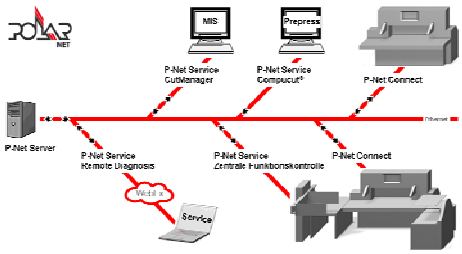
SERVICE – DIAGNOSIS

Edition 01 – 2011

for

Cutting- machines as of 1995



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Diagnosis for:
S, ES, E, ED, XS, X, XT, X-Plus, XT- Plus - 66 bis 176
Autocut 25, AC-115 und Autotrim-M

Error No.: 67

Error Text: SCAN REFERENCE POSITION

State: ERROR **addition:** RED

Cause:

This message is displayed when the machine is switched on (Menue: "SCAN REFERENCE POINT") provided any of the following cases applies:

- the machine has been shut off during active backgauge movement
- a machine is switched on for the first time (commissioning)
- CPxx- board has been replaced.
- a function has been selected in menu "PRESET FUNCTIONS".

However, if this condition occurs frequently (or always) without any of the above conditions applying this suggests that there is a malfunction in data saving when the machine is switched off (loss of data due to ageing battery or defective CPxx board).

If this message is issued in operation (not after start-up), e.g. when starting a positioning process it signals a major malfunction or software error. In that case the data areas for ramp control and for presetting the ramps for backgauge advance movement have become volatile because of a malfunction or a defective CPxx board or have been overwritten due to a software error in the operating program.

Remedy:

- Scan reference point in order to recalculate the initialization values for drive control. After that, check functioning of backgauge drive unit in manual / automatic mode.
- Verify the drive data in service menue “Machine data“.
- If the malfunction cannot be removed by performing a reference run, a static defect in the drive unit will be the cause.
- On machines equipped with swivel and/or tilting backgauge, verify home position.

Memos: Status changed from HINT to ERROR

Error No.: 74

Error Text: AUXIL.OPERAT

State: HINT **addition:** YELLOW

Cause: This message indicates that the machine is in emergency mode. This mode can be selected by the operator via start menu "Scan reference point". This is the only possibility to operate the machine in case of a malfunction or a defect in the drive unit.
"Secondary operation" can only be left by moving correctly over the reference point. This condition is indicated every time the operator tries to perform a function inadmissible in emergency operation (such as e.g. positioning).

Remedy: - Remove the malfunction in the drive unit and make a reference run. After that, check backgauge drive functioning and check parameters in service menu "machine data".

Memos:

Error No.: 77

Error Text: BACKGAUGE END POSITION

State: HINT **addition:** PURPLE

Cause: The message is indicated when the backgauge is interrupted upon manual backgauge adjustment or when positioning the backgauge, since the table limit switch in that direction has been approached or overrun.

Remedy: Check position and function of the corresponding limit switch for advance/return. This can be checked via the LEDs on board SAP. Simultaneously, the value for the table end stored in the service menue must be checked. After every adjustment of the hardware limit switches the reference run must be carried out to update the stored value. The table end value is still taken as a basis for detecting the correct model size. This is indicated in parentheses behind the table end position in service menu "machine data". This size must be correct in order to select the right knife change mode and to make other machine-specific distinctions.
- check switch S8
- check switch S217a.
- check S1 / S2 rear table guard with electrical interlocking
- check plug X71

Memos: for trouble shooting: remove plug 107 (Please note: plugs S6, S218, S218b, S219 have no functions assigned)

Error No.: 78

Error Text: SIZE ERROR

State: HINT **addition:** PURPLE

Cause: The value determined and filed for the table end size during the reference run is exceeded by a positioning input. Size inputs smaller than the accurancy allowance adjusted (default = 0.008 cm) or negative values will cause the same error message.

Remedy:
- Check size input and correct, if necessary
- Check position of table limit switch "at rear" S13 and correct, if necessary, if a size admissible for the respective machine size cannot be approached.

Memos:

Error No.: 79

Error Text: POSITION NOT ACHIEVED

State: ERROR **addition:** RED

Cause:
This error message is indicated after a positioning process, if it is detected that the difference between the required nominal position and the actually achieved position of the backgauge exceeds the accuracy allowance adjusted (default = 0.008 cm).

Remedy:
In that case the drive data of the machine (brake afterrun and slow-down travel) should be calculated again and revised via function "SCAN REFERENCE POINT" . If these data are within the permissible range and the malfunction occurs all the same it is necessary to inspect the drive system completely.
- For ED and XT machines deactivade function "Smooth stop at position".
- Check setting of frequency converter
- Check setting of backgauge motor brake (rotor/wedge), replace if necessary
- Adjust or replace SAP- board
- Inspect backgauge motor (movable?) and pulse generator
- Revise values in service menu "machine data"
- is there any axial play at fitting key of spindele or tablemotor.
- Check slot cover belt, lubricate or grease bearings from reversing roller
- Check breake afterrun of backgauge.
- Make sure that the pulse generator has been fastened correctly.
- verify an accuracy allowance of a min. 0.008 cm.
- Replace frequency converter (without an other error)
- Check setting C016 with 8 up to 20%
  (please, refer also to the parameter list in the frequency converter manual).
- Replace the backgauge motor including the brake.
- Check limit switch S7 (if problems with forward movement of backgauge occur temporarily).
- please see also Error 870.

Memos:
With backgauge speed on 60cm/sec the Parameter C010=0,5 Hz

Error No.: 80

Error Text: I/O BUS ERROR

State: ERROR **addition:** RED

Cause: After machine is switched on, this message indicates that the operating program of the CPxx-board is not able to read the input and output signals of the I/O bus system correctly. The cause may originate in one or several of the I/O bus boards, the master- board or CPxx- board.

Remedy:
- Check voltage supply of machine
- Unplug the I/O- boards one by one to check if the error can be located on one of the I/O- boards
- Replace CPxx- board
- With ED machines check / replace I/O- 3, I/O- 5 board
- With XT machines replace base plate ERWII
- Check plug-in connections of peripheral equipment (X95 - X93).
- Check / replace CPxx- board.
- Check / replace SK 95- board.
- Check Power supply PS 95 (no 12V supply)
- Check cable of cutting-line indicator (short circuit).

Memos:

Error No.: 81

Error Text: SYSTEM HAS NO FLASH EPROMS

State: HINT **addition:** YELLOW

Cause: The operator tried to make a download, although no flash EPROM or known flash EPROM exists. The computer switches back to the data image. The message is indicated in the additional status line.

Remedy:
- replace CPxx- board

Memos:

Error No.: 82

Error Text: DOWNLOAD CARD ILLEGIBLE

State: HINT **addition:** YELLOW

Cause: The download card or data have probably been destroyed by electrostatic charging. This affects mainly SRAM cards. A card that causes this error messages to be generated can be "repaired" under certain circumstances by a new transfer of the software.

Remedy: - before touching SRAM cards, make sure you have discharged electrostatically (e.g. hold machine table with both hands).

Memos: Attention:with ED machines only

Error No.: 83

Error Text: PMS CHECKSUM CALCULATION

State: HINT **addition:** YELLOW

Cause: This note is issued on machines with large-size display in conjunction with a download process. During the internal check of the 1-MB download cards this status message is issued to inform the technician about the current state.
Once the test is terminated and the download card is impeccable, the system switches over to the download mask. If the check sum calculation results negative, the message DOWNLOAD CARD DEFECTIVE will be indicated.

Remedy: - insert new download card.

Memos: Attention:with ED machines only

Error No.: 84

Error Text: DOWNLOAD CARD REMOVED

State: HINT **addition:** YELLOW

Cause: If the Download menu has not been terminated via the menu item "exit", but the download card has been removed instead, this note is indicated.

Remedy: - leave the menu via command "exit".

Memos: Attention:with ED machines only

Error No.: 90

Error Text: DEACTIVATE CUT BUTTONS

State: HINT **addition:** YELLOW

Cause: After the machine has been switched on this message informs the operator that the cut buttons must be released, because the basic initialization of the "cutting cycle" (board SK95) requires the input signals of the NC contacts for both cut buttons (on board SK95) to be set.

Remedy:
- Deactivate cut buttons S28a + S28b
- Check contacts and cabling of cut buttons
- Replace SK 95- board
- Check input / output control in service menue

Memos:

Error No.: 92

Error Text: NONCOMPATIBLE ADD.FUNCTION

State: HINT **addition:** YELLOW

Cause: This message is output, if someone tries to program additional functions together with a cut size, that cannot be combined logically. For instance, if a cut size is programmed both together with "air table ON" and "air table OFF".

Remedy: - correct the additional functions that have been selected.

Memos:

Error No.: 97

Error Text: WRONG PROGRAM STRUCTURE

State: HINT **addition:** PURPLE

Cause: The step structure of the program cannot be processed in automatic operation. This can be due to the fact that a / several step/s of the existing cutting program have been deleted. This is no hardware malfunction.

Remedy: - Check and correct cutting program, if necessary.

Memos:

Error No.: 101

Error Text: MEMORY BANK NOT READABLE

State: ERROR **addition:** RED

Cause: The three error signals (101, 240, 592) have identical meanings. They merely differ in their max. text length and in the positions of the display. All data of a memory area of the machine ("A" or "B") or on the PMS card are no longer accessible (ED only). Due to a malfunction or ageing of the battery the data are no longer complete or they are incorrect; this can be stated on the basis of the check sums and the plausibility analysis of the data.
Attention! This message may be displayed when the machine is switched on for the first time (commissioning) and/or when the PMS card is used for the first time (ED only), since the memories "A" or "B" or the PMS board (ED only) have not yet been initialized by a cancelling process.

Remedy: The affected memory area can only be cleared to allow a new storage or to reload the data from a safety copy (from PMS- CARD (ED only) or COMPUCUT). If the error cannot be deleted by cancelling, replace battery on CPxx- board or complete CPxx- board.

Memos:

Error No.: 103

Error Text: PROGRAM NOT READABLE

State: ERROR **addition:** RED

Cause: Error messages 103, 241, 594 have the same meaning and indicate the same malfunction. They differ in their maximum text lengths and the position of the indication. The messages indicate that all the data of a program in the memory areas of the machine (ie.e. "A" and "B") or a program of board PMS (ED only) are no longer accessible. Because of a malfunction or an ageing battery the data are no longer complete or they are incorrect. This is detected by doing the checksums and checking data plausibility.

Remedy: The respective program(s) can only be deleted for making a new storage or reloading the data from a safety copy (from PMS- CARD (ED only) or COMPUCUT). If the error cannot be deleted by a clearing process, replace battery on CPxx- board or complete CPxx- board.

Memos:

Error No.: 104

Error Text: STEP NOT READABLE

State: ERROR **addition:** RED

Cause: Both error messages "104 and 242" have the same meaning. They only differ in their maximum text length. In one of the programs of machine memory areas "A" or "B" the data of one or several steps are no longer accessible (as a consequence all the data of any succeeding data step might be affected as well). Due to a malfunction or ageing of the battery the data are no longer complete or incorrect; this can be stated on the basis of the check sums and the plausibility analysis of the data. The steps affected are identified by marking the contents by dashes " - - - - -" in menues "CUTTING PROGRAM" and "PROGRAM INFORMATION".

Remedy: These steps must be removed from the program by a clearing operation and stored again. More convenient is the new storage of the complete program from a safety copy on PMS CARD (ED only) or COMPUCUT.
If the malfunction cannot be removed by an erasing process, replace battery on CPxx- board or complete CPxx- board.

Memos:

Error No.: 109

Error Text: PROGRAM(S) BUSY

State: HINT **addition:** YELLOW

Cause: This message indicates that one or more programs cannot be run, because they are being processed at that time in a different application (printer, Compucut).

Remedy: - Wait until program is released from other application
- Switch-on machine again or press reset key on CPxx- board.

Memos:

Error No.: 115

Error Text: AUTOTRIM TABLE OPEN

State: HINT **addition:** YELLOW

Cause:
Informs the operator that the AUTOTRIM table has not been closed (input signal "table open" to board CPxxhas been set). In some cases this message is output when a particular operating function (such as e.g. advance backgauge) is inadmissible while the table is open. This message is output cyclically while the Autotrim table remains open.
Some information concering the color status; a green colored hint serves to inform the operator, while a yellow message indicates a malfunction/error.

Remedy:
- Close Autotrim table
- if the table is mechanically closed, but the message remains, check limit switches S364 and cable connections.
- With ED machines check / replace SFM 95- board
- With ED machines check / replace ATR- board.
- With XT machines check / replace I/O-P1- board.
- With XT machines check relais K369

Memos:

Error No.: 116

Error Text: BACKGAUGE LOCKED

State: HINT **addition:** PURPLE

Cause:
In general, this message informs the operator that there is an external facility (such as e.g. Transomat) locking the backgauge movement. This is signalled by the corresponding external unit via its input to board SFM 95 when the peripheral equipment connected is not in resting position in stand alone mode (key-operated switch) in a system configuration.
Any trial to activate a machine function (e.g. backgauge movement) is prevented by the computer and indicated by an error message.

Remedy:
- Take peripheral equipment to resting position.
- Turn key-operated switch to position "generate operation with peripheral equipment"
- With ED machines check / replace SFM 95- board
- With XT machines ceck / replace I/O-P1- board
- Check plug-in connections and adapter
- On AC 25: verify position of LT- S and pressure clamp.

Memos:

Error No.: 117

Error Text: CUT INTERRUPTED

State: HINT **addition:** YELLOW

Cause: Indicates that a cut has been interrupted when the machine was in upper dead centre position. This is no malfunction, but a status message.
The machine should not be disconnected in this condition, because an error message would result when the machine is switched on again, because of the inadmissible home position.
In that case, the knife must be returned manually to its home position (clutch handles).

Remedy:
- Terminate cut, until knife has returned to home position (upper dead centre)
- Observe light barrier at the clamp A30 ("High-Speed Cutting" Option)
- Light barrier at the clamp is not properly recognised
- With ED and XT check connector 416 at transformer unit (8 V for knife upstroke control MHS)
- With POLAR 78ES and 78XS check / replace Transformer TR1 if necessary.
- Check proximity switches of safety bolt / replace them, if necessary (B. SBE + B. SBA).
- Check fixing of safety bolt solenoid (holding angle)

Memos:

Error No.: 118

Error Text: CLAMPING TIME INTERRUPTED

State: HINT **addition:** YELLOW

Cause: Indicates that a clamping process already started has been interrupted. This is no error indication but a status message.

Remedy:
- Terminate clamping process
- Observe possibly adjusted preclamping time
- V-belt of hydraulic pump is defective.

Memos:

Error No.: 125

Error Text: SAFETY BOLT MONITORING FAULTY

State: ERROR **addition:** RED

Cause: This error message signals that the safety rocker switch for the knife bar is in undefined position. Both proximity switches at the safety rocker, which are connected with the input of board SK 95, signal the positions "knife bar enabled" and "knife bar locked" at the same time.

Remedy:
- Check function and position of proximity switch B. SBE + B. SBA.
- Check / replace SK 95- board.
- Check cabling of B. SBE + B. SBA.

Memos:

Error No.: 127

Error Text: LIGHT BARRIER FAULTY

State: ERROR **addition:** RED

Cause: This error message signals that a fault was detected in the first inspection of the light barrier at the start of a cut. Cutting is no longer possible.

Remedy:
- Check light barrier board and cabling, replace LS board if necessary
- Replace SK 95- board.

Memos:

Error No.: 128

Error Text: CUT BUTTONS FAULTY

State: ERROR **addition:** RED

Cause: On one or both cut buttons the input signals for NO contacts and NC contacts (inputs of board SK95) have been detected as being set simultaneously. This constitutes a malfunction since only one input (either NO contact or NC contact) is admissible.

Remedy:
- Replace defective cut button S28a and S28b.
- Check cabling.
- Check / replace SK 95- board.
- Revise signals in input/output control of service menue.

Memos:

Error No.: 129

Error Text: SAFETY BOLT RETRACTED

State: ERROR **addition:** RED

Cause: This message indicates that in home position of machine (knife in upper dead centre or machine just switched on) the safety rocker switch for the knife bar is not in safety position "knife bar locked". For this purpose, a proximity switch at the safety rocker switch is connected with the input of board SK95 to allow detection. The error message is indicated after the machine is switched on or after a cut has been terminated (i.e. the knife has returned to UDC) and expiration of a waiting time of two seconds, if safety position “knife bar locked“ has not been reached. On 78ES this error may be caused when the computer voltage is dropping too fast.

Remedy:
- Check function and position of proximity switch B. SBE + B. SBA.
- Check / replace SK 95- board.
- Check cabling of B. SBE + B. SBA.
- Check mechanical stiffness of safety rocker switch.
- Switching time can be checked in menue "knife gearbox - control".
- On models 78 ES and 78XS check power supply unit G1/G2 and replace, if necessary.
- On 78 ES: Install capacitor with cable connection (id.no. 048320).

Memos:

Error No.: 130

Error Text: SAFETY BOLT LOCKING

State: ERROR **addition:** RED

Cause: This message indicates that during active cut (knife between upper and lower dead centre) or after the start of a cut (if the knife is to be activated) the safety rocker switch for the knife bar is not in safety position "knife bar enabled".
For this purpose, a proximity switch at the safety rocker switch is connected with the input of board SK95 to allow detection. The error message is indicated when the cutting position "knife bar enabled" is activated, but the Safety-Bolt has not reached the unlocked Position after a waiting time of 2 seconds.

Remedy:
- Check function and position of proximity switch B. SBE + B. SBA
- Check / replace SK 95- board.
- Check cabling of B. SBE + B. SBA
- Check mechanical stiffness of safety rocker switch
- Switching time can be checked in menue "knife gearbox - control"
- Check light barrier
- Check safety bolt fixture.

Memos:

Error No.: 131

Error Text: CUT CIRCUIT STAT. FAULT

State: ERROR **addition:** RED

Cause: Regarding the cutting function this error signal indicates a static "disagreement" (still existing after a "cutting cycle interruption") of software control and safety control channel of board SK95.

Remedy:
- Check SK 95- board, sensors and cabling of cutting cycle
- Check knife upstroke control
- Check light barrier.
- Use auxiliary screens "Input/output control and knife gearbox control" for localizing the malfunction.
- With ED machines check inline relay to the control panel for stacklift (short circuit).

Memos:

Error No.: 132

Error Text: CUT CIRCUIT INTERRUPTED

State: ERROR **addition:** PURPLE

Cause:

Regarding the cutting function, this error signal indicates a dynamic (one-time, sporadic) "disagreement" of software control and safety control channel of board SK95. This malfunction can be caused by a defective SK95 board. It is quite "normal" if this malfunction occurs sporadically.
As of software version ED V 1.4.0, error # 132 is no longer classified as a "serious" error in the red window. The new status as an "important hint" is filed in the status section.

Remedy:

- Press cut buttons for a longer time.
- Check SK 95- board, sensors and cabling of cutting cycle
- Check knife upstroke control, replace if necessary and connect it to +24Volt.
- Check light barrier
- Use auxiliary screens "Input/output control and knife gearbox control" to locate the malfunction
- Check / replace SAP- board.
- With ED machines check inline relay to the control panel for stacklift (short circuit)
- Check safety bolt; axial play, shatter of switches B. SBE + B. SBA, switching cam
- With ED and XT machines KAP- board (24 V defective)
- With 78ES and 78XS replace Transformer TR1 (id. no. 250967)
- On POLAR 66 this may result from a short circuit in the table lighting or cutting-line indicator.
- Safety bolt magnet (under load) has a short circuit.
- On 78 ES/ XS: Check transformer cabling.

Memos:

As of software version ED V 1.4.0, error # 132 is no longer regarded as a "serious" error in the red window. The new status as an "important hint" is filed in the status section.

Error No.: 133

Error Text: LIGHT BARRIER INTERRUPTED

State: HINT **addition:** YELLOW

Cause:
Informs the operator that the cut just being carried out has been aborted for safety reasons due to a light barrier obstruction.
If this error message occurs in spite of a non interrupted light barrier (display in LS) it may be possible that the second internal LS test has recognized an error.

Remedy:
- Check operating status display of light barrier. If LEDs D1 and D2 of LS are flashing there was an internal LS malfunction
- Replace LS board
- With ED machines, if this message is displayed in automatic mode only, check plug no.65
- Check / replace SAP- board
- With ED machines check / replace SFM- board.
- With XT machines check / replace I/O-P1- board.
- on X, XT machines: update software to V1.1.1 or more recent version (AT only).
- On AC 115: Deloading finger does not move up fast enough ?
- Check electrical rear-table protection.

Memos:
broken cable/wire from cut buttons S28a / S28b: With Autotrim machines in automatic knife mode, the Autotrim table opens, but stops on it's half way.

Error No.: 134

Error Text: CLAMP NOT LOWERED

State: HINT **addition:** YELLOW

Cause:
This information is issued when the operator tries cutting in "knife change" mode without having lowered the clamp. In this context, the message constitutes no error. For detecting if the clamp has been moved downward proximity switch "B29" is polled (clamp - top position).
This error message may also be displayed in option "cutting optimization", after the safety monitoring system of the detached knife has detected an error.
This condition is present when the clamp does no longer cover the cutting edge.

Remedy:
- Check proximity switch B29
- Replace SK 95- board
- Check LS for cutting optimization and cable in clamp.
- Check sensor for cutting optimization located in clamp
- Revise clamp travel speed
- With ED machines check PDR 95- board and smooth clamping valve.
- With XT machines check I/O-P1- board and smooth clamping valve.
- Check V-belt of hydraulic pump.
- Wrong direction of rotation with main motor.

Memos:
IN MACHINES WITH SOFTWARE FROM ED 1.4.0 AND UP THIS HINT COULD BE BASED ON A FAULT WITH THE CLAMP CONTROL. IF THE POWER SUPPLY FOR THE HYDRAULIC VALVES Y27 AND Y27a IS NOT ENSURED THIS MESSAGE WILL ALSO BE DISPLAYED.

Error No.: 136

Error Text: CUT LOCKED

State: HINT **addition:** PURPLE

Cause:
There are various operating conditions of the machine (such as e.g. parts of the knife change function) in which cutting is locked by the computer for safety reasons. If someone tries to trigger a cut, the above message is indicated.

Remedy:
- Establish home position for cut on operator level
- Change to program data display
- On machine type 78, menu "continued clamping" has been selected

Memos:

Error No.: 137

Error Text: SIDE GAUGE RETRACTED

State: HINT **addition:** YELLOW

Cause: There is a periodical display of this information while one or both side gauges are not in their resting position.
The message is also issued in automatic operation when a cut size has been programmed together with additional function "Retract side gauge" and the backgauge has moved to this position. The activated automatic knife is either switched off ormoved back to "preparation" step.

Remedy:
- With ED machines check switching position of SHM 95- board
- Take side gauges manually to upper resting position
- Check cabling and position limit switches of side gauges
- With ED machines check / replace SHM 95- board
- With XT machines check / replace I/O-P1- board

Memos:

Error No.: 138

Error Text: JOGGING MARK

State: HINT **addition:** GREEN

Cause: This additional function for a cut size prevents a cut from being released at this position.

Remedy:
- Delete additional function
- Position the next cut size

Memos:

Error No.: 140

Error Text: LOCKING VALVE 25V FAULTY

State: ERROR **addition:** RED

Cause: This error message indicates that input signal "locking valve 25V" to board CPxx has not been set, i.e. the 25-V voltage supply of locking valve Y315 must be verified. On 78 ES, this error may be caused when the computer voltage is dropping too fast.

Remedy:
- Measure supply voltage of 25 Vd.c. for locking valve Y 315
- Check mechanically if locking valve is functioning
- Measure solenoid (9-22 ohms)
- Check / replace SK 95- board
- With ED machines AC-IN- board is defective
- With XT machines check / replace electric rectifier V2
- Check / replace CPxx- board
- Check fuse on DC board.
- Rectifier AC board
- Check DIP switch on CPxx- board.
- On 78ES: install capacitor with cable connection (048320).
- Check POLAR 78ES transformer and replace it, if necessary (plug 94).
- check CU 0 volts.
- CU plug SK6 pin7 missing / please check.
- CU plug SK 52 missing / please check.
- SKÜ check plug no. 6
- Check correct setting of DIP-switches on CPxx- board for POLAR 66
- Check impulse generator IG1 and it's cabling.
- Short circuit in cutting circuit transformer area. (Check cabling.)

Memos:

Error No.: 189

Error Text: FIXOMAT OPERATION LOCKED

State: HINT **addition:** PURPLE

Cause: Informs the operator that front- and side margins must not be moved upward or downward at the moment, since the backgauge is positioned too close to the rear edge of the clamp (to prevent the claws from contacting the rear of the clamping bar.)

Remedy:
- Move to a position larger than 30 cm in order to move the claws (software).
- Check position and function of the respective table limit switch (360).

Memos:

Error No.: 190

Error Text: FIXOMAT LIMIT SWITCH FAULTY

State: ERROR **addition:** RED

Cause: Indicates a malfunction of front and side margins, i.e. both limit switches have been set at the same time, i.e. one or both claws could not be moved to a defined home position (e.g. if a limit switch is defective). In this condition the backgauge advance movement is locked.

Remedy:
- Check functioning of microswitch S341.
- Check functioning of microswitch S342.
- Check functioning of microswitch S343.
- Check functioning of microswitch S344.
- Check cabling of limit switches.
- Check switching cams and sliding clutch.
- With ED machines check / replace DNF 95- board.
- With XT machines check / replace I/O-P1- board.
- Check Fixomat motor.

Memos:

Error No.: 191

Error Text: FIXOMAT LIMIT SWITCH MISSING

State: ERROR **addition:** RED

Cause:
This message indicates that the computer has recognized no limit position of front- or side margins when the machine was switched on or during the operation.
The front or side margin is positioned at a location between both final positions which is not defined for CPxx. In this status the backgauge advance movement is locked.

Remedy:
- Move front / side margin to resting position
- Check functioning of microswitch S341.
- Check functioning of microswitch S342.
- Check functioning of microswitch S343.
- Check functioning of microswitch S344.
- Check cabling of limit switches
- Check switching cams and sliding clutch
- With ED machines check / replace DNF 95- board.
- With XT machines check / replace I/O-P1- board.
- Check Fixomat motor.

Memos:

Error No.: 196

Error Text: SWIVEL GAUGE END POSITION

State: HINT **addition:** PURPLE

Cause:

Informs the operator that one of the final positions has been moved to in manual mode. The respective final positions are scanned by microswitches.
In standard operation there is no malfunction,when the message is given at the corresponding mechanical position of the swivel backgauge.
However, if there is a permanent message or if it occurs within the admissible adjusting range of the swivel backgauge you should follow the remedies recommended.

Remedy:

- With ED machines check basic adjustment of DNF 95- board.
- Check mechanical and electrical basic adjustment of swivel backgauge.
- Check limit switches S347 and S348 and their cabling.
- With ED machines check / replace DNF 95- board.
- With XT machines check / replace I/O-P1- board.
- Check the complete cabling (0V shielding, e.g. on connector 713).
- Check and/or replace potentiometer.

Memos:

Error No.: 197

Error Text: TILT GAUGE END POSITION

State: HINT **addition:** PURPLE

Cause: Informs the operator that one of the final positions has been approached in manual mode. The corresponding final positions are polled by microswitches.
In normal operation no error is existing when the message is output at the corresponding mechanical position of the tilt backgauge.
However, if the message is displayed permanently or if it is output at an admissible position of the tilt gauge within its adjusting range the measures specified as remedies should be performed.

Remedy:
- With ED machines check basic adjustment of DNF 95- board.
- Check mechanical and electrical adjustment of tilting backgauge.
- Check limit switches S349 and S350 and their cabling
- With ED machines check / replace DNF 95- board.
- With XT machines check / replace I/O-P1- board.
- Check the complete cabling (0V shielding, e.g. on connector 713).
- Check and/or replace potentiometer.

Memos:

Error No.: 198

Error Text: SWIVEL GAUGE NO REACTION

State: ERROR **addition:** RED

Cause: This error message is issued if no position change has been registered on board CPxx after a time period of 5 seconds has elapsed subsequent to manual or automatic activation of the swivel backgauge.

Remedy:
- Check mechanical adjustability of swivel backgauge
- Check positioning motor M357.
- With ED machines check SER 95 unit / relay contacts.
- With XT machines check relais K357 and contacts.
- Check function / cabling of potentiometer "RD"
- With ED machines check / replace DNF 95- board.
- With XT machines check / replace I/O-P1- board.

Memos:

Error No.: 199

Error Text: TILT GAUGE NO REACTION

State: ERROR **addition:** RED

Cause: After the tilt gauge has been activated manually or automatically: when no position change has been registered by board CPxx after a waiting time of 5 seconds, this error message is output.

Remedy:
- Check mechanical adjustability of tiling backgauge.
- Check positioning motor M358.
- With ED machines check SER 95 unit / relay contacts.
- With XT machines check relais K358 and contacts.
- Check function / cabling of potentiometer "RN"
- With ED machines check / replace DNF 95- board.
- With XT machines check / replace I/O-P1- board.

Memos:

Error No.: 240

Error Text: MEMORY BANK FAULT: DELETE

State: ERROR **addition:** RED

Cause:

The three error signals (101, 240, 592) have identical meanings. They merely differ in their max. text length and in the positions of the display. All data of a memory area of the machine ("A" or "B") or on the PMS card (ED only) is no longer accessible. Due to a malfunction or ageing of the battery the data is no longer complete or it is incorrect; this can be stated on the basis of the check sums and the plausibility analysis of the data.
Attention! This message may be displayed when the machine is switched on for the first time (commissioning) and/or when the PMS board (ED only) is used for the first time, since the memory areas "A" or "B" or the PMS board (ED only) have not yet been initialized by a clearing process.

