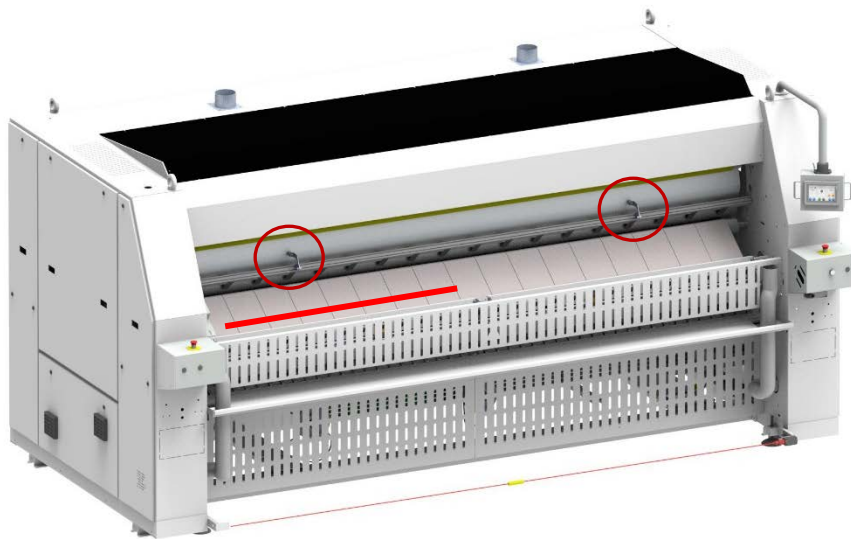




1) Problem : **A01 MAX TEMPERATURE ROLL RIGHT SIDE**

This alarm happens when the ironing roll temperature on the right side goes over the 190°C
The reasons can be:

- a) The operator uses only a side of the machine during the work, causing an abnormal overheating on the side not used.
- b) Problems on the probed of temperature detection, dirt or the probes aren't well in contact with the roll surface.
- c) Combustion not homogeneous on the length of the burner



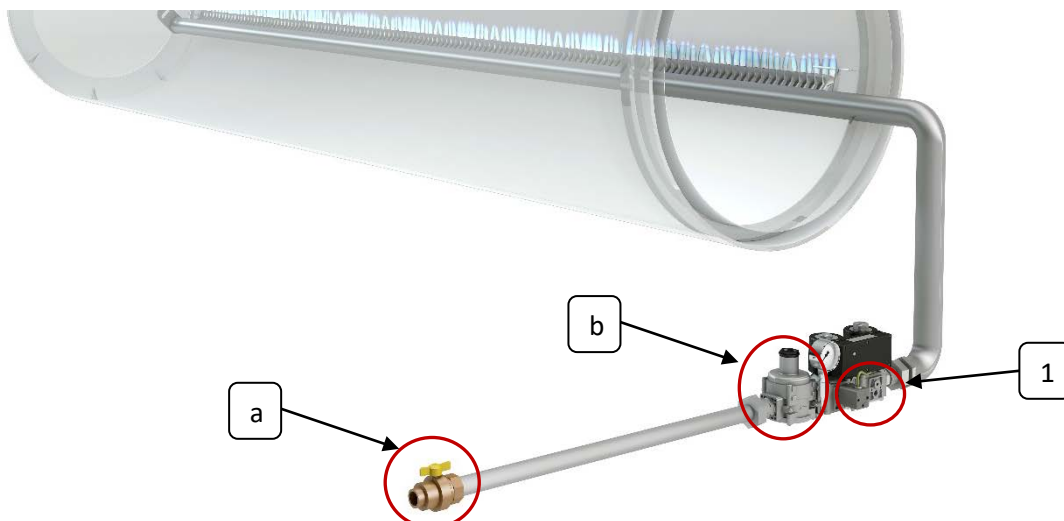
2) Problem : **A02 GAS PRESSURE LOW**

This alarm happens when the gas pressure in input of the burner is lower than the minimum pressure of work. The pressure switch (1) detects this error.

The reasons can be:

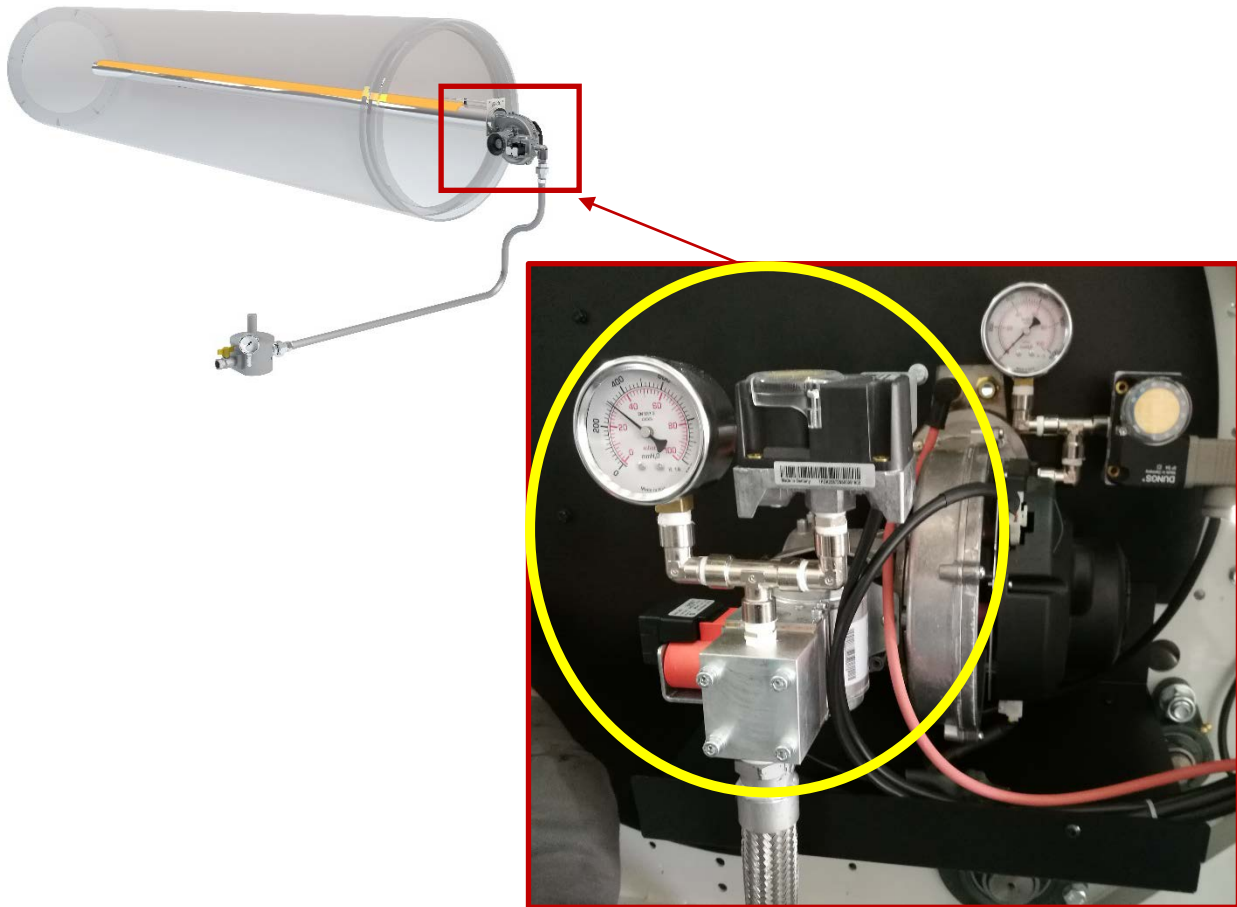
- a) Gas tap closed
- b) Regulator filter of the plant with dirt
- c) Low pressure of the gas net

Athmospheric burner





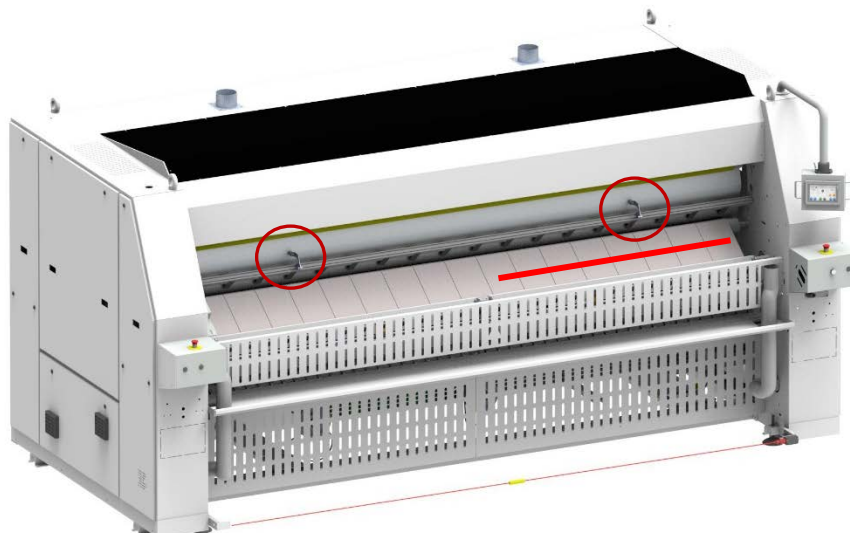
Premix burner



3) Problem : **A03 MAX TEMPERATURE ROLL LEFT SIDE**

This alarm happens when the ironing roll temperature on the left side goes over the 190°C
The reasons can be:

- The operator uses only a side of the machine during the work, causing an abnormal overheating on the side not used.
- Problems on the probe of temperature detection, dirt or the probes aren't well in contact with the roll surface.
- Combustion not homogeneous on the length of the burner



