

Explanation of alarm description:

A.Sudden stop switch error: Means some of the emergency stop button are pressed.

Solution: Find the pressed button and unlock it.

B.Communication error: Means the communication line between main PLC and slave PLC is not connected.

Solution:

- a.Check if the DC24V power source is working.
- b.Check if the indicator light on the PLC communication module is flickering.
- c.Check the line connection circuit between each PLC.

C.Locating pin timeout: means the locating pin on the rack is not working correctly.

Solution:

- a.Check every locating pin on the rack.
- b.Check if the magnetic switch on the locating pin is working.
- c.Adjust the location of magnetic switch until the LED light is on. If not,please replace with a new one.

D.Frequency converter error: means the motor or the frequency converter has some problem.

Solution:

- a.Check if the motor is heating or locked.
- b.Check the error code on the frequency converter.

E.Inboard/Outboard timeout error: means the movement of frame has problem.

Solution:

- a.Check if there is attached materials in the frame.

b.Adjust the location of magnetic switch until the LED light is on. If not, please replace with a new one.

F.Scraper moving timeout error: means the movement of scraper has problem.

Solution:

a.Check if the location of scraper is correct.

b.Check if the proximity switch is working, if not, please replace with a new one.

c.Check the straight line track on the printing head.

d.Check the circuit of the motor.