Remedy:

The affected memory area can only be cleared to allow a new storage or to reload the data from a safety copy (from PMS CARD (ED only) or COMPUCUT).
If the error cannot be deleted by a clearing process, replace battery on CPxx- board or complete CPxx- board or PMS CARD (ED only).
- ED machines depending on basic software version:
  1. V1.4.7 or higher
  2. V3.0.7 or higher
  3. V4.0.5 or higher
  4. V5.2.5 or higher

- XT machines depending on basic software version:
  1. V1.2.6 or higher

Memos:

Error No.: 241

Error Text: PROGRAM FAULT: DELETE

State: ERROR **addition:** RED

Cause: Error messages 103, 241, 594 have the same meaning and indicate the same malfunction. They differ in their maximum text lengths and the position of the indication. The messages indicate that all the data of a program in the memory areas of the machine (i.e. "A" and "B") or a program of PMS Card (ED only) is no longer accessible. Because of a malfunction or an ageing battery the data is no longer complete or it is incorrect. This is detected by doing the checksums and checking data plausibility.

Remedy: The respective program(s) can only be deleted for making a new storage or reloading the data from a safety copy (from PMS CARD (ED only) or COMPUCUT). If the error cannot be deleted by a clearing process, replace battery on CPxx- board or complete CPxx- board.

Memos:

Error No.: 242

Error Text: PROGRAM STEP FAULT: DELETE

State: ERROR **addition:** RED

Cause: Both error messages "104 and 242" have the same meaning. They only differ in their maximum text length. In one of the programs of machine memory areas "A" or "B" the data of one or several steps are no longer accessible (as a consequence all the data of any succeeding data step might be affected as well). Due to a malfunction or ageing of the battery the data are no longer complete or incorrect; this can be stated on the basis of the check sums and the plausibility analysis of the data. The steps affected are identified by their contents marked by dashes "- - - - - " in the menus "CUTTING PROGRAM" and "PROGRAM INFORMATION".

Remedy: These steps must be removed from the program by a clearing operation and stored again. More convenient is the new storage of the complete program from a safety copy on PMS CARD or COMPUCUT.
If the error cannot be deleted by a clearing process, replace battery on CPxx- board or complete CPxx- board.

Memos:

Error No.: 285

Error Text: WRONG REFERENCE POS. SIGNAL

State: ERROR **addition:** RED

Cause: The input signal of the mechanical reference sensor (B341) is not registered by SAP- board. The reference point (pulse) is only accepted by the computer if it is in the range of the mechanical switching flag of the reference sensor.

Remedy:
- Make a reference run and move the backgauge alongt the entire width of the table, if the position of the mechanical reference point switch has been modified
- Check functioning and position of sensor B 341
- Check cabling of B341
- Verify position values in service menu "machine data"

Memos:

Error No.: 286

Error Text: MULTIPLE MECH. REFERENCE POS.

State: ERROR **addition:** RED

Cause: In the range of the switching flag of reference switch B 341 (B341 high) the electrical reference point of the pulse transducer is registered several times. This is the case when the switching phase of B 341 is too long or has been detected in several positions.
The message is also output, if CPxx detects the reference position signal in a table position, which is beyond the range determined in the reference run.

Remedy:
- Make a reference run and move the backgauge alongt the entire length of the table.
- Erroneous or wrongly adjusted switching flag of reference point sensor
- Ceck / replace Pulse generator.
- Sensor B 341 defective.
- Check the proper mechanical connection between spindle and front extension part.

Memos: as of Version ED 5.0.0, this message is made more precise by messages 1778 and 1779.

Error No.: 289

Error Text: CUTTING NOT POSSIBLE

State: HINT **addition:** PURPLE

Cause: There are various operating conditions of the machine (such as e.g. parts of the knife change function) in which cutting is locked by the computer for safety reasons. If someone tries to trigger a cut, the above message is indicated.

Remedy:
- Establish home position for cut on operator level
- Change to program data display

Memos:

Error No.: 313

Error Text: OPTION NOT PRESENT

State: HINT **addition:** YELLOW

Cause: This message is indicated when the operator calls an optional machine function which is not available with this machine. The availability of this option is detected by polling the pre-adjustment for the corresponding option on the respective I/O-board. Other additional functions of the machine depend upon the machine type adjusted on CPxx- board.

Remedy:
- Check switches of corresponding I/O- boards for additional functions
- Check / replace I/O- boards for corresponding option
- Check / correct machine type adjustment on CPxx- board.

Memos:

Error No.: 328

Error Text: MACHINE NOT IN GROUND STATE

State: HINT **addition:** PURPLE

Cause:
A function which is not permitted at the actual condition of the machine is refused by the computer by issueing this note. At present, this message is provided for the downloading function planned.
The machine is in ground state when any of the following operating conditions applies:
a. active or interrupted cut / clamping process
b. backgauge movement active
c. knife changing mode
d. basic measurement setting

Remedy:
- Terminate the function started
- Change over to program data display
- Press reset pushbutton at CPxx- board
- Switch machine off/on

Memos:

Error No.: 399

Error Text: AUTOCUT ERROR:

State: HINT **addition:** PURPLE

Cause:
This error message is only issued on machines integrated into AUTOCUT 90-systems. It is indicated by the ED control system, exclusively on command of the programmable logical control of AUTOCUT-90 in order to signal malfunctions and error conditions in the AUTOCUT 90-peripherals.
The number specifies in detail the respective malfunction or the error condition. For the evaluation of this number a special description has been prepared.

Remedy:
- see Autocut 90 - list of errors

Memos:

Error No.: 432

Error Text: POSITION IMPULSES MISSING !

State: ERROR **addition:** RED

Cause: If the backgauge motor has been activated by the computer, but no travel difference at all or an insufficient travel distance is recognized after the preset nominal distance to be covered at a particular speed, this error message is issued.

Remedy:
- Check setting of frequency converter.
- Check smooth running of backgauge drive unit.
- Check setting of SAP- board (offset)

Memos:

Error No.: 469

Error Text: MAXIMUM CUTTING TIME ELAPSED

State: ERROR **addition:** RED

Cause:

This message is displayed if, during the execution of a cut, a maximum time allowance is exceeded while the knife is in active movement,
(safety watchdog in case the changeover valve does not operate correctly or any other malfunction has occurred.) When this error message is displayed the cut will be aborted automatically and the automatic knife operation is switched off. The maximum time allowance is 2.0 seconds UDC=> BDC (upper dead centre to bottom dead center) and 1.4 sec. BDC=> UDC. The actual time periods of the latest cut can be checked by the service staff.
(Operation: FUNCTION SURVEY -> SERVICE ->8520->MACHINE DATA).

Remedy:

- Check circuit P2 (clutch)
- Screw caps of valves Y33 and Y33a have loosened.
- Hydraulic oil is too cold
- Check main clutch (belt, air gap,air core 0,2 - 0,25mm, lining, fouled by oil).
- Mechanical stiffness of knife drive unit.
- Check pressure piston at gearbox
- Check magnetic clutch, type 78S, 78E (iron air gap, brake air gap).
- Various drive data can be revised in the service menu (for knife gearbox inspection)
- Defective knife upstroke control (MHS)
- Update the ED machine software to V1.4.5-13 or more recent version
- Check direction of rotation of main motor on Polar 66.
- Check solenoid of safety bolt
- Locking valve for knife change has twisted (Polar 66)
- If six internal springs (id. no. 279159) are mounted to the brake disk, two have to be removed.
- Install a new SKÜ "cutting circuit transformer" id. no. 49996". On POLAR 78, a value higher than 20 V d. c. must be measured at the clutch during a cut.
- Intermittent problems with +24Volt power supply, with ED machines check board PS 95- board.

Memos:

- On POLAR 66 this message will be displayed during knife change when the knife rests on the cutting stick. The error message is deleted whenthe knife returns to the uppermost position after the hydraulic locking valve has been opened. This malfunction is removed in the follow-up version of V2.1 of machine 66.

Error No.: 470

Error Text: WIND KNIFE UP MANUALLY !

State: HINT **addition:** PURPLE

Cause: After the machine has been switched on, this message signals that the knife is not in the upper dead centre. Machine was switched off during an aborted cut !

Remedy: Switch the machine off and wind the knife up to the upper dead centre by turning the flywheel. After that, machine operation can be continued by switching the machine on again.
- Check proximity switches B.SBE and B.SBA for safety bolt. (Correct adjustment and functioning)
- KAP- board defective (verify 8 V)
- Check knife upstroke control (MHS 95) and adjust, if necessary.
- Check / replace solenoid of safety bolt.
- Check / replace SAP- board.
- Check / replace SK- board.
- if this malfunction occurs with 78ES and 78XS machines in connection with error no. 603, replace transformer TR1 / PM unit.
- Check and/or replace cutting circuit transformer.
- Check the fuse F3.

Memos:

Error No.: 481

Error Text: SIDE GAUGE TIME ERROR

State: ERROR **addition:** RED

Cause:

The positioning of one or both side gauges has been interrupted after a max. time allowance of 15 seconds had expired without having reached the desired operating position (resting position or retracted position). The side gauges affected may be at an undefined position somewhere between upper and lower operating position.

Remedy:

- With ED machines check activation of corresponding magnetic valves Y155LU, Y155RU, Y155LO and Y155RO.
- With XT machines check activation of corresponding magnetic valves Y155, Y156, Y157 and Y158.
- ED machines with hydraulic side gauge check activation and function of hydr. changeover valve.
- With pneumatic operated side gauges check setting of exhaust air restrictor at the pneumatic valves.
- Check correct compressed air supply for the pneumatic valves.
- On ED machines check limit switches S120LU, S120LO, S120RU and S120RO and cabling.
- On XT machines check limit switches S120, S121, S122 and S123 and cabling.
- Check mechanical easy movement of side gauges.
- With ED machines check configuration of switches on SHM 95- board.
- With ED machines check / replace SHM 95- board.
- With XT machines check / replace I/O-P1- board.
- Check interlocking to peripheral equipment.

Memos:

Error No.: 482

Error Text: SIDE GAUGE END POS. MISSING

State: ERROR **addition:** YELLOW

Cause: For the next control cycle of the machine, the current position of the side gauge is polled by the computer. If no such position, signalled by limit switches, can be recognized by the computer, the system will output this message.

Remedy:
- On ED machines check limit switches S120LU, S120LO, S120RU and S120RO and cabling.
- On XT machines check limit switches S120, S121, S122 and S123 and cabling.
- With ED machines check / replace SHM 95- baord.
- With XT machines check / replace I/O-P1- board.
- Tiltable rear table guard is open / Check limit switch and cabling.

Memos:

Error No.: 483

Error Text: ERROR SIDE GAUGE END POS.

State: ERROR **addition:** RED

Cause: The limit switches of one or both side gauges do not work properly. The operating program detects the limit switch of the upper resting position as well as the bottom limit switch for the retracted position in activated condition.

Remedy:
- On ED machines check limit switches S120LU, S120LO, S120RU and S120RO and cabling.
- On XT machines check limit switches S120, S121, S122 and S123 and cabling.
- With ED machines check / replace SHM 95- board.
- With XT machines check / replace I/O-P1- board.
- Rear table guard open / please check limit switches.

Memos:

Error No.: 484

Error Text: KNIFE AT BDC:TIME INTERRUPTED

State: HINT **addition:** YELLOW

Cause: The cut buttons have been let off before the preset time for the knife to reach the mechanical BDC had passed. The minimum dwell time is 400 ms and starts as soon as the electr. BDC signal is reached. This message is merely a hint for the operator to inform him that the present "knife dwell time" has not been fully utilized. The computer continues normal operation assuming that the cutting material has been properly cut through.

Remedy:
- Keep pressing the cut buttons, until knife is automatically moved to TDC by the computer
- If the material has not been properly cut, the dwell time may be extended in menue "machine parameters"

Memos: only POLAR 66

Error No.: 485

Error Text: FIXOMAT END POSITION

State: HINT **addition:** PURPLE

Cause: The minimum cut size with activated Fixomat has been reached. The table limit switch assigned to the Fixomat has been actuated.

Remedy:
- Move backgauge sufficiently backwards and move Fixomat to resting position.

Memos:

Error No.: 486

Error Text: CLAMPING UNIT END POSITION

State: HINT **addition:** PURPLE

Cause: the minimum cut size with activated hold-down clamp in front of knife has been reached. The table limit switch assigned to the hold-down clamp (= Fixomat limit switch) has been actuated.

Remedy:
- Move backgauge sufficiently backwards and move hold-down clamping unit to resting position.
- Check micro switch S360 for "swivel hold-down clamp" and replace it, if necessary.

Memos:

Error No.: 488

Error Text: TIME ERROR FIXOMAT

State: ERROR **addition:** RED

Cause: This message is displayed, if the desired nominal position of the claws has not been reached within a max. time allowance of 5 seconds in the case of a manual or automatic change of front- or side margins. The claw positioning is aborted or terminated at the respective actual position.

Remedy:
- Check Fixomat limit switches S341, S342, S343 and S344.
- Check Fixomat motors M345 and M346
- Check cabling of limit switches / motor
- Check correct functioning of slide clutch
- With ED machines check / replace DNF 95- board.
- With XT machines check / replace I/O-P1- board.
- With XT machines check / replace FIX- board.
- Check smooth running of axles / claws.

Memos:

Error No.: 489

Error Text: TIME ERROR CLAMPING UNIT

State: ERROR **addition:** RED

Cause: This message is indicated when the clamping unit has been changed manually or automatically and the desired nominal position has not been reached within a max. time allowance of 5 seconds. Clamping bar positioning is interrupted and terminated at the actual position. The pneumatic cylinder and the correct air pressure is also monitored.

Remedy:
- Check correct attachment of plug-in connection X750.
- Check correct air supply and operating pressure.
- Check function of pneumatic valve Y1, replace if necessary.
- Check functioning of initialization switch S355.
- Check clamping unit for smooth running.
- Check swivelling motor M346 for clamping unit
- With ED machines check / replace DNF 95- board.
- With XT machines check / replace FIX- board.
- Check friction lining for sliding clutch and replace it, if necessary.
- Check / replace F2 fuse on AC-IN.

Memos:

Error No.: 492

Error Text: PUT FIXOMAT/CLAMPING UNIT IN RESTING POSITION

State: HINT **addition:** PURPLE

Cause: When the machine is switched on the computer is not able to distinguish between special equipment "hold-down clamping unit and Fixomat". This is done by automatically actuating the pressure cylinder or the side margin of the Fixomat. The movement made and the end position could not detect a clear identification of the special equipment.

Remedy:
- Move clamping unit / Fixomat manually to resting position
- Check correct attachment of plug-in connection X750.
- Check correct air supply as well as operating pressure (hold-down clamping unit)
- Check function of pneumatic valve Y1, replace if necessary.
- check function of initialization switch S355 (clamping unit).
- Check mechanical smooth running of clamp (clamping unit).
- Check swivel motor M346 for clamping unit.
- Check Fixomat limit switches S343 and S344.
- Check correct functioning of slide clutch.
- With ED machines check / replace DNF 95- board.
- With XT machines check / replace IO-P1 board
- With XT machines check / replace FIX- board.

Memos:

Error No.: 493

Error Text: CLAMPING UNIT BLOCKED

State: HINT **addition:** PURPLE

Cause: Indicates that the swivelling mechanism of the clamping unit must not be actuated at present, because the backgauge is located too far in front of the rear edge of the clamping bar.

Remedy:
- Move to backgauge position bigger than 30 cm.

Memos:

Error No.: 494

Error Text: ERROR CLAMPING UNIT END POS.

State: ERROR **addition:** RED

Cause: As far as the swivelling mechanism of the holding-down clamping unit is concerned, this indicates that both end positions have been set simultaneously, i.e. the swivel mechanism could not be moved to a defined home position.

Remedy:
- Move hold-down clamping unit / Fixomat manually to resting position
- Check correct attachment of plug-in connection X750.
- Check correct function of pneumatic valve Y1, if necessary replace it.
- Check functioning of initialization switch S355 (clamping unit)
- Check limit switches S343 and S344 of swivelling unit.
- Check correct functioning of slide clutch.
- With ED machines check / replace DNF 95- board.
- With XT machines check / replace I/O-P1- board.

Memos:

Error No.: 495

Error Text: CLAMPING UNIT END POS MISSING

State: ERROR **addition:** RED

Cause: Indicates that the clamping unit is at none of the three possible operating positions (resting position, ready-position, clamping), but at an undefined position or between two operating positions. This may occur when the clamping unit has been adjusted manually, i.e. not by key, or if the adjusting process for the clamping unit has been aborted because of a malfunction.

Remedy:
- A correction can be made by pressing any of the clamping unit keys. If the error message is deleted after that, the error has been caused by the clamping unit.
- Check correct fixing of plug-in connection X750.
- Check functioning of initialization switch S355 (clamping unit).
- Check limit switches S343 and S344 of swivelling unit.
- Check correct functioning of slide clutch.
- With ED machines check / replace DNF 95- board.
- With XT machines check / replace I/O-P1- board.
- With XT machines check / replace FIX- board.

Memos:

Error No.: 496

Error Text: FIXOMAT/CLAMP.UNIT END POS. ?

State: ERROR **addition:** RED

Cause:
This error message is displayed when the operating program of the machine is no longer able to detect if option FIXOMAT or hold-down clamp is present at that particular time.
Only the end positions indicate if FIXOMAT or hold-down clamp is connected. This message will generally be displayed when the machine has been retooled from FIXOMAT to hold-down clamp (or vice versa) while it was switched on.

Remedy:
As a remedy, press a key of the keypad for FIXOMAT and hold-down clamp. The subsequent conversion will cause the control unit to recognize automatically which of the options is connected at that time.
- Move clamping unit / Fixomat manually to resting position.
- Check correct attachment of plug-in connection X750.
- Check function of pneumatic valve Y1, if necessary replace it.
- Check correct air supply as well as operating pressure (hold-down clamp)
- Check function of initialization switch S355 (hold-down clamp).
- Check mechanical smooth running of clamp (hold-down clamp).
- Check swivel motor M346 for hold-down clamp.
- Check Fixomat limit switches.
- Check Fixomat motors M345 and M346.
- Check correct functioning of slide clutch.
- With ED machines check / replace DNF 95- board.
- With XT machines check / replace I/O-P1- board.
- With XT machines check / replace FIX- board.
- Parting of a cable in the trailing cable
- With ED machines check F6 on PM unit and F1, F2 on board DNF, and replace, if necessary

Memos:

Error No.: 498

Error Text: FUNCTION NOT ALLOWED

State: HINT **addition:** YELLOW

Cause: This message is displayed after an attempted input of inadmissible functions.

Remedy: - Check program setup and / or input of functions

Memos: The POLAR cutter 66 is equipped only with Memory Bank A. If Memory B will be selected this message will be displayed.

Error No.: 511

Error Text: PMS CARD NOT INSERTED

State: HINT **addition:** PURPLE

Cause: This message informs the operator that the execution of the desired function requires the PMS card to be inserted into the slot at the control unit. The operating program of keyboard computer KCxx- board detects whether the PMS card has been inserted or not.

Remedy: When this error message has been displayed after PMS card has been inserted, please check the following items:

- PMS Card defective
- Fixture of PMS Card on KCxx- board defective
- Check / replace KCxx- board.

Memos: Attention:with ED machines only

Error No.: 512

Error Text: DATA ERROR ON PMS CARD

State: ERROR **addition:** RED

Cause: This message indicates that a part of the data stored on the PMS card is no longer legible (i.e. individual programs and/or records).
The data is no longer complete or incorrect, as a consequence of a malfunction or an ageing battery. This has been detected when doing the check sums and inspecting the plausibility of data.

Remedy: The affected programs on card PMS must be detected and deleted. The programs that have been lost must be set up anew or loaded from a safety copy (from Compucut or machine memory "A"/"B").

- Replace battery of PMS card
- Replace PMS card

Memos: Attention:with ED machines only

Error No.: 513

Error Text: PMS CARD VERIFY ERROR

State: ERROR **addition:** RED

Cause: This message indicates a serious malfunction during recording access to the PMS Card. After the recorded information was read again the unit detected an error. This may be caused by an aged battery or a defective PMS card. A defective keyboard may also be the cause of the malfunction.

Remedy: The corresponding program on PMS card must be detected and deleted. The lost programs must be set up anew or loaded from a safety copy (from Compucut or machine memory "A"/"B").

- Replace battery of PMS card
- Replace PMS card

Memos: Attention:with ED machines only

Error No.: 514

Error Text: PMS CARD COMPLETELY ILLEGIBLE

State: ERROR **addition:** RED

Cause: All data stored on PMS card is no longer accessible. The data is no longer complete or is incorrect, as a consequence of a malfunction or an ageing battery. This has been detected when doing the check sums and inspecting the plausibility of data. The affected PMS board can only be cleared in order to allow a new storage. Attention! This message may be displayed generally when the PMS board is used for the first time, since this PMS card has not yet been initialized by a clearing process.

Remedy: The lost programs must be set up anew or loaded newly from a safety copy (from Compucut or machine memory "A"/"B").

- Replace battery of PMS card
- Replace PMS card
- “Initialize“ the card by deleting it complete.

Memos: Attention:with ED machines only

Error No.: 515

Error Text: PMS CARD INVALID

State: HINT **addition:** PURPLE

Cause: This message is issued in menue "PMS CARD" when the PMS card inserted into the keyboard unit cannot be identified to be a cutting program card. This may be the case when the PMS card is defective, does not have a minimum capacity of 64 kilobytes RAM or cannot be recorded (no RAM card). As a principle, only writable PMS cards can be detected in the keyboard unit. Such cards must have a capacity of 64 kB to 1 MB.

Remedy:
- Insert proper type of card
- Possible defect in PMS card

Memos: Attention:with ED machines only

Error No.: 516

Error Text: ALL DATA ILLEGIBLE: DELETE

State: ERROR **addition:** RED

Cause: The complete data of a program storage area in the machine (A or B) or on the PMS card (ED only) is no longer accessible. Due to a malfunction or ageing of the battery the data is no longer complete or incorrect; this can be stated on the basis of the check sums and the plausibility analysis of the data.
Attention! This message may be displayed generally when the machine is switched on for the first time (commissioning) and/or when the PMS card (ED only) is used for the first time, since the memory areas A or B or the PMS card (ED only) have not yet been initialized by a clearing process.

Remedy: The affected memory areas can only be cleared to allow a new storage.

Memos:

Error No.: 517

Error Text: VERIFY ERROR: DELETE

State: ERROR **addition:** RED

Cause: This message signals a crucial malfunction in a writing access to the machine program memories ("A" or "B") or on card PMS (ED only).
After the recorded information has been read, a dissimilarity has been detected.

Remedy: The error may be caused by an aged battery on board CPxx- board (or battery of PMS card -ED only-) or a defective CPxx- board (or else defective PMS card -ED only-).
If this error message is issued during access to PMS card (-ED only-) this may also be caused by a defect in the programming unit.

Memos:

Error No.: 573

Error Text: SOURCE PROGRAM ILLEGIBLE

State: ERROR **addition:** RED

Cause: This message may be displayed during operating functions "COPY PROGRAMS", "COPY ON PMS CARD" and "LOAD FROM PMS CARD" (ED only). The message indicates that the data stored in a source program (in memory areas "A" or "B" of the machine or on PMS card (ED only) is no longer accessible. Because of a malfunction or an ageing battery the data is no longer complete or it is incorrect. This is detected by doing the checksums and checking data plausibility. The program in question can neither be copied nor loaded. It can only be cleared in order to make a new storage or to reload it.

Remedy:
- Clear the affected source programs, generate them again or load them from a safety copy
- Safe all programs that are still legible and replace the battery after that
- Replace PMS Card (ED only)

Memos:

Error No.: 574

Error Text: DESTINAT. PROGRAM DATA ERROR

State: ERROR **addition:** RED

Cause: This error may occur with operating functions "COPY PROGRAMS", "COPY ONTO PMS CARD" and "LOAD FROM PMS CARD" (ED only). The message indicates that the data of the destination program is no longer accessible. Because of a malfunction or an ageing battery the data is no longer complete or it is incorrect. This is detected by doing the checksums and checking data plausibility.

Remedy: The respective program(s) can only be deleted to permit a new storage or reload the data from a safety copy (on COMPUCUT or PMS card -ED only-)

Memos:

Error No.: 576

Error Text: SOURCE MEMORY ILLEGIBLE

State: ERROR **addition:** RED

Cause: This message may be displayed during operating functions "COPY PROGRAMS", "COPY ON PMS CARD" and "LOAD FROM PMS CARD" (ED only). The message indicates that the data stored in one of the memory areas of the machine ("A" or "B") or on card PMS is no longer accessible. Because of a malfunction or an ageing battery the data is no longer complete or it is incorrect. This is detected by doing the checksums and checking data plausibility.
The data in this memory area can neither be copied nor loaded.

Remedy: The affected memory area can only be cleared in order to permit a new storage or to reload the data.
- Clear the affected source memory, generate it again or load it from safety copy
- Safe all programs that are still legible and replace battery after that
- Replace PMS Card (ED only)

Memos:

Error No.: 577

Error Text: DESTINATION MEMORY ILLEGIBLE

State: ERROR **addition:** RED

Cause: This error may occur with operating functions "COPY PROGRAMS", "COPY ONTO PMS CARD" and "LOAD FROM PMS CARD" (ED only). The message indicates that all the data of a memory section of the machine (i.e. "A" or "B") or of card PMS (ED only) are no longer accessible. Because of a malfunction or an ageing battery the data is no longer complete or it is incorrect. This is detected by doing the checksums and checking data plausibility. No data can be copied or stored onto this memory section.

Remedy: The respective memory section can only be deleted to permit a new storage or reload the data from a safety copy (on COMPUCUT or PMS card -ED only-).

Memos:

Error No.: 585

Error Text: CLAMP NOT IN UPPER POSITION

State: HINT **addition:** PURPLE

Cause:

Once a cut has been terminated and the knife returned to the upper dead centre a timer is started (10 seconds) in the course of which the clamp has to recognize switch B29. If the return of the clamp is not registered during this waiting time the above error message is issued.
Exception: (machines 78 - 176)
If the clamp has been locked on the cutting material by means of a pedal the timer is only started after the switches S390 and S309 have been released. If the clamp is actuated again during the upstroke the timer will be RESET. This is why the above message is usually indicating a real malfunction which causes the automatic backgauge to be automatically switched off.
Exception: (Polar 66)
On this type of machine switches S309 and S390 are not scanned by the computer. This is why this message may also occur during operation while the pedal is still actuated after a cut. In this case the message serves as a user information, the automatic backgauge is not shut off and the automatic operation is continued once B29 has been recognized.

Remedy:

- Check mechanical adjustment of clamp guiding
- Check adjustment of recuperating spring
- Check adjustment of kinematics
- Check clamp travel time
- Check adjustment and functioning of S390 and S309 as well as switching cams
- Check clamp limit switch B29
- Check cabling to switches
- Check SK 95- board

Memos: The status has been changed to "hint" as of ED Version V 4.0.0.

Error No.: 592

Error Text: MEMORY SECTION ILLEGIBLE

State: ERROR **addition:** RED

Cause: The three error signals (101, 240, 592) have identical meanings. They merely differ in their max. text length and in the positions of the display. All data of a memory area of the machine ("A" or "B") or on the PMS card (ED only) is no longer accessible. Due to a malfunction or ageing of the battery the data is no longer complete or it is incorrect; this can be stated on the basis of the check sums and the plausibility analysis of the data.
Attention! This message may be displayed when the machine is switched on for the first time (commissioning) and/or when the PMS card (ED only) is used for the first time, since the memories "A" or "B" or the PMS card (ED only) have not yet been initialized by a clearing process.

Remedy: The affected memory area can only be cleared to allow a new storage or to reload the data from a safety copy (from PMS card -ED only- or COMPUCUT). If the error cannot be deleted by clearing, replace battery on CPxx- board or complete CPxx-board.

Memos:

Error No.: 594

Error Text: PROGRAM DATA ERROR

State: ERROR **addition:** RED

Cause: Error messages 103, 241, 594 have the same meaning and indicate the same malfunction. They differ in their maximum text lengths and the position of the indication. The messages indicate that all the data of a program in the memory areas of the machine (ie.e. "A" and "B") or a program of card PMS (ED only) is no longer accessible. Because of a malfunction or an ageing battery the data is no longer complete or they are incorrect. This is detected by doing the checksums and checking data plausibility.

Remedy: The respective program(s) can only be deleted for making a new storage or reloading the data from a safety copy (from PMS card -ED only- or COMPUCUT). If the error cannot be deleted by a clearing process, replace battery on CPxx- board or complete CPxx- board.

Memos:

Error No.: 602

Error Text: NEGATIVE IMPULSES FROM KNIFE

State: ERROR **addition:** RED

Cause:
Negative counting pulses occurring upon the start-up or in active knife movement or negative values less than minus 8 degrees or minus 5 pulses for knife position will cause this error message to be output. The cut is aborted or refused.
Negative counting pulses can be caused by changes of direction or mechanical gear play in a newly started knife movement.

Remedy:
- Check correct grounding of frequency converter.
- Knife upstroke control defective.
- Check cable route or bus connection / knife upstroke control - SAP- board/ CPxx- board.
- Check / replace SAP- board.
- Check / replace CPxx- board.
- Check data of knife gear control or knife trace; wrong pulse values in the trace are represented inversely.
- Check mechanical play of gears.
- Check knife adjustment (too deep into the cutting stick).
- PS 95- board (ED only) intermittent problems with +24Volt.

Memos:

Error No.: 603

Error Text: KNIFE POSITION ERROR

State: ERROR **addition:** RED

Cause:
After start of cutting or during active cut, this message is output if the positions of electrical BDC and knife pulse counter are not plausible with respect to each other. In such a case, the knife movement is interrupted or not permitted, for safety reasons.

Remedy:
- With ED machines check fuse F3 of voltage supply of MHS (knife upstroke control).
- With XT machines check fuse F4 of voltage supply of MHS (knife upstroke control).
- Knife upstroke control is defective.
- Check correct grounding of frequency converter.
- Check cable route or bus connection / knife upstroke control - SAP- board/ CPxx- board.
- Check / replace SAP- board.
- Check / replace CPxx- board.
- Check data of knife gear control or knife trace; wrong pulse values in the trace are represented inversely
- Check mechanical play of gears
- Replace transformer TR1 on 78 ES / 78XS, or, if necessary, replace entire PM unit (Transformer id. no. 250967, series as of mach. no. 7161001)
- Check / replace SK- board.
- Replace CU of 66.
- Replace power supply unit G1 of 66.

Memos:
Before V 1.4.0, this text read "KNIFE PULSE POSITION ERROR".