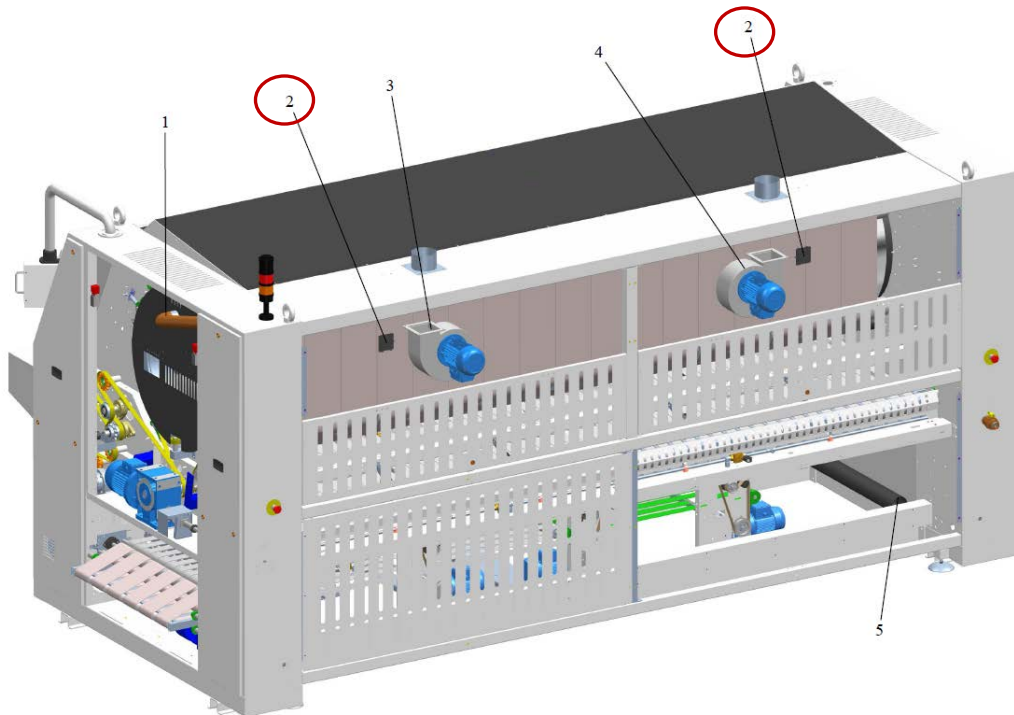


4) Problem : **A04 ANOMALY PRESSURE SUCTION SMOKES LEFT**

This alarm happens when the pressure switch (2) of the fumes suction left side doesn't detect the minimum suction pressure

The reasons can be:

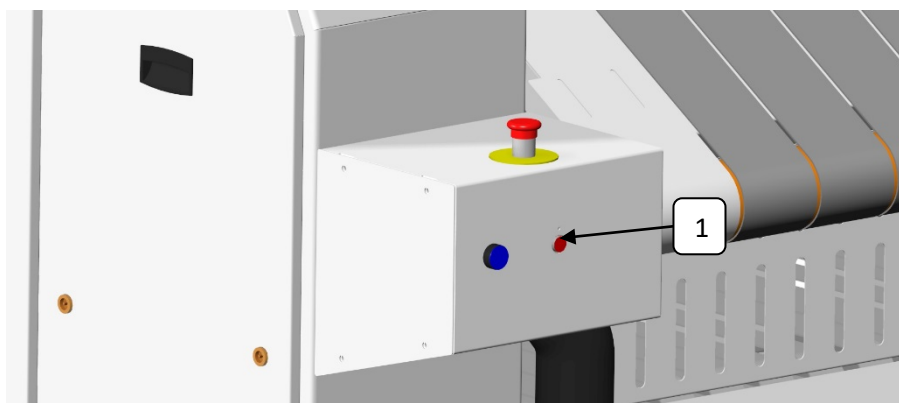
- a) Silicon pipes of connection between Venturi joint and pressure switch dirty or disconnected
- b) Suction pipes full of dirty (1)
- c) Pressure switch damaged



5) Problem : **A05 ANOMALY GAS UNIT CONTROL**

This alarm happens when the gas control unit (1) that manages the burner detects malfunction of the burner

- a) Check the electrodes position
- b) Check gas pressure





6) Problem : **A06 ANOMALY INVERTER MAIN MOTOR**

This alarm happens when the inverter detects some problems on the main motor.

Check the alarm code appeared on the display of the inverter and see the inverter manual to identify the possible reason [J1000 QSG IT TOIP C710606 27A 2 0.pdf](#)



7) Problem : **A07 ANOMALY BURNER SWITCH OFF FOR TOO LOW ROLL SPEED**

This alarm happens when, with the burner on, the machine reaches the speed lower than 1 meter/minute. This alarm can be the reason also for the alarm **A08**

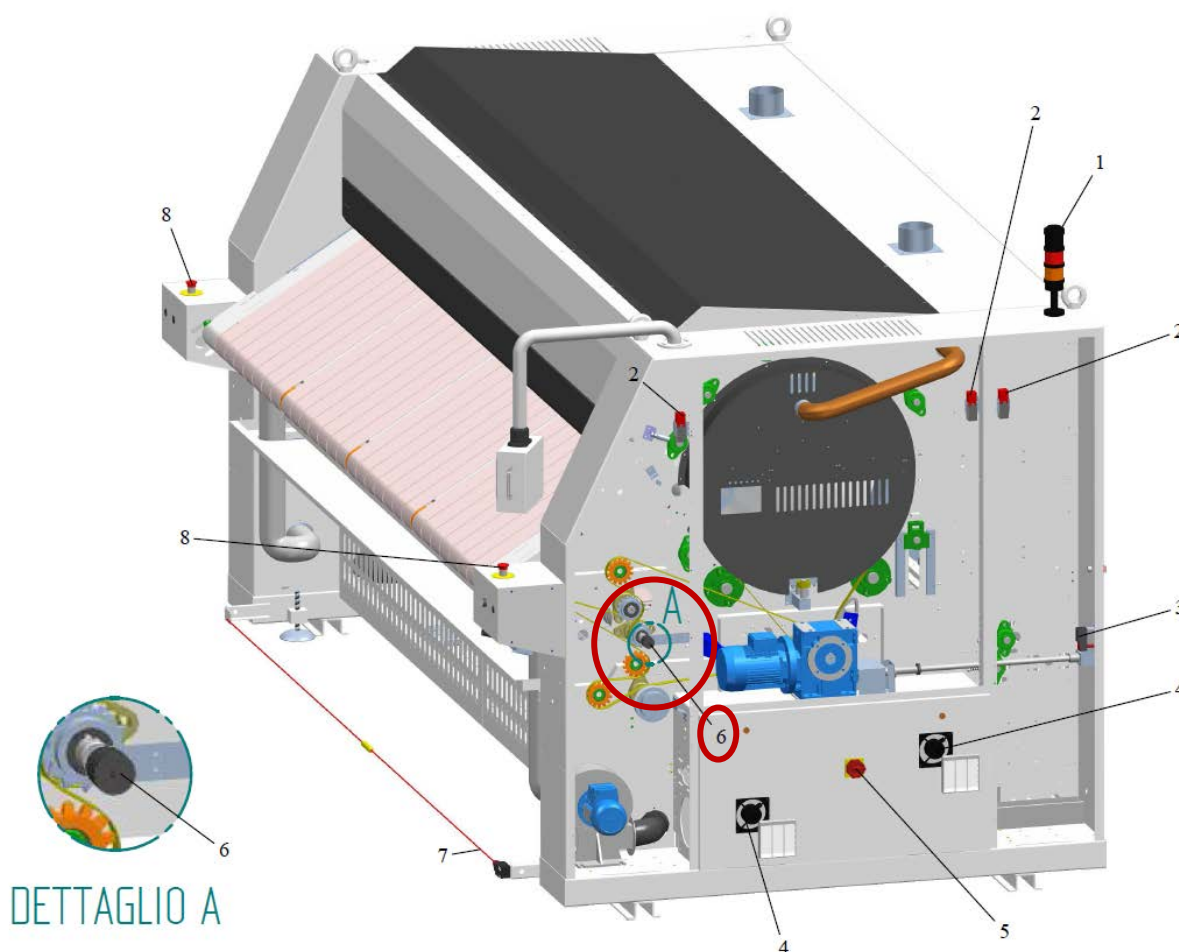


8) Problem : **A08 ANOMALY BROKEN SPEED ENCODER SENSOR**

This alarm happens when, with the machine running and ironing roll rotating, the encoder (6) doesn't transfer any signal to the PLC.

The reasons can be:

- a) Elastic joint encoder damaged
- b) Encoder damaged
- c) Connection cables disconnected



9) Problem : **A09 THERMAL FAULT (TRIP CROSSFOLDS A35.1)**

10) Problem : **A010 THERMAL FAULT TRIP 1^a CROSSFOLD L1 LEFT A35.2**

11) Problem : **A11 THERMAL FAULT TRIP 1^a CROSSFOLD L2 RIGHT A35.3**



12) Problem : **A12 THERMAL FAULT TRIP 1ª CROSSFOLD L3 CENTRAL A35.2**

13) Problem : **A13 THERMAL FAULT TRIP 2ª CROSSFOLD A36.1**

14) Problem : **A14 THERMAL FAULT TRIP 3ª CROSSFOLD A36.2**

15) Problem : **A15 THERMAL FAULT TRIP STACKER MOTORS A37.1 - A37.2**

16) Problem : **A16-A17 THERMAL FAULT TRIP FAN A37.3 – A37.4**

17) Problem : **A18 THERMAL FAULT TRIP TABLE SUCTION A37.5 - A37.6**

18) Problem : **A19 THERMAL FAULT TRIP BRUSHES FEEDER A38.1 - A38.2**

19) Problem : **A20 THERMAL FAULT TRIP STACKER TABLE 4 **A38.3****

This alarm happens when the control motor device detects an overload or other type of problem:
The reasons can be:

- a) Check that in the machine there isn't any item or other pieces that can block the motor rotation
- b) Device sensitivity very high. Check the current value on the device with the motor value written on the plate
- c) Check the alarms table of the manual **[0 Contactron Completo.pdf](#)**





20) Problem : **A21 THERMAL FAULT TRIP MAIN MOTOR E6.2 QF.9.1**

This alarm happens when the motor control device detects an overload or other type of problem.
The reasons can be:

- a) Check that in the machine there isn't any item or other pieces that can block the motor rotation
- b) Device sensitivity very high. Check the current value on the device with the motor value written on the plate



23) Problem : **A24 ANOMALY PHOTOCEL 1LF LINE 3 CENTRAL E0.3**

24) Problem : **A25 ANOMALY PHOTOCEL LINEN TENSIONING E5.2**

This alarm happens when with the program 0 (sensors control) one sensor is on, abnormal condition with the program 0 because this program isn't a working program and for this reason there shouldn't any piece in progress in the machine

The reasons can be:

- a) Sensor or photocel dirty
- b) Sensor or photocel not in line
- c) Piece jammed in the machine

To identify the active sensor use the **MAPPA FOTOCELLULE**

And by the page **Test Input** of the touchscreen identify the sensor/photocel active



