



## ***Bagtender Encoder Replacement & Timing***

1. Remove power and lock/tagout your machine.
2. Remove the wires and replace the high-speed counter card.
3. Reconnect the wiring.
4. Replace the encoder. Do not install the timing belt.
5. Restore power and reset the machine.
6. On the operator panel, Press Transfer Setup Continue to bring up the second setup screen.
7. Have someone manually turn the encoder counter-clockwise. Watch the Encoder Count on the screen to be sure the number increases when the encoder is turned counter-clockwise. This insures that the wiring is correct. If it is not, refer to your electrical schematic for rewiring information.
8. Jog the bagtender until the final stack pusher fingers move a bag fully onto the stack lift table and stop.
9. Manually turn the encoder counter-clockwise until the alternators move inward and stop.
10. Carefully hold the encoder in this position and install the timing belt.
11. Reset the machine and jog a bag into the turntable. The bag bottom should rotate so the bag bottom is on the same side as the air cylinder inside the index drum. If it is not:
  - a. Jog the bagtender until the final stack pusher fingers move a bag fully onto the stack lift table and stop the machine.
  - b. Remove the encoder timing belt.
  - c. Manually turn the encoder counter-clockwise until the alternators move out and back in and stop.
  - d. Carefully hold the encoder in this position and install the timing belt.
12. Repeat step number 11.