Error No.: 605

Error Text: KNIFE LIFT IS DOWN, CUTTING NOT POSSIBLE

State: HINT **addition:** PURPLE

Cause: This indication has been prepared for future position scanning during the knife change. This input signal is supplied to SAP- board, but at present it is switched permanently to 0 signal by a jumper !! This error message is generally displayed in the knife change screen form.

Remedy:
- Peripheral connector with jumper 98.4 to 98.5 is missing.
- Replace SAP- board.
- Fuse F3 defective.

Memos:

Error No.: 606

Error Text: KNIFE LIFT IS DOWN !

State: HINT **addition:** PURPLE

Cause: This indication has been prepared for future position scanning during the knife change. This input signal is supplied to SAP- board, but at present switched firmly to 0 signal by a jumper !! This error message is generally displayed when the operator tries to perform a cut in the knife change screen form, although the display indicates that no cutting is possible in this mode.

Remedy:
- Peripheral connector with jumper 98.4 to 98.5 is missing.
- Replace SAP- board.
- Fuse F3 defective.

Memos: B 342 knife lift lowered? See Diagram SAP, if switch is missing than jumper 98.4 to 98.5 has to be set.

Error No.: 608

Error Text: KNIFE IMPULSES MISSING

State: ERROR **addition:** RED

Cause: Too few counting pulses have been registered by the computer during an active cut. The sum of the counting pulses determined is bigger than 275 (knife pulse trace).

Remedy:
- Check correct grounding of frequency converter
- Knife upstroke control is defective
- Check cable route or bus connection / knife upstroke control - SAP- board/ CPxx- board.
- Check / replace SAP- board.
- Check / replace CPxx- board.
- Check data of knife gear control or knife trace; wrong pulse values in the trace are represented inversely
- Check mechanical play of gears
- Knife speed too low (clutch slides, clutch pressure too low).
- Wear of clutch and brake linings.
- Gear is too tight (replace it).
- Check wear or soiling of slip ring and carbon brushes.
- Replace magnetic valve Y33, ball cage is defective.
- Short circuit of left bulb of optical cutting line indicator (model 115).
- Check card SK95, replace, if necessary.
- Check solenoid and sensors B.SBE and B.SBA of safety bolt.
- Update the software (V 1.4.5-13 or higher).
- Check air gap of brake on gearbox.
- Check tight fit of shear bolt.
- Check V-belt of hydraulic pump.
- With ED machines Software Update to V 1.4.5-13 or V 3.0.6-13, resp., (includes the latest updates and the same time window as V1.4.5-13)
- PS 95- board (ED only) intermittent Problems with +24Volt power supply.

Memos:

Error No.: 621

Error Text: BACKGAUGE HOME POS. UNKNOWN

State: HINT **addition:** PURPLE

Cause: This note is displayed when the machine, after having been switched on, has lost all the information filed in CMOS on CPxx (home position, brake afterrun etc.). This note is also displayed during the first commissioning or when board CPxx has been replaced.

Remedy:
- Make reference run and adjust home position (menu)
- Check battery on CPxx- board (min. 3V)
- CPxx- board defective (RAM malfunction)

Memos:

Error No.: 632

Error Text: FLAP FOR KNIFE CHANGE IS OPEN

State: HINT **addition:** PURPLE

Cause: When the knife change flap is opened during a knife change or during normal operation, this indication is displayed when the operator tries to trigger a cut.

Remedy:
- Close knife change flap
- Check proximity switch of knife change flap (S340)
- Check cable route / input of SAP- board.

Memos:

Error No.: 639

Error Text: KNIFE AFTER-RUNNING TOO LARGE

State: ERROR **addition:** RED

Cause:
This message is output if the computer recognizes an inadmissible deviation of the knife afterrunning. The factory-adjusted tolerance value as well as the actual value can be revised in service survey "knife gearbox contro"l "machine data".
Knife afterrunning is checked by the computer as far as time and distance is concerned. If the message is displayed in magenta colour the maximum limit value is almost achieved. A message displayed in red indicates that the max. limit value has been exceeded. In that case no more cuts can be performed.

Remedy:
- Switch machine off /on to make a test cut
- Inspect main clutch (fouled by oil, brake air gap too wide, friction value of linings)
- Check magnetic clutch (iron air gap and/or brake springs)
- Inspect mechanical gear play
- Check / replace cutting circuit transformer (SKÜ)
- Replace springs from the brakedisk (gearbox), increase brake force

Memos:
As of V 4.0.0, this error number is no longer used. It has been replaced by two new messages to allow for a better distinction.

Error No.: 641

Error Text: SMOOTH PRESSURE VALVE DEFECT.

State: ERROR **addition:** RED

Cause:
Machines fitted with the option "cutting optimization" revise the functioning and availability of the smooth pressure valve after start-up and with every cut. This is made by briefly activating it and evaluating the feedback.
Machines not furnished with this option must be adjusted correspondingly by a configuration (DIP switch CPxx- board).

Remedy:
- Check configuration of DIP switch on CPxx- board (SW2 - switch # 5)
- Hydraulic valve defective / cabling.
- With ED machines check / replace PDR 95- board.
- With XT machines check / replace SAP-02 board.
- Check / replace SK 95- board.

Memos:

Error No.: 653

Error Text: NO REFERENCE POSITION IMPULSE

State: ERROR **addition:** RED

Cause: This error message is displayed when:

- No electrical reference pulse is detected during the reference run
- No electrical reference pulse is detected in the switching phase of the mechanical reference switch
- No electrical reference pulse is detected when moving over the reference position stored.
- During the reference run, neither the mechanical nor the electrical reference point is detected.

Remedy:

- Make a reference run and move the backgauge along the entire width of the table, if the position of the mechanical reference point switch has been modified
- Check functioning and position of sensor B 341
- Check cabling B 341
- Check position values in service menu "machine data".
- Check / replace pulse generator
- Check /replace SAP- board
- Check /replace CPxx- board .
- Flag for B341 needs to be adjusted correctly (distance and position).
- Check the coupling for spindle extension.
- Is the pulse generator plugged to X23 (Polar 78ES)
- has pulse generator on plug X23 been plugged in? (Polar 78 ES/XS)
- check S1 electrical interlocking of rear-table guard (neither cut nor backgauge movements are possible)
- Check backgauge motor, electrical connections and it's cabling.

Memos:

Error No.: 654

Error Text: NO POSITION COUNTER IMPULSES

State: ERROR **addition:** RED

Cause:

During an active backgauge run: if no or too few counting pulses are received from the signal transducer the above error message will be output.
This is done whenever the actual speed of the backgauge falls below the nominal speed by 1/8. On 78 ES, this error may be caused when the computer voltage is dropping too fast.

Remedy:

- Verify setting of frequency converte.
- Mechanical stiffness of backgauge drive, check table spindle.
- C014: with Lenze Motor=2, others=0. resp. see description of freq. Converter.
- Check / adjust backgauge drive motor with brake, brake is moving on small measurements.
- Check and/or replace the backgauge drive motor with brake. (If the brake is shaking when dealing with short cutting position, replace the brake)
- Frequency converter is defective (on machines with TML, check the display, and compare with error list in frequency converter manual).
- Check / replace pulse generator
- Check cable routes / connections
- Check / replace SAP- board
- Check / replace CPxx- board
- Check proper connection of main terminals from backgauge motor
- Parting of cable to the limit switches in the clamp (S6, S218, S218b)
- Check fuse F8
- Current limitation G3 is active (POLAR 66)
- Check correct adjustment of S13 and switching cam
- Check correct grounding of backgauge motor
- Install supporting rings for spindle (Polar 66)
- Check tight fit of spindle extension
- Adjust 0V by means of potentiometer on board SAP.
- Verify smooth operation of slot cover band rolls.
- On 78ES: install capacitor with cable connection (048320).
- update XT with rear-table loading to V1.1.2-0 software or higher.
- Check plug no. 26 for Freq. Converter / SAP.
- Frequency converter setting, parameter step, try C016 with 8-20%. (please, refer also to the current parameter list in the frequency converter manual).
- Verify cable routes and connections (connectors 23/ 24 may be reversed).
- On machines with servo: check if toothed belt is too slack or to tense: Adjust offset on SAP- board and/ or servo device.
- Check position B 341.
- After converting to Vector, there may be a contact malfunction on the I/O module.

Memos:

Turn machine 66 off for approx. 30 sec. to reactivate current limitation.

Error No.: 655

Error Text: POSITION COUNTER CHIP DEFECT.

State: ERROR **addition:** RED

Cause: When the selftest for the "position counter chip" results negative after the machine has been switched on or during operation of machine.

Remedy: - Replace CPxx- board.

Memos:

Error No.: 656

Error Text: REFERENCE POSITION ERROR

State: ERROR **addition:** RED

Cause: The actual position loaded into the control counter when the reference position is passed does not coincide with the reference position stored. The allowance adjusted is also exceeded in this case (default = 0.008 cm).
This is caused by the loss of counting pulses during the backgauge run, or if the mechanical reference switch detects "multiple" positions, or positions beyond the range determined during the reference run.
On 78 ES, this error may be caused when the computer voltage is dropping too fast.

Remedy:
- Make a reference run and move the backgauge along the entire width of the table, if the position of the mechanical reference point switch has been modified
- Use service menu "machine data" for troubleshooting
- Check / replace pulse transducer
- Check cable routes / connection.
- Check / replace SAP- board.
- Check / replace CPxx- board.
- Check mechanical reference switch (flush version, id. no. 228472 on POLAR 66) and switching flag.
- Check power supply units G1 / G2 and replace, if necessary.

Memos: Previously, i. e. before ED V 1. 4. 0, a different text was used (POSITION COUNTER CONTROL ERROR.)

Error No.: 663

Error Text: CHECK DIP SWITCH SETTING ON SFM BOARD

State: HINT **addition:** PURPLE

Cause: When the key-operated switch in a "system" is set to "machine - single operation", but the setting of the DIP switches on board SFM95 does not show any system configuration.

Remedy: The malfunction can be corrected by setting the right configuration or removing the wiring of "input key-operated switch".

- Check / replace SFM 95- board
- Check key-operated switch / wiring.

Memos: Attention:with ED machines only

Error No.: 664

Error Text: MOVE ALL PERIPHERAL EQUIPMENT TO HOME POSITION !

State: HINT **addition:** PURPLE

Cause: When the key-operated switch in a system configuration has been turned to „machine single operation“, but the peripheral equipment connected is not at home position.

Remedy:
- Move peripheral equipment to home position
- Set key-operated switch to position „system operation“
- With ED machines check / replace SFM 95- board.
- With XT machines check / replace I/O-P1- board.
- Check key-operated switch / wiring
- Check cabling of peripheral equipment to SFM 95- board.

Memos:

Error No.: 667

Error Text: SYSTEM CONFIGURATION MISSING

State: ERROR **addition:** RED

Cause: This message signals a wrong setting or a wrong switching of board SFM 95. The input "key-operated switch Stand Alone" of board SFM95 has been recognized (only connected in system configuration), but no external peripheral equipment has been configured (DIP switches 1 - 3 OFF) on board SFM.

Remedy: Malfunction can be eliminated by adjusting the correct configuration or by removing the connection with Input key-operated switch.

Memos: Attention:with ED machines only

Error No.: 668

Error Text: OPERATION WITHOUT PERIPHERALS

State: ERROR **addition:** RED

Cause: This important notice serves to inform the operator permanently that the cutting machine has been released from the system operation (key-operated switch = single operation). In this particular situation the machine can be operated independently from the peripheral equipment. This requires "utmost" care on the part of the operator.

Remedy:
- Turn machine to "system operation" by means of key-operated switch
- With ED machines check / replace SFM 95- board.
- With XT machines check / replace I/O-P1- board.
- Check key-operated switch / wiring.
- With ED machines check cabling of peripheral equipment to SFM 95- borad.
- With XT machines check cabling of peripheral equipment to I/O-P1- board.

Memos:

Error No.: 672

Error Text: OPERATION WITH PERIPHERALS

State: HINT **addition:** GREEN

Cause: This note serves to inform the operator permanently that the machine has been switched to system configuration. (key-operated switch = system operation). In this situation the machine can only be operated in connection with the peripherals linked to it.
- I/O P board is plugged in, and no optional equipment available (lift, VL, peripheral equipment)

Remedy:
- Turn machine to "single operation" by means of key-operated switch
- With ED machines check / replace SFM 95- board.
- With XT machines check / replace I/O-P1- board.
- Check key-operated switch / wiring.
- With ED machines check cabling of peripheral equipment to SFM 95- borad.
- With XT machines check cabling of peripheral equipment to I/O-P1- board.

Memos:

Error No.: 673

Error Text: POLAR NOT READY FOR OPERATION

State: HINT **addition:** PURPLE

Cause: The key-operated switch in a "system" has been set to "machine - stand-alone operation", but the peripheral equipment connected is not at resting position. In this special situation the machine cannot be operated independently from the peripheral equipment.

Remedy:
- Set peripheral equipment to resting position
- Set key-operated switch to position "system operation"
- With ED machines check / replace SFM 95- board.
- With XT machines check / replace I/O-P1- board.
- Check key-operated switch / wiring.
- With ED machines check cabling of peripheral equipment to SFM 95- borad.
- With XT machines check cabling of peripheral equipment to I/O-P1- board.

Memos:

Error No.: 674

Error Text: POLAR IS READY FOR OPERATION

State: HINT **addition:** PURPLE

Cause: When the key-operated switch in a "system" has been set to "machine - stand-alone operation", but the peripheral equipment connected is at resting position. In this special situation the machine can be operated independently from the peripheral equipment.

Remedy:
- Set key-operated switch to position "system operation"
- With ED machines check / replace SFM 95- board.
- With XT machines check / replace I/O-P1- board.
- Check key-operated switch / wiring.
- With ED machines check cabling of peripheral equipment to SFM 95- borad.
- With XT machines check cabling of peripheral equipment to I/O-P1- board.

Memos:

Error No.: 701

Error Text: WRONG BACKGAUGE DIRECTION !

State: ERROR **addition:** RED

Cause: The counting pulses expected from the positioning counter are checked for their plausibility depending upon their direction of rotation. As a consequence, the value must be decreased with an advance movement of the backgauge and increased with the reverse movement. If this is not the case the backgauge run is interrupted and an error message output. This may be caused by a frequency converter or pulse generator improperly connected. This monitoring function is also active in secondary operation.

Remedy:
- Check connection of backgauge motor M17 to frequency converter
- Check connection / cable from encoder
- Replace pulse transducer
- Replace SAP- board.
- Check limit switch S13.
- On machines with Servo: - Check offset (0V) at Servo.
- On machines without Servo: - Check offset (0V) at SAP board.

Memos:

Error No.: 703

Error Text: WARNING ! KNIFE AFTERRUN

State: HINT **addition:** PURPLE

Cause: This message is caused by an "excessive" afterrun of the knife, detected by the computer. Although the machine can still be operated with the calculated afterrun, the cause for this increase in afterrun ought to be analyzed and eliminated by a service engineer. (This operating condition can be compared with the amber phase of a traffic light).

Remedy:
- Inspect main clutch (fouled by oil, brake air gap too wide, friction value of linings).
- Check magnetic clutch (iron air gap and / or brake springs).
- Check mechanical gear play.
- Bleed the gearbox
- Make sure, there is no excessive V-belt tension.
- Replace springs in brake plate (as on model 78)
- Replace KAP- board (X4).
- Install new version of brake linings (115 = id. no. 48170, 137 = id. no. 48171,

Memos:
- Software update with ED machines (V 1.4.5 - 13 or higher)

Error No.: 704

Error Text: KNIFE AFTERRUN LIMIT EXCEEDED

State: ERROR **addition:** RED

Cause: The knife afterrun calculated by the computer is too long to ensure a safe functioning of the machine. After this error message has been output only one single cut can be performed at a time, for testing purposes within one switching - on period. The message is filed in the Error Trace.

Remedy:
- Switch the machine off / on to make a check cut
- Inspect main clutch (fouled by oil, brake air gap too wide, friction value of linings)
- Check magnetic clutch (iron air gap and / or brake springs).
- Check mechanical gear play.
- Bleed the gearbox.
- Replace the cutting circuit transformer (SKÜ).

Memos:

Error No.: 745

Error Text: PROGRAM WITHOUT GRAPHICS

State: HINT **addition:** YELLOW

Cause: This indicates a cutting program generated without the necessary additional information for establishing graphical process visualization.
The hint is also given when a program that carries such additional information is modified by the operator, causing the additional information for process visualization to become invalid and hence be cleared automatically.
In this particular case graphic process visualization is only possible with machine version ED Color and XT. The additional information mentioned is either generated by Compucut or block programming.
In general, a cutting program can be processed without process visualization.

Remedy: - Check adjustment of DIP switches on CPxx- board
- Reload program with necessary additional information from PMS board (ED only).

Memos:

Error No.: 746

Error Text: WARNING: LOOSING GRAPHICS !

State: HINT **addition:** YELLOW

Cause: This note is issued when a cutting program generated with additional information for establishing process visualization is modified by the operator, causing the additional information for process visualization to become invalid and hence be cleared automatically. When this note is displayed no modification of the program has yet been made.
Program change is only executed after the ENTER key is pressed again by the operator. After that, the program can only be processed without process visualization. In this particular case graphical process visualization is not possible with machine version ED Color.

Remedy: - Check setting of machine type on CPxx- board.

Memos:

Error No.: 806

Error Text: DOWNLOAD CARD IS INSERTED

State: HINT **addition:** YELLOW

Cause: This note is only displayed, when the Download card has been plugged in, but the machine is not in ground state. The ground state is obtained, when the initialization has been terminated and no cutting or positioning process is performed. If the Download card is plugged-in with the machine in this condition, the Download menu is offered once the check sum test has been terminated successfully.

Remedy:
- Make a reference run
- Switch to auxiliary operation
- Terminate automatic operation

Memos: Attention:with ED machines only

Error No.: 807

Error Text: MAIN DRIVE IS NOT READY

State: HINT **addition:** PURPLE

Cause: This message is displayed when SAP- board has not registered the "ready signal" from the main drive unit after a max. of 5 seconds subsequent to the display of the Polar logo.
(contact K5M or K0)
This message is also output, if the main drive unit breaks down or is switched off with the machine in progress. If anyone tries to trigger any functions that require the hydraulic drive unit (knife, clamp), the same note is output.

Remedy:
- Check contact of corresponding relay.
- Check star-delta-switching or smooth start unit.
- Check / replace SAP- board.
- Check cabling /plug-in connection to SAP- board.
- Check time setting for timer of smooth start unit or star-delta switching.
- Is board SK inserted correctly (fixed)
- No supply voltage of 25 V
- With ED machines check / replace AC /AC -IN board

Memos: Please note: On machines without relay 304 the message is generally displayed when Start-Button is not pressed.

Error No.: 808

Error Text: TIMEOUT MAIN DRIVE

State: ERROR **addition:** RED

Cause: This message is issued when SAP- board has not registered the "ready signal" from main drive unit after a max. of 45 seconds subsequent to the display of the Polar logo.
(contacts K5M or K0).
The machine operation can be continued by pressing the ACT. key, but all functions requiring the hydraulic drive unit (knife, clamp) remain locked until the necessary enabling signal has been supplied.

Remedy:
- Check contact of respective relay.
- Check star-delta-switching or smooth start unit.
- Check / replace SAP- board.
- Check cabling /plug-in connection to SAP- board.
- Check time setting for timer of smooth start unit or star-delta switching.
- With ED machines replace I/O bus - motherboard (I/O-5).
- Check correct seat of plug-in boards in rack.
- On ED (AC defective)

Memos:

Error No.: 809

Error Text: SERVO MOTOR OVERCURRENT

State: ERROR **addition:** RED

Cause: This error message is only output when the servo driveunit is used. It indicates that the control unit has registered an overcurrent from the drive motor. This results in an interruption of any active backgauge run.

Remedy:
- Check driving configuration on SAP- board.
- Check / replace servo control device.
- Check servo motor.
- Check driving mechanism, spindle and sledge guiding for stiffness.
- Check / replace SAP- board.
- Check thermal contact on FU- N3 at X105.1 and X105.5.

Memos:

Error No.: 810

Error Text: BACKGAUGE MOTOR OVERHEATED

State: ERROR **addition:** RED

Cause: As of ED program version V 1.4 this error message is BACKGAUGE MOTOR OVERHEATED! On drive units that employ frequency converters the thermocouple of the backgauge motor shows an excessive operating temperature of the motor.

Remedy:
- Check backgauge motor and thermocouple.
- Check driving mechanism, spindle and sledge guiding for stiffness.
- Check / replace SAP- board.
- Check adjustment of frequency converter.
- Check cabling / plug-in connections.
- Check voltage supply.
- With ED machines check / replace AC /AC -IN board

Memos:

Error No.: 811

Error Text: FREQUENCY CONV. SIGNALS ERROR

State: ERROR **addition:** RED

Cause:
This is a signal generated by the frequency converter, which is issued in case of an internal error detection of the frequency converter. It is a collective information on malfunctions in the frequency converter and backgauge motor.

Remedy:
- Check backgauge motor.
- Check drive mechanism, spindle and sledge guide for stiffness.
- Check / replace SAP- board.
- Check setting and cabling of frequency converter.
- Check cabling / plug-in connections at frontside of converter correct ?
- Check frequency converter.
- If SAP- board has been changed already and Error is displayed during Main Motor is running, than check aerea SAP-board / K5M.
- If the error message is still active after frequency converter has been replaced, observe instructions for setting in the frequency converter manual (check jumper, terminal 28).
- If internal frequency converter error message CF, bf and/or FC5 is shown, replace the frequency converter.

Memos:
With internal Error message of frequency converter change CF and bF connections.

Error No.: 813

Error Text: SERVO MOTOR DOES NOT MOVE

State: ERROR **addition:** RED

Cause: This error signal is only output in connection with option "auxiliary drive". Once the servo motor is activated by the control unit the tachometer-generator of the backgauge motor does not supply any voltage to the control circuit of the servo device.

Remedy:
- Check driving configuration on SAP- board.
- Check / replace servo control device.
- Check servo motor.
- Check driving mechanism, spindle and sledge guide for stiffness.
- Replace SAP- board.
- Check tachometer-generator with cabling.

Memos:

Error No.: 833

Error Text: CLAMP LIGHT BARRIER ERROR !

State: ERROR **addition:** PURPLE

Cause: In optional equipment "Cutting optimization" a light barrier is employed below the clamp in order to detect the cutting material. If this light barrier has been activated in menu "machine data" the activation of the knife in an active cut will only be performed after the light barrier has registered that the clamp contacts the cutting material. The maximum admissible waiting time for cutting material detection is 1.5 seconds. If this time is exceeded light barrier function is automatically switched off and the above error message is output. Nevertheless, the cutting sequence is continued. The function remains deactivated until the operator has again switched on the machine.

Remedy:
- Check setting and functioning of light barrier.
- Check connecting cable of light barrier / Observe cable laying.
- With ED machines check / replace PDR 95- board.
- With XT machines check / replace SAP-02 board.
- Check clamp travel time.
- Inspect smooth clamping valve.

Memos: As of ED machines V 4.0.0 the status has been changed from "ERROR" to "HINT"

Error No.: 835

Error Text: WRONG SIGNALS UDC/BDC (KNIFE)

State: ERROR **addition:** RED

Cause:
This error message (with abortion of cut) is issued when the following constellation is present prior to or during the cut:
a: knife movement is activated, but UDC signal (non BDC) is no longer supplied to the cutting circuit board.
b: during the knife return movement the electrical UDC and BDC are recognized at the same time.

Remedy:
- defective knife upstroke control.
- defective SAP 66- board.
- defective SK 66- board.
- defective CPxx- board.
- check cable routes and I/O- bus from SAP- board to SK 95- board.
- reflections of clamp light barrier upon cut optimization option.

Memos:

Error No.: 861

Error Text: RESET OF KEYBOARD/KC !

State: ERROR **addition:** RED

Cause:

After an asynchronous reset of the keyboard computer, i.e. a reset of the keyboard computer performed while the main computer is in action, the keyboard computer is sometimes not in the position to continue operation correctly while the main computer continues working. For instance, inoperable POLAR logotype and display of text fragments.
Now, the keyboard computer will adjust correctly to the main computer after an asynchronous reset. The main computer cuts off the automatic operation and supplies the keyboard computer with the necessary re-initialization, i.e. Texts are loaded in the POLAR logotype and a current image is displayed with up-to-date data.
Since the asynchronous reset of the keyboard computer is regarded as a malfunction, this error message is issued.

Remedy:

- On ED machines with versions 3.0 and higher, KCxx- board must be replaced.
- On ED Machines fitted with versions older than 3.0 must be completely re-equipped and fitted with V3.0 or higher.
- Check / replace KCxx- board.

Memos:

Error No.: 870

Error Text: BACKGAUGE POSITION CHANGED!

State: ERROR **addition:** PURPLE

Cause: The backgauge position has been modified without activation of the brake, e.g. when the cutting material is violently contacting the backgauge at standstill or the manual precision adjustment is turned violently while the backgauge advance is blocked. The current backgauge position is scanned by the computer at certain intervals and compared with the measure after the positioning has been terminated. On 78 ES, this error may be caused when the computer voltage is dropping too fast.

Remedy:
- check mechanical adjustment and/or condition of backgauge drive unit.
- check fastening of pulse generator.
- check functioning of backgauge motor brake Y17.
- Install a filter (id. no. 415373) on POLAR 78ED with K1M.
- On 78ES: install capacitor with cable connection (048320).
- please see also Error 79.

Memos: Status has been changed form "ERROR" to "HINT" as of V 4. 0. 0.

Error No.: 900

Error Text: KNIFE SUPPORT !

State: HINT **addition:** PURPLE

Cause: When the knife support is inserted and the operator tries to trigger a cut, this note is output and the cutting function is locked.

Remedy:
- Check recognition switch of knife support
- Check operating pin for switch actuation
- Check SAP- board
- Check connector and cabling
- Check current machine position (78 or 92): Indication in menu "Machine Data"

Memos: Attention:with ED machines only

Error No.: 911

Error Text: LANGUAGE NOT AVAILABLE !

State: HINT **addition:** PURPLE

Cause: The selected language is not available in the memory of CPxx- board.

Remedy:
- Insert CPxx- board carrying the desired languages.
- As of version 3.0.0 with CPxx- board the desired language can be installed by downloading.

Memos:

Error No.: 975

Error Text: HIGHSPEED CUTTING SENSOR DEF.

State: ERROR **addition:** RED

Cause: When the knife goes through the bottom dead centre the highspeed cutting sensor located in the clamp must be activated.
Conversely, the sensor in the upper dead centre must no longer be activated. When this condition is not recognized by the computer the error message mentioned is issued and the option "high-speed cutting" adjusted by the operator is automatically shut off. The machine remains ready for operation in the standard function.

Remedy:
- Check sensor, adjust, if necessary
- Check connecting cable for sensor
- With ED machines check / replace PDR 95- board.
- With XT machines check / replace SAP-02 board.
- Check / replace CPxx- board.

Memos:

Error No.: 993

Error Text: HYDRAULIC SYSTEM OVERHEATED

State: ERROR **addition:** RED

Cause: This error message is issued when the thermal contact of the hydraulic motor indicates an interruption during the release of the cut. Since Polar 66 is not fitted with a safety bolt the thermal contact is used for generating the signal "safety bolt (SB) activated". The SB safety cicuit serves to monitor the thermal contact of the hydraulic motor.

Remedy:
- Check loading of hydraulic motor.
- Check thermal contact WSK/M3.
- Check cabling.
- Check cutting circuit card.
- K1 on SAP 66- board (contact 11/12).
- Check 24-V power supply unit and replace it, if necessary

Memos: only POLAR 66

Error No.: 994

Error Text: HYDRAULIC SYSTEM CUTOFF DEF.

State: ERROR **addition:** RED

Cause: In order to ensure that the hydraulic motor is safely shut off, a relay has been switched in parallel with the motor control. Hence, when the hydraulic motor is switched off and the corresponding relay contact does not open, this error message is issued. This is monitored by the SB control circuit, which is not required on the 66 machine and inspects the hydraulic motor cutoff in this case.

Remedy:
- Check supply voltages.
- Check contactor K1M and its contacts.
- Check / replace SK 95- board / SK 66- board.
- Check cabling.
- Check / replace SAP 66- board.

Memos: only POLAR 66

Error No.: 995

Error Text: HYDRAULICS MONITORING FAULTY

State: ERROR **addition:** RED

Cause: This error message describes a simultaneous recognition of the conditions "safety bolt in locking position" and "safety bolt unlocked". Since on machine type 66 the safety circuit of the safety bolt monitors the hydraulic motor this message indicates a defect of thermal contact or turn-off relay.

Remedy:
- Excessive motor temperature, thermal contact WSK/M3 of hydraulic motor has opened
- Check / replace SK 95- board / SK 66- board.
- Check cabling.
- Check / replace SAP 66- board.

Memos: only POLAR 66

Error No.: 996

Error Text: KNIFE NOT IN UPP. DEAD CENTRE

State: ERROR **addition:** PURPLE

Cause: This message must be regarded in different ways, i.e. according to the respective machine condition.
a: if the message is supplied statically, the "mechanical UDC" condition for the start of a cut has not been met.
b: if the message is issued during the knife return movement the operator has triggered the cut buttons again before the electrical UDC has been recognized.

Remedy:
- Defective knife upstroke control or wrong adjustment of cable
- Check / replace SAP 66- board.
- Check / replace SK 66- board.
- Check / replace CPxx- board.
- Check cable routes as well as I/O- bus of SAP - SK board
- Trigger sequential cuts only after the knife dead centre has been recognized

Memos: only POLAR 66

Error No.: 1098

Error Text: PCM INCOMPATIBLE

State: HINT **addition:** PURPLE

Cause: When the machine and the internal PC are started, the version numbers of the software of computer CPxx- board and the software version on the PCM / IPC computer are checked. If they are not compatible with each other, this error message is output.

Remedy:
- Replace CPxx- board or the software on this board.
- Update the software on the internal PC of the machine (PCM / IPC - computer)

Memos:

Error No.: 1099

Error Text: DC INCOMPATIBLE

State: HINT **addition:** PURPLE

Cause: The software version installed of Heidelberg Data Control is incompatible with the IPC software present in the high-speed cutter. The released IPC software expects a determined program version of HD DC. When this software has been modified and another version number of the IPC software has been signalled, this error message will be output.