Sensor not active



Sensor active

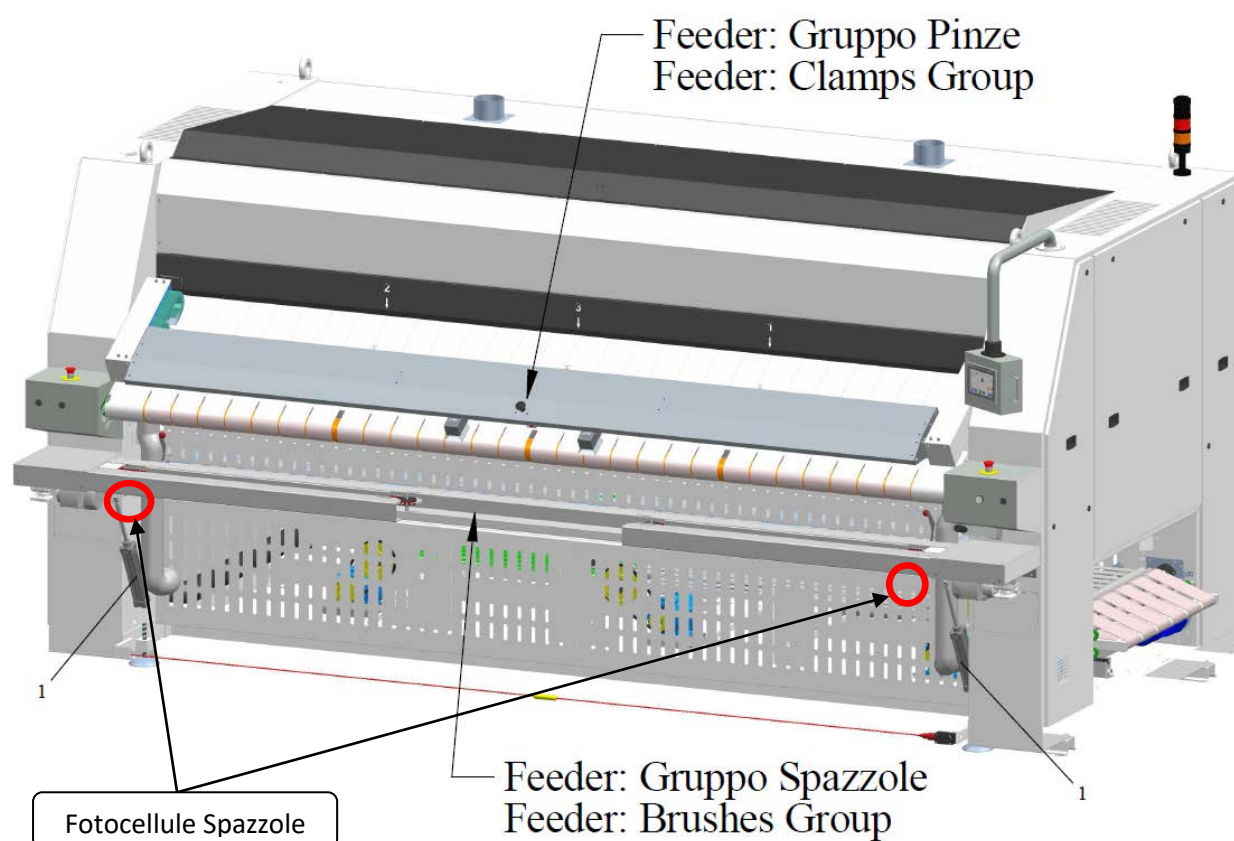


25) Problem : **A26 ANOMALY STOP PHOTOCEL INTERVENTION FEEDER BRUSHES E5.4**

The error is given when the photosensors of the brushes (A) and (B) detect a sheet passage or of the other things on its reading field.

Possible reasons:

- A) Reading intensity of the photosensor too high, then regulate it.
- B) The bed sheets are large in exceed until cover really the photosensor



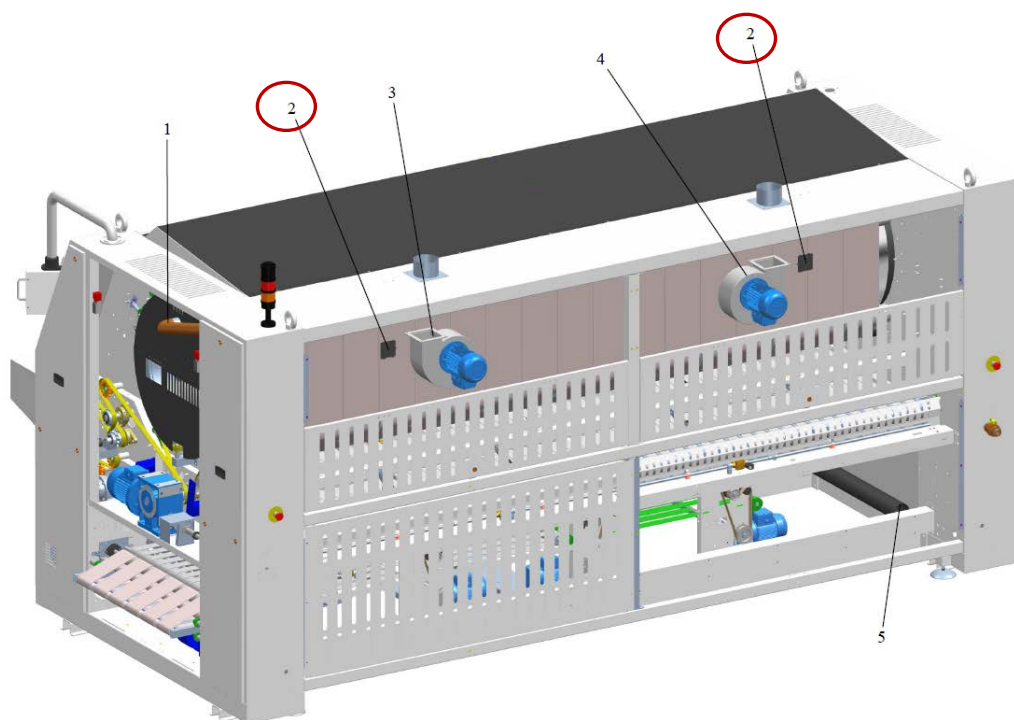


26) Problem : **A27 ANOMALY PRESSURE SUCTION SMOKES RIGHT E4.5**

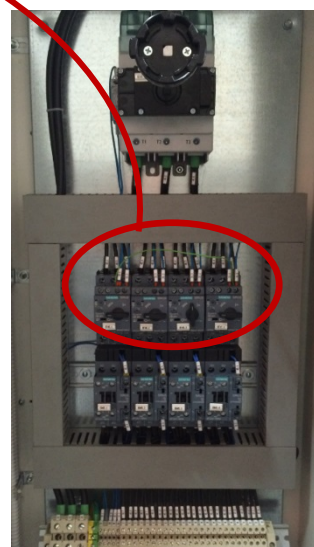
This alarm Questo allarme happens when the fumes suction pressure switch on the right side doesn't detect the minimum suction pressure

The reasons can be:

- a) Silicon pipes of connection between Venturi joint and pressure switch dirty or disconnected
- b) Suction pipes full of dirty (1)
- c) Pressure switch damaged



27) Problem : **A28 THERMAL FAULT TRIP RESISTANCES FEEDING E5.1**



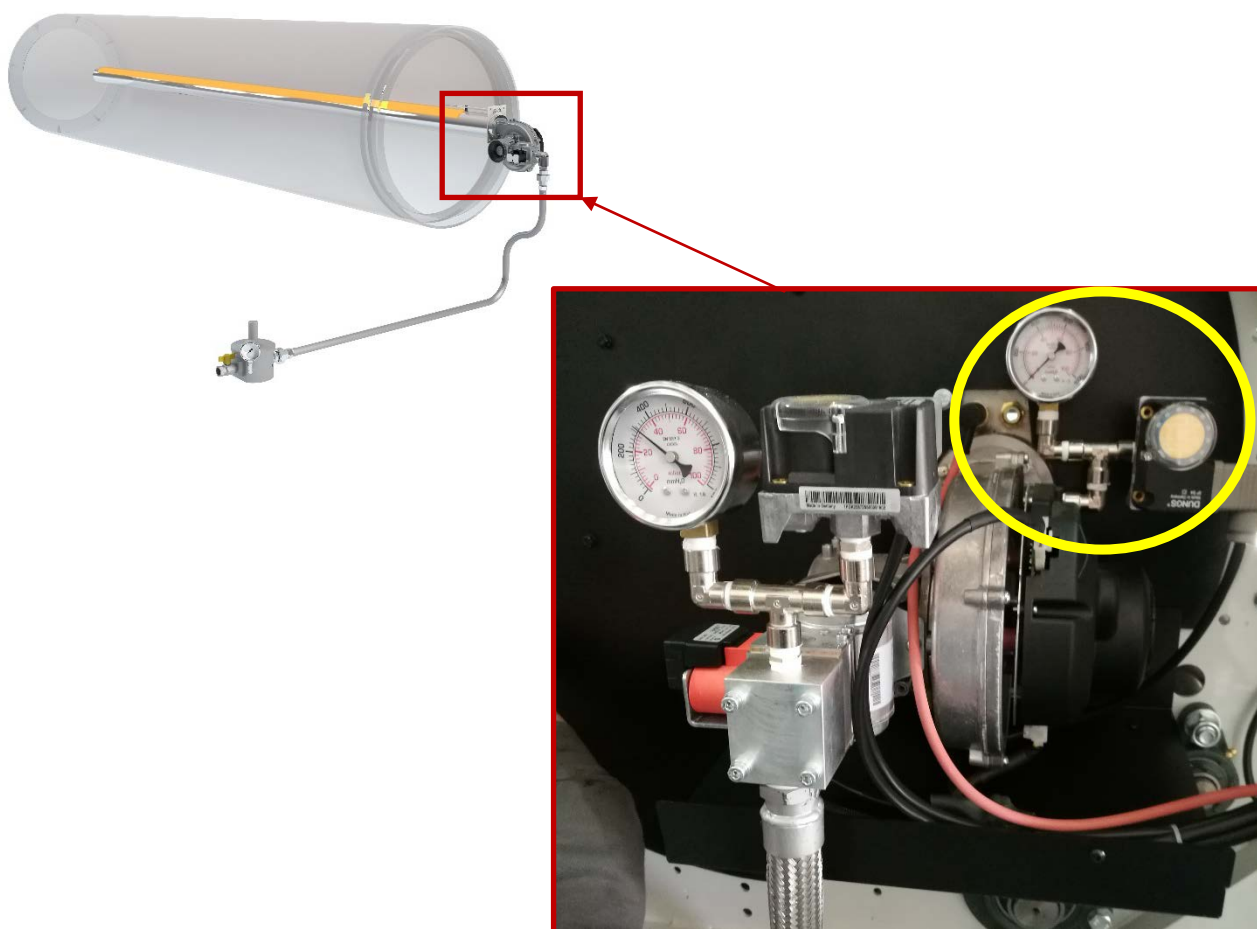


28) Problem : **A29 LOW PRESSURE AIR / GAS PREMIX**

This alarm happens when the pressure of air/gas in input of the burner is lower of the minimum working pressure (20 mbar)

