



System Messages

INFORMATIONAL MESSAGES:

Informational messages will prompt with cause, but will not shut stacker down.

- (123) INTERCEPT FAILURE- Monitor HT can not intercept the trigger paper correctly to assure proper count in stack.
 - 1. Check paper stream lap. Lap between papers can not go below two (2) inches.
 - 2. If stacker is operating on an insert line, check that the infeed section is in "CONSTANT SPEED MODE ON". Also, increase the speed of the infeed section.
 - 3. If stacker is operating on a press line, check that the infeed line is in "CONSTANT SPEED MODE OFF". In this mode stacker will tach follow the conveyor line, if tach is installed and connected to conveyor. Verify that the stacker infeed section is calibrate with conveyor tach.
 - 4. Abrupt stream lap change.
 - 5. Infeed section minimum speed set too low.

- (208) EXCEEDED CYCLE TIME - Stacking section motor running behind schedule.
 - 1. Fenner drive for stacking section is misadjusted.
 - 2. Check D/A board for proper zero adjustment to fenner drives.
 - 3. Check stacking section tach. Possible loose gear, or damaged proximity sensor.

- (106) INPUT JAM SENSOR- Paper jam switch was actuated in the input section.
 - 1. Paper jam occurred in infeed section, actuating JLS.
 - 2. JLS not properly adjusted.
 - 3. Faulty JLS
 - 4. Faulty JLS I/O module.
 - 5. Check for broken wires or loose connections.

- (107) MAX BATCH SENSOR - Exceeded stacking section batch size and actuated MBPS.
 - 1. Check MBPS and I/O module.
 - 2. Check that the trigger wire is not too tight to body of MBPS.
 - 3. Check for broken or loose wires.
 - 4. Check to see if count is correct.

ERROR MESSAGES:

Error messages will prompt with message and shut stacker down until problem is resolved.

- (112) ROTATE INCOMPLETE - Bucket did not complete rotate cycle in allotted amount of time (>1 sec.).
 - 1. Papers binding bucket rotation.
 - 2. Rotate valve solenoid improperly adjusted for proper bucket cushion.
 - 3. Faulty solenoid.
 - 4. Check "TPLS1", "TPLS2", "RCLS" proximity sensors for proper operation. Also, check I/O modules for "TPLS1", "TPLS2", and "RCLS".
 - 5. Check wires from rotate solenoid to the bucket PCB.
 - 6. Refer to HPS TECHNICAL BULLETIN NO. 88-012.
 - 7. Check E-Stop.
 - 8. Check air pressure.
 - 9. Check 24V power supply.

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- (110) STACKING SECTION FAILED TO DRIVE - Computer did not see enough movement from the stacking section tach at beginning of cycle.
1. Check stacking section tach and corresponding I/O module.
 2. Check fenner drive for stacking section, stacking section motor, or D/A board in card cage.
 3. Check for binding in stacking section chains and tyne truck assemblies.
 4. Check home proximity switch and corresponding I/O modules.
 5. Check E-Stop.
- (111) LATCH CAM FAILURE - Computer after actuating latch cam, still sees home proximity switch made.
1. Check air to stacker.
 2. Lack of lubrication
 3. Check latch solenoid, and corresponding I/O module
 4. Check home proximity sensor and corresponding I/O module.
 5. Check fenner drive adjustments.
- (113) EXCEEDED DISCHARGE TIME - Discharge of bundles did not complete in allotted amount of time (800ms).
1. Check for blown fuses (FU-8, FU-9, FU-10).
 2. Check discharge bars and chains for binding.
 3. Check discharge motor starter relay and overloads.
 4. Check discharge I/O modules.
 5. Check discharge motor and power cable from motor to motor starter.
- (115) EXCEEDED ROTATE TIME - Bucket did not complete rotate cycle in allotted amount of time (>1 sec.).
1. Check air pressure.
 2. Check rotate solenoid and corresponding I/O modules.
 3. Check "TPLS1", "TPLS2", and corresponding I/O modules, also check for loose or broken wires.
 4. Check for papers binding.
- (114) STACKING SECTION DRIVE CALIBRATION - Computer memory was cleared. Computer is calibrating the stacking section.
1. CPU battery is faulty.
- (122) NO AIR AT LATCH CAM - Computer actuated latch cam, but home proximity switch saw no movement or tyne trucks.
1. No air to stacker.
 2. Faulty latch solenoid to latch cylinder.
 3. Check home prox switch.
 4. Check I/O modules for home prox and latch solenoid.
 5. Check E-Stop and start/clear.
- (109) BUCKET NOT HOME - Bucket bound up on start, not at home.
1. No air to stacker.
 2. Papers binding in bucket.
 3. Check "TPLS1", "TPLS2" prox sensors, and corresponding I/O modules.
 4. Check E-Stop and start/clear relay.