Press the Yellow PC Link Button.



Press the Green PC Link Set Button Enter 2 on the Keypad and press enter for T-1000 Bagger and Ti-1000z printer. Enter 3 on the Keypad and press enter for T-1000 Bagger, Ti-1000z printer and Scale. Enter 2 on the Keypad and press enter for T-1000 Bagger and Scale (No Printer).





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For a T-1000 Bagger and Ti-1000z Printer Turn Off Bagger for 5 seconds then Turn Bagger On.

The Bagger and Printer should PLC Link.

Go to Main Menu / Technical Assistance / PLC IO Status / PC Link

PLC Units Lights 1 and 2 should be Green.

The Error Light should not be Lit (RED if Lit)

For a T-1000 Bagger, Ti-1000z Printer and Scale make sure that the bagger 110 AC Plug is plugged into the Scale Module. Turn Off the Scale Module for 5 seconds then Turn the Scale Module On.

The Bagger, Printer and Scale Module should PLC Link.

Go to Main Menu / Technical Assistance / PLC IO Status / PC Link

PLC Units Lights 1, 2 and 3 should be Green.

The Error Light should not be Lit (RED if Lit)

For a T-1000 Bagger and Scale make sure that the bagger 110 AC Plug is plugged into the Scale Module. Turn Off the Scale Module for 5 seconds then Turn the Scale Module On.

The Bagger and Scale Module should PLC Link.

Go to Main Menu / Technical Assistance / PLC IO Status / PC Link

PLC Units Lights 1 and 2 should be Green.

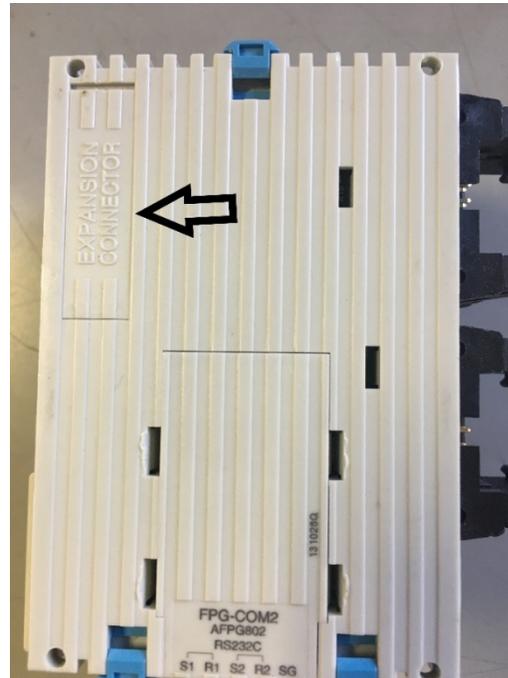
The Error Light should not be Lit (RED if Lit)



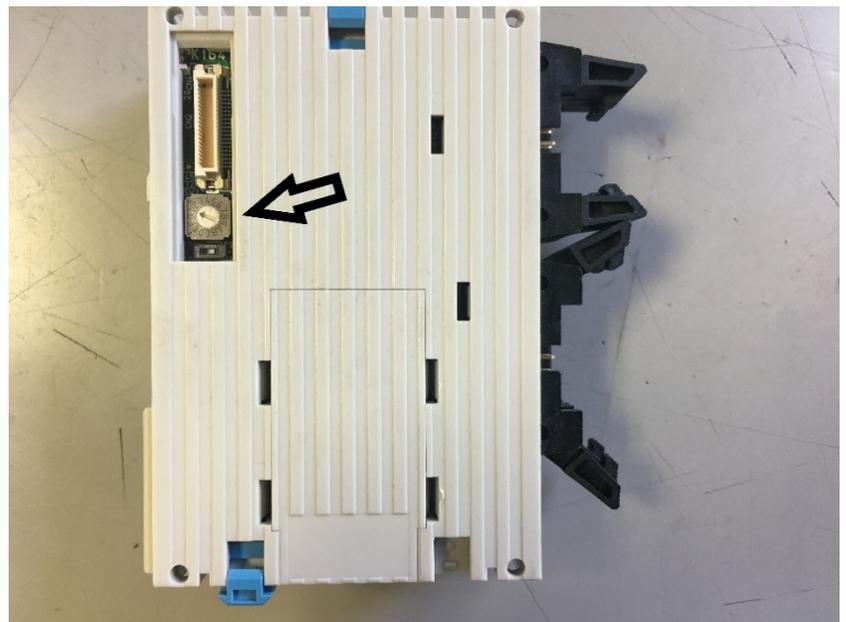
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If the PLCs do NOT Link
check the Dial Settings
on the PLCs.
Remove the cover on
the PLC that covers the dial.



Set the Dial to 1 on the
Bagger PLC. Set the Dial to
2 on the Printer PLC. Set the
Dial to 3 on the Scale Module
PLC. If there is no Printer set the
Dial to 2 on the Scale Module.





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Repeat the Powering down and Powering up steps.

Call Advanced Poly-Packaging if the PLC will not PC Link.

(330) 785-4000

Or

(800) 754-4403