The reasons can be:

- a) Fan speed premix group too low
- b) Fan damaged
- c) Pressure switch damaged





29) Problem : **A30 ACTIVATE THE RESISTANCE SWITCH (Only electrical heating)**

This alarm happens when the supply switch of the resistances is OFF

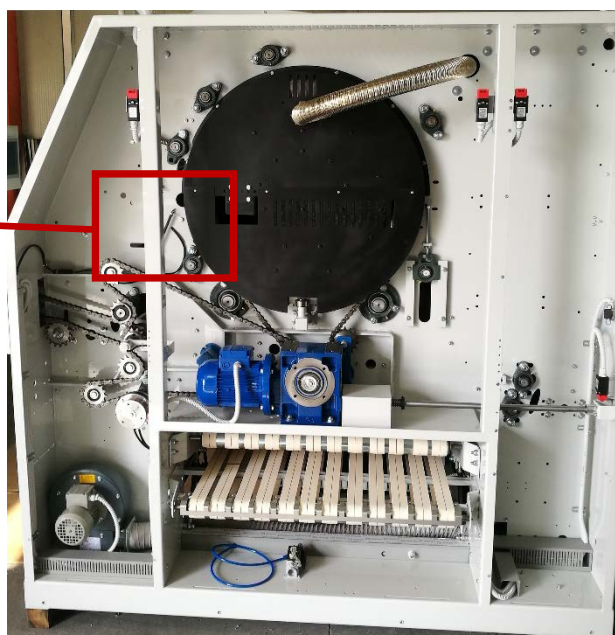


30) Problem : **A31 ANALOG INPUT T. CABLE FAULT INTERRUPTED LEFT**

This alarm happens when the temperature converter located in the electrical board detects the cable of probe on the left side broken

The reasons can be:

- a) Cable damaged
- b) Probe damaged
- c) Converter damaged



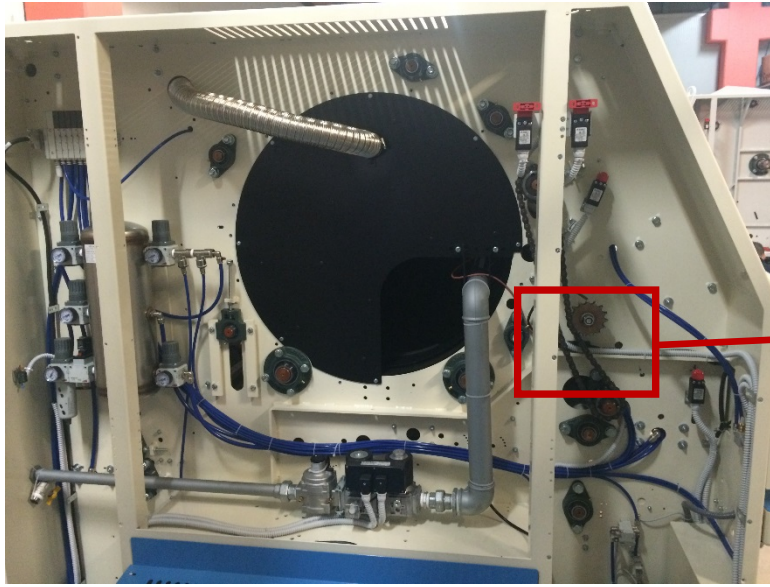


31) Problem : **A32 ANALOG INPUT T. CABLE FAULT INTERRUPTED RIGHT**

This alarm happens when the temperature converter located in the electrical board detects the cable of probe on the right side broken

The reasons can be:

- a) Cable damaged
- b) Probe damaged
- c) Converter damaged



32) Problem : **A33 –**

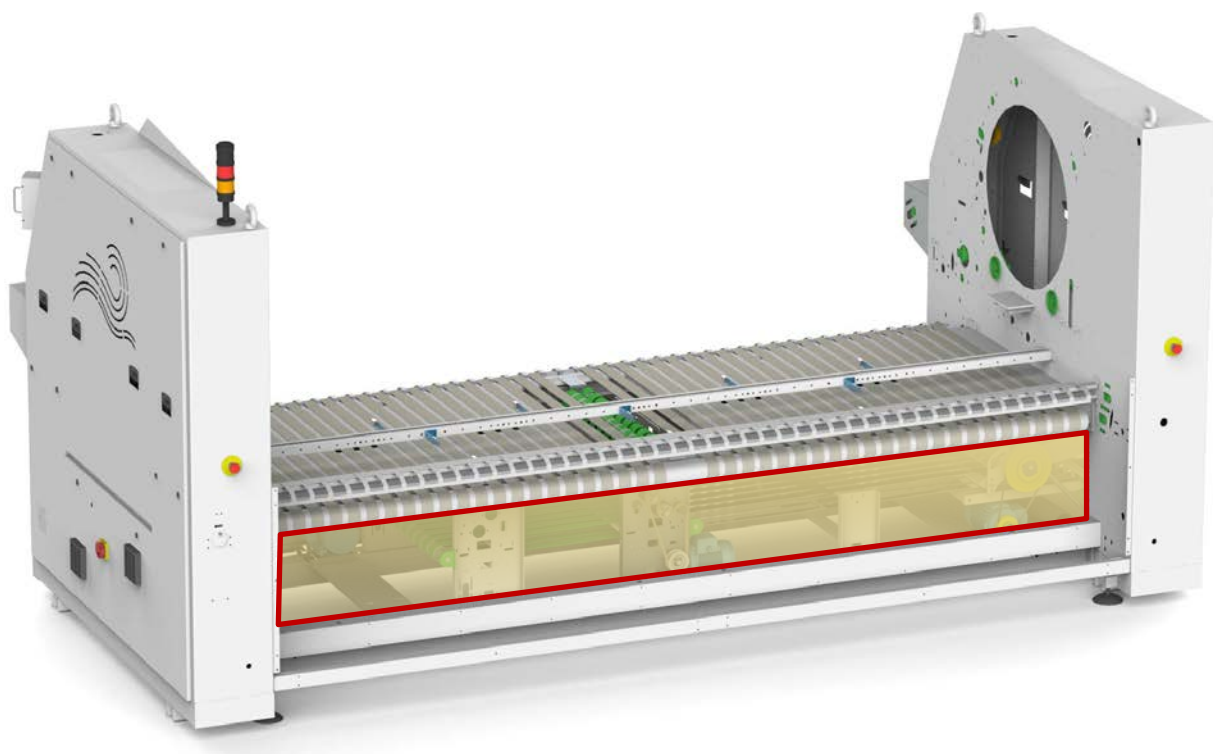
33) Problem : **A34 –**



34) Problem : **A35 ANOMALY JAMMED PIECE CROSSFOLDS**

This alarm happens when the machine detects a jammed piece on the crossfold fold
The reasons can be:

- a) Items too wet
- b) Item inserted with wrong working program
- c) Damaged linen
- d) Linen not suitable for the folding phase



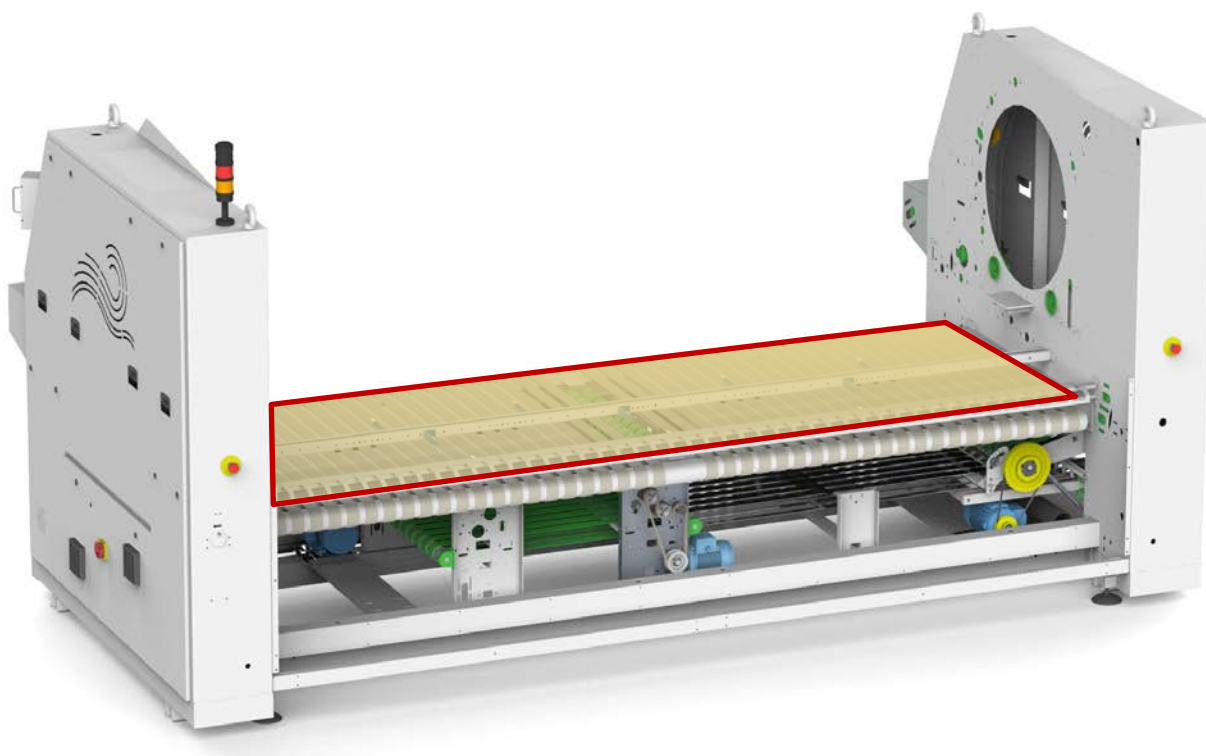


35) Problem : **A36 ANOMALY JAMMED PIECE FIRST CROSSFOLD**

This alarm happens when the machine detects a jammed piece on the first crossfold

The reasons can be:

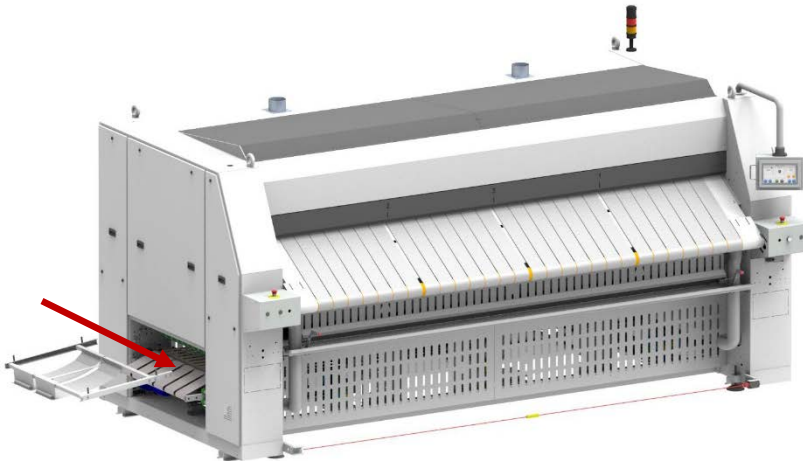
- a) Items too wet
- b) Item inserted with wrong working program
- c) Damaged linen
- d) Linen not suitable for the folding phase
- e) Activation time electrovalve first crossfold too low (Reg026)
- f) Electrovalve / membrane damaged
- g) Air jet pipe not in line with the rolls position



36) Problem : **A37 –**



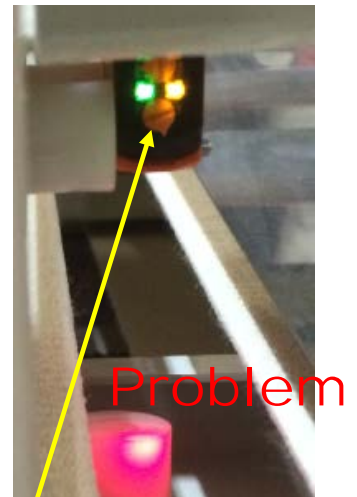
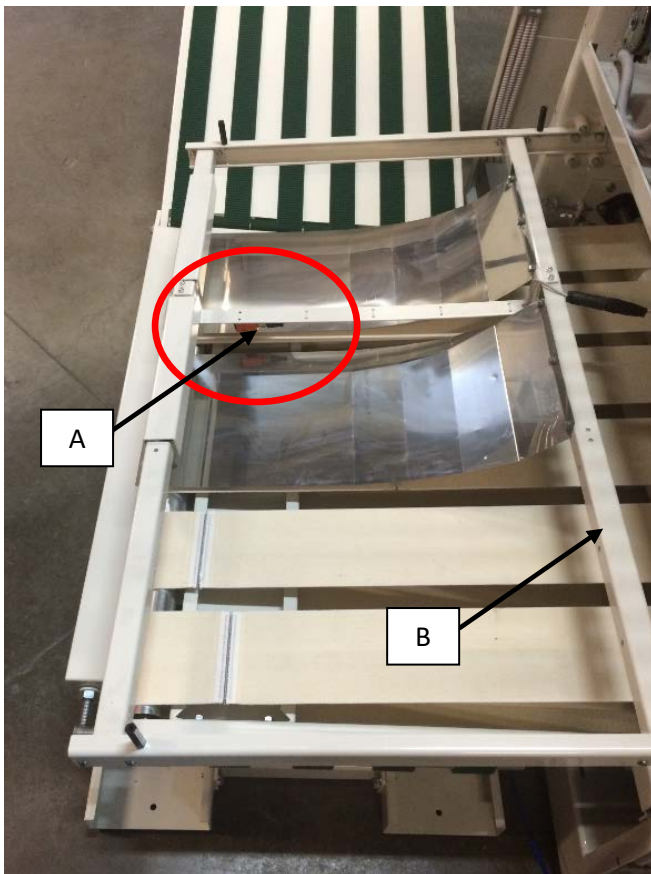
37) Problem : A38 ANOMALY STACKER SHOVEL FORWARD E6.4



Problem : A39 ANOMALY JAMMED PIECE ON STACKER PHOTOCEL E2.1

This alarm occurs when the photosensor (A) of the stacker roll off remains on
Possible reasons are:

- A) Bed sheet folded bad that stops under the photosensor without be discharged on the conveyor belt.
- B) Photosensor regulation with high sensibility
- C) Support (B) of the photosensor that goes down decreasing the distance with the reading point



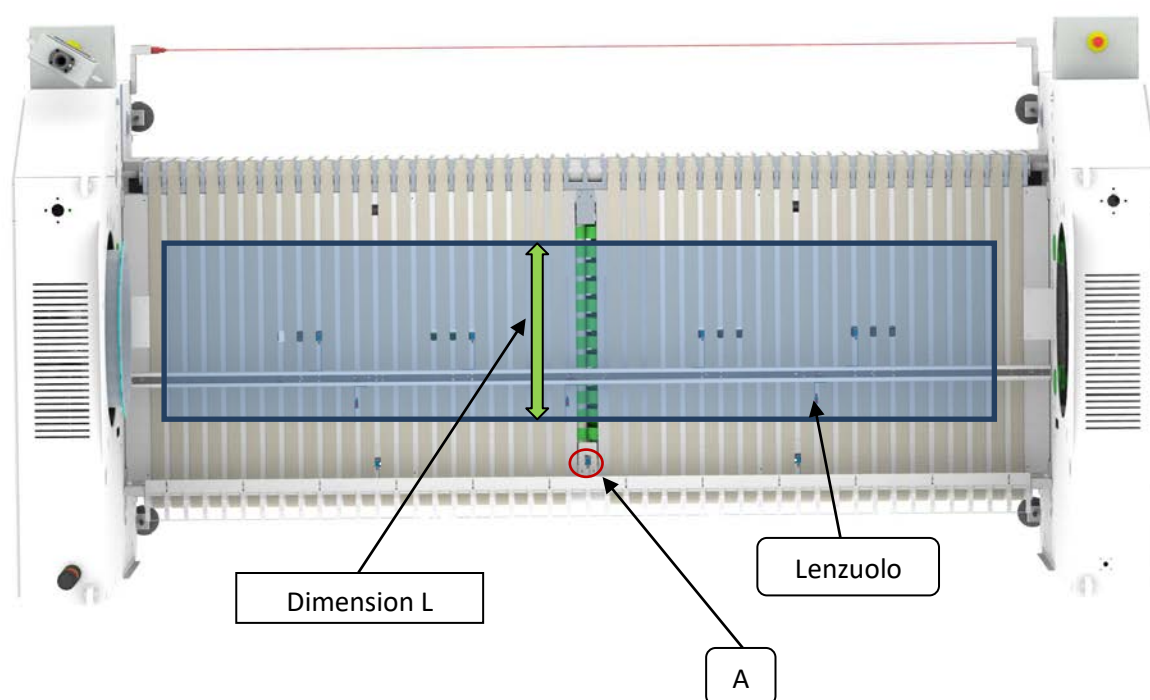
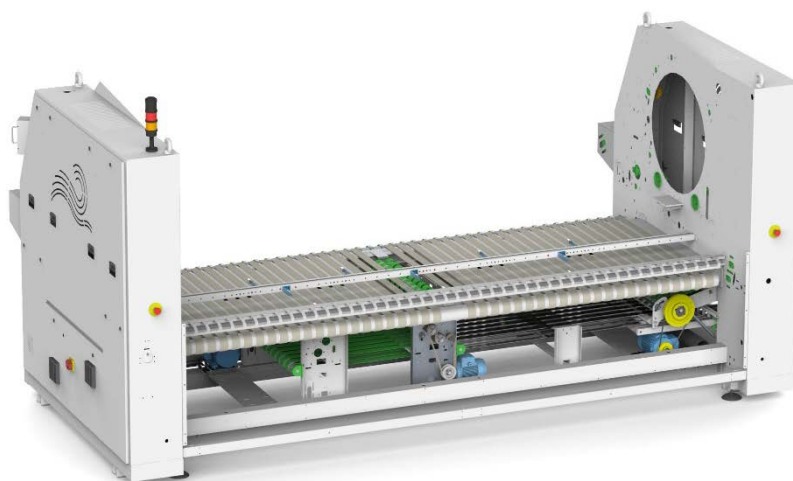
Regulation



- 38) Problem : **A40** -
- 39) Problem : **A41** -
- 40) Problem : **A42** -
- 41) Problem : **A43** -
- 42) Problem : **A44** -
- 43) Problem : **A45** -
- 44) Problem : **A46** -
- 45) Problem : **A47** -
- 46) Problem : **A48** -



47) Problem : **A49 ANOMALY DISCHARGED PIECE MAX LENGTH ON TABLE 1CFCE**



The errore A49 shows that the bed sheet in progress on the first crossfold table has the dimension L greater than the maximum allowed dimensions to be folded. This is a safety check to avoid line jam.

The maximum allowed dimension can be inserted on **REG034** for each program.

It is absolutely forbidden to change this parameter without manufacturer authorization.

The detected value can be read on the keyboard page **Data dimensions** and is detected by the photocell (A).

The error can be caused also by a wrong working of the photocel A, for example photocel not in line or dirt.