Remedy:
- Contact the Polar Software Development or replace the IPC software.

Memos:

Error No.: 1100

Error Text: CP INCOMPATIBLE

State: HINT **addition:** PURPLE

Cause: The software version on CPxx- board is incompatible with the DC software version of the IPC installed on the high-speed cutter.

Remedy: - Replace the IPC or the respective software version.

Memos:

Error No.: 1101

Error Text: IPC-LINK NOT READY

State: ERROR **addition:** RED

Cause: This error message is only issued in a configuration with Data Control. Board CP usually transmits data to the IPC via the DPR (Dual Port RAM) and waits for the corresponding acknowledgements. If the linkup is interrupted, the above error message is issued.

Remedy:
- Switch off Data Control in the menu "preset of functions". Use DIP switches to set computer board CP to Service Mode. You can test the communication using the test program "test management system" in mask "Diagnosis / Test" .
- Check / replace CPxx- borad.
- Check / replace DPR- board.
- Replace the industrial PC (IPC).

Memos:

Error No.: 1102

Error Text: SOFTWARE VERSION INCOMPATIBLE

State: ERROR **addition:** RED

Cause: This message is output, when the operator tries to load a keyboard computer version that is not compatible with the existing program version of the main computer. The same applies when the corresponding text versions are downloaded.

Remedy: - Use correct program version and/or download card

Memos:

Error No.: 1103

Error Text: ALL TYPES OF DOWNLOAD BLOCKED

State: ERROR **addition:** RED

Cause: An error has occurred during a preceding downloading process. After the machine is switched on again, error message "DL-ERROR" is issued. If the download card for the main computer is plugged in at that time, the message "ALL DOWNLOAD CARDS BLOCKED" is issued. The number behind the DL-ERROR display indicates the defective computer. The figure 1 denominates the keyboard computer, figures 2 - 4 refer to the main computer.

Remedy:
- Replace corresponding computer board
- Clear CMOS-RAM of computer card by removing the battery (for approximately 5 minutes).

Memos:

Error No.: 1141

Error Text: OBSERVE SAFTY CHECK !

State: HINT **addition:** PURPLE

Cause: The next safety check is due. This message is displayed one month before the inspection date. This note is extinguished by pressing a key or actuating the manual precision adjustment.

Remedy: - Carry out safety inspection, re-adjust the counter after the inspection has been terminated and no malfunctions found. Observe inspection intervals.

Memos: This error message has existed since program version ED V 4.0.0

Error No.: 1142

Error Text: SAFTY CHECK REQUIRED !

State: ERROR **addition:** RED

Cause: As soon as the preset inspection date has been reached or failed to meet, this message is displayed every time the machine is switched on. The message can be deleted by pressing the Clear key. The operation of the machine is ensured.

Remedy: - carry out safety inspection, re-adjust the counter after the inspection has been terminated and no malfunctions found. Observe inspection intervals.

Memos: This error message has existed since program version ED V 4.0.0

Error No.: 1225

Error Text: FINAL POSIT. WITH FALSE CLAMP

State: HINT **addition:** PURPLE

Cause: The minimum cut size with false clamp inserted has been reached. The table limit switch assigned to this false clamp has been actuated.

Remedy:
- If this hint is output although no false clamp plate has been inserted, please check the plunger, limit switches and cables.
- Check / replace SAP- board.
- Check connection to Transomat / Gripper system (enabling).
- On X/XT generation: replace table limit switch S8.
- Tiltable rear guards open? / check limit switch.0
- On Fixomat: check connector 707 and switch 342/ 343.

Memos: This error message exists since ED program version V 4.0.0

Error No.: 1226

Error Text: ERROR ON PDR BOARD !

State: ERROR **addition:** RED

Cause: This message occurs only in connection with a PDR board installed. The message is output during a cut release, if the computer detects a difference between the nominal and actual values of the clamping pressure. The nominal value results from the machine parameter setting. The actual value of the current clamping process is fed back to the computer via the board PDR for control purposes.
Attention! Please note: To carry out the tutorial during any service work performed, the DIP switch on card CPxx for the service mode must have been previously switched on, since the error control is suppressed in this way.

Remedy:
- Check / replace PDR- board.
- Replace hydraulic control block.
- Check external switching of board PDR (S29).
- Short circuit +24V d.c.
- Check connection to ground.

Memos: This error message has existed since ED program version V 4.0.0

Error No.: 1230

Error Text: CHECK MACHINE IDENTIFICATION!

State: HINT **addition:** PURPLE

Cause: The equipment list of the machine in the service menu has not been completed. This is why no information about the machine equipment can be learned when it is decoded via the PC program.

Remedy:
- Select service menu and complete machine equipment list.
- This message is shown, if SW3- 4 on CPxx- board is set to "off", the operator wants to access the Service and there is no entry in the options list.

Memos: This error message has existed since ED program version V 4.0.0

Error No.: 1243

Error Text: FOOT PEDAL PRESSED DOWN

State: HINT **addition:** YELLOW

Cause: This message is output when switch S390 or S309 has been actuated, or if the computer recognizes one of these switches to be actuated, and therefore blocks the cutting cycle. Automated operation will only be continued, if both switches are not actuated.

Remedy:
- Check settings of switches S309 / S390 and cams.
- Check switches and cabling and replace, if necessary.
- Check / replace SK- board.
- Check / replace SAP- board.

Memos:

Error No.: 1255

Error Text: LENGTH ERROR COMPRESSED TEXT

State: ERROR **addition:** RED

Cause: During a download of compressed texts, a length error has occurred. This type of download is new on software version V 4.0.0

Remedy:
- Switch machine on /off
- Call POLAR Service

Memos: This error message has existed since ED program version V 4.0.0

Error No.: 1256

Error Text: LENGTH ERROR TEXT DATA

State: ERROR **addition:** RED

Cause: During a download of compressed texts, a length error has occurred. This type of download is new on software version V 4.0.0

Remedy:
- Switch machine on /off
- Call POLAR Service

Memos: The error message has existed since ED program version V 4.0.0

Error No.: 1257

Error Text: CHECKSUM ERR. COMPRESSED TEXT

State: ERROR **addition:** RED

Cause: During a download of compressed texts, a check sum error has occurred. This type of download is new on software version V 4.0.0

Remedy:
- Switch machine on /off
- Call POLAR Service

Memos: This error message has existed since ED program version V 4.0.0

Error No.: 1258

Error Text: AUTOTRIM NOT SET ON DIP SWIT.

State: HINT **addition:** PURPLE

Cause: Neither manual nor automatic operation of optional equipment "Autotrim" is possible. The Autotrim table cannot be opened, lifted or lowered. Optional "Autotrim" has not been properly configured.

Remedy:
- With ED machines check Switch SW3 no. 6 on CPxx- board must be switched to ON (as of ED version V4.0).
- With XT machines check Switch SW3 no. 6 on CPxx- board must be switched to ON.
- With ED machines check Switch S1 on SFM- board must be switched to ON (up to ED version V4.0).
- Check / replace SFM- board.
- Check / replace CPxx- board.

Memos: This error message has existed since ED program version V 4.0.0

Error No.: 1259

Error Text: AUTOTRIM TABLE DOES NOT OPEN

State: HINT **addition:** PURPLE

Cause: The configuration of "Autotrim" has been selected, but the table does not open even though it has been activated by the computer.

Remedy:
- Make sure that the machine light barrier has not been obstructed while the table was opened.
- Check limit switch for limit position signal of table.
- With ED machine check / replace SFM- board (S1).
- With XT machine check / replace I/O-P1- board.
- Check cabling.
- Check / replace CPxx- board.

Memos: This error message has existed since ED program version V 4.0.0

Error No.: 1262

Error Text: DPR TRANSMIT BUFFER OVERFLOW!

State: HINT **addition:** PURPLE

Cause: This message is output, if an order for transmitting an information to PCM (industrial PC) cannot be entered into the corresponding buffer, because it is complete.

Remedy:
- Switch machine off and connect it again.
- Replace computer CPxx- board.
- Replace DPR- board.
- Replace the industrial PC (IPC).
- Replace the motherboard.

Memos:

Error No.: 1263

Error Text: DPR HIGH PRIO.BUFFER OVERFLOW

State: HINT **addition:** PURPLE

Cause: This message is output, if an order for transmitting an information to PCM (industrial PC) cannot be entered into the corresponding buffer, because it is complete.

Remedy: The DPR is overloaded at the moment (e. g. uninterrupted pressing of menu key), The high-priority buffer has an overflow. If this error occurs various times, check Pal on CPxx- board (for Digiloc PCs (PCM), Pal 45.3 must be present).

Memos: Refers only to PCM-modules as of V4.1.0.

Error No.: 1291

Error Text: ILLEGAL STATUS FROM DCONTROL!

State: HINT **addition:** PURPLE

Cause: This message is output, if the machine has received information from the Data Control System, which includes an undefined status.

Remedy: - If this message is output repeatedly, call the SERVICE.

Memos:

Error No.: 1343

Error Text: ALIGN.STAT.FIX.ERROR END POS.

State: ERROR **addition:** RED

Cause:
Complete message: ERROR END POSITION UPON FIXING OF ALIGNING STATION
This error message is indicated, if the system detects an inadmissible combination of limit switch signals from the aligning station. The limit switches involved are: "fixing bolt, bottom left", "fixing bolt, bottom, right", "aligning station in fixing position" and "aligning station in parking position".

Remedy:
- Check correct functioning of limit switches B5, B6, B7, B8.
- Check correct connections and functioning of valves /valve unit. This refers to
- the valves "fixing bolt upward" Y5 and "clamping lock, retracted"Y4.
- Check / replace I/O-2 board.
- Check cabling of switches.
- Check / replace CPxx- board.
- Check / replace CU unit.

Memos:

Error No.: 1344

Error Text: ALIGN.STAT. FAULT WHEN FIXING

State: HINT **addition:** PURPLE

Cause:
Complete message: FAULT UPON FIXING OF ALIGNING STATION
This error message is indicated, when a malfunction is detected while the aligning station is fixed. The message is also output, if the monitoring time for the fixing process is exceeded, or the fixing process has been performed in the wrong position of the aligning station.

Remedy:
- Precise detection of proximity switch B6 for active operating position of aligning station.
- Check function and cabling of proximity switch B7 / B8.
- Check mechanically required position for "fixing" function.
- Check correct connections and functioning of valves /valve unit. This refers to
- the valves "fixing bolt upward" Y5 and "clamping lock, retracted" Y4.
- Check / replace I/O-2 board.
- Check cabling of switches.
- Check / replace CPxx- board.
- Check / replace CU unit.

Memos:

Error No.: 1345

Error Text: ALIGN.STAT.FAULT AT RELEASING

State: HINT **addition:** PURPLE

Cause: Complete message: FAULT WHEN RELEASING THE FIXING OF THE ALIGNING STATION
This error message is output, when a malfunction is detected while the aligning station is fixed. The message is also output, if the monitoring time for the releasing process is exceeded.

Remedy:
- Precise detection of proximity switch B6 for active operating position of aligning station.
- Check function and cabling of proximity switch B7 / B8.
- Check correct connections and functioning of valves /valve unit. This refers to
- the valves "fixing bolt upward" Y5 and "clamping lock, retracted" Y4.
- Check replace I/O-2 board.
- Check cabling of switches.
- Check / replace CPxx- board.
- Check / replace CU unit.

Memos:

Error No.: 1366

Error Text: ERROR END POSITION AUTOTRIM

State: ERROR **addition:** RED

Cause: This error message is output, when limit switch "Autotrim table open" (SFM or I/O-P1- board) is activated and limit switch "Autotrim table not closed" (SFM or I/O-P1- board) is not activated

Remedy:
- Verify correct functioning of limit switches S364 and S365.
- With XT machines check / replace I/O-P1- board.
- With ED machines check / replace SFM- board.
- Check cabling of switches.
- Check / replace CPxx- board.
- Check / replace CU unit.

Memos:

Error No.: 1367

Error Text: AUTOTRIM-M I/O-BOARD1 MISSING

State: ERROR **addition:** RED

Cause: This error message is output, if the machine configuration of CPxx- board and SFM-board (ED only), set at DIP switches, means that hte machine in question is "Autotrim-M", but the I/O-1 board required for this machine, cannot be found in the control computer.
If the special version ....-23 for Autotrim-M and Autocut 115 is installed in a standard machine, this error message is also output.

Remedy:
- Check positions of DIP switches of CPxx- board and SFM- board (ED only).
- Replace I/O 1- board for Autotrim.
- Is I/O 1- board installed and functioning perfectly?

Memos:

Error No.: 1368

Error Text: ERROR DIP SWITCH SETTING AT-M

State: ERROR **addition:** RED

Cause: FULL MESSAGE: WRONG SETTING OF DIP SWITCHES FOR AUTOTRIM M
This error message is output, if the machine configuration for Autotrim-M set at the DIP switches is inadmissible.
If the special version ....-23 for Autotrim-M and Autocut 115 is installed in a standard machine, this error message is also output.

Remedy:
- Check positions of DIP switches of CPxx- board and SFM- board (ED only).

Memos:

Error No.: 1370

Error Text: KEYBOARD DOWNLOAD ERROR

State: HINT **addition:** PURPLE

Cause: This message is indicated, if an error occurs during the software download for the keyboard computer.
- The download already started has been definitely carried out incorrectly.
- Since "protect" is set on the Flash EPROM, no download is possible.
- There were communication problems during the download.

Remedy:
- Replace flash EPROM in keyboard.
- Replace keyboard and re-start download.

Memos:

Error No.: 1377

Error Text: DELOADING FINGER END POSITION

State: HINT **addition:** PURPLE

Cause: This message is output, when the deloading finger is moved in manual operation and has reached a stop limit switch, and has been stopped there.

Remedy:
- This is a status message in manual operation.

Memos:

Error No.: 1378

Error Text: TIMOUT DEL.FINGER TO END POS.

State: ERROR **addition:** RED

Cause: The admissible time limit (5 minutes) granted by the software for the horizontal movement of the deloading finger has been exceeded. Within this preset time the computer has neither recorded any stop nor a change of direction.

Remedy:
- Check proximity switch for deloading finger. Adjust or replace it. (B404, B406, B402, B403, B430)
- Ensure a smooth mechanical operation of the deloading finger.
- Check toothed belt of deloading drive.
- Check adjustment and function of frequency converter N1.
- Check or replace the M1 motor of the deloading finger.
- Check or replace brake Y421 of M1 motor.
- Check cabling of all the components involved.
- Check / replace I/O- board.

Memos:

Error No.: 1379

Error Text: TIMEOUT DELOADING FINGER !

State: ERROR **addition:** RED

Cause: The admissible time limit granted by the software for the vertical movement of the deloading finger has been exceeded.

Remedy:
- Check the proximity switches B401 / B1 for the individual limit positions.
- Check cabling of limit switches.
- Verify smooth mechanical operation / lifting cylinder.
- Check the Y418 solenoid valve and replace it, if necessary.
- Verify the pressure setting of the pneumatic system.
- Check / replace I/O 1- board.
- With downholder at the deloading to right side check switches B2 and B2a.
- With downholder at the deloading to left side check switches B3 and B3a.
- If deloading finger is not equipped with downholder make sure that jumper plug has been installed.

Memos:

Error No.: 1387

Error Text: INTERNAL ERROR OF DEL.FINGER!

State: ERROR **addition:** RED

Cause: This message describes a software error. This error message is output, when the software tries to start a new process while deloading is still in progress.

Remedy:
- Switch machine off, and on again.
- Update the software of CPxx- board.

Memos:

Error No.: 1388

Error Text: DEL.FINGER NOT IN UPPER POS.!

State: HINT **addition:** PURPLE

Cause: This hint is output, when a function is not admissible or aborted, ifthe deloading finger is not in upper limit position.

Remedy:
- Verify limit position of deloading finger in TDC.
- Limit position must be reached without causing the proximity switch B401 to rebound. (Check pneumatic system)

Memos:

Error No.: 1389

Error Text: DEL.FINGER NOT IN LOWER POS.!

State: HINT **addition:** PURPLE

Cause: This hint is output, when a function is not admissible or aborted, ifthe deloading finger is not in lower limit position.

Remedy:
- Verify limit position of deloading finger in BDC.
- Limit position must be reached without causing the proximity switch to rebound. (Check pneumatic system)

Memos:

Error No.: 1391

Error Text: START DELOADING PROCEDURE !

State: HINT **addition:** PURPLE

Cause: If the deloading cycle is frequently aborted with this message, the computer recognizes a short-term interruption of the signal "deloading finger in upper position" (B401)

Remedy:
- Verify "Deloading finger in upper position" (B401)
- End-of-travel indication must be issued without contact bounces of prox. Switch B401.
- Check compressed air supply.
- Ensure the mechanical smoothness of the upward and downward movement of the deloading finger.
- Check speed of upward movement of deloading finger.
- Check limit position damping of pneumatic cylinder.
- Check cable between B401 and junction box XB.

Memos:

Error No.: 1393

Error Text: DEL. FINGER OVER AUTOTR.TABLE

State: HINT **addition:** PURPLE

Cause: This message is output when the deloading finger is in therange of the Autotrim flap and in lowered position. Any different mechanical movement would cause a collision and damage the deloading finger. For instance, the advance movement of the backgauge, opening/closing of the Autotrim table or similar actions.

Remedy: - Move deloading finger manually upwards (menu Autotrim-M)

Memos:

Error No.: 1394

Error Text: ERROR LIMIT SWITCH DEL.FINGER

State: ERROR **addition:** RED

Cause: FULL MESSAGE: ERROR LIMIT SWITCH OF DELOADING FINGER!
This error message is output, if the computer detects several limit switches in the travel range of the deloading finger in active condition.

Remedy:
- Check correct functioning of limit switches B402, B403, B404, B405, B406, B407, B430..
- Check / replace I/O 1- board.
- Check cabling of switches.
- Check / replace CPxx- board.
- Check / replace CU unit.

Memos:

Error No.: 1395

Error Text: DEL.FING.LIM.SW.MISS.: SLOW/L

State: ERROR **addition:** RED

Cause: COMPLETE MESSAGE: DELOADING FINGER LIMIT SWITCH MISSING: SLOWLY LEFT
This error message is output, if the deloading finger must have passed the limit switch "slowly left", but the control computer has receivedno signal from the limit switch.

Remedy:
- Check correct functioning of limit switch.
- Check / replace I/O 1- board.
- Check cabling of switches.
- Check / replace CPxx- board.
- Check / replace CU unit.

Memos:

Error No.: 1396

Error Text: DEL.FING.LIM.SW.MISS.:TABLE/L

State: ERROR **addition:** RED

Cause: COMPLETE TEXT: DELOADING FINGER LIMIT SWITCH MISSING: TABLE END/ LEFT
This error message is output, if the deloading finger must have passed the limit switch "table end - left", but the control computer has receivedno signal from the limit switch.

Remedy:
- Check correct functioning of limit switch.
- Check cabling and function of switch B430.
- Check / replace I/O 1- board.
- Check / replace CPxx- board.
- Check / replace CU unit.
- AT- M (ED/ XT) service menu: activate "gauge at frame". Otherwise, this error message may occur.

Memos:

Error No.: 1397

Error Text: DEL.FING.LIM.SW.MISS.: FORMAT

State: ERROR **addition:** RED

Cause: COMPLETE TEXT: DELOADING FINGER LIMIT SWITCH MISSING: FORMAT LIMITATION
This error message is output, if the deloading finger must have passed the limit switch "format limitation", but the control computer has receivedno signal from the limit switch. The same applies, when the deloading finger, on its way back, moves too far beyond the B402 switch and activates the B430 switch.

Remedy:
- Check correct functioning of limit switch B402.
- Check / replace I/O 1- board.
- Check cabling of switches.
- Check / replace CPxx- board.
- Check / replace CU unit.

Memos:

Error No.: 1398

Error Text: DEL.FING.LIM.SW.MISS.:TABLE/R

State: ERROR **addition:** RED

Cause: COMPLETE TEXT: DELOADING FINGER LIMIT SWITCH MISSING: TABLE END/ RIGHT
This error message is output, if the deloading finger must have passed the limit switch "table end - right", but the control computer has receivedno signal from the limit switch.

Remedy:
- Check correct functioning of limit switch B403.
- Check / replace I/O 1- board.
- Check cabling of switches.
- Check / replace CPxx- board.
- Check / replace CU unit.

Memos:

Error No.: 1399

Error Text: DEL.FING.LIM.SW.MISS.: SLOW/R

State: ERROR **addition:** RED

Cause: COMPLETE MESSAGE: DELOADING FINGER LIMIT SWITCH MISSING: SLOWLY RIGHT
This error message is output, if the deloading finger must have passed the limit switch "slowly right", but the control computer has receivedno signal from the limit switch.

Remedy:
- Check correct functioning of limit switch B405.
- Check / replace I/O 1- board.
- Check cabling of switches.
- Check / replace CPxx- board.
- Check / replace CU unit.

Memos:

Error No.: 1400

Error Text: DELOADING RIGHT MISSING READY

State: HINT **addition:** PURPLE

Cause: Complete message: DELOADING GAUGE RIGHT MISSING READY
After a maximum waiting time, the finishing units (cycled pusher, buffer table, banding machine) on the right have given no enabling for unloading.

Remedy:
- Enabling from external unit (finishing, right side) is missing.
- Check enabling signal from external unit.
- Check cabling to cutting machine.
- Check / replace I/O 1- board.
- Check / replace CPxx- board.

Memos:

Error No.: 1401

Error Text: DELOADING RIGHT MISS.ACCEPTED

State: HINT **addition:** PURPLE

Cause: Complete text: DELOADING RIGHT ACCEPTED IS MISSING
After a maximum waiting time, the finishing units (cycled pusher, buffer table, banding machine) on the right have given no acceptance signal for the deloaded labels.

Remedy:
- Enabling from external unit (finishing, right side) is missing.
- Check enabling signal from external unit.
- Check cabling to cutting machine.
- Check / replace I/O 1- board.
- Check / replace CPxx- board.

Memos:

Error No.: 1402

Error Text: DELOADING LEFT MISSING READY

State: HINT **addition:** PURPLE

Cause: Complete message: DELOADING GAUGE LEFT MISSING READY
After a maximum waiting time, the finishing units (cycled pusher, buffer table, banding machine) on the left have given no enabling for unloading.

Remedy:
- Enabling from external unit (finishing, left side) is missing.
- Check enabling signal from external unit.
- Check cabling to cutting machine.
- Check / replace I/O 1- board.
- Check / replace CPxx- board.

Memos:

Error No.: 1403

Error Text: DELOADING LEFT MISS. ACCEPTED

State: HINT **addition:** PURPLE

Cause: Complete text: "DELOADING LEFT ACCEPTED" IS MISSING
After a maximum waiting time, the finishing units (cycled pusher, buffer table, banding machine) on the left have given no acceptance signal for the deloaded labels.

Remedy:
- Enabling from external unit (finishing, left side) is missing.
- Check enabling signal from external unit.
- Check cabling to cutting machine.
- Check / replace I/O 1- board.
- Check / replace CPxx- board.

Memos:

Error No.: 1404

Error Text: MISSING PUSHER RIGHT AT BACK

State: HINT **addition:** PURPLE

Cause: Complete text: "PUSHER RIGHT AT BACK" IS MISSING (no position feedback)
After a maximum waiting time, the finishing units on the right have given no signal that the pusher is at the back.

Remedy:
- Enabling from external unit (finishing) is missing.
- Check enabling signal from external unit.
- Check cabling to cutting machine.
- Check / replace I/O 1- board.
- Check / replace CPxx- board.

Memos:

Error No.: 1405

Error Text: MISSING PUSHER RIGHT UP FRONT

State: HINT **addition:** PURPLE

Cause: Complete text: "PUSHER RIGHT UP FRONT" IS MISSING (no position feedback)
After a maximum waiting time, the finishing units on the right have given no signal that the pusher is at the front side.

Remedy:
- Enabling from external unit (finishing) is missing.
- Check enabling signal from external unit.
- Check cabling to cutting machine.
- Check / replace I/O 1- board.
- Check / replace CPxx- board.

Memos:

Error No.: 1406

Error Text: MISSING PUSHER LEFT AT BACK

State: HINT **addition:** PURPLE

Cause: Complete text: "PUSHER LEFT AT BACK" IS MISSING (no position feedback)
After a maximum waiting time, the finishing units on the left have given no signal that the pusher is at the back.

Remedy:
- Enabling from external unit (finishing) is missing.
- Check enabling signal from external unit.
- Check cabling to cutting machine.
- Check / replace I/O 1- board.
- Check / replace CPxx- board.

Memos:

Error No.: 1407

Error Text: MISSING PUSHER LEFT UP FRONT

State: HINT **addition:** PURPLE

Cause: Complete text: "PUSHER LEFT UP FRONT" IS MISSING (no position feedback)
After a maximum waiting time, the finishing units on the left have given no signal that the pusher is at the front.

Remedy:
- Enabling from external unit (finishing) is missing.
- Check enabling signal from external unit.
- Check cabling to cutting machine.
- Check / replace I/O 1- board.
- Check / replace CPxx- board.

Memos:

Error No.: 1410

Error Text: DELOADING RIGHT WAITING READY

State: HINT **addition:** YELLOW

Cause: Complete text: WAITING FOR READY-SIGNAL FROM RIGHT SIDE FOR DELOADING.
This is a note to the machine operator that the deloading finger waits for the enabling from the finishing units (cycled pusher, buffer table, banding machine) on the right to deload the labels.

Remedy:
- Wait until process is continued or error message is output.

Memos:

Error No.: 1411

Error Text: DELOADING RIGHT WAIT.ACCEPTED

State: HINT **addition:** YELLOW

Cause: Complete text: WAITING FOR ACCEPTED-SIGNAL FROM RIGHT SIDE FOR DELOADING.
This is a note to the machine operator that the deloading finger waits for the message from the finishing units (cycled pusher, buffer table, banding machine) on the right that the unloaded labels have been accepted.

Remedy: - Wait until process is continued or error message is output.

Memos:

Error No.: 1412

Error Text: DELOADING LEFT WAITING READY

State: HINT **addition:** YELLOW

Cause: Complete text: WAITING FOR READY-SIGNAL FROM LEFT SIDE FOR DELOADING.
This is a note to the machine operator that the deloading finger waits for the enabling from the finishing units (cycled pusher, buffer table, banding machine) on the left to deload the labels.

Remedy: - Wait until process is continued or error message is output.

Memos:

Error No.: 1413

Error Text: DELOADING LEFT WAIT. ACCEPTED

State: HINT **addition:** YELLOW

Cause: Complete text: WAITING FOR ACCEPTED-SIGNAL FROM LEFT SIDE FOR DELOADING.
This is a note to the machine operator that the deloading finger waits for the message from the finishing units (cycled pusher, buffer table, banding machine) on the left that the unloaded labels have been accepted.

Remedy: - Wait until process is continued or error message is output.

Memos:

Error No.: 1414

Error Text: WAITING PUSHER RIGHT AT BACK

State: HINT **addition:** YELLOW

Cause: Complete text: WAITING FOR PUSHER AT RIGHT-HAND BACK.
This is a note to the machine operator that the deloading finger waits for the message from the finishing units on the right that the pusher is at the back.

Remedy: - Wait until process is continued or error message is output.

Memos:

Error No.: 1415

Error Text: WAITING PUSHER RIGHT UP FRONT

State: HINT **addition:** YELLOW

Cause: Complete text: WAITING FOR PUSHER AT RIGHT UP FRONT.
This is a note to the machine operator that the deloading finger waits for the message from the finishing units on the right that the pusher is at the front.

Remedy: - Wait until process is continued or error message is output.

Memos:

Error No.: 1416

Error Text: WAITING PUSHER LEFT AT BACK

State: HINT **addition:** YELLOW

Cause: Complete text: WAITING FOR PUSHER AT LEFT-HAND BACK.
This is a note to the machine operator that the deloading finger waits for the message from the finishing units on the left that the pusher is at the back.

Remedy: - Wait until process is continued or error message is output.

Memos:

Error No.: 1417

Error Text: WAITING PUSHER LEFT UP FRONT

State: HINT **addition:** YELLOW

Cause: Complete text: WAITING FOR PUSHER AT LEFT UP FRONT.
This is a note to the machine operator that the deloading finger waits for the message from the finishing units on the left that the pusher is at the front.

Remedy: - Wait until process is continued or error message is output.

Memos:

Error No.: 1421

Error Text: AT. TABLE NOT COMPLETELY OPEN

State: HINT **addition:** PURPLE

Cause: The Autotrim table should be completely open, but it is neither closed nor completely open. Therefore, any further action is denied by the computer.

Remedy: - Open Autotrim table completely.

Memos:

Error No.: 1422

Error Text: FINGER DOWN: NEXT M.NOT READY

State: HINT **addition:** PURPLE

Cause: Complete message: FINGER DOWN: NO ENABLING FROM FINISHING
This message is output, when the deloading finger is to be lowered beyond the range of the front table in manual operation, or the lowered deloading finger moves beyond the front-table area in manual operation, although the finishing units on the respective side are not ready to accept the labels. In this case, the unit might collide with the cycled pusher of the finishing unit (buffer table or banding machine)

Remedy:
- Message is output in manual operation, if there is no enabling from the finishing units involved.
- Check enabling signal from external device
- Check cabling to cutting machine
- Check / replace I/O 1- board.
- Check / replace CPxx- board.

Memos:

Error No.: 1425

Error Text: ERROR IN DELOADING SOFTWARE !

State: ERROR **addition:** RED

Cause: The software of the deloading finger tries to give a start signal to the finishing units, although this is inadmissible. This is caused by an error in the software of the control computer.

Remedy:
- Switch machine off, switch it on again.
- If this malfunction occurs repeatedly, replace CPxx- board (with updated software).
- Call the Service

Memos:

Error No.: 1433

Error Text: AUTOTRIM-M I/O BOARD2 MISSING

State: ERROR **addition:** RED

Cause: The machine configuration set at the DIP switches indicates that the machine is an Autotrim-M or Autocut unit with extended options (aligning station - intermediate cut aligning unit), but the required I/O 2- board has not been found in the control computer.

Remedy:
- Check DIP switches on SFM- board (options)
- Check / replace I/O 2- board for Autotrim-M

Memos:

Error No.: 1434

Error Text: AUTOTRIM-M AIR PRESSURE FAULT

State: HINT **addition:** PURPLE

Cause: The compressed-air control unit for the aligning station of an Autotrim-M machine detects an insufficient air pressure.

