



System Messages

INFORMATIONAL MESSAGES:

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

- (125) INTERCEPT FAILURE - Monitor HT II cannot intercept the trigger paper correctly to assure proper count in stack.
 - 1. Check paper stream lap. Lap between papers cannot go below 2 inches.
 - 2. If stacker is operating on an insert line, check that the in feed section of stacker is in "INSERT MODE".
 - 3. If stacker is operating on a press line, check that the in feed section of stacker is in "PRESS MODE".
 - 4. Abrupt stream lap change.
 - 5. In feed section minimum speed set too low.
 - 6. Batch size too small for press speed.

- (222) EXCEED CYCLE TIME - Stacking section motor running behind schedule.
 - 1. Motion Control Board for stacking section is misadjusted.
 - 2. Check for binding in stacking section.

- (107) INPUT JAM SENSOR - Paper jam switch was actuated in the infeed section.
 - 1. Paper jam occurred in infeed section, actuating the Jam Limit Switch [JLS].
 - 2. JLS out of adjustment, to high in infeed section.
 - 3. Faulty JLS.
 - 4. Faulty JLS I/O Module #16.
 - 5. Broken wire grounding switch out.

- (108) MAXIMUM BATCH SENSOR - Exceed stacking section batch size and actuated Maximum Batch Switch.
 - 1. Counter failure
 - 2. Toggle switch on laser power supply is in wrong position.
 - 3. Maximum batch actuator out of adjustment.
 - 4. Faulty I/O module #15.
 - 5. Broken wire grounding switch out.

ERROR MESSAGES:

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

- (110) ROTATE INCOMPLETE - Bucket did not complete cycle in proper amount of time (<1 sec.)
 - 1. Papers binding bucket rotation.
 - 2. Cushion for rotate flow control valve is out of adjustment.
 - 3. TPLS1, TPLS2, or RCLS is out of adjustment or faulty.
 - 4. One of the following I/O modules are defective. TPLS1 - #10; TPLS2 - #9; or RCIS - #11.
 - 5. Broken wire on rotate solenoid to PCB.
 - 6. Defective rotate solenoid.
 - 7. No air going to stacker.

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- (120) STACKING SECTION FAILED TO DRIVE - Computer did not see enough movement from the stacking section tach at the beginning of the cycle.
1. E-Stop is either pushed in or defective.
 2. 15 AMP breaker on Servo drive has been tripped.
 3. FU9; FU11; FU12; or FU13 may be blown.
 4. Servo drive assembly is defective.
 5. Servo Motor is defective.
 6. Motion Control Board is defective.
 7. Servo goes into fault.
 8. Binding in stacking section chains and tyne truck assemblies.
- (112) EXCEED DISCHARGE TIME - Discharge of bundle did not complete cycle in allotted time (<1.25 sec.).
1. Discharge chains binding or out of adjustment.
 2. Discharge motor overload tripped.
 3. FU6; FU7; or FU8 may be blown.
 4. DSPS out of adjustment.
 5. Defective DSPS I/O module #12.
 6. Discharge motor starter relay defective.
 7. Defective DM-CW, or DM-CCW I/O module # 20 or 23.
 8. Intermittent of defective discharge motor coil cord.
 9. Defective discharge motor.
 10. Binding in discharge motor brake assembly.
 11. Defective rectifier in discharge motor brake.
- (111) EXCEEDED ROTATE TIME - Bucket did not complete its cycle in the allotted time (<1.25 sec.).
1. Main air pressure too low.
 2. Defective rotate solenoid.
 3. Defective rotate I/O module # 4.
 4. Rotate flow control valves out of adjustment.
 5. TPLS1; TPLS2; or RCLS is out of adjustment or defective.
 6. One of the following I/O modules defective: TPLS1 - #10, TPLS2 - #9, or RCLS - #11
- (109) BUCKET NOT HOME - Bucket bound up on start up, not at home.
1. No air to stacker.
 2. E-Stop in.
 3. Papers binding in bucket.
 4. TPLS1 or TPLS2 out of adjustment or defective.
 5. One of the following I/O modules are defective: TPLS - #10, TPLS2 - #9.
- (218) STACKING SECTION DRIVE CALIBRATION - Computer memory was cleared. Computer is calibrating stacking section.
1. Battery on C.P.U. board is dead.
 2. C.P.U. power supply is defective.
 3. RAM on C.P.U. defective.

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- (114) BUCKET FUNCTION INCOMPLETE - Can be caused by anything in discharge or rotate function that exceeds allotted time.
1. Refer to
 - (110) ROTATE INCOMPLETE
 - (111) EXCEEDED ROTATE TIME
 - (112) EXCEEDED DISCHARGE TIME
- (233) INTERRUPT - Data read failure in C.P.U.
1. E-PROM not seated in socket.
 2. Damaged E-PROM
 3. Bad C.P.U. board
- (113) DISCHARGE MOTOR OVERLOAD - Discharge motor has gone into current overload.
1. Discharge motor overload is tripped.
 2. Discharge motor or discharge assembly jams or binds for any mechanical reason.
 3. Loss of phasing on input power.
 4. Defective break assembly on discharge motor.
 5. Defective rectifier for brake coil.
- (121) EXCEEDED CYCLE DISTANCE - Stacking section has gone past home position without sensing home proximity.
1. Motion Control board out of adjustment.
 2. Motion Control board defective.
 3. Home proximity switch out of adjustment or defective.
 4. I/O module defective.
- (222) EXCEEDED CYCLE TIME - Calculated time to do entire cycle exceeded.
1. Binding in stacking section.
- (123) EXCEEDED HOME DISTANCE - Stacking section traveled to far on start up.
1. Refer to (121) EXCEEDED CYCLE TIME
- (131) NO INFEED TACH - No tach signal reaching motion control board.
1. Defective ring tach.
 2. FU10 blown
 3. Defective motion control board.
 4. Defective C.P.U. board
 5. E-Stop pulled in with defective N/O contact block for I/O 0-3 channel 4.
- (119) CALIBRATION FAILURE - Stacking section failed to produce required base RPM of 29 and 966 tach pulses per inch.
1. Defective Motion Control board.
 2. Defective Servo motor.
 3. Defective Servo drive.