Data dimensions pieces in progress mm

	Left line	Central line	Right line
1ª Length fold	0	0	0
2ª Length fold	0	0	0
1ª Crossfold	0	0	0
Head shift phase	-	0	-
Tail shift phase	-	0	-
2ª Crossfold S	0	0	0
2ª Crossfold M	-	0	-
3ª Crossfold	0	0	0

←

The showed value is in mm, meanwhile the value to set on Reg034 is in impulses, (1impuls = 2,9 mm)

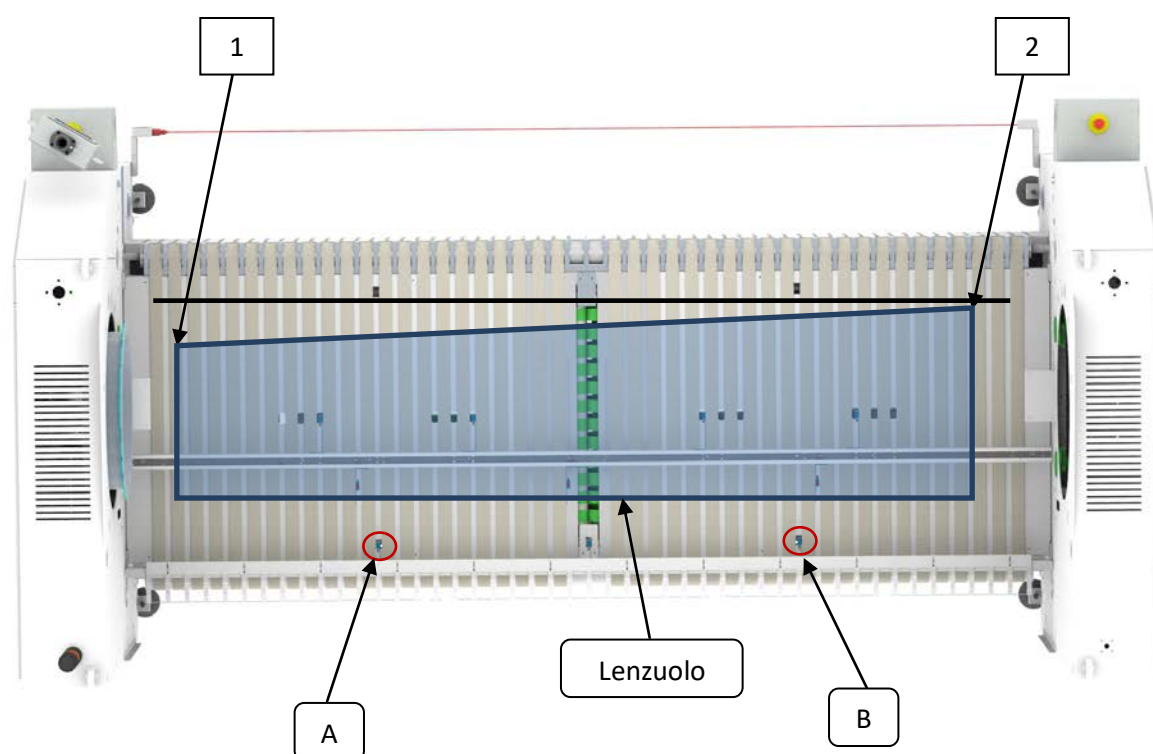
If the "not in line" exceeds this set value the linen piece is discharged without any crossfold.

Solution:

- 1) Check that the bed sheet is inserted in right way on the length folds checking that there isn't electrostatic current
- 2) Check the right measure on the second length fold
- 3) Check the photosensor (A)



48) Problem : **A50 ANOMALY DISCHARGED PIECE PHASE SHIFT FLAP HEAD**



The error A50 shows that the bed sheet in progress on the first crossfold table has the ends (1) and (2) not in line. This check is done by the photosensors (A) and (B)

The maximum "not in line" allowed can be set on **REG035** that the operator can choose for each program as he wants.

When the linen piece has a big "not in line", it is discharged to avoid any linen jam on the first crossfold. For this reason it's important set a right value and insert the linen as in right way as possible.

The "not in line" value can be detected from the machine and it can be read in the page **Data dimensions**





Data dimensions pieces in progress mm

	Left line	Central line	Right line
1ª Length fold	0	0	0
2ª Length fold	0	0	0
1ª Crossfold	0	0	0
Head shift phase	-	0	-
Tail shift phase	-	0	-
2ª Crossfold S	0	0	0
2ª Crossfold M	-	0	-
3ª Crossfold	0	0	0



The showed value is in mm, meanwhile the value to set on Reg035 is in impulses, (1impuls = 2,9 mm)

If the "not in line" exceeds this set value the linen piece is discharged without any crossfold.

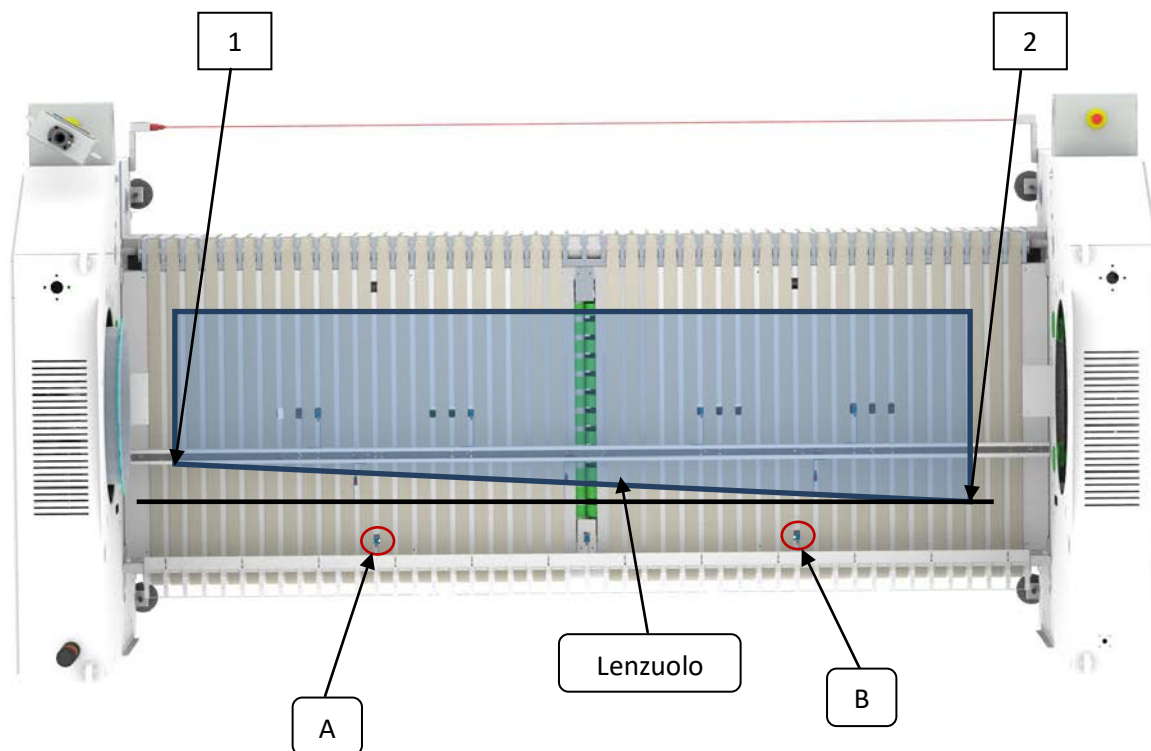
Solution:

- 1) Check the right insertion of the bed sheet on the second length fold
- 2) Check the right measure of the second length fold
- 3) Check the photosensors (A) and (B)



49) Problem : **A51 ANOMALY DISCHARGED PIECE PHASE SHIFT FLAP TAIL**

Back side machine view




The error A51 shows that the bed sheet in progress on the first crossfold table has the ends (1) and (2) not in line. This check is done by the photosensors (A) and (B)

The maximum "not in line" allowed can be set on **REG036** that the operator can choose for each program as he wants.

When the linen piece has a big "not in line", it is discharged to avoid any linen jam on the first crossfold. For this reason it's important set a right value and insert the linen as in right way as possible.


The "not in line" value can be detected from the machine and it can be read in the page **Data dimensions**





Data dimensions pieces in progress mm

	Left line	Central line	Right line
1ª Length fold	0	0	0
2ª Length fold	0	0	0
1ª Crossfold	0	0	0
Head shift phase	-	0	-
Tail shift phase	-	0	-
2ª Crossfold S	0	0	0
2ª Crossfold M	-	0	-
3ª Crossfold	0	0	0



The showed value is in mm, meanwhile the value to set on Reg036 is in impulses, (1impuls = 2,9 mm)

If the "not in line" exceeds this set value the linen piece is discharged without any crossfold.

Solution:

- 4) Check the right insertion of the bed sheet on the second length fold
- 5) Check the right measure of the second length fold
- 6) Check the photosensors (A) and (B)

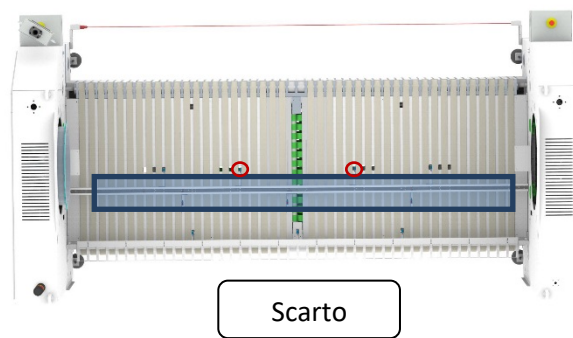
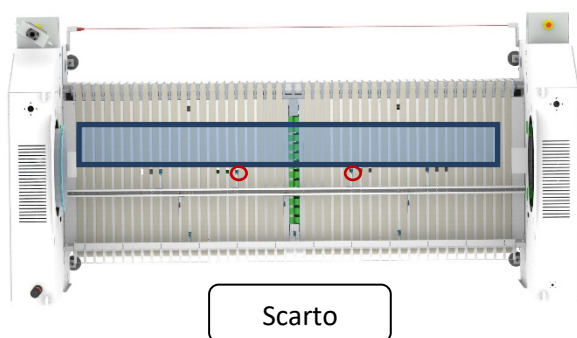
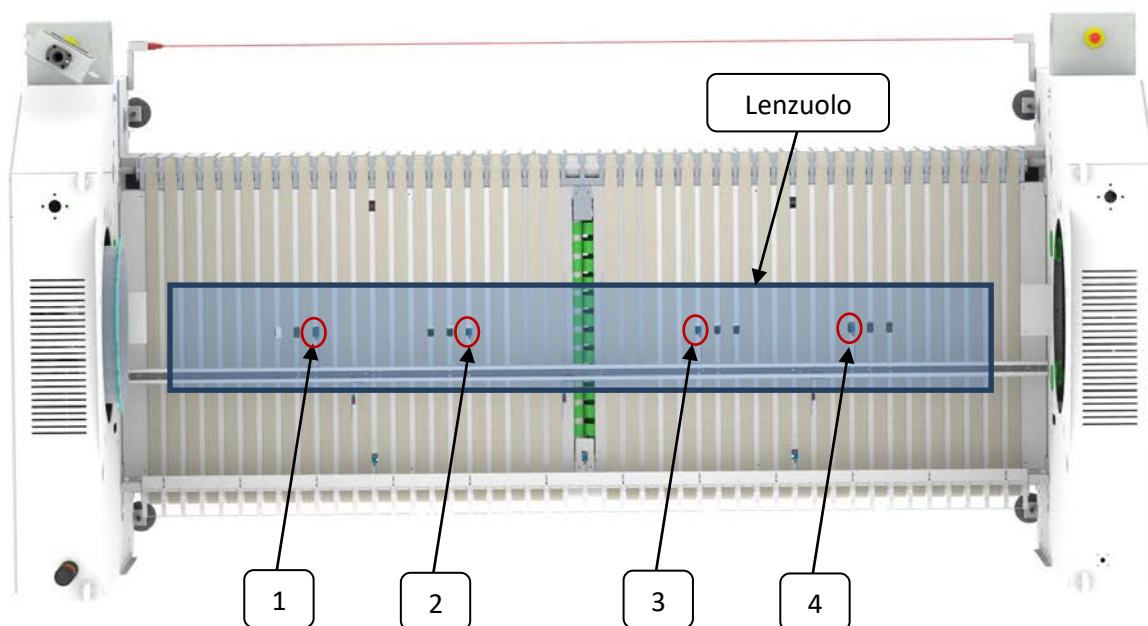


50) Problem : **A52 ANOMALY DISCHARGED PIECE FOR STOP CONTROL ON CROSSFOLDS TABLE**

This alarm happens when the stop command position of the piece on the crossfold table isn't correct. The pieces have to stop under the photocells 2 and 3, so the photocells can detect their width for the crossfold phase. If it isn't so, the piece is discharged and the alarm is generated.