Remedy:
- Verify compressed-air supply.
- Check filter pressure regulator at the central distributor.
- Check cabling from sensor to I/O 2- board, resp. Jumper to I/O 2- board.
- Check / replace CPxx- board.

Memos:

Error No.: 1450

Error Text: DEL.FINGER END POSITION ERROR

State: ERROR **addition:** RED

Cause: This message is output when limit switches "deloading finger at top" and "deloading finger at bottom" are active at the same time.

Remedy:
- Check correct functioning of limit switches B401 and B1.
- Check / replace I/O 1- board.
- Check cabling of switches.
- Check / replace CPxx- board.
- Check / replace CU unit.

Memos:

Error No.: 1451

Error Text: FINGER WIDTH END POSIT. ERROR

State: ERROR **addition:** RED

Cause: Complete text: MOTORIZED FINGER ADJUSTMENT - END POSITION ERROR
This message is output when limit switches for the adjustment of the finger width "finger completely open" and "finger completely closed" are active at the same time.

Remedy:
- Check correct functioning of limit switches B437 and B438.
- Check / replace I/O 1- board.
- Check cabling of switches.
- Check / replace CPxx- board.
- Check / replace CU unit.

Memos:

Error No.: 1452

Error Text: STOP:PAPER SENSOR ALIGN.STAT.

State: HINT **addition:** PURPLE

Cause: Complete text: STOP ADVANCE MOVEMENT OF ALIGNING STATION DUE TO PAPER SENSOR
This message is output when the advance movement of the backgauge or aligning gauge is aborted, because the paper sensor at the aligning gauge has responded.

Remedy:
- Check correct functioning of paper sensor at aligning gauge and replace, if necessary.
- Check / replace I/O 1- board.
- Check cabling of switches.
- Check / replace CPxx- board.
- Check / replace CU unit.

Memos:

Error No.: 1453

Error Text: ALIGN.STAT. ILLEGAL REF. POS.

State: HINT **addition:** PURPLE

Cause: Complete text: ALIGNING STATION ILLEGAL REFERENCE POSITION
This message is output when the reference position required for positioning the gauge of the aligning station is unknown or within an inadmissible range.

Remedy:
- Reference run of aligning gauge with re-adjustment of current position.
- Re-adjust current position

Memos:

Error No.: 1456

Error Text: ALIGNING STATION END POSITION

State: HINT **addition:** PURPLE

Cause: This message is output when the aligning gauge while being moved has contacted a limit switch. In manual operation, this happens when the movement is maintained until the limit switch is reached. When the aligning gauge is positioned to a certain target, there is usually a malfunction when this message is displayed; the target position cannot be approached, because the limit switch has been reached.

Remedy:
- Reference run of aligning gauge with re-adjustment of current position.
- Check cutting program and correct, if necessary (Label size too big or small)

Memos:

Error No.: 1457

Error Text: ALIGN.STATION SOFTWARE ERROR!

State: ERROR **addition:** RED

Cause: This message is output when a malfunction has been detected in the control software of the aligning station.

Remedy:
- Switch machine off, switch it on again.
- If this malfunction occurs repeatedly, replace CPxx- board (with updated software).
- Call the Service

Memos:

Error No.: 1458

Error Text: ALIGN.STAT.MULTIPLE REF.POS.!

State: ERROR **addition:** RED

Cause: Complete text: ALIGNING STATION - MULTIPLE REFERENCE POSITION!
This message is output, when a reference run of the aligning station is performed and reference signals are detected on various positions.

Remedy:
- Wrong or poorly adjusted switching cam of reference position sensor.
- Use mechanical reference sensor B343 (id.no.228472)
- Pulse generator is defective, replace generator.
- Make a reference run tor update the reference value.

Memos:

Error No.: 1459

Error Text: ALIGN.STAT. REF.POS. MISSING!

State: ERROR **addition:** RED

Cause: Complete text: ALIGNING STATION - REFERENCE POSITION MISSING!
This message is output, when a reference run of the aligning station is performed and no reference signal is detected.

Remedy:
- check mechanical reference sensor B343.
- Wrong or poorly adjusted switching cam of reference position sensor.
- Pulse generator is defective, replace generator.
- Make a reference run tor update the reference value.

Memos:

Error No.: 1460

Error Text: ALIGN.STAT.BOTH LIMIT SWITCH.

State: ERROR **addition:** RED

Cause: Complete text: ALIGNING STATION - LIMIT SWITCH ERROR: FRONT AND REAR SWITCHES SIMULTANEOUSLY
This message is output, when both limit switches of the aligning gauge respond simultaneously (front and rear at the same time).

Remedy:
- Check correct functioning of limit switches S435 and S436.
- Check / replace I/O 2- board.
- Check cabling of switches.
- Check / replace CPxx- board.
- Check / replace CU unit.

Memos:

Error No.: 1461

Error Text: ALIGN. STAT. POS. NOT REACHED

State: HINT **addition:** PURPLE

Cause: Complete text: ALIGNING STATION - POSITION NOT REACHED!
This message is output, when the preset target is not reached within a certain tolerance when the aligning gauge is positioned.

Remedy:
- Check correct mechanical function of drive unit.
- Check / replace pulse generator.
- Check / replace CPxx- board.

Memos:

Error No.: 1462

Error Text: ALIGN. STAT. ILLEGAL POSITION

State: HINT **addition:** PURPLE

Cause: Complete text: ALIGNING STATION - ILLEGAL POSITION
This message is output, when the current position of the aligning gauge is calculated, but the resulting value is illegal. This may be caused by a wrong reference position or an error in the position measuring system.

Remedy:
- Make a reference run to update the reference value.
- Check / replace pulse generator.
- Check / replace CPxx- board.

Memos:

Error No.: 1463

Error Text: ALIGN.STAT.POS.PULSES MISSING

State: ERROR **addition:** RED

Cause: Complete text: ALIGNING STATION - POSITION PULSES MISSING!
This message is output, when a certain movement of hte aligning station is triggered, but the control computer does not receive any or sufficient pulses from the position sensors.

Remedy:
- Check / replace pulse generator.
- Check / replace CPxx- board.
- Drive unit is too tight, check mechanical system.
- Verify motor control.
- on AC115 and AT-M, check for parting of cable K4 > K4a
- Check / replace SAP- board.

Memos:

Error No.: 1464

Error Text: ALIGN.STATION DIRECTION ERROR

State: ERROR **addition:** RED

Cause: This error message is output, when the aligning gauge is moved in a certain direction, but hte position pulses received correspond to the opposite direction of movement.

Remedy:
- If this occurs during commissioning, it indicates faulty wiring.
- Parting of a cable in the connection line of the position transducer.
- Drive motor is not connected correctly (direction of rotation).
- Check 0° and 90° signal lines for shaft encoder

Memos:

Error No.: 1465

Error Text: ALIGN.STAT.COUNTER RESET ERR.

State: ERROR **addition:** RED

Cause: Complete text: POSITION COUNTER RESET ERROR IN ALIGNING STATION
At a certain time during the reference run the position counter of the aligning gauge is reset. If this action is not correctly indicated to the software, this text is output as an error message.

Remedy:
- Error indicates that ASIC is defective, replace CPxx- board.

Memos:

Error No.: 1466

Error Text: ALIGN.STAT.ERR.REF.IMP.POSIT.

State: ERROR **addition:** RED

Cause: Complete text: ALIGNING STATION - WRONG POSITION OF REFERENCE IMPULSE
This message is output if the position of the reference point has no minimum distance of 5 mm from the limit switch "aligning gauge at front".

Remedy:
- Error may be caused by a defective limit switch, check / replace, if necessary.
- the computer detects no position pulses, replace CPxx- board.

Memos:

Error No.: 1468

Error Text: FINGER ADJUST.DIRECTION ERROR

State: ERROR **addition:** RED

Cause: Complete text: DIRECTION ERROR UPON MOTORIZED FINGER WIDTH ADJUSTMENT
This error message is output during motorized adjustment of the width of the deloading finger, if the operator detects that the width is increased instead of decreased, or vice versa.

Remedy:
- Check direction of rotation of finger adjusting motor M15.
- Check connection of potentiometer R2 for finger adjusting motor.

Memos:

Error No.: 1469

Error Text: TIMEOUT DEL.FINGER ADJUSTMENT

State: HINT **addition:** PURPLE

Cause: Complete text: TIMEOUT DURING MOTORIZED WIDTH ADJUSTMENT OF DELOADING FINGER
This error message is output during motorized adjustment of the width of the deloading finger cannot be completed within a specified maximum time.

Remedy:
- Check mechanical funcioning, smooth running
- Check potentiometer R2 for finger width adjustment, replace, if necessary
- Malfunction of corresponding I/O 1- board for motor control
- Check / replace motor M15.

Memos:

Error No.: 1473

Error Text: ALIGN.STAT.FIX.LIMIT SW. DEF.

State: ERROR **addition:** RED

Cause: Complete text: LIMIT SWITCHES OF ALIGNING STATION FIXING
This error message is output, if the system has detected a defect of one of the limit switches of the aligning station. This may be one of the switches "fixing bolt left bottom", "fixing bolt right bottom", "aligning station in fixing position" and "aligning station in parking position". The malfunction can also be caused by a wrong or missing connection of control outputs "fixing bolt upward" or "clamping lock, retracted".

Remedy:
- Check correct functioning of limit switches B5, B6, B7, B8.
- Check / replace I/O 2- board.
- Check wiring of switches.
- Check / replace CPxx- board.
- Check / replace CU unit.
- Check electrical and pneumatic connections of aligning station.

Memos:

Error No.: 1476

Error Text: AUTOTRIM NOT OPEN OR CLOSED

State: HINT **addition:** PURPLE

Cause: This error message is output, when the operator prompts a certain action of the machine, which requires the Autotrim table to be either opened or closed completely, but the Autotrim is neither entirely open nor closed.

Remedy:
- Open or close Autotrim table before action is re-started.
- If the table is indeed opened or closed completely, check the corresponding limit switches, with ED machine SFM- board and I/O- P1- board with XT machines.
- Check the wiring and the plug-in cards affected.

Memos:

Error No.: 1477

Error Text: ERROR WHEN FIXING AUTOTRIM

State: ERROR **addition:** RED

Cause: This error message is output, if an error has occured during the fixing of the Autotrim table. After a timeout, it is detected that the fixing unit of the Autotrim table is defective. This may be caused by the following facts:
- Malfunction in electrical or pneumatic connection.
- Limit switches " table open", "table closed" are badly adjusted or defective.
- Autotrim table / Fixing device is mechanically locked.

Remedy:
- Check electrical and pneumatic connections.
- Check and/or correctly adjust final position switches S364 (table open) S365 (table closed).
- Mechanical blocking of Autotrim table / fixing device.
- Check function and cabling of switches B4 and B4a.
- Make sure that fixing device is running smoothly.
- Check / replace I/O 1- board.
- Check / replace SFM- board.

Memos:

Error No.: 1478

Error Text: ERROR WHEN RELEASING AUTOTRIM

State: ERROR **addition:** RED

Cause: This error message is output, if an error has occured while the fixing of the Autotrim table is released. After a timeout, it is detected that the fixing of the Autotrim table is defective. This may be caused by the following facts:
- Malfunction in electrical or pneumatic connection.
- Limit switches " table open", "table closed" are badly adjusted or defective.
- Autotrim table / Fixing device is mechanically locked.

Remedy:
- Check electrical and pneumatic connections
- Check and/or correctly adjust final position switches S364 (table open) S365 (table closed).
- Mechanical blocking of Autotrim table / fixing device.
- Check function and cabling of switches B4 and B4a.
- Make sure that fixing device is running smoothly
- Check / replace I/O 1- board.
- Check / replace SFM- board.

Memos:

Error No.: 1479

Error Text: FIXING OF AUTOTRIM DEFECTIVE

State: ERROR **addition:** RED

Cause: This error message is output, if an error has occured during the fixing of the Autotrim table. Whilethe Autotrim table is opened or closed, and after the table fixing is released, the limit position signal (fixing released) is no longer detected.

Remedy:
- Check electrical and pneumatic connections
- Check and/or correctly adjust final position switches S364, S365, B4 and B4a.
- Make sure that fixing device is running smoothly
- Check / replace I/O 1- board.
- Check / replace SFM- board.

Memos:

Error No.: 1491

Error Text: TOUCH BUFFER IS FULL !

State: HINT **addition:** PURPLE

Cause: This error message is output, as soon as the buffer for transmitting information via the buttons of the display to the PCM is full. This indicates a malfunction in the PCM or in the transmission to the PCM.

Remedy:
- Switch machine off, switch it on again.
- Replace PCM module.

Memos:

Error No.: 1492

Error Text: ILLEGAL ASSIGNMENT TO AUTOCUT

State: HINT **addition:** PURPLE

Cause: The DIP switch setting on CPxx- board indicates that the present machine is of model Autotrim-M. However, the second serial interface of the CPxx- board is assigned to Autocut (old version 90, with pallet buffer). Since this is not possible at the same time, the assignment of the interface to the old model of Autocut 90 will be ignored.

Remedy:
- Correctly assign interface in the menu "Survey of functions".
- If the machine in question is neither Autotrim-M nor a new Autocut 115/25, the DIP switches are badly adjusted.
- Check if the standard machine is fitted with the proper standard software.

Memos:

Error No.: 1493

Error Text: WASTE ALIGNER: END POS. ERROR

State: ERROR **addition:** RED

Cause: Complete text: WASTE ALIGNER: END POSITION ERROR
This error message is output, if both limit switches (top/bottom) of the waste aligner respond at the same time. This indicates a defect.

Remedy:
- Check correct functioning of limit switches B9 and B10.
- Check / replace I/O 2- board.
- Check wiring of switches.
- Check / replace CPxx- board.
- Check / replace CU unit.

Memos:

Error No.: 1494

Error Text: WASTE ALIGNER NOT IN LOW.POS.

State: HINT **addition:** PURPLE

Cause: Complete text: WASTE ALIGNER NOT IN LOWEST POSITION.
This error message is output, if the waste aligner should be in bottom dead center (lowered into AT table), but the corresponding limit switch is not active.
Consequently, a particular action has not been executed or was interrupted.

Remedy:
- Check bottom limit switch B10.
- Check / replace IO 2- board and cabling.

Memos:

Error No.: 1495

Error Text: WASTE ALIGNER: TABLE NOT OPEN

State: ERROR **addition:** RED

Cause: This error message is output, if the waste aligner shall be or has been extended to the top position, but the Autotrim table is not open.

Remedy:
- at Autotrim table: check electrical and pneumatic connections.
- Check limit switches at Autotrim table S365 (open/closed) and replace, if necessary.
- Check correct functioning of waste aligner (limit position detection B9 and B10)
- Check / replace IO 1- board.
- Check / replace IO 2- board.

Memos:

Error No.: 1496

Error Text: TIMEOUT WASTE ALIGNER !

State: ERROR **addition:** RED

Cause: This error message is output, if the waste aligner has not reached the corresponding limit position within the preset maximum time.

Remedy:
- Check limit position switches (top B9 /bottom B10) of waste aligner.
- Check electrical and pneumatic controls.
- Check correct functioning / smooth running of mechanical system.
- Check / replace IO 2- board.

Memos:

Error No.: 1525

Error Text: TIMEOUT MOVING ALIGN.STATION!

State: ERROR **addition:** RED

Cause: This error message is output, if the moving aligning gauge of the aligning stationdoes not reach its position or a limit switch within the preset time.

Remedy:
- Check mechanical condition of aligning station.
- Check drive unit for aligning station and control of drive unit.

Memos:

Error No.: 1545

Error Text: SYS. STRUCT. PCM INCOMPATIBLE

State: HINT **addition:** PURPLE

Cause: Complete text: SYSTEM STRUCTURE INCOMPATIBLE WITH POLAR CONTROL MANAGEMENT
This error message is output, if the remote diagnosis has been activated and the system discovers that the structure of the system data has been changed and is no longer compatible with the structure of the system data in Polar Control Management.

Remedy:
- De-activate remote diagnosis at cutting machine.
- Machine software stored on CPxx- board and in PCM computer is incompatible.
- Update software version on PCM computer.

Memos:

Error No.: 1551

Error Text: FINGER WIDTH DOES NOT CHANGE

State: ERROR **addition:** RED

Cause: This error message is output, if the control computer outputs a command to change the width of the deloading finger, but no change of the finger width can be detected.

Remedy:
- Adjust finger width in menu "Manual operation".
- Check motor M15 and control for finger adjustment.
- Check potentiometer and wiring for position feedback.
- Check and replace I/O 1- board for finger adjustment, if necessary.
- Update the ED software to V5.2.0-23 at AC115 and AT-M, if the error message is always displayed after the strips have been changed.
- Fix the shield for the cables from "finger adjustment" potentiometer R2 only in the control cabinet.
- Check / replace the RC module of the finger motor brake (id. No. 225721)
- Check / replace the RC module of the AT motor brake (id. no. 214066)

Memos:

Error No.: 1559

Error Text: FINGER WIDTH:ERRONEOUS SIGNAL

State: ERROR **addition:** RED

Cause: Complete text: ERRONEOUS ANALOG SIGNAL FOR FINGER WIDTH!
This error message is output during a reference run for finger width adjustment, if the width is set to a very narrow position and the value of 0 is input.

Remedy:
- Check limit switches B437 and 438 and potentiometer R2, reset, if necessary.
- Replace I/O 1- board.

Memos:

Error No.: 1567

Error Text: DOWNLOAD FROM PC IS ILLEGAL !

State: HINT **addition:** PURPLE

Cause: This error message is output, if someone tries to use the PC for transferring an inadequate software upload. The information string of the software contains an information, if the respective software is meant for a cutting machine or a die-cutter for instance.
So, if someone tries to transfer the die-cutter software to a high-speed cutter, this hint is indicated to the technician.

Remedy: - Use the correct software version for the corresponding machine / die-cutter / etc.

Memos:

Error No.: 1570

Error Text: LAT.ALIGN.GAUGE NOT BACK !

State: HINT **addition:** PURPLE

Cause: Complete text: LATERAL ALIGNING GAUGE NOT IN REAR POSITION!
This error message is output, if the lateral aligning gauge is not in its rear position, although it should be. Consequently, an action initiated by the operator, has not been performed or was interrupted.

Remedy:
- Move lateral aligning gauge backward in manual operating menu.
- Check lateral aligning gauge in manual operation.
- Check motor, wiring and corresponding I/O 2- board.
- Check limit switch B12 for rear end position and replace, if necessary.

Memos:

Error No.: 1571

Error Text: LAT.AL.GAUGE ERR.END POS. A/B

State: ERROR **addition:** RED

Cause: Complete text: LATERAL ALIGNING GAUGE AT FRONT / REAR END POSITION ERROR
This error message is output, if the limit switches "at front" and "at rear" of the lateral aligning gauges respond simultaneously.

Remedy:
- Check correct functioning of limit switches B11 and B12.
- Check / replace I/O 2- board.
- Check cabling of switches.
- Check / replace CPxx- board.
- Check / replace CU unit.

Memos:

Error No.: 1572

Error Text: LAT.AL.GAUGE ERR.END POS. D/U

State: ERROR **addition:** RED

Cause: Complete text: LATERAL ALIGNING GAUGE AT TOP / BOTTOM END POSITION ERROR
This error message is output, if the limit switches "at top" and "at bottom" of the lateral aligning gauges respond simultaneously.

Remedy:
- Check correct functioning of limit switches B13 and B14.
- Check / replace I/O 2- board.
- Check cabling of switches.
- Check / replace CPxx- board.
- Check / replace CU unit.

Memos:

Error No.: 1573

Error Text: LAT.ALIGN.GAUGE ILLEGAL POS.

State: HINT **addition:** PURPLE

Cause: Complete text: LATERAL ALIGNING GAUGE ILLEGAL POSITION
This error message is output, if the lateral aligning gauge has an illegal position (neither at the front nor the rear nor the top position).

Remedy:
- Move lateral aligning gauge to defined position, in manual control menu.
- Check correct functioning of limit switches B11, B12, B13, B14.
- Check magnetic valves Y7, Y407 and 408.
- Check / replace I/O 2- board.
- Check cabling of switches, control line and pneumatic system.
- Check / replace CPxx- board.
- Check / replace CU unit.

Memos:

Error No.: 1574

Error Text: LAT.ALIGN.GAUGE INTERRUPTET

State: ERROR **addition:** RED

Cause: Complete text: LATERAL ALIGNING GAUGE INTERRUPTED
This error message is output, if the movement of the lateral aligning gauge is interrupted.

Remedy:
- Check smooth mechanical operation.
- Check limit switch.

Memos:

Error No.: 1575

Error Text: LAT.ALIGN.GAUGE TIMEOUT !

State: ERROR **addition:** RED

Cause: Complete text: LATERAL ALIGNING GAUGE TIMEOUT!
This error message is output, if the lateral aligning gauge is adjusted, but does not reach the expected end position within the maximum preset time.

Remedy:
- Move lateral aligning gauge to defined position, in manual control menu.
- Check correct functioning of limit switches B11, B12, B13, B14.
- Check magnetic valves Y7, Y407 and 408.
- Check / replace I/O 2- board.
- Check cabling of switches, control line and pneumatic system.
- Check / replace CPxx- board.
- Check / replace CU unit.

Memos:

Error No.: 1576

Error Text: BACKGAUGE END AT LAT.AL.GAUGE

State: HINT **addition:** PURPLE

Cause: The backgauge is in its front limit position. The smallest cut size with activated adjusting gauges has been reached.

Remedy:
- Move the backgauge manually backwards.
- Check / replace I/O- board.
- Check limit switch S360 and its cabling.

Memos:

Error No.: 1579

Error Text: LAT.ALIGN.GAUGE NOT AT TOP !

State: HINT **addition:** PURPLE

Cause: Complete text: LATERAL ALIGNING GAUGE NOT AT TOP!
This error message is output, when a machine function is in progress or has been started, which presupposes that the lateral aligning gauge is in top position, but the gauge is not (no longer) at the top. The computer does not detect the lateral aligning gauge in top position.

Remedy:
- Move lateral aligning gauge upward in manual operating menu.
- Check lateral aligning gauge in manual operation.
- Check magnetic valves Y7, Y407 and 408.
- Check / replace I/O 2- board.
- Check limit switch B12, B14 for rear end position and replace, if necessary.

Memos:

Error No.: 1598

Error Text: BACKG.LIMIT/LAT.AL.GAUGE BACK

State: HINT **addition:** PURPLE

Cause: Complete text: LATERAL ALIGNING GAUGE AT BACK - BACKGAUGE LIMIT
This error message is output, ifthe backgauge is to be moved so far to the front that it would collide with the lateral aligning gauge in its rear end position (at approx. 2.5 cm). If the lateral gauge is moved to its front position, the backgauge can still be moved further to the front.

Remedy:
- Move lateral aligning gauge to rear position in manual operating menu.

Memos:

Error No.: 1602

Error Text: CAMERA CHECK: ALIGNING NOT OK

State: HINT **addition:** PURPLE

Cause: This error message is output if cutting is started and the camera surveillance detects that the cutting material is not positioned correctly at the backgauge or side gauge. Hence, the cut is not carried out.

Remedy: - Align cutting material correctly, then repeat the cut manually.

Memos:

Error No.: 1615

Error Text: LB-TEST INTERRUPTS AUTOTRIM

State: HINT **addition:** PURPLE

Cause: Complete text: LIGHT BARRIER TEST INTERRUPTS AUTOTRIM
This error message is output, if a light barrier test has been performed while the Autotrim table is opened or closed, and this test has interrupted the movement of the table.

Remedy: - Check travel speed of AT table / fixing device and optimize, if necessary
- Software needs to be updated.

Memos:

Error No.: 1621

Error Text: TIMEOUT CAMERA SURVEILLANCE !

State: HINT **addition:** PURPLE

Cause: This error message is output when cutting is started and the video camera surveillance of the alignment has not signalled the result of its check within a preset time. A new cut is not locked.

Remedy: - Re-boot PCM computer in the machine.

Memos:

Error No.: 1622

Error Text: AUTOCUT-25 SWIVEL U. REFUSED!

State: ERROR **addition:** RED

Cause: This error message is output if the swivel unit of an Autocut 25 machine is to perform a certain function, but the corresponding software refuses to carry it out. This is usually an error in the cutting machine software.

Remedy:
- Re-start sequence of functions.
- Re-start the machine.
- Update the software of CPxx- board.

Memos:

Error No.: 1625

Error Text: AUTOCUT-25 PROCESS ERROR !

State: ERROR **addition:** RED

Cause: This error message is output if the image the machine software of an Autocut 25 has formed of the process may no longer be correct. This is usually an error in the cutting machine software.

Remedy:
- Re-start sequence of functions.
- Re-start the machine.
- Update the software of CPxx- board.

Memos:

Error No.: 1628

Error Text: REPLACE HYDRAULIC OIL FILTER

State: HINT **addition:** PURPLE

Cause: The monitoring of the external oil filter of the hydraulic system gives notice of a contamination and indicates that the filter needs to be replaced.

Remedy:
- Replacement of filter cartridge.
- Check switch S462 with cabling, replace the switch, if necessary.

Memos:

Error No.: 1631

Error Text: SEGMENT 4 MOUNTED, 3 MISSING

State: HINT **addition:** PURPLE

Cause: This message is output, if the computer of Autocut 25 has detected that segment (tooth) no. 4 of the rake is installed while segment no. 3 is not. This is not admissible.

Remedy:
- Mount segment no. 3 and/or remove segment no. 4.
- Check limit switches for segments no. 3 (B19) and no. 4. (B20)
- Check / replace I/O- board.

Memos:

Error No.: 1632

Error Text: DIE CUTTER DISABLES SWIVEL IN

State: HINT **addition:** PURPLE

Cause: This message is output on Autocut 25, if the die-cutter has not enabled the swivel in.

Remedy:
- Put die-cutter into a position to make enabling possible.
- Verify signal path from die-cutter output to Autocut-25 input.
- Check / replace I/O- board.

Memos:

Error No.: 1633

Error Text: SAFETY CIRCUIT INTERRUPTED

State: HINT **addition:** PURPLE

Cause: This message is output on Autocut 25, if the safety circuit of the cutting machine has been interrupted, e.g. by opening a cover flap or switching-off the rear-table feeder.

Remedy:
- Close cover flaps in safety circuit.
- Switch on / start rear-table feeder.
- Verify signal path of safety circuit.
- Check / replace I/O- board.
- Check / replace relay K100.

Memos:

Error No.: 1634

Error Text: DIE CUTTER DISABLES SWIV. OUT

State: HINT **addition:** PURPLE

Cause: This message is output on Autocut 25, if the die-cutter has not enabled the swivel unit to be swivelled out.

Remedy:
- Put die-cutter in a position to allow enabling.
- Verify signal path from die-cutter output to Autocut-25 input.
- Check / replace I/O- board.

Memos:

Error No.: 1635

Error Text: TIMEOUT SWIVEL OUT

State: ERROR **addition:** RED

Cause: This message is output on Autocut 25, if the swivel unit when swivelled has not reached the position "swivelled out" within the maximum standard time.

Remedy:
- Ensure smooth operation of mechanical system.
- Check limit switch/es for final positions.
- Check motor and control as of I/O- board.
- Check / replace I/O- board.

Memos:

Error No.: 1636

Error Text: TIMEOUT SWIVEL IN

State: ERROR **addition:** RED

Cause: This message is output on Autocut 25, if the swivel unit when swivelled has not reached the position "swivelled in" within the maximum standard time.

Remedy:
- Ensure smooth operation of mechanical system.
- Check limit switch/es for final positions.
- Check motor and control as of I/O- board.
- Check / replace I/O- board.

Memos:

Error No.: 1637

Error Text: TIMEOUT WASTE GUIDE BACKWARDS

State: ERROR **addition:** RED

Cause: This message is output on Autocut 25, if the waste guide does not reach the "rear" position within a maximum standard time when it is moved backward.

Remedy:
- Ensure smooth operation of mechanical system.
- Check limit switch/es for final positions.
- Check pneumatic drive unit (pneumatic cylinder and control valve)
- Check signal path for activation of pneumatic valve.
- Check / replace I/O- board.

Memos:

Error No.: 1638

Error Text: ENABLE TO SWIVEL IN VANISHED

State: HINT **addition:** PURPLE

Cause: This message is output on Autocut 25, if the enabling to swivel-in the swivel unit vanishes unexpectedly in the course of the swivel-in process.

Remedy:
- Put die-cutter in a position to allow enabling.
- Verify signal path from die-cutter output to Autocut-25 input.
- Check / replace I/O- board.

Memos:

Error No.: 1639

Error Text: ENABLE TO SWIVEL OUT VANISHED

State: HINT **addition:** PURPLE

Cause: This message is output on Autocut 25, if the enabling to swivel-out the swivel unit vanishes unexpectedly during the swivel-out process.

Remedy:
- Put die-cutter in a position to allow enabling.
- Verify signal path from die-cutter output to Autocut-25 input.
- Check / replace I/O- board.

Memos:

Error No.: 1640

Error Text: LIGHT BARR.SWIVEL UNIT INTER.

State: HINT **addition:** PURPLE

Cause: This message is output on Autocut 25, if the swivel unit should be swivelled in, but the light barrier of the swivel unit singals that this is impossible, since there is paper or something different which blocks the swivel range of the swivel unit.

Remedy:
- Remove the obstacles from the swivel range of the swivel unit.
- Check correct functioning of light barrier.
- Check / replace I/O- board.

Memos:

Error No.: 1641

Error Text: TIMEOUT CLAMP DOWN

State: ERROR **addition:** RED

Cause: This message is output on Autocut 25, if the clamp is lowered and has not reached the position "at bottom" within a maximum standard time.

Remedy:
- Check setting of hydraulic pressure for sensor.
- Replace pressure sensor in hydraulic system.
- Meter hydraulic pressure for clamp.
- Replace valve for pressure buildup.
- Check electrical activation of hydraulic valve.
- Check / replace I/O- board.

Memos:

Error No.: 1642

Error Text: TIMEOUT KNIFE DOWN

State: ERROR **addition:** RED

Cause: This message is output on Autocut 25, if the knife is lowered, but has not reached the position "at bottom" within a maximum standard time.

Remedy:
- Check hydraulic pressure for knife movement, re-set, if necessary.
- Check smooth running of knife carrier.
- Check electrical activation of hydraulic drive of knife.
- No response "knife at BDC", check proximity switch B14.
- Check / replace I/O- board.

Memos:

Error No.: 1643

Error Text: TIMEOUT KNIFE UP

State: ERROR **addition:** RED

Cause: This message is output on Autocut 25, if the knife is lifted and has not reached the position "at TDC" within a maximum standard time.

Remedy:
- Check smooth running of knife carrier.
- Check sensor B13 "knife at TDC".
- Check hydraulic drive of knife carrier.
- Check / replace I/O- board.

Memos:

Error No.: 1644

Error Text: TIMEOUT CLAMP UP

State: ERROR **addition:** RED

Cause: This message is output on Autocut 25, if the clamp is lifted and has not reached the position "at TDC" within a maximum standard time.

Remedy:
- Check smooth running of the clamp.
- Check sensor "clamp at TDC".
- Check hydraulic drive of clamp.
- Check / replace I/O- board.

Memos:

Error No.: 1645

Error Text: LAT.ALIGN.GAUGE ILLEGALY OUT

State: HINT **addition:** PURPLE

Cause: This message is output on Autocut 25, if the lateral aligning gauge is unpressurized (i.e. it is neither activated to move forward nor to move backward), but the limit switch "at front" responds.

Remedy:
- Check correct functioning of sensor "aligning gauge at front" B10 and B21.
- Check functioning of pneumatic cylinder and control valves.
- Ensure smooth running of lateral aligning gauge.
- Check / replace I/O- board.

Memos:

Error No.: 1646

Error Text: TIMEOUT FIXING SWIVEL UNIT

State: ERROR **addition:** RED

Cause: This message is output on Autocut 25, if the fixing of the swivel unit does not reach the position "fixed" within a maximum standard time.

Remedy:
- Check the function via manual operating program.
- Ensure movability of fixing bolt.
- Check limit position signal of sensors B3 and B4 of fixing bolt.
- Check pneumatic control Y4 of bolt.
- Check signal path of sensors to I/O- board.
- Check / replace I/O- board.

Memos: Attention:with ED machines only

Error No.: 1647

Error Text: TIMEOUT UNFIXING SWIVEL UNIT

State: ERROR **addition:** RED

Cause: This message is output on Autocut 25, if the fixing mechanism of the swivel unit when being released, does not reach the position "released" within a maximum standard time.

Remedy:
- Check the function via manual operating program.
- Ensure movability of fixing bolt.
- Check limit position signal of sensors B3 and B4 of fixing bolt.
- Check pneumatic control Y4 of bolt.
- Check signal path of sensors to I/O- board.
- Check / replace I/O- board.

Memos: Attention:with ED machines only

Error No.: 1648

Error Text: LAT.ALIGN.GAUGE ILLEGALY BACK

State: HINT **addition:** PURPLE

Cause: This message is output on Autocut 25, if the lateral aligning gauge is unpressurized (i.e. it is neither activated to move forward nor to move backward), but the limit switch "at rear" responds.

Remedy:
- Check correct functioning of sensor "aligning gauge at rear"
- Check functioning of pneumatic cylinder and control valves
- Check / replace I/O- board.

Memos:

Error No.: 1649

Error Text: LAT.ALIGN.GAUGE->NO MATERIAL

State: HINT **addition:** PURPLE

Cause: Complete text: LATERAL ALIGNING GAUGE AT FRONT, NO MATERIAL LOADED
This message is output on Autocut 25, if the lateral aligning gauge - when aligning the cutting material - has reached the limit switch "at front", which is only possible if no material is present under the knife or limit switch "at front" responds erroneously.

Remedy:
- Check limit switches B10 and B21 for aligning gauge "at front", replace, if necessary.
- Check pneumatic cylinders and valves Y11, Y12, Y407, replace, if necessary.
- Load the material to be cut.
- Check / replace I/O- board.

Memos:

Error No.: 1650

Error Text: TIMEOUT WASTE ALIGNER BACK

State: ERROR **addition:** RED

Cause: This message is output on Autocut 25, if the waste aligner of the swivel unit - when moving backward - does not reach the position "at rear" within the max. standard time.

Remedy:
- Check the function via manual operating program.
- Check mechanical smooth running of waste aligner.
- Check sensor "waste aligner at rear" B11 and B22 and replace, if necessary.
- Check pneumatic control Y11, Y12, Y407 for aligner.
- Check / replace I/O- board.

Memos:

Error No.: 1651

Error Text: TIMEOUT SWIVEL U.ALIGNER BACK

State: ERROR **addition:** RED

Cause: Complete text: TIMEOUT SWIVEL UNIT ALIGNER BACK
This error message is output on Autocut 25 if the aligner of the swivel unit - when moving backward - does not reach the position "at rear" within the max. standard time.

Remedy:
- Check the function via manual operating program.
- Check mechanical smooth running of aligner.
- Check sensor "aligner at rear" B2 and replace, if necessary.
- Check pneumatic control Y8 for aligner.
- Check / replace I/O- board.

Memos:

Error No.: 1652

Error Text: CLAMP OF SWIVEL UNIT NOT DOWN

State: HINT **addition:** PURPLE

Cause: This error message is output on Autocut 25 if the clampr of the swivel unit has been lowered by the control computer, but the limit switch "clamp at TDC" is still active after a max. standard time.

Remedy:
- Check the function via manual operating program.
- Check pneumatic control Y1 and Y2 and functioning of hold-down clamp.
- Check signal path for activation of pneumatic vales "clamp".
- Check sensor for limit positions B5 and replace, if necessary.
- Check / replace I/O- board.

Memos:

Error No.: 1653

Error Text: CLAMP SWIVEL U. ILLEGALLY UP

State: HINT **addition:** PURPLE

Cause: This error message is output on Autocut 25 if the clamp of the swivel unit is unpressurized (i.e. it is neither activated to move upward nor to move downward), but the limit switch "at TDC" responds.

Remedy:
- Check the function via manual operating program.
- Check correct functioning of sensor B5 "clamp at TDC".
- Check functioning of pneumatic cylinders and control valves Y1 and Y2.
- Check / replace I/O- board.

Memos:

Error No.: 1654

Error Text: SWIVEL U. ALIGNER STILL BACK

State: HINT **addition:** PURPLE

Cause: This error message is output on Autocut 25, if the aligner of the swivel unit has been advanced by the control computer, but limit swich "swivel unit aligner" is still active after a maximum standard time.

Remedy:
- Check the function via manual operating program.
- Check mechanical smooth running of aligner.
- Check pneumatic drive Y8 / cylinder for aligner.
- Check limit switch B2 "swivel unit aligner at rear", replace, if necessary.
- Check / replace I/O- board.

Memos:

Error No.: 1655

Error Text: TIMEOUT CLAMP SWIVEL UNIT UP

State: ERROR **addition:** RED

Cause: This error message is output on Autocut 25, if the clamp of the swivel unit moves upward, but does not reach the position "upC" within a max. standard time.

Remedy:
- Check the function via manual operating program.
- Ensure mechanical smooth running of clamp.
- Check pneumatic drive Y1 and Y2 / cylinder for clamp.
- Check limit switch B5 "clamp up", replace, if necessary.
- Check / replace I/O- board.

Memos:

Error No.: 1656

Error Text: BEATER DOES NOT MOVE DOWN

State: ERROR **addition:** RED

Cause: This error message is output on Autocut 25 if the beater at the swivel unit is activated by the control computer to move down (with ED) or up (with XT), but the limit switch "beater in resting position" is still active after a maximum standard time.

Remedy:
- Check the function via manual operating program.
- Check mechanical flexibility of beater.
- Check limit position sensor B1 and replace, if necessary.
- Check beater activation via pneumatic system.
- Check signal path from I/O- board to pneumatic valve Y3.
- Check / replace I/O 1- board.

Memos:

Error No.: 1657

Error Text: TIMEOUT BEATER UP

State: ERROR **addition:** RED

Cause: This error message is output on Autocut 25 if the beater at the swivel unit moves upward, but does not reach the position "up" (with ED) or down (with XT),within the maximum standard time (upper position = resting position with XT machines and lower position = resting position with ED machines).

Remedy:
- Check the function via manual operating program.
- Check mechanical flexibility of beater.
- Check limit position sensor B1 and replace, if necessary.
- Check beater activation via pneumatic system Y3.
- Check signal path from I/O 1- board to pneumatic valve.
- Check / replace I/O 1- board.

Memos:

Error No.: 1658

Error Text: ERROR LIM. SWITCHES SWIVEL U.

State: ERROR **addition:** RED

Cause: Complete text: ERROR LIMIT SWITCHES OF SWIVEL UNIT - SWIVELLED IN / SWIVELLED OUT
This error message is output on Autocut 25 when limit switches "swivel unit swivelled in" and "swivel unit swivelled out" are active at the same time.

Remedy:
- Check limit position sensors B31 and B32 and replace, if necessary.
- Check / replace I/O 2- board.

Memos:

Error No.: 1659

Error Text: ERROR LIMIT SWITCHES FIXING

State: ERROR **addition:** RED

Cause: Complete text: ERROR LIMIT SWITCHES OF FIXING MECHANISM - RETRACTED / EXTENDED
This error message is output on Autocut 25 when limit switches "fixing mechanism retracted" and "fixing mechanism extended" are active at the same time.

Remedy:
- Check limit position sensors B3, B4 and replace, if necessary.
- Check / replace I/O 1- board.

Memos:

Error No.: 1660

Error Text: ERROR LIM.SW. CLAMP SWIVEL U.

State: ERROR **addition:** RED

Cause: Complete text: ERROR LIMIT SWITCHES OF HOLD-DOWN CLAMP OF SWIVEL UNIT
This error message is output on Autocut 25 when limit switches "clamp of swivel unit at top" and "clamp of swivel unit at bottom" are active at the same time.

Remedy:
- Check limit position sensors B5, B8 and replace, if necessary.
- Check / replace I/O 1- board.

Memos:

Error No.: 1661

Error Text: ERROR LIM.SW. LATERAL ALIGNER

State: ERROR **addition:** RED

Cause: Complete text: ERROR LIMIT SWITCHES OF LATERAL ALIGNER
This error message is output on Autocut 25 when limit switches "lateral aligner at front" and "lateral aligner at rear" are active at the same time.

Remedy:
- Check limit position sensors B10, B11, B21, B22 and replace, if necessary.
- Check / replace I/O- board.

Memos:

Error No.: 1662

Error Text: ERROR LIMIT SWITCHES CLAMP

State: ERROR **addition:** RED

Cause: This error message is output on Autocut 25 when limit switches "pressure clamp at top" and "pressure clamp at bottom" are active at the same time.

Remedy:
- Check setting of hydraulic pressure for sensor.
- Check limit position / pressure sensors for clamp at bottom, and replace, if necessary.
- Check / replace I/O 1- board.

Memos:

Error No.: 1663

Error Text: ERROR LIMIT SWITCHES KNIFE

State: ERROR **addition:** RED

Cause: This error message is output on Autocut 25 when limit switches "knife in top position" and "knife in bottom position" are active at the same time.

Remedy:
- Check limit position sensors B13, B14 and replace, if necessary.
- Check / replace I/O- board.

Memos:

Error No.: 1664

Error Text: TIMEOUT WASTE GUIDE FORWARDS

State: ERROR **addition:** RED

Cause: This error message is output on Autocut 25 if the waste guide moves forwards, but does not reach the position "at front" within the max. standard time. The waste guide conveys the waste cuttings into the waste channel.

Remedy:
- Ensure smooth mechanical operation.
- Check limit position sensors.
- Check pneumatic drive (pneumatic cylinders and control valve)
- Check signal path for controlling the pneumatic valve.
- Check / replace I/O- board.

Memos:

Error No.: 1665

Error Text: CAMERA REPORTS ALIGNMENT ERR.

State: ERROR **addition:** RED

Cause: This error message is output on Autocut 25 if the carmer of the rear-table surveillance reports that the cutting material is not correctly aligned at the backgauge. The cut is blocked.

Remedy:
- Position the cutting material correctly.
- Then, initiate cut again.

Memos:

Error No.: 1666

Error Text: NO RESPONSE FROM CAMERA

State: ERROR **addition:** RED

Cause: This error message is output if the camera for rear-table surveillance at Autocut 25 does not report within the max. standard time, if the system is running perfectly.

Remedy: - Re-boot PCM computer in the machine.

Memos:

Error No.: 1667

Error Text: WASTE ALIGNER NOT AT BACK POS

State: ERROR **addition:** RED

Cause: Complete message: WASTE ALIGNER NOT AT BACK POSITION
This error message is output on Autocut 25 if limit switch "waste aligner at rear position" is not (no longer) active during a cut. The waste aligner is a device that pushes the cutting material against the backgauge (i.e. aligns it) before a trim out is performed, to make sure that all sheets of the material are precisely aligned.

Remedy:
- Check limit switch B9 "aligner at rear position" and replace, if necessary
- Check signal path I/O- board to limit switches.
- Check / replace I/O 1- board.

Memos:

Error No.: 1668

Error Text: WASTE ALIGN.NOT AT FRONT POS.

State: ERROR **addition:** RED

Cause: Complete text: WASTE ALIGNER NOT IN FRONT POSITION
This error message is output on Autocut 25, if the waste aligner was activated by the control computer to move to the front, but limit switch "waste aligner in rear position" is still active after max. standard time.

Remedy:
- Check smooth mechanical operation of aligner.
- Check pneumatic drive / pneumatic cylinder and valve Y10.
- Check signal path from IO 1- board to limit switch B9.
- Check signal path from IO 1- board to magnetic valve Y10.

Memos:

Error No.: 1696

Error Text: WRONG MACHINE TYPE SETTING

State: ERROR **addition:** RED

Cause: This message is output, when the control computer of the cutting machine detects that the machine type set at the DIP switches of CPxx is wrong. This is the case, for instance, if the machine detects that Autotrim-M, Autocut 115 or Autocut 25 is preset, but not machine type "ED".

Remedy:
- Correctly set machine type on CPxx- board, DIP switches according to service documentation.
- Replace CPxx- board.
- For standard machine, use standard program.
- with XT machines the Touch display could be defectiv, for trouble shooting set DIP-Switch on CPxx- board to machine version X.
- Check and/or replace the cable from CPxx- board X4 to touch X516.

Memos:

Error No.: 1697

Error Text: BAD AUTOCUT-25 DIP-SW.SETTING

State: ERROR **addition:** RED

Cause: Complete text: BAD AUTOCUT-25 DIP-SWITCH SETTING
This message is output, when the control computer of the cutting machine detects that the machine configuration set at the DIP switches on CPxx is wrong. An Autocut 25 must always be preset to machine type ED.

Remedy:
- Correctly set machine type on CPxx- board, DIP switches according to service documentation.
- Replace CPxx- board.
- For standard machine, use standard program.

Memos:

Error No.: 1698

Error Text: AUTOCUT-25 I/O-BOARD MISSING

State: ERROR **addition:** RED

Cause: This message is output, when the control computer has detected a machine of type Autocut 25, but cannot find the correct I/O- board. In the case of Autocut 25 this means that the board is not correctly plugged in, is missing or defective.

Remedy:
- Check / replace I/O- board.
- If this is a standard machine, DIP switches are badly set, or a wrong program version (..-23) has been used.

Memos:

Error No.: 1699

Error Text: SPECIAL PROG. 23/28 NECESSARY

State: ERROR **addition:** RED

Cause: This message is output, when the control computer has detected a machine of type Autocut 25 or Autocut 115 or Autotrim_M, but the software of the control computer is neither of the two special program versions 23 nor 28..

Remedy:
- Install correct program version.
- Use computer board with correct special program.
- With XT machines perhaps touch panel could be defective, try to select Model X at CPxx- board DIP switches für trouble shooting.

Memos:

Error No.: 1700

Error Text: SWIVEL UNIT IS NOT CLOSED !

State: HINT **addition:** PURPLE

Cause: This message is output, if the Autocut 25 is to perform a function or if a function was aborted which requires the swivel unit to be closed.

Remedy: - Close swivel unit via manual operating menu.

Memos:

Error No.: 1701

Error Text: SWIVEL UNIT IS NOT OPEN !

State: HINT **addition:** PURPLE

Cause: This message is output, if the Autocut 25 is to perform a function or if a function was aborted which requires the swivel unit to be open.

Remedy: - Open swivel unit via manual operating menu.

Memos:

Error No.: 1702

Error Text: PARAMETER IS TOO LARGE !

State: HINT **addition:** PURPLE

Cause: Internal software error.

Remedy:
- Carry out the function again.
- Switch machine off, switch it on again.
- Software update on CPxx- board.

Memos:

Error No.: 1703

Error Text: SWIVEL UNIT IS NOT CLAMPED !

State: HINT **addition:** PURPLE

Cause: This message is output, if the Autocut 25 is to perform a manual function which requires the swivel unit to be clamped.

Remedy:
- Switch clamping on, carry out manual function again.

Memos:

Error No.: 1704

Error Text: SWIVEL UNIT IS NOT FIXED !

State: HINT **addition:** PURPLE

Cause: This message is output, if the Autocut 25 is to perform a manual function which requires the swivel unit to be fixed.

Remedy: - Fix the swivel unit, then carry out manual function again.

Memos:

Error No.: 1705

Error Text: ENABLE OF DIE CUTTER MISSING!

State: HINT **addition:** PURPLE

Cause: This message is output, if the Autocut 25 is to perform a manual function which requires an enabling signal from the die-cutter.

Remedy: - Put die-cutter in the position to give enabling signal.

Memos:

Error No.: 1706

Error Text: BEATER IS NOT IN HOME POSIT.!

State: HINT **addition:** PURPLE

Cause: This message is output, if the Autocut 25 is to perform a manual function which requires the beater of the swivel unit to be in home position.

Remedy: - Move beater to home position, then carry out manual function again.

Memos:

Error No.: 1707

Error Text: SWIVEL UNIT ALIGNER NOT BACK!

State: HINT **addition:** PURPLE

Cause: This message is output, if the Autocut 25 is to perform a manual function which requires the swivel unit aligner to be in rear position.

Remedy: - Move aligner to rear position, then carry out manual function again.

Memos:

Error No.: 1708

Error Text: SWIVEL UNIT IS UNFIXED !

State: HINT **addition:** PURPLE

Cause: This message is output, if the Autocut 25 is to perform a manual function which requires the swivel unit to be not unfixed.

Remedy: - Fix the swivel unit, then carry out manual function again.

Memos: Attention:with ED machines only

Error No.: 1709

Error Text: SWIVEL UNIT CLAMP IS NOT UP !

State: HINT **addition:** PURPLE

Cause: This message is output, if the Autocut 25 is to perform a manual function which requires the hold-down clamp of the swivel unit to be in upper position.

Remedy: - Move clamp up, then carry out manual function again.

Memos:

Error No.: 1710

Error Text: WASTE GUIDE IS NOT BACK !

State: HINT **addition:** PURPLE

Cause: This message is output, if the Autocut 25 is to perform a manual function which requires the waste guide to be in rear position.

Remedy: - Move waste guide to rear position, then carry out manual function again.

Memos:

Error No.: 1711

Error Text: WASTE ALIGNER IS NOT BACK !

State: HINT **addition:** PURPLE

Cause: This message is output, if the Autocut 25 is to perform a manual function which requires the waste aligner to be in rear position.

Remedy: - Move waste aligner to rear position, then carry out manual function again.

Memos:

Error No.: 1712

Error Text: OTHER PROCESS IS ACTIVE !

State: HINT **addition:** PURPLE

Cause: This message is output, if the Autocut 25 is to perform a manual function, but this is not possible since another process is active at that time.

Remedy:
- First terminate the active process.
- Repeat function after a short waiting time.
- Switch machine off, switch it on again and repeat the function.

Memos: Attention:with ED machines only

Error No.: 1713

Error Text: FIXING OF SW.UNIT NOT UNFIXED

State: HINT **addition:** PURPLE

Cause: This message is output, if the Autocut 25 is to perform a manual function which requires the fixing of the swivel unit to be released.

Remedy:
- Release the fixing, then carry out the manual function again.

Memos: Attention:with ED machines only

Error No.: 1714

Error Text: LIGHT BARRIER SWIVEL UNIT !

State: HINT **addition:** PURPLE

Cause: This message is output, if the Autocut 25 is to perform a manual function which requires the light barrier of the swivel unit to be not interrupted.

Remedy:
- Remove any obstacles from the swivel range of the swivel unit.
- Verify correct functioning of light barrier.

Memos: Attention:with ED machines only

Error No.: 1715

Error Text: SAFETY CIRCUIT INTERRUPTED !

State: HINT **addition:** PURPLE

Cause: This message is output on Autocut 25, if the safety circuit of the cutting machine has been interrupted, e. g. by opening a protective flap or because the rear-table pusher is not ready for operation.

Remedy:
- Close protective flap in safety circuit.
- Switch-on the rear-table pusher and make it ready for operation.
- Check signal path of safety circuit.

Memos:

Error No.: 1718

Error Text: BACKGAUGE IS NOT BACK !

State: HINT **addition:** PURPLE

Cause: This message is output, if the Autocut 25 is to perform a manual function which requires the backgauge to be in rear position.

Remedy: - Move backgauge to rear final position, then carry out function again.

Memos:

Error No.: 1721

Error Text: RELEASE CUT BUTTON

State: HINT **addition:** PURPLE

Cause: This prompt for the operator is output on an Autocut-25 machine if a certain action has been triggered by pushing the cut button (e.g. continuation after an interruption or manual cut), and the cut button has not been released after this action was terminated.

Remedy:
- Release cut button and actuate again.
- Check cut button S28c and signal path.
- Replace cut button or I/O 1- board.

Memos:

Error No.: 1724

Error Text: SEPARATION BAR IS NOT DOWN !

State: HINT **addition:** PURPLE

Cause: This message is output, if the Autocut 25 is to perform a manual function, or if a manual function has been interrupted which requires the separation bar to be in bottom position.

Remedy: - Lower the separation bar, then carry out the function again (manual menu)

Memos:

Error No.: 1725

Error Text: SEPARATION BAR IS NOT UP !

State: HINT **addition:** PURPLE

Cause: This message is output, if the Autocut 25 is to perform a manual function, or if a manual function has been interrupted which requires the separation bar to be in top position, for instance for rear-table loading.

Remedy: - Raise the separation bar, then carry out the function again (manual menu)

Memos:

Error No.: 1757

Error Text: PAPER IS ON THE SWIVEL UNIT !

State: HINT **addition:** PURPLE

Cause: Within the sequence of functions on Autocut 25, the system expects the next labels to be advanced. Due to the preceding sequence, the control system presupposes that there is still paper on the swivel unit. This is the case, when there is still paper within the die-cutting space, and the following paper is already cut and positioned on the swivel unit, waiting for the enabling.

Remedy:
- Eliminate/ remove the cause for the production stop in die-cutter / banding machine.
- Continue the process by pressing the cut button.

Memos:

Error No.: 1758

Error Text: TIMEOUT BACKG. BACK FOR SW.U.

State: ERROR **addition:** RED

Cause: Complete text: TIMEOUT BACKGAUGE BACK FOR SWIVEL UNIT
The swivel unit on Autocut 25 is to be swivelled out, but this is impossible, since the backgauge is positioned too far advanced and the max. standard time to move the backgauge backward has been exceeded.

Remedy:
- Move backgauge behind the cutting line in manual operating menu.
- Then swivel out the swivel unit.

Memos:

Error No.: 1759

Error Text: BACKG. POS.DISABLES SWIVEL U.

State: HINT **addition:** PURPLE

Cause: This message is output, if the swivel unit is to be swivelled in or out, but this is impossible, since the backgauge is positioned too far advanced.

Remedy:
- Move backgauge behind the cutting line.
- Then, swivel out the swivel unit.

Memos:

Error No.: 1760

Error Text: PILE MISSING IN DELOADED LAB.

State: HINT **addition:** PURPLE

Cause: This message is output, if a line of small piles has been deloaded, but the light barrier for detecting the length of the pile line has discovered that the line does not contain the designated number of piles.

Remedy:
- Remove incomplete line of piles and continue the process.
- Verify correct setting of light barrier.
- Make sure that the sensors in question are working perfectly (soiling).
- Check I/O 1- board and corresponding wiring and replace, if necessary.

Memos:

Error No.: 1763

Error Text: DPR LINK: END OF BUSY TIMEOUT

State: HINT **addition:** PURPLE

Cause: This message is output, if a certain problem has presented itself in the communication (link) via Dual Port RAM between control computer and Polar Control Management Computer. The signal "busy" is still indicated after the max. waiting time has elapsed, i.e. too long.

Remedy:
- Check PAL on CPxx- board. (45.3must be present instead of 45.2).
- Switch machine off, and on again.
- Replace CPxx- board.

Memos: Concerns only machines with PCM module as of V4.1.0.
This may also occur on X / XT models.

Error No.: 1764

Error Text: CUT STOPS BACKGAUGE MOVEMENT !

State: ERROR **addition:** RED

Cause: This message is output, if the following system error is present: During a downward movement of the knife, the computer detects that the backgauge is still moving forward. This is a safety monitoring feature for the machine.

Remedy:
- if necessary, remove cutting material from the machine table.
- Terminate the interrupted cut.
- Continue the desired function.
- Replace CPxx- board or update the software .
- Replace the pulse generator.

Memos:

Error No.: 1765

Error Text: STANDARD FALSE CLAMP MOUNTED

State: HINT **addition:** YELLOW

Cause: This is indicated as an information, when the standard false clamp has been inserted into the clamp. The recognition is ensured by the micro switches installed in the clamp.

Remedy: - If the message has been output erroneously (i. e. no false clamp plate or a special one has been mounted), check micro switches, cabling and SAP- board.

Memos:

Error No.: 1766

Error Text: SPECIAL FALSE CLAMP 1 MOUNTED

State: HINT **addition:** YELLOW

Cause: This is indicated as an information, when the special false clamp-1 has been inserted into the clamp. The recognition is ensured by the micro switches installed in the clamp.

Remedy: - If the message has been output erroneously (no false clamp plate or another one has been mounted), check micro switches, cabling and SAP- board.

Memos:

Error No.: 1767

Error Text: SPECIAL FALSE CLAMP 2 MOUNTED

State: HINT **addition:** YELLOW

Cause: This is indicated as an information, when the special false clamp-2 has been inserted into the clamp. The recognition is ensured by the micro switches installed in the clamp.

Remedy: - If the message has been output erroneously (false clamp plate has not been removed), check micro switches, cabling and SAP- board.

Memos:

Error No.: 1768

Error Text: ILLEGAL FALSE CLAMP CODING

State: ERROR **addition:** RED

Cause: An inadmissible combination of the three micro switches installed in the clamp indicates that a false clamp is inserted, but cannot be properly identified.

Remedy: - Check micro switches, wiring and SAP- board.
- Check coding pin of the false clamp used.

Memos:

Error No.: 1769

Error Text: WRONG LIM.SW.POS.FOR FALSE CL

State: HINT **addition:** PURPLE

Cause: The backgauge has fallen below a table position which is smaller than the position assigned to the false clamp inserted. This position must be reasonable with respect to the position of the corresponding false clamp limit switch at the machine table. (approx. 1cmm away from false clamp plate).

Remedy:
- Check the assigned position in the menu and correct it, if necessary.
- Check corresponding table limit switch for correct position and functioning.
- Check wiring and SAP- board and replace, if necessary.

Memos:

Error No.: 1775

Error Text: FALSE CLAMP REMOVED

State: HINT **addition:** YELLOW

Cause: Is indicated as a hint, if the false clamp plate has been removed from the clamp. This detection is made by the microswitches located in the clamp.

Remedy:
- If the message has been output erroneously (false clamp plate has not been removed), check micro switches, cabling and SAP- board.

Memos:

Error No.: 1777

Error Text: CONTINUOUS OPERATION ACTIVE !

State: HINT **addition:** PURPLE

Cause: This message is only output on machines which are integrated in a production line. In this case, a higher-ranking control or a key-operated switch disconnects certain safety functions (e. g. automatic disconnection of automatic knife during return run of backgauge). This mode is carried out by switching an input on board SFM. Since this function is absolutely necessary for the operation of the entire system, the operator is given a corresponding hint.

Remedy:
- If this hint is output on a standard machine, check SFM- board and CU unit with ED machines.
- If this hint is output on a standard machine, check SAP-02 board and CU unit with XT machines.

Memos: On Pace system, this message is only meant as an information.

Error No.: 1778

Error Text: MULTIPLE REF.POSITION IMPULSE

State: ERROR **addition:** RED

Cause: In the range of the switching flag of reference switch B 341 (B341 high) the electrical reference point of the pulse transducer is registered several times. This is the case when the switching phase of B 341 is too long.

Remedy:
- Make a reference run and move the backgauge along the entire width of the table, if the position of the mechanical reference point switch has been modified
- Erroneous or badly adjusted switching flag of reference point sensor
- B 341 is defective (mechanical reference position switch)
- Check the proper mechanical connection between spindle and front extension part.
- Start a reference run to update the reference value.

Memos:

Error No.: 1779

Error Text: MECH.REF.POSITION ERROR !

State: ERROR **addition:** RED

Cause: The message is output, if CPxx- board detects the reference position signal of the mechanical switch in a table position which is beyond the range determined in the reference run.

Remedy:
- Make a reference run and move the backgauge along the entire width of the table, if the position of the mechanical reference point switch has been modified
- Erroneous or badly adjusted switching flag of reference point sensor
- B 341 is defective (mechanical reference point switch)
- Check the proper mechanical connection between spindle and front extension part.
- Start a reference run of the backgauge to update the reference value.

Memos:

Error No.: 1816

Error Text: AUTOCUT-25 IO-BOARD-2 MISSING

State: ERROR **addition:** RED

Cause: The I/O 2- board required in Autocut-25 is not recognized by the CPxx- board.

Remedy:
- Install IO 2- board.
- Verify +12 V main power supply.
- Check plug-in connection between I/O-5 of motherboard and the expansion units.
- Replace I/O 2- board.
- Install CPxx- board with software, suitable for the machine type.
- Replace CPxx- board.
- Replace I/O 5- board resp. Expansion unit-II (ERW-II).

Memos:

Error No.: 1817

Error Text: LIM.SW. ERROR SEPARATOR BAR !

State: ERROR **addition:** RED

Cause: The CPxx computer identifies both limit positions of the separation bar at the same time.

Remedy:
- Check limit switches B15/B16 (separation bar top/bottom), and adjust or replace them, if necessary.
- Check cabling of limit switches B15/B16.
- Check / replace I/O- board.

Memos:

Error No.: 1818

Error Text: LIM.SW.ERROR BACKGAUGE LIFT !

State: ERROR **addition:** RED

Cause: The CPxx computer identifies both limit positions of the backgauge (top/bottom) at the same time.

Remedy:
- Check limit switches B24 (teeth up) and B25 (teeth down) and adjust or replace them, if necessary.
- Check cabling of limit switches B24/B25.
- Check / replace I/O 2- board.

Memos:

Error No.: 1831

Error Text: AUTOCUT-25 REFUSES #1 !

State: ERROR **addition:** RED

Cause: This message describes a software error in the swivel unit area of Autocut-25. The indicated values #1 to #14 or #?? include more detailed information for the software development at POLAR.

Remedy: - Update the machine software to ED V-5.2.0 or a more recent version.

Memos:

Error No.: 1832

Error Text: AUTOCUT-25 REFUSES #2 !

State: ERROR **addition:** RED

Cause: This message describes a software error in the swivel unit area of Autocut-25. The indicated values #1 to #14 or #?? include more detailed information for the software development at POLAR.

Remedy: - Update the machine software to ED V-5.2.0 or a more recent version.
- For XT updated to version V- 1.6.0-28 later than 5 Oct. 2009.

Memos: When the last pack of a strip is loaded on the swivel unit, and the operator presses the cut button again, the swivel unit will be stopped. If the next initial cut is an edge trim, the feeder of the die-cutter will start automatically.

Error No.: 1833

Error Text: AUTOCUT-25 REFUSES #3 !

State: ERROR **addition:** RED

Cause: This message describes a software error in the swivel unit area of Autocut-25. The indicated values #1 to #14 or #?? include more detailed information for the software development at POLAR.

Remedy: - Update the machine software to ED V-5.2.0 or a more recent version.

Memos:

Error No.: 1834

Error Text: AUTOCUT-25 REFUSES #4 !

State: ERROR **addition:** RED

Cause: This message describes a software error in the swivel unit area of Autocut-25. The indicated values #1 to #14 or #?? include more detailed information for the software development at POLAR.

Remedy: - Update the machine software to ED V-5.2.0 or a more recent version.

Memos:

Error No.: 1835

Error Text: AUTOCUT-25 REFUSES #5 !

State: ERROR **addition:** RED

Cause: This message describes a software error in the swivel unit area of Autocut-25. The indicated values #1 to #14 or #?? include more detailed information for the software development at POLAR.

Remedy: - Update the machine software to ED V-5.2.0 or a more recent version.

Memos:

Error No.: 1836

Error Text: AUTOCUT-25 REFUSES #6 !

State: ERROR **addition:** RED

Cause: This message describes a software error in the swivel unit area of Autocut-25. The indicated values #1 to #14 or #?? include more detailed information for the software development at POLAR.

Remedy: - Update the machine software to ED V-5.2.0 or a more recent version.

Memos:

Error No.: 1837

Error Text: AUTOCUT-25 REFUSES #7 !

State: ERROR **addition:** RED

Cause: This message describes a software error in the swivel unit area of Autocut-25. The indicated values #1 to #14 or #?? include more detailed information for the software development at POLAR.

Remedy: - Update the machine software to ED V-5.2.0 or a more recent version.

Memos:

Error No.: 1838

Error Text: AUTOCUT-25 REFUSES #8 !

State: ERROR **addition:** RED

Cause: This message describes a software error in the swivel unit area of Autocut-25. The indicated values #1 to #14 or #?? include more detailed information for the software development at POLAR.

Remedy: - Update the machine software to ED V-5.2.0 or a more recent version.

Memos:

Error No.: 1839

Error Text: AUTOCUT-25 REFUSES #9 !

State: ERROR **addition:** RED

Cause: This message describes a software error in the swivel unit area of Autocut-25. The indicated values #1 to #14 or #?? include more detailed information for the software development at POLAR.

Remedy: - Update the machine software to ED V-5.2.0 or a more recent version.

Memos:

Error No.: 1840

Error Text: AUTOCUT-25 REFUSES #10 !

State: ERROR **addition:** RED

Cause: This message describes a software error in the swivel unit area of Autocut-25. The indicated values #1 to #14 or #?? include more detailed information for the software development at POLAR.

Remedy: - Update the machine software to ED V-5.2.0 or a more recent version.

Memos:

Error No.: 1841

Error Text: AUTOCUT-25 REFUSES #11 !

State: ERROR **addition:** RED

Cause: This message describes a software error in the swivel unit area of Autocut-25. The indicated values #1 to #14 or #?? include more detailed information for the software development at POLAR.

Remedy: - Update the machine software to ED V-5.2.0 or a more recent version.

Memos:

Error No.: 1842

Error Text: AUTOCUT-25 REFUSES #12 !

State: ERROR **addition:** RED

Cause: This message describes a software error in the swivel unit area of Autocut-25. The indicated values #1 to #14 or #?? include more detailed information for the software development at POLAR.

Remedy: - Update the machine software to ED V-5.2.0 or a more recent version.

Memos:

Error No.: 1843

Error Text: AUTOCUT-25 REFUSES #13 !

State: ERROR **addition:** RED

Cause: This message describes a software error in the swivel unit area of Autocut-25. The indicated values #1 to #14 or #?? include more detailed information for the software development at POLAR.

Remedy: - Update the machine software to ED V-5.2.0 or a more recent version.

Memos:

Error No.: 1844

Error Text: AUTOCUT-25 REFUSES #14 !

State: ERROR **addition:** RED

Cause: This message describes a software error in the swivel unit area of Autocut-25. The indicated values #1 to #14 or #?? include more detailed information for the software development at POLAR.

Remedy: - Update the machine software to ED V-5.2.0 or a more recent version.

Memos:

Error No.: 1845

Error Text: AUTOCUT-25 REFUSES #?? !

State: ERROR **addition:** RED

Cause: This message describes a software error in the swivel unit area of Autocut-25. The indicated values #1 to #14 or #?? include more detailed information for the software development at POLAR.

Remedy: - Update the machine software to ED V-5.2.0 or a more recent version.

Memos:

Error No.: 1846

Error Text: RIGHT GAP COVER NOT BACK

State: ERROR **addition:** RED

Cause: The gap cover of the waste aligner has not moved back to its resting position. But this is the precondition for closing the Autotrim table.

Remedy:
- Eliminate any waste paper or dirt accumulated in the gap cover area.
- Ensure a smooth mechanical operation of the gap cover.
- Check and adjust the B15 reed contact "gap cover, right", or replace it, if necessary.
- Check the cabling of reed contact B15.
- Check / replace I/O 2- board.

Memos:

Error No.: 1847

Error Text: LEFT GAP COVER NOT BACK

State: ERROR **addition:** RED

Cause: The gap cover of the waste aligner has not moved back to its resting position.
But this is the precondition for closing the Autotrim table.

Remedy:
- Eliminate any waste paper or dirt accumulated in the gap cover area.
- Ensure a smooth mechanical operation of the gap cover.
- Check and adjust the B16 reed contact "gap cover, left", or replace it, if necessary.
- Check the cabling of reed contact B16.
- Check / replace I/O 2- board.

Memos:

Error No.: 1848

Error Text: BOTH GAP COVERS NOT BACK

State: ERROR **addition:** RED

Cause: The gap cover of the waste aligner has not moved back to its resting position
But this is the precondition for closing the Autotrim table.

Remedy:
- Eliminate any waste paper or dirt accumulated in the gap cover area.
- Ensure a smooth mechanical operation of the gap cover.
- Check and adjust the B16 /B15 reed contacts "gap cover, left and right", or replace them, if necessary.
- Check cabling of reed contacts B16/B15.
- Check / replace I/O 2- board.

Memos:

Error No.: 1870

Error Text: STOP! SUFFICIENT LUBRICATION!

State: ERROR **addition:** RED

Cause: After the lubrication, a limit switch at the central lubrication system indicates that sufficient lubricant has been filled.

Remedy:
- Make sure to use the lubricant specified in the operating instructions.
- Set the "central lubrication" switch S461 correctly and verify the cabling.
- Check operation of progressive dispatcher.
- Check / replace I/O 2- board.

Memos: Attention: Message is normal when lubricating the machine!

Error No.: 1871

Error Text: KNIFE CLAMP NOT RELEASED !

State: ERROR **addition:** RED

Cause: Someone tried to trigger a cut despite the activated clamping of the knife bar or someone activated the clamping mechanism during a cut.

Remedy:
- Inspect the Y7 solenoid valve.
- Check cabling and power supply to the valve (V36 / I/O-1).
- Check / replace I/O- board.

Memos:

Error No.: 1872

Error Text: FINGER W.POT.VALUE TOO SMALL!

State: ERROR **addition:** RED

Cause: The system falls below the admissible tolerance of the minimum analog value of the potentiometer for finger adjustment.

Remedy:
- Verify the setting of the "R2" potentiometer.
- Check / replace proximity switch "B438" (finger adjustment, minimum), and make a reference run.
- Check the cabling of the R2 potentiometer with resistor R1 (1500 ohms).
- Replace the I/O 1- board and carry out a reference run of the finger width adjustment.
- Check the cabling of switch B438.

Memos:

Error No.: 1873

Error Text: FINGER W.POT.VALUE TOO LARGE!

State: ERROR **addition:** RED

Cause: The system falls below the admissible tolerance of the maximum analog value of the potentiometer for the finger adjustment.

Remedy:
- Verify the setting of the "R2" potentiometer.
- Check / replace proximity switch "B437" (finger adjustment, minimum), and make a reference run.
- Check the cabling of the R2 potentiometer with resistor R1 (1500 ohms).
- Replace the I/O 1- board and carry out a reference run of the finger width adjustment.
- Check the cabling of switch B437.

Memos:

Error No.: 1922

Error Text: WASTE ALIGN.NOT AT FRONT POS.

State: ERROR **addition:** RED

Cause: The waste aligner has not left its resting position (at the rear). For the programmed "align waste cut" function, before aligning the strips the waste aligner must move the waste aligner upward and then carry out an advance movement.

Remedy:
- Eliminate any waste paper or dirt accumulated in the waste aligner area.
- Ensure a smooth mechanical operation of the waste aligner.
- Increase the pressure setting of the contacting pressure.
- Check the waste aligner limit position, front.
- Check / replace proximity switch B17.
- Check the cabling of switch B17.
- Check / replace I/O 2- board.

Memos:

Error No.: 1923

Error Text: WASTE ALIGNER NOT AT BACK POS

State: ERROR **addition:** RED

Cause: The waste aligner has not reached its resting position (at the rear). For the programmed "align waste cut" function, the waste aligner must be moved to its "rear" end position after it has been aligned and before it is lowered.

Remedy:
- Eliminate any waste paper or dirt accumulated in the waste aligner area.
- Ensure a smooth mechanical operation of the waste aligner.
- Check / replace proximity switch B17.
- Check the cabling of switch B17.
- Check / replace I/O 2- board.

Memos:

Error No.: 1928

Error Text: MISSING ADD.I/O-BOARD !

State: ERROR **addition:** RED

Cause: The IO board which is additionally required in this customized installation is not recognized by the CPxx computer.

Remedy:
- Install the I/O- board suitable for the customized version.
- Verify +12 V main power supply.
- if the error is also present with the I/O- board installed, replace the board.
- Install / replace the CPxx- board with a software suitable for the machine type.
- With ED machine replace I/O-5- board.
- With XT machine replace ERW-II board.

Memos:

Error No.: 1950

Error Text: LIM.SW.ERR.LAT.ALIGNER FRAME!

State: ERROR **addition:** RED

Cause: The lateral aligning gauge at the machine frame is not in a defined limit position. The micro switches S343 and S344 are not recognized.

Remedy:
- Make sure that there is no material under the lateral aligning gauge.
- Check the micro switches S343 and S344 and their resp. cabling
- Verify the motor control of M346
- Inspect the sliding clutch at the M346 motor
- With ED machines check the DNF plug-in board and replace it, if necessary
- Verify the operating pressure of the pneumatic system.

Memos:

Error No.: 1951

Error Text: LAT.ALIG.FRAME CYL.STILL BACK

State: ERROR **addition:** RED

Cause: After the computer has requested "align before cutting", the B34 limit switch has not been released.

Remedy:
- Check the position of the aligning gauge.
- Verify the pneumatic contacting pressure.
- Check the manual functioning of the aligning gauge by pressing the buttons.
- Ensure a smooth mechanical operation of the aligning gauge.
- Check the control of solenoid valve Y416.
- Check the B34 switch and its cabling.
- Check / replace I/O- board.
- Verify the operating pressure of the pneumatic system.

Memos:

Error No.: 1952

Error Text: LAT.ALIGN. FRAME CYL.NOT BACK

State: ERROR **addition:** RED

Cause: After the function "align before cutting" has been performed, the aligning gauge is not backwards to its home position.

Remedy:
- Check the manual functioning of the aligning gauge by pressing the buttons.
- Ensure a smooth mechanical operation of the aligning gauge.
- Check the disconnection of solenoid valve Y416.
- Check the B34 switch and its cabling.
- Check / replace I/O- board.
- Verify the operating pressure of the pneumatic system.

Memos:

Error No.: 1953

Error Text: LIM.SW.ERR.LAT.ALIGN.BACKG. !

State: ERROR **addition:** RED

Cause: The lateral aligning gauge at the backgauge is not in a defined limit position.
The micro switches S341 and S342 are not recognized.

Remedy:
- Make sure that there is no material under the lateral aligning gauge.
- Check the micro switches S341 and S342 and their resp. cabling
- Verify the motor control of M345.
- Inspect the sliding clutch at the M345 motor
- Check / replace DNF- board.
- Verify the operating pressure of the pneumatic system.

Memos:

Error No.: 1954

Error Text: LAT.ALIG.BACKG.CYL.STILL BACK

State: ERROR **addition:** RED

Cause: After the computer requested "align before cutting", the B35 limit switch has not been released.

Remedy:
- Check the manual functioning of the aligning gauge by pressing the buttons.
- Ensure a smooth mechanical operation of the aligning gauge.
- Check the disconnection of solenoid valve Y415.
- Check the B35 switch and its cabling.
- Check / replace I/O- board.
- Verify the operating pressure of the pneumatic system.

Memos:

Error No.: 1955

Error Text: LAT.ALIGN.BACKG.CYL. NOT BACK

State: ERROR **addition:** RED

Cause: After the function "align before cutting" had been performed, the aligning gauge was not moved backwards to its home position.

Remedy:
- Check the manual functioning of the aligning gauge by pressing the buttons.
- Ensure a smooth mechanical operation of the aligning gauge.
- Check the disconnection of solenoid valve Y415.
- Check the B35 switch and its cabling.
- Check / replace I/O- board.
- Move the backgauge backwards manually.
- Verify the operating pressure of the pneumatic system.

Memos:

Error No.: 2054

Error Text: CPU DIP SETTING IOP BOARD OK?

State: ERROR **addition:** RED

Cause: On CPxx- board certain options have been set by means of DIP switches, which require an IO-P1- board. But the computer does not recognize any such board.

Remedy:
- Correct the setting of the DIP switches. Install an I/O-P1- board

Memos:

Error No.: 2090

Error Text: AUTOTRIM ERROR SIGNAL !

State: ERROR **addition:** RED

Cause: There is no agreement between software and hardware regarding the status of the light barrier when the Autotrim table is being closed.

Remedy:
- Check the light barrier, light barrier cables and plugs.
- Check / replace I/O-P- board.

Memos:

Error No.: 2091

Error Text: AUTOTRIM OK SIGNAL MISSING !

State: ERROR **addition:** RED

Cause: When the software tries to close the Autotrim table the okay of the hardware has not been signaled within 10 ms. No agreement about status of light barrier, or Autotrim table is not "open" / "closed" limit position (only with automatic operation).

Remedy:
- as above, check the limit switches, limit switch cables and plugs.
- on XT generation: update the software to V1.1.1 or a more recent version.
- Check / replace I/O-P- board.
- Check clutch of Autotrim motor.

Memos:

Error No.: 2100

Error Text: SWIVEL GAUGE ADJUST. MISSING

State: ERROR **addition:** RED

Cause: CPxx- board has no values stored regarding the swivel backgauge positions.

Remedy: Carry out a reference run. After that, a reference run of the swivel backgauge is automatically made to determine the respective parameters. Of course, the correct values can only be determined, if the mechanical system of the swivel backgauge has been properly adjusted.
- Replace CPxx- board.

Memos: After replacement of CPxx: Verify setting of dip switches. Carry out a reference run of swivel/ tilting backgauge.

Error No.: 2101

Error Text: SWIVEL G.ANALOG.MAX.TOO LARGE

State: ERROR **addition:** RED

Cause: The power supplied by the potentiometer with maximum displacement to the left (limit switch) is higher than 23.0 volts. (nominal value = 23.0 volts)

Remedy:
- Verify and correct, if necessary, the maximum displacement and the limit switch position.
- Position the potentiometer in the center.

Memos:

Error No.: 2102

Error Text: SWIVEL G.ANALOG.MIN.TOO SMALL

State: ERROR **addition:** RED

Cause: The power supplied by the potentiometer with maximum displacement to the right (limit switch) is lower than 1.0 volt. (nominal value = 1.0 volt)

Remedy:
- Verify and correct, if necessary, the maximum displacement and limit switch position.
- Position the potentiometer in the center.
- Carry out a reference run of swivel / tilting backgauge.

Memos:

Error No.: 2103

Error Text: SWIV.G.ANALOG.RANGE TOO SMALL

State: ERROR **addition:** RED

Cause: The potential difference supplied by the potentiometer between the two limit switch positions is too small (< 3.3V).

Remedy:
- Verify / readjust limit switch positions. Check, replace potentiometer.
- Carry out a reference run of swivel / tilting backgauge.

Memos:

Error No.: 2104

Error Text: CHECK SWIVEL G.POS./ADJUST. !

State: ERROR **addition:** RED

Cause: The actual position of the swivel backgauge does not match the stored position.

Remedy: Carry out a reference run. After that, a reference run of the swivel backgauge is automatically made, too, to determine the respective parameters. Of course, the correct values can only be determined, if the mechanical system of the swivel backgauge has been correctly adjusted.
If the potentiometers are stored in the Menue "Swivel backgauge setting", than this value will be taken over automatically as 0 Position of the swivel backgauge.

Memos:

Error No.: 2105

Error Text: SWIVEL GAUGE ANALOGUE 0 WRONG

State: ERROR **addition:** RED

Cause: The voltage value for the 0 position supplied by the potentiometer is beyond the admissible range of +12.0 volts ±0.5.

Remedy: - Position the potentiometer in the center

Memos:

Error No.: 2106

Error Text: SWIVEL GAUGE WRONG DIRECTION!

State: ERROR **addition:** RED

Cause: Wrong direction of rotation of motor, potentiometer has been set the wrong way.

Remedy:
- Correct the direction of rotation of the motor, check the cables and plugs, correct, if necessary.
- Install the potentiometer correctly.
- Install potentiometer correctly, or connect properly (observe pin assignment of plugs)

Memos:

Error No.: 2107

Error Text: SWIVEL G. LIMIT SWITCH ERROR!

State: ERROR **addition:** RED

Cause: Both limit switches are active at the same time. With a displacement to the left, the right-hand limit switch will be actuated.

Remedy:
- Check limit switch and cable.

Memos:

Error No.: 2108

Error Text: TILTING GAUGE ADJUST. MISSING

State: ERROR **addition:** RED

Cause: CPxx- board has no values stored regarding the tilting backgauge positions.

Remedy: Carry out a reference run. After that, a reference run of the tilting backgauge is automatically made, too, to determine the respective parameters. Of course, the correct values can only be determined, if the mechanical system of the tilting backgauge has been correctly adjusted.
- Software Update with XT-machines to Version V1.2.5 or higher.

Memos:

Error No.: 2109

Error Text: TILT.G.ANALOGUE MAX.TOO LARGE

State: ERROR **addition:** RED

Cause: The power supplied by the potentiometer with maximum displacement to the rear (limit switch) is higher than 23.0 volts. (nominal value = 23.0 volts)

Remedy:
- Verify and correct, if necessary, the maximum displacement and the limit switch position.
- Position the potentiometer in the center.

Memos:

Error No.: 2110

Error Text: TILT.G.ANALOGUE MIN.TOO SMALL

State: ERROR **addition:** RED

Cause: The power supplied by the potentiometer with maximum displacement to the front (limit switch) is lower than 1.0 volt. (nominal value = 1.0 volt)

Remedy:
- Verify and correct, if necessary, the maximum displacement and the limit switch position.
- Position the potentiometer in the center.

Memos:

Error No.: 2111

Error Text: TILT.G.ANALOG.RANGE TOO SMALL

State: ERROR **addition:** RED

Cause: The potential difference supplied by the potentiometer between the two limit switch positions is too small (< 3.3V).

Remedy: - Verify / readjust limit switch positions. Check / replace potentiometer.

Memos:

Error No.: 2112

Error Text: CHECK TILT.GAUGE POS./ADJUST.

State: ERROR **addition:** RED

Cause: The actual position of the tilting backgauge does not match the stored position.

Remedy: Carry out a reference run. After that, a reference run of the tilting backgauge is automatically made, too, to determine the respective parameters.
Of course, the correct values can only be determined, if the mechanical system of the tilting backgauge has been properly adjusted.
If the potentiometers are stored in the Menue "Tilting backgauge setting", than this value will be taken over automatically as 0 Position of the tilting backgauge.

Memos:

Error No.: 2113

Error Text: TILT.GAUGE ANALOGUE 0 WRONG !

State: ERROR **addition:** RED

Cause: The voltage value for the 0 position, supplied by the potentiometer is beyond the admissible range of +7.7 volts ±0.5.

Remedy: - Set the potentiometer according to the voltage value (turn).

Memos:

Error No.: 2114

Error Text: TILTING GAUGE WRONG DIRECTION

State: ERROR **addition:** RED

Cause: Wrong direction of rotation of motor, potentiometer has been set the wrong way.

Remedy:
- Correct the direction of rotation of the motor, check the cables and plugs, correct, if necessary.
- Install the potentiometer correctly.
- install potentiometer correctly, or connect properly (observe pin assignment of plugs).

Memos:

Error No.: 2115

Error Text: TILT.GAUGE LIMIT SWITCH ERROR

State: ERROR **addition:** RED

Cause: Both limit switches are active at the same time. With a displacement to the rear, downward, the upper limit switch will be actuated.

Remedy:
- Check limit switch and cable.

Memos:

Error No.: 2130

Error Text: SWIVEL GAUGE AUX. OPERATION !

State: HINT **addition:** PURPLE

Cause: No reference run has been performed and successfully terminated.

Remedy: - Make a new reference run in case of abortion with error message, then proceed correspondingly.

Memos:

Error No.: 2131

Error Text: TILTING GAUGE AUX.OPERATION !

State: HINT **addition:** PURPLE

Cause: No reference run was performed and successfully terminated.

Remedy: - Make a new reference run. In case of an abortion with error message, proceed according to error message.

Memos:

Error No.: 2135

Error Text: EXT.PHERIPH. NOT IN HOME POS.

State: HINT **addition:** PURPLE

Cause: This concerns only those peripheral units whose control systems are connected with the cutting machine (e. g. loading units, gripper system, turning gripper etc.) Use circuit diagrams to check which external peripheral unit reports no resting or limit positions via the relevant interface to the cutting machine control system.

Remedy:
- Switch on control system of external peripheral equipment
- Get peripheral unit to resting position
- Inspect interface and cabling

Memos:

Error No.: 2143

Error Text: READ ERROR INTERN.PROG.MEMORY

State: ERROR **addition:** RED

Cause: When reading the cutting program from the internal program memory (i. e. program memory of cutting machine) a reading error has occurred.

Remedy:
- Select requested cutting program again
- If error occurs permanently, re-develop the program or transfer again from Compucut.
- Select another program number

Memos:

Error No.: 2159

Error Text: CONFIGURE AT-M/AUTOCUT-115 !

State: ERROR **addition:** RED

Cause: The computer on the CPxx- board has detected that the parameters for the special functions of the Autotrim-M or Autocut-115 machine have been destroyed in the memory.

Remedy:
- Re-configure AT-M or AC115 in the Service menu
- Examine battery on CPxx- board and replace, if necessary
- Replace CPxx- board

Memos:

Error No.: 2188

Error Text: PROGRAM BLOCK TOO LARGE

State: HINT **addition:** PURPLE

Cause: When converting Eltrotact block into individual cutting program steps with absolute dimensions the number of cutting steps exceeds the available memory space.

Remedy:
- Delete existing programs to de-allocate storage space
- Use another program memory (A / B)

Memos:

Error No.: 2189

Error Text: COPY STEPS (MAXIMUM = 100)

State: HINT **addition:** PURPLE

Cause: The operator has tried to copy more than 100 steps of a cutting program. The maximum is 100.

Remedy: - Please observe maximum number of steps to be copied.

Memos:

Error No.: 2196

Error Text: PLEASE CALIBRATE TOUCH !

State: HINT **addition:** PURPLE

Cause: The touch screen calibration is lost. The user is asked to calibrate the touch screen.

Remedy:
- Calibrate touch screen
- Replace the complete control panel unit.
- Press Reset key on CPxx- board (if available) or re-start the machine.
- Check the battery on CPxx- board and replace it, if necessary.

Memos:

Error No.: 2201

Error Text: ERROR IN P-NET COMMUNICATION

State: ERROR **addition:** RED

Cause: Composite error "communication with ESPV". When service switch is set, further error numbers regarding this subject will be activated.

Remedy:
- Check P-Net connections
- Is the P-Net Server activated?
- Has the Apache web server been started?

Memos:

Error No.: 2348

Error Text: ERR.ENDPOS.50MM STROKE LAT. AL

State: HINT **addition:** PURPLE

Cause: After activation, the end position has not been reached in the required time period of 1.5 seconds.

Remedy:
- Safeguard smooth mechanical operation.
- Is the pneumatic system working perfectly?
- Check limit switches / cabling.
- Check / replace I/O 2- board.

Memos:

Error No.: 2349

Error Text: LAT.ALIGN.GAUGE IO2-SETTING ?

State: ERROR **addition:** RED

Cause: The new aligning gauge for a strip width of 105 cm is installed, but has not been recognized by computer CPxx- board.

Remedy: - Required jumper of +24 Volt to I/O 2- board contact B19 is missing.

Memos:

Error No.: 2366

Error Text: RAKE MOVED, SEGMENTS CHANGED!

State: ERROR **addition:** RED

Cause: During a backgauge movement the limit position of at least one rake segment was changed (tilted up or down). On Autocut 25 the "tilted down" and "tilted up" positions of the rake segments are monitored by proximity switches during the backgauge movement.

Remedy:
- Verify and correct positions of individual rake segments, if necessary
- Check proximity switches and cables of rake segments
- Check / replace relevant I/O- board.

Memos:

Error No.: 2367

Error Text: ERROR OF SWIFEL UNIT DRIVE !

State: ERROR **addition:** RED

Cause: A malfunction or error message from the servo controller causes this error text to be issued. It is frequently generated by an overcurrent in the servo controller.

Remedy:
- Ensure a smooth mechanical operation of the waste aligner.
- Check and/or replace servo controller.

Memos:

Error No.: 2368

Error Text: MACHINE IS SHUTTING DOWN !

State: HINT **addition:** PURPLE

Cause: The machine has already been shut down. While this message is issued, the P-Net server is shut down.

Remedy:
- Turn-on machine again in order to re-start the server.

Memos:

Error No.: 2369

Error Text: LIMIT SWITCH ERROR TABLE B/F

State: ERROR **addition:** RED

Cause: Computer detects backgauge positions "front" and "rear" simultaneously.

Remedy:
- Check the affected limit switches, their cabling and relevant input boards.
- Check switch on tiltable rear table guard.
- On machines with manual rear loading: check light barrier.

Memos:

Error No.: 2392

Error Text: AUTHORIZATION CODE REJECTED

State: ERROR **addition:** RED

Cause: Several times an inadmissible authorization code was input. An authorization code consists of letters and numbers and must be input in order to use certain P-Net services in the cutting machine.

Remedy:
- Re-start machine, verify if authorization code is correct and input again
- Request new authorization code from POLAR, indicating the MAC address on the DBR- board

Memos:

Error No.: 2393

Error Text: INCOMPATIB.AUTHORIZATION CODE

State: ERROR **addition:** RED

Cause: The authorization code that was input is not compatible with the machine software. An authorization code consists of letters and numbers and must be input in order to use certain P-Net services in the cutting machine.

Remedy:
- The authorization code is incompatible with the existing machine software
- Replace the DBR- board

Memos:

Error No.: 2394

Error Text: WRONG AUTHORIZATION CODE

State: ERROR **addition:** RED

Cause: The authorization code that was input is compatible with the machine software but was recognized as wrong (invalid). An authorization code consists of letters and numbers and must be input in order to use certain P-Net services in the cutting machine

Remedy:
- The authorization code input is incompatible with the MAC address
- Request authorization code again from POLAR, indicating the MAC address

Memos:

Error No.: 2400

Error Text: DIRECTORY INQUIRY FAILED

State: ERROR **addition:** RED

Cause: The cutting machine has demanded from P-Net memory management a list of the cutting programs stored in a memory area, but the list could not be transferred correctly.

Remedy:
- Select memory area of segments C to Z again
- Verify network connection to P-Net Server
- Check ESPV on P-Net Server

Memos:

Error No.: 2412

Error Text: A SOFTWARE ERROR OCCURRED

State: ERROR **addition:** RED

Cause: The program transfer between the cutting machine and another device was aborted because of a software error.

Remedy:
- Turn the machine(s) off, then switch on again

Memos:

Error No.: 2466

Error Text: UNEXPECTED MESSAGE RECEIVED

State: ERROR **addition:** RED

Cause: The cutting machine has received a message from P-Net which was not expected at that time.