Possible solution:

- a) Set Reg023 in order the piece stops under the photocells written above





51) Problem : **A53 ANOMALY DISCHARGED PIECE FOR FOLLOWING PIECE ON CROSSFOLDS TABLE**

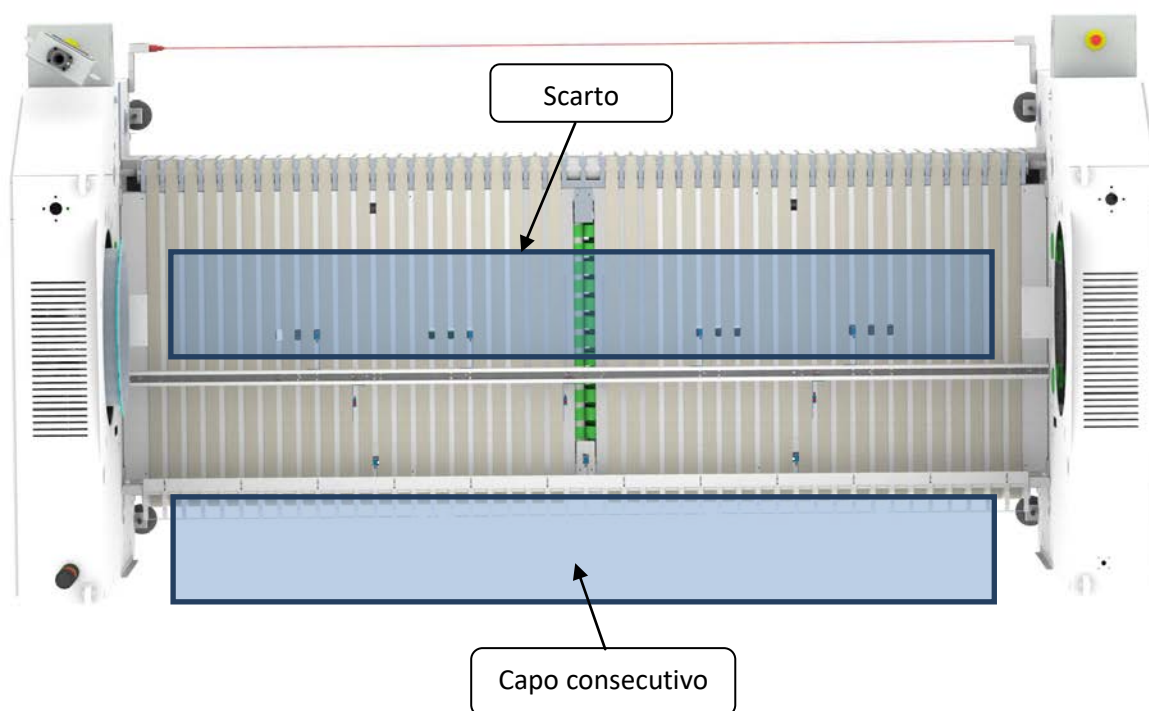
This alarm happens when a piece is stopped on the crossfolds table, waiting for be folded and another arrives soon after. To not generate jam problems the machine discharges the first piece of the series.

The reasons can be:

- a) Machine jam
- b) **Reg039**: Delay activation air jet 1^a crossfold CE too high

Possible solution:

- a) Increase the distance between an item and the following during the feeding phase
- b) Decrease **Reg039**





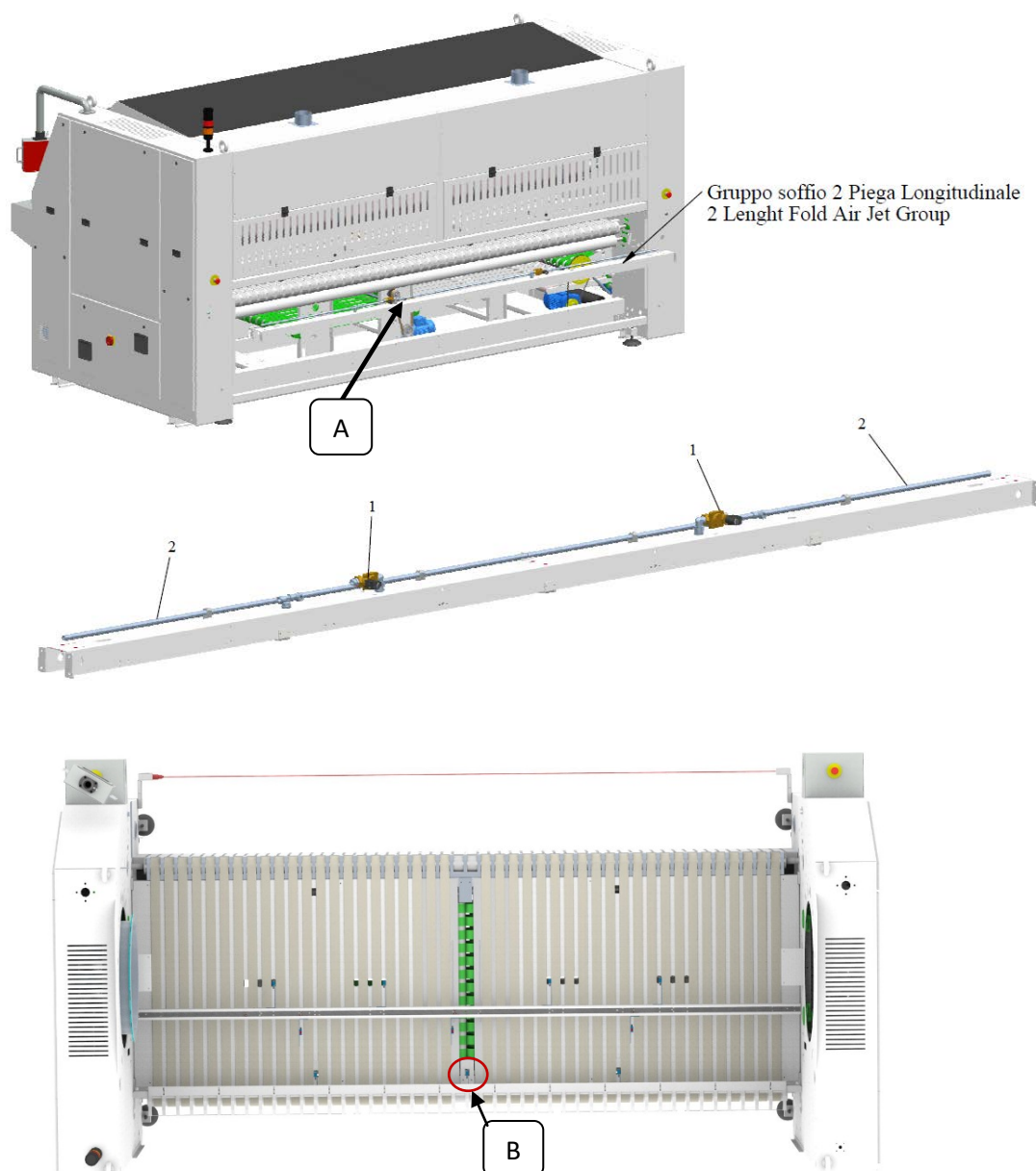
52) Problem : **A54 ANOMALY MISSING PIECE FIRST CROSSFOLD 1PTCE**

After that the air jets are activated on the second length fold (A), the machine does a check on the photosensor of the first crossfold (B).

If after 2 seconds from the air jet of the second length fold the photosensor doesn't view the bed sheet on the table activates the alarm A54 to say that the item isn't inserted on the crossfolds table.

Possible reasons are:

- A) Wrong lighting of the photosensor on feeding table. If the photosensor activates for any reason without the real presence of the linen, the alarm will on because on the crossfolds table there will not be any item.
- B) Because of electrostatic current problems the item doesn't the right working cycle and the machine does alarm.
- C) Check that the air jets of the second length fold work well to insert the linen between the rolls.





53) Problem : **A55 ANOMALY MISSING PIECE FIRST CROSSFOLD 1PTSX**

Uguale A54 cambiare linea

54) Problem : **A56 ANOMALY MISSING PIECE FIRST CROSSFOLD 1PTDX**

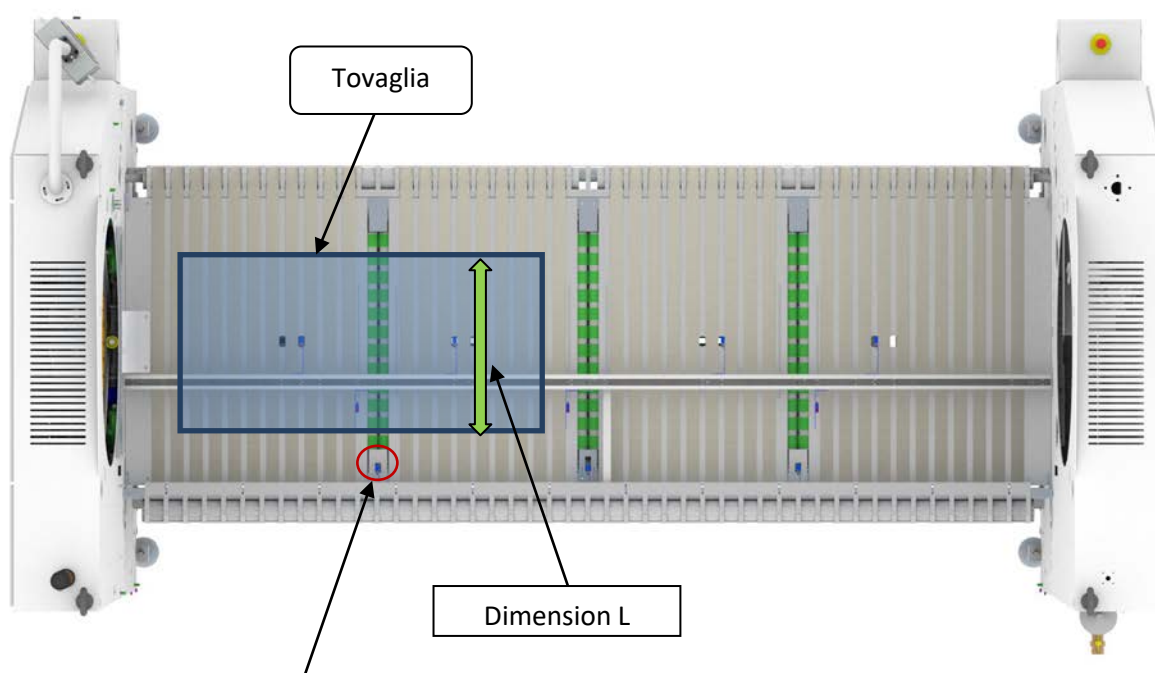
55)

Uguale A54 cambiare linea

56) Problem : **A57 –**

57) Problem : **A58 ANOMALY DISCHARGED PIECE MAX LENGTH ON TABLE 1CFLH**

Uguale A49 cambiare linea





A

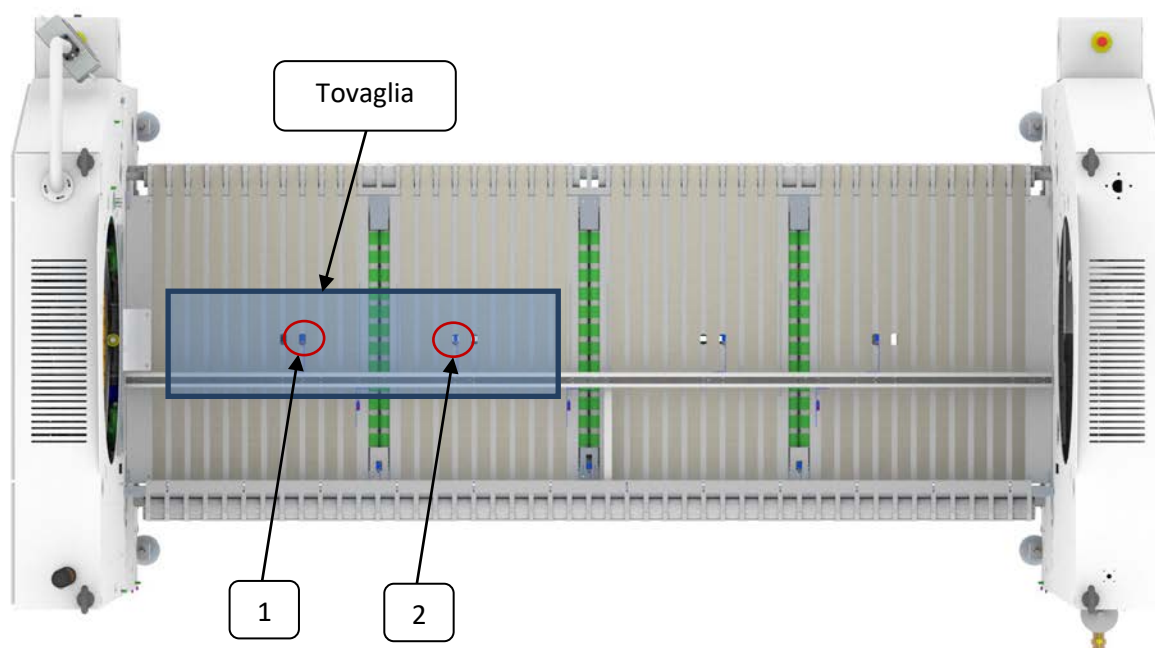
58) Problem : A59 ANOMALY DISCHARGED PIECE FOR STOP CONTROL ON CROSSFOLDS

TABLE LLH

This alarm happens when the the position of stop of the piece on the crossfold table isn't correct. The pieces have to stop under the photocells 1-2, if this doesn't happen the piece is discharged and following the alarm is generated

Possible solution:

- a) Set the Reg021 in order the piece stops undert the photocells written above





59) Problem : **A60 ANOMALY DISCHARGED PIECE FOR FOLLOWING PIECE ON CROSSFOLDS TABLE LLH**

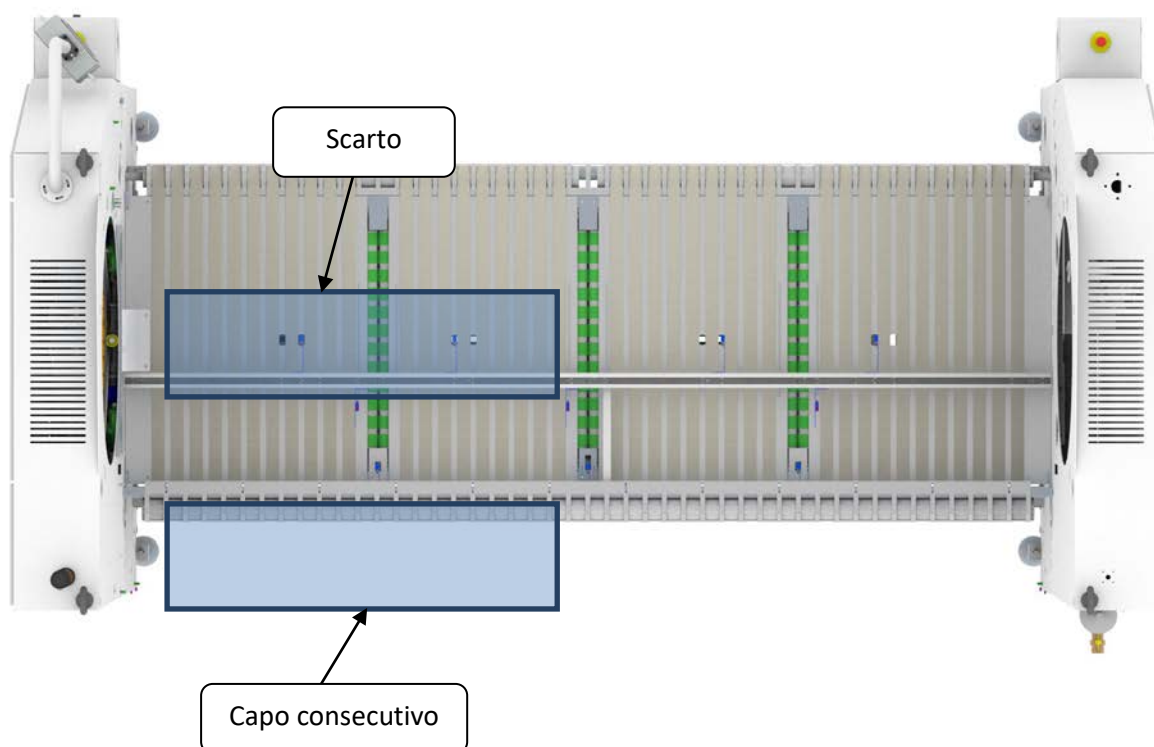
This alarm happens when on the crossfold table left lane there are more consecutive pieces. So to avoid jam problems the machine discharges the first piece of the series.

The reasons can be:

- a) Machine jam
- b) Semaphore times not correct

Possible solution:

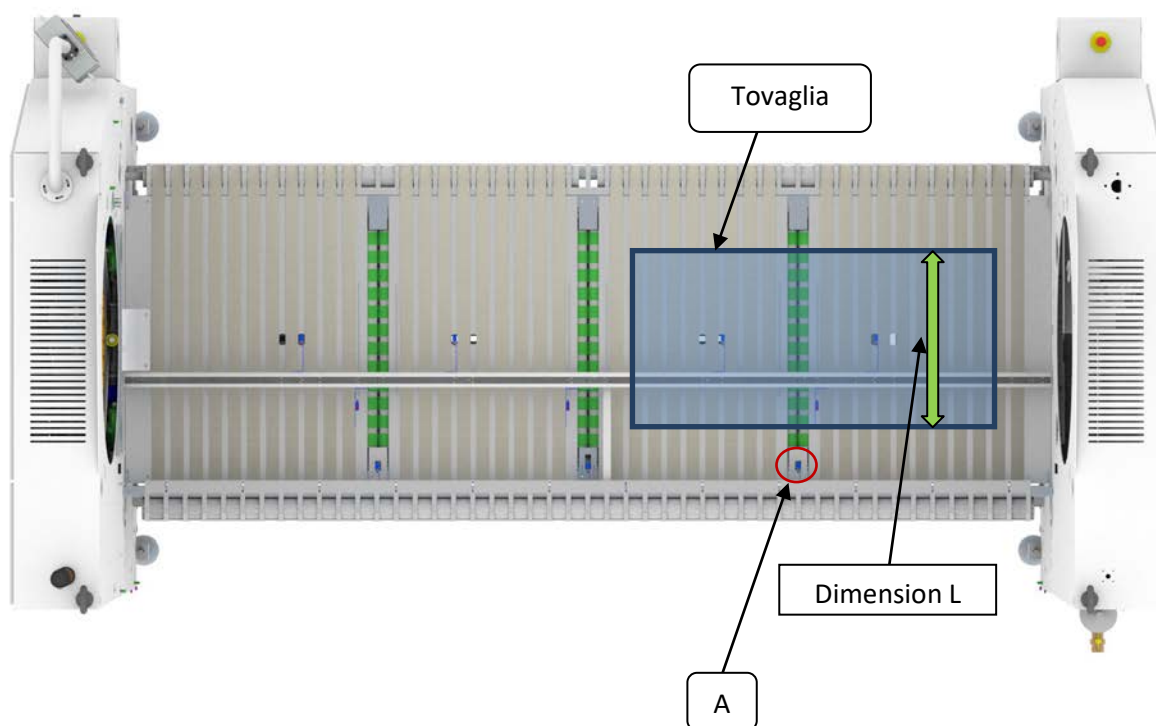
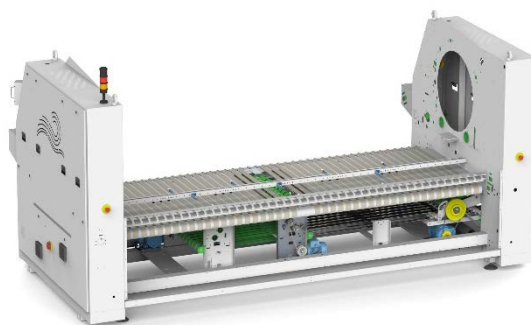
- a) Increase the distance between a piece and another during the feeding phase
- b) Check the set values on **Reg028** and **Reg029**
- c) Decrease **