Remedy:
- Turn the cutting machine off, then switch on again
- Re-boot the P-Net Server

Memos:

Error No.: 2473

Error Text: CLAMP AT THE KNIFE IS NOT UP

State: HINT **addition:** PURPLE

Cause: The hold-down clamp is not in resting position. Proximity switch B406 is not recognized.

Remedy:
- Check the B406 switch and connecting cable.
- Check / replace I/O P2- board.
- Verify smooth mechanical operation and pneumatic system.

Memos:

Error No.: 2487

Error Text: COMMUNICATION WITH BECK PC NOT READY

State: ERROR **addition:** RED

Cause: The cutting machine tries to communicate with the P-Net Server, but the Beck-PC on the DBR board, which is responsible for the communication, does not respond.

Remedy:
- Check / replace DBR- board
- Check / replace CU- unit

Memos:

Error No.: 2490

Error Text: P-NET SERVER IS NOT AVAILABLE

State: ERROR **addition:** RED

Cause: The cutting machine tries to communicate with the P-Net Server, but P-Net Server is currently not available.

Remedy:
- Verify TCP / IP configuration
- Switch on P-Net Server and start application
- Check the network system that is used

Memos:

Error No.: 2496

Error Text: SERVICE IS NOT AUTHORIZED

State: HINT **addition:** PURPLE

Cause: The operator tries to activate a service which is not authorized.
A service is authorized when the customer has bought the service as an optional feature of the cutting machine and the relevant authorization code has been input. Otherwise the service is not authorized and cannot be activated or used in the machine.

Remedy: - Authorize the requested service before the application

Memos:

Error No.: 2539

Error Text: LT-S NOT READY !

State: HINT **addition:** PURPLE

Cause: This note is displayed when the pusher of the LT-S unit cannot push strips into the Autocut. This information is only output in connection with ZFK.

Remedy: - Position strips again
- Turn-on LT-S and check control system

Memos:

Error No.: 2540

Error Text: LT-S RAKE SEGMENTS NOT OK !

State: HINT **addition:** PURPLE

Cause: The number and position of rake segments placed by Autocut is not acknowledged by LT-S in the same manner. This information is only output in connection with ZFK.

Remedy: - Check position signals of rake segments

Memos:

Error No.: 2545

Error Text: DELOADING END,FINGER ON TABLE

State: HINT **addition:** PURPLE

Cause: During deloading process, when the "material in position" light barrier detects material and the deloading finger has not yet reached the end of the table, this note is output.

Remedy:
- Verify the max. strip length possible.
- Examine light barrier, re-adjust or replace it, if necessary
- Check cable connection and I/O for light barrier.
- Check sensor, cable or I/O for end of table.

Memos:

Error No.: 2546

Error Text: SUCTIONTABLE NOT AT TRANSOMAT

State: HINT **addition:** PURPLE

Cause: This message is output, when the pusher intends to pass over the gap between Transomat pallet and aligning table, but the table is not at the Transomat pallet.

Remedy:
- Check reed contacts at pneumatic cylinder, cabling and I/O.
- Check electrical and pneumatic energizing of pneumatic cylinder.
- Check cabling and I/O of electrical energizing.
- Move the Transomat to the correct loading position.

Memos:

Error No.: 2547

Error Text: SUCTION TABLE NOT AT AT-TABLE

State: HINT **addition:** PURPLE

Cause: This message is output, when the pusher intends to pass over the gap between AT table and aligning table, but the table is not at the AT.

Remedy:
- Check reed contacts at pneumatic cylinder, cabling and I/O- board.
- Check electrical and pneumatic energizing of pneumatic cylinder.
- Check cabling and I/O of electrical energizing.

Memos:

Error No.: 2548

Error Text: SUCTION TABLE ERROR ENDPOS

State: ERROR **addition:** RED

Cause: Both end positions are signaled at the same time.

Remedy: - Check reed contacts, cabling and I/O.

Memos:

Error No.: 2549

Error Text: TIMEOUT DEL.FINGER CLAMP UP !

State: ERROR **addition:** RED

Cause: The deloading finger clamp has not moved to its upper limit position within the preset time.

Remedy:
- Verify smooth mechanical operation.
- Check correct function of pneumatic control system.
- Check reed contact, cabling and I/O.

Memos:

Error No.: 2550

Error Text: PUSHER POSITION IS NOT KNOWN!

State: ERROR **addition:** RED

Cause: The pusher position on the front table is unknown to the computer of CPxx- board.

Remedy: - Move pusher manually over a position switch

Memos:

Error No.: 2551

Error Text: PUSHER END POSITION

State: HINT **addition:** PURPLE

Cause: Pusher has reached its end position.

Remedy: - Check position of pusher and relevant switches and cabling

Memos:

Error No.: 2552

Error Text: PUSHER STOP AT MATERIAL !

State: ERROR **addition:** RED

Cause: The pusher was stopped during return to prevent it from colliding with the material to be cut which is lying in its travel.

Remedy:
- Remove the material
- If the message has been output without any material lying in the travel, check switches and cabling.

Memos:

Error No.: 2553

Error Text: ALIGNING GAUGE IS NOT UP !

State: ERROR **addition:** RED

Cause: The aligning gauge is not up, although it should be. The aligning gauge is ad device which helps to align the material to be cut and ensures that sheets or labels lie precisely one on top of the other.

Remedy:
- Check the relevant limit switch, cabling and I/O- board.
- Verify smooth mechanical operation of gauge.
- Check the corresponding pneumatic control and guide elements

Memos:

Error No.: 2554

Error Text: ALIGNING GAUGE IS NOT BACK !

State: ERROR **addition:** RED

Cause: The aligning gauge is not at the back, although it should be. The aligning gauge is ad device which helps to align the material to be cut so that sheets or labels lie precisely one on top of the other.

Remedy:
- Check the relevant limit switch, cabling and I/O- board.
- Verify smooth mechanical operation of gauge.
- Check the corresponding pneumatic control and guide elements

Memos:

Error No.: 2555

Error Text: MULTIPLE PUSHER LIMIT SWITCH!

State: ERROR **addition:** RED

Cause: Several pusher limit switches are activated at the same time. This is a malfunction, because the pusher can only be at one position of its travel

Remedy: - Check the affected limit switches, cabling and relevant I/O- board.

Memos:

Error No.: 2556

Error Text: ALIGN.GAUGE LIMIT SWITCH ERR.

State: ERROR **addition:** RED

Cause: The limit switches of both end positions of the aligning gauge are active at the same time.

Remedy: - Check the affected limit switches, cabling and relevant I/O- board.

Memos:

Error No.: 2557

Error Text: SUCTION BAR LIMIT SWITCH ERR.

State: ERROR **addition:** RED

Cause: The limit switches of both end positions of the suction bar are active at the same time.

Remedy: - Check the affected limit switches, cabling and relevant I/O- board.

Memos:

Error No.: 2558

Error Text: GAP FLAP LIMIT SWITCH ERROR !

State: ERROR **addition:** RED

Cause: The limit switches of both end positions of the gap flap are active at the same time.

Remedy: - Check the affected limit switches, cabling and relevant I/O- board.

Memos:

Error No.: 2559

Error Text: SUCTION BAR IS NOT DOWN !

State: ERROR **addition:** RED

Cause: The suction bar is not at the bottom limit position, although it should be there.
The suction bar is a longish device provided with holes for sucking the air. When the air is sucked through these holes, the sheet placed upon it is held by the suction bar.

Remedy:
- Inspect the "suction bar down" limit switch", the cabling and the corresponding I/O- board.
- Safeguard smooth mechanical operation.
- Check operation of pneumatic equipment.

Memos:

Error No.: 2560

Error Text: GAP FLAP IS NOT UP !

State: ERROR **addition:** RED

Cause: The gap flap is not at the top limit position, although it should be there. The gap flap is a flap which covers the suction bar gap and allows to push material to be cut over the gap.

Remedy:
- Inspect the "gap flap up" limit switch, the cabling and the corresponding I/O-board.
- Safeguard smooth mechanical operation.
- Check operation of pneumatic equipment.

Memos:

Error No.: 2561

Error Text: ALIGNER OF PUSHER IS NOT BACK

State: ERROR **addition:** RED

Cause: The aligner of the pusher is not at "rear" limit position, although it should be.

Remedy:
- Check the affected limit switch, the cabling and the I/O- board.
- Safeguard the smooth mechanical operation.
- Examine the relevant pneumatic components

Memos:

Error No.: 2562

Error Text: ENABLE FROM TRANSOMAT MISSING

State: ERROR **addition:** RED

Cause: The automatic operation of the cutting machine was aborted, because there was no enabling from the Transomat.

Remedy:
- Check control and supply voltage of Transomat unit.
- Does Transomat send enable signal?
- Is required home position for the further procedure correct ?

Memos:

Error No.: 2563

Error Text: PUSHER NOT AT HOME POSITION

State: ERROR **addition:** RED

Cause: The pusher is not at home position.

Remedy:
- Move pusher to the left-hand end position.
- Check position of limit switch: "pusher left-hand end position".
- Check the cabling and the affected I/O- board.

Memos:

Error No.: 2565

Error Text: WRONG SEQUENCE LIM.SW. PUSHER

State: ERROR **addition:** RED

Cause: When the pusher was moved over the front table the limit switches were not activated in the expected sequence.

Remedy:
- Verify performance of all the limit switches relevant for this function.
- Check correct cabling of limit switches.
- Check / replace I/O- board.

Memos:

Error No.: 2566

Error Text: ALIGNING GAUGE NOT DOWN

State: ERROR **addition:** RED

Cause: The aligning gauge is not at its bottom limit position.

Remedy:
- Check the relevant limit switch, cabling and I/O- board.
- Verify smooth mechanical operation of gauge.
- Check the corresponding pneumatic control and guide elements

Memos:

Error No.: 2567

Error Text: ALIGNING GAUGE NOT UP FRONT

State: ERROR **addition:** RED

Cause: The aligning gauge is not at its front limit position.

Remedy:
- Check the relevant limit switch, cabling and I/O- board.
- Verify smooth mechanical operation of gauge.
- Check the corresponding pneumatic control and guide elements

Memos:

Error No.: 2568

Error Text: WAITING FOR TRANSOMAT ENABLE

State: HINT **addition:** PURPLE

Cause: The automatic operation of the cutting machine was stopped, because system is waiting for the Transomat to be enabled.

Remedy:
- Transomat is still in sequence of functions and cannot enable the cutting machine.

Memos:

Error No.: 2569

Error Text: STOP BEHIND SUCTION POSITION!

State: ERROR **addition:** RED

Cause: The pusher has moved too far and has missed the position where the bottom sheet of a pile must be sucked.

Remedy:
- Check functioning and setting of relevant sensor.
- Check cabling and relevant I/O- board.
- Check setting of frequency converter for drive unit and re-adjust, if necessary.

Memos:

Error No.: 2570

Error Text: PUSHER LIMIT SWITCH LEFT STOP

State: HINT **addition:** PURPLE

Cause: Pusher has reached its end position on the left.

Remedy:
- This is a status message meant for the operator during the normal sequence of functions.

Memos:

Error No.: 2571

Error Text: PUSHER LIMIT SWITCH LEFT SLOW

State: HINT **addition:** PURPLE

Cause: The pusher has reached the "left slow" limit switch.

Remedy: - This is a status message meant for the operator during the normal sequence of functions.

Memos:

Error No.: 2572

Error Text: PUSHER LIM. SW. AT-TABLE SLOW

State: HINT **addition:** PURPLE

Cause: The pusher has reached the "AT table slow" limit switch.

Remedy: - This is a status message meant for the operator during the normal sequence of functions.

Memos:

Error No.: 2573

Error Text: PUSHER LIM.SW. AT-TABLE RIGHT

State: HINT **addition:** PURPLE

Cause: The pusher has reached the "AT table right" limit switch.

Remedy: - This is a status message meant for the operator during the normal sequence of functions.

Memos:

Error No.: 2574

Error Text: PUSHER LIM.SW. ALIGN POSITION

State: HINT **addition:** PURPLE

Cause: The pusher has reached the "align position" limit switch.

Remedy: - This is a status message meant for the operator during the normal sequence of functions.

Memos:

Error No.: 2575

Error Text: TABLE SENSOR SUCTION POS.SLOW

State: HINT **addition:** PURPLE

Cause: The pusher has reached the "suction position slow" table sensor. The travel speed is set to slow to ensure that the pusher can precisely go to the suction position.

Remedy: - This is a status message meant for the operator during the normal sequence of functions.

Memos:

Error No.: 2576

Error Text: TABLE SENSOR SUCTION POS.STOP

State: HINT **addition:** PURPLE

Cause: The pusher has reached the "suction position" table sensor and stops in order to suck the bottom sheets.

Remedy: - This is a status message meant for the operator during the normal sequence of functions.

Memos:

Error No.: 2577

Error Text: PUSHER LIMIT SW. FORMAT SLOW

State: HINT **addition:** PURPLE

Cause: The pusher has reached the limit switch "slow" which depends on the material format and moves forward at low speed.

Remedy: - This is a status message meant for the operator during the normal sequence of functions.

Memos:

Error No.: 2578

Error Text: TRANSOMAT SENSOR FORMAT STOP

State: HINT **addition:** PURPLE

Cause: The pusher has reached the "stop" limit switch which depends on the material format (in the Transomat unit) (stack is set against the gauge of the Transomat pallet).

Remedy: - This is a status message meant for the operator during the normal sequence of functions.

Memos:

Error No.: 2579

Error Text: PUSHER LIM. SWITCH RIGHT SLOW

State: HINT **addition:** PURPLE

Cause: The pusher has reached the "end position right slow " limit switch.

Remedy: - This is a status message meant for the operator during the normal sequence of functions.

Memos:

Error No.: 2580

Error Text: PUSHER LIM. SWITCH RIGHT STOP

State: HINT **addition:** PURPLE

Cause: The pusher has reached the "end position - right" limit switch.

Remedy: - This is a status message meant for the operator during the normal sequence of functions.

Memos:

Error No.: 2581

Error Text: PUSH.LIM.SW.OUTSIDE TRANSOMAT

State: HINT **addition:** PURPLE

Cause: The pusher has reached the S??? limit switch in return stroke and consequently left the Transomat pallet (= enabling for Transomat).

Remedy: - This is a status message meant for the operator during the normal sequence of functions.

Memos:

Error No.: 2582

Error Text: PUSHER LIGHT BARR. NEAR PAPER

State: HINT **addition:** PURPLE

Cause: The light barrier installed in front of the pusher was interrupted, which means that there is paper positioned immediately in front of the pusher.

Remedy: - This is a status message meant for the operator during the normal sequence of functions.

Memos:

Error No.: 2584

Error Text: MATERIAL AT SUCTION GAP

State: HINT **addition:** PURPLE

Cause: The pusher has reached the position where the bottom sheets are sucked in.

Remedy: - This is a status message meant for the operator during the normal sequence of functions.

Memos:

Error No.: 2585

Error Text: MATERIAL ON TRANSOMAT

State: HINT **addition:** PURPLE

Cause: On the transfer side from cutting machine to Transomat, some material has been detected. In the usual function cycle this message is only displayed in the Transomat loading process.

Remedy: - Check sensor, cabling and relevant I/O- board and replace it if necessary

Memos:

Error No.: 2586

Error Text: GAP FLAP IS NOT DOWN !

State: ERROR **addition:** RED

Cause: The gap flap is not at its bottom limit position.

Remedy:
- Check the relevant limit switch, cabling and I/O- board.
- Verify smooth mechanical operation of gap flap.
- Check the corresponding pneumatic control and guide elements

Memos:

Error No.: 2587

Error Text: SUCTION BAR IS NOT UP !

State: ERROR **addition:** RED

Cause: The suction bar is not at its upper limit position.

Remedy:
- Check the relevant limit switch, cabling and I/O- board.
- Verify smooth mechanical operation of suction bar.
- Check the corresponding pneumatic control and guide elements

Memos:

Error No.: 2588

Error Text: ALIGNER OF PUSH. NOT UP FRONT

State: ERROR **addition:** RED

Cause: The aligner of the pusher is not at its "front" limit position.

Remedy:
- Check the relevant limit switch, cabling and I/O- board.
- Verify smooth mechanical operation of pusher aligner.
- Check the corresponding pneumatic control and guide elements

Memos:

Error No.: 2590

Error Text: SIZE OF CUT SHEET TOO LONG

State: ERROR **addition:** RED

Cause: The cut material has a size (length x width) which is too long for automatic finishing on the front table.

Remedy:
- use an acceptable size.

Memos:

Error No.: 2591

Error Text: SIZE OF CUT SHEET TOO WIDE

State: ERROR **addition:** RED

Cause: The cut material has a size (length x width) which is too wide for automatic finishing on the front table.

Remedy: - use an acceptable size.

Memos:

Error No.: 2592

Error Text: PROTECTION FLAP NOT CLOSED !

State: ERROR **addition:** RED

Cause: The protection flap is not closed.

Remedy: - Close the protection flap.

Memos:

Error No.: 2594

Error Text: CONTINUOUS OPERATION INACTIVE

State: HINT **addition:** PURPLE

Cause: Key-operated switch is set to "Continuous operation OFF"

Remedy: - Check the switch and the relevant cabling.

Memos:

Error No.: 2595

Error Text: CCUT HAS NOT BEEN AUTHORIZED

State: HINT **addition:** PURPLE

Cause: Correct authorization code has not been input or saved.

Remedy: - input or save correct authorization code.
- request authorization code from POLAR.

Memos:

Error No.: 2597

Error Text: SAPG HAS NOT BEEN AUTHORIZED

State: HINT **addition:** PURPLE

Cause: SAPG = service "automatic cutting program generator"
Correct authorization code has not been input or saved.

Remedy: - input or save correct authorization code.
- request authorization code from POLAR.

Memos:

Error No.: 2748

Error Text: SUPER- CLAMP TIME ERROR

State: ERROR **addition:** RED

Cause: The upper switches (B345 - B348) will not reached.

Remedy: - Check / replace switches B345 - B348.
- Check if Super Clamp mechanism is sluggish.

Memos:

Text- Messages:
S, ES, E, ED, XS, X, XT, X-Plus, XT-Plus, - 66 bis 176
Autocut 25, AC- 115 und Autotrim- M

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Text- Messages

Reg. Nr. **1**

Text **BSY - ERROR**

Cause: The message "BSY ERROR" signals an internal error in the operating program of CPxx-board.

Remedy:
- Replace CPxx- board.
- Update to a more recent software status.
- Check connection to external computer (such as Autocut).
- Check / replace SAP- board.
- RAM on CPxx- board is defectiv.
- Check and/or replace frequency converter (see comment).

Memo

For example, on 137 XT and BSY Error 5 (frequency converter defective)
- No frequency converter error message
- in secondary operation, only "Backgauge slow" is possible.
- Error message during reference run "Backgauge only slow".

Reg. Nr. **2**

Text **TMS - ERROR**

Cause: This message designates malfunctions in the exchange of data between CPxx (main computer) and the graphic card (GC1).

Remedy:
- Replace GC1- board
- Replace CPxx- board
- Replace combination of CPxx- board and GC1- board
- Replace SMP- bus p.c. board

Memo

Reg. Nr. **3**

Text **PMS - ERROR**

Cause: Message "PMS - ERROR" designates a software error of the operating system to control the exchange of data between PMS card and program memory on CPxx- board.

Remedy:
- Check / replace CPxx- board.
- Check / replace KCxx- board.
- Are KCxx- board and CPxx- board compatible (observe program status / version)

Memo

Text- Messages

Reg. Nr. **4**

Text **SPV - ERROR**

Cause: These messages designate usually software errors in the operating program of CPxx-board. They are output in the case of any inadmissible actions in connection with the access to the program memory.

Remedy: - Replace CPxx- board.
- Update to a more recent software status.

Memo

Reg. Nr. **5**

Text **DUST - ERROR**

Cause: Message "DUST ERROR" may only occur in the "test version" mode. The message indicates irregularities in the software. It has no effect on the operating cycle of the machine. * The numbers 1 and/or 11 indicate that terminal units, such as Compucut and Autocut are not recognized..

Remedy: - Adjust configuration of the second serial interface to printer.
- Switch test mode off.
- Check configuration of interfaces to terminal units.
- On X / XT generation, check fuse F2 and replace it, if necessary.

Memo Make sure you always preset "printer" for the second serial interface of CPxx- board, because otherwise CPxx- board will try to function in response to Compucut at this interface, when the "Service operation-SW 2.4-" function has been selected.

Reg. Nr. **6**

Text **BRK - ERROR**

Cause: This message designates malfunctions in the exchange of data between CPxx (main computer) and KCxx (keyboard computer).

Remedy: - Check serial interface connection CPxx- board - KCxx- board.
- Replace CPxx- board.
- Replace KCxx- board.
- Are KCxx- board and CPxx- baord compatible (observe program status / version).

Memo

Text- Messages

Reg. Nr. **7**

Text **TXT - ERROR**

Cause: This message is caused by a fault in the text repertoire of the software.

Remedy: - Replace CPxx- board
- Update to a more recent software status

Memo

Reg. Nr. **8**

Text **DPR - ERROR**

Cause: This error message is only output on machines fitted with IPC (industrial PC). It indicates malfunctions in connection with the data exchange via the dual-port RAM of CPxx and industrial PC.

Remedy: - Check connection IPC-DPR - SMP- bus - CPxx- board
- Replace dual port RAM
- Replace CPxx- board
- Replace SMP bus p.c. board
- Replace IPC assembly

Memo

Reg. Nr. **9**

Text **DL - ERROR**

Cause: This error message is indicated only in the case of a defective downloading process. The additional number indicates the type of downloading in which the malfunction occurred.
1 = keyboard computer, 2 = main computer, 3 = language, 4 = service data.
Keyboard computer, main computer and language download errors are serious ones. Such an error can only be eliminated by replacing the corresponding computer card and performing a new download.

Remedy: - Replace Kcxx- board (if error occurred during keyboard computer download)
- Replace CPxx- board (if error occurred during main computer or language download)
- Clear CMOS Ram and transfer data again to CPxx- board. (Only for download of service
data or selection of "Load from service card".)

Memo

Text- Messages

Reg. Nr. **10**

Text **UNDEFINED COMMAND IN OBJTCT NO. Xxx**

Cause: This error message is representative for further texts that are output on the red display when the graphic processor has detected an error in the data sent from the main computer. If these errors are caused by the software, the message disappears after a certain period and the system is again ready for operation. If the present error is a static one or can only be corrected by a reset of the computer, it originates probably from a defective data transfer from CPxx- board to the graphic processor.

Remedy:
- Replace GC1- board
- Replace CPxx- board.
- Replace combination of CPxx- board and GC1- board
- Replace SMP- bus board

Memo

Reg. Nr. **11**

Text **XS1 - ERROR**

Cause: This error message is only output on the display with the service mode (test mode) switched on CPxx- board. It is caused by conflicting addresses in the memory area between board XS1 and the SMP- bus. In this connection, please consider the following constellation arising in relation with XS1 and the internal PC. In one and the same machine, board XS1 can only be operated in combination with an IPC (Data-Control) , but never with a PCM computer.

Remedy:
- Remove XS1- board.
- Replace GC2- board.
- Replace CPxx- board.

Memo

Text- Messages

Reg. Nr. **12**

Text **CHECKSUM ERROR**

Cause: During the internal inspection by the operating system of the CPxx- board an illogical error has occurred. This may also happen if the SMP- bus or the I/O- bus has suffered a malfunction.
If the error message "TMS Error" has been recorded in the error trace, it can be regarded as a cause of the Checksum Error. Please, refer to the description of the "TMS-Error".

Remedy:
- Replace CPxx- board.
- Replace KCxx board.
- Replace the PMS chip card.
- Malfunction during / after software download
- Replace GC1- board
- Replace CU- unit
- Set CPxx- board DIP Switch SW3 switch 8 to "OFF" if P-Net is not connected.
- red Display on X/XT machines, wrong PAL used on graphic board GC2.

Memo

Reg. Nr. **13**

Text **PKK 16**

Cause: The machine setting includes the definition of a production system.

Remedy:
- At "preset functions": select "no production system".
- CP6 board, S3.8 must be set to "OFF" if no DBR- baord is used in this machine.

Memo

Reg. Nr. **14**

Text **SPECIAL PROGRAM 23/28 REQUIRED**

Cause: The computer comes to realize that the wrong software has been used for the configured machine.

Remedy:
- Check machine configuration on CPxx- board
- Use special version 23 / 28
- Verify supply voltage +24V.

Memo

Text- Messages

Reg. Nr. **15**

Text **CALL SERVICE**

Cause: Due to a malfunction the booting process of the machine computer cannot be run as usual.

Remedy: - Adjust correct machine type
- Touch screen plug is missing or not plugged in
- Call POLAR Service help line

Memo

Reg. Nr. **16**

Text **TOU-ERROR**

Cause: There is a communication error between touch controller and CPxx board. The malfunction may also occur if Compucut and / or AAN board are available.

Remedy: - Check connection between touch controller and CPxx- board.
- Replace touch controller, CPxx- board, connecting cable (for testing purposes, the serial
cable can be changed from keyboard computer to CPxx- board, the system may indicate
BRK- Error if the cable is defective).
- Carry out software update to Version V1.1.1 or higher.

Memo

Reg. Nr. **17**

Text **MKS-Error 1**

Cause: This message will be displayed on machines with electronic handwheel, if reference run has not been completed and a new backgauge positioning has been started.

Remedy:

Memo

Text- Messages

Reg. Nr. **18**

Text **MKS-Error 2**

Cause: This message will be displayed when backgauge is already travelling and another movement has been tried to start with the electronic handwheel.

Remedy:

Memo

Reg. Nr. **19**

Text **TRK Error**

Cause: This message indicates that there is a communication problem between software and touch display.

Remedy: - Is the correct machine type set on computer CPxx- board ?
- Check / replace CPxx- board.

Memo If a DBR board is installed:
Carry out a test without the DBR board. Set dip switch on CPxx- board SW3 - 8 to "off".

Reg. Nr. **20**

Text **LPC - BRK1**

Cause: This message refers to P-Net and occurs only in connection with the service switch that has been set on the computer board. In this constellation, this message must be regarded as "normal".

Remedy: - Reset service switch on CPxx- board (SW 2.4).

Memo

Text- Messages

Reg. Nr. **21**

Text **TPK- Error**

Cause:

Remedy:
- CPxx software (on machines equipped with P- Net) V1.6.0 or higher.
- Check CPxx- board dip switches (SW3- 8), depending on what kind of board installed..
  - DBR- board, SW3- 8 "on"
  - CPL7- board with software V 2.0.0 SW3- 8 "off"
  - CPL7- board as of software V 2.0.2 SW3- 8 "off" (is no longer scanned).
- Check / replace DBR- board.
- Check / replace CPL7- board.
- SMP- BUS board (verify / replace connection between CP and DBR/ CPL7).

Memo

If a DBR- board is installed:
Carry out a test without the DBR- board. Set dip switch on CPxx- board SW3 - 8 to "off".

Reg. Nr. **22**

Text **PPK- Error**

Cause:

Remedy:
- CPxx software (on machines equipped with P- Net) V1.6.0 or higher.
- Check CPxx- board dip switches (SW3- 8), depending on what kind of board is installed..
  - DBR- board, SW3- 8 "on"
  - CPL7- board with software V 2.0.0 SW3- 8 "off"
  - CPL7- board as of software V 2.0.2 SW3- 8 "off" (is no longer scanned).
- Check / replace DBR- board.
- Check / replace CPL7- board.
- Check / replace SMP- BUS board (connection between CP and DBR/ CPL7).

Memo

Text- Messages

Reg. Nr. **23**

Text **COM- Error**

Cause:

Remedy:
- Check / replace GC2- board
- Check / replace CPxx- baord.
- Check / replace KCxx- board.
- Check / replace cable X3 - KCxx- board.
- Check I/O- board connection.
- Verify if machine is correctly connected to ground.

Memo

Reg. Nr. **24**

Text **Illegal Command (red display)**

Cause:

Remedy:
- Check / replace GC1- board.
- Check / replace CPxx- board.
- Replace combination of CPxx- board and GC1- baord.
- Replace SMP- bus board.
- Replace the display.

Memo

Reg. Nr. **25**

Text **Checksum error at command (red display)**

Cause:

Remedy:
- Check / replace GC1- board.
- Check / replace CPxx- board.
- Replace combination of CPxx- board and GC1- board.
- Replace SMP- bus board.

Memo

Text- Messages

Reg. Nr. **26**

Text **Empty Object number xxxx (red display)**

Cause:

Remedy:
- Check / replace GC2- board.
- Check / replace CPxx- board.
- Replace combination of CPxx- board and GC1- board.
- Replace SMP- bus board.
- Check cable connection to display.
- Replace the display.
- Carry out a software update to Version V1.4.0 or higher.

Memo

Reg. Nr. **27**

Text **Object number too large (red display)**

Cause:

Remedy:
- Check / replace GC2- board.
- Check / replace CPxx- board.
- Replace combination of CPxx- board and GC1- board.
- Replace SMP- bus board.
- Check cable connection to display.
- Replace the display.
- Carry out a software update to Version V1.4.0 or higher.

Memo

Reg. Nr. **28**

Text **Text memory overflow**

Cause: Only on ED machines equipped with "Farsi" language and software version V1.3.0

Remedy: - Carry out a software update to the most recent version.

Memo

Text- Messages

Reg. Nr. **29**

Text **Wrong time setting, "Call Service"**

Cause: Wrong time setting in Prinect System / Cut Manager

Remedy: - De-install the DBR- board. Set SW3- 8 on CPxx- board to"off".
Turn the machine on. Verify and/or set the time and date.
Re-install the DBR- board and turn SW3- 8 on the CPxx- board to "on" position.

Memo The machine should carry out a normal booting process now. If it doesn't, verify the Prinect setting.

Reg. Nr. **30**

Text **Keyboard not connected (only in boot program)**

Cause:

Remedy: - Check / replace connection between the CPxx- board and KCxx- board.
- Check the light emitting diodes on CPxx- board.
- Check / replace CPxx- board.
- Check / replace KCxx- board.

Memo

Reg. Nr. **31**

Text **Init- 1/ 2 asic- 1/ 2 fail**

Cause: This error message is only output on machines equipped with Count Monitor.

Remedy: - Check / replace CPxx- board.
- Check, if CPxx- board is using the right software for Count Monitor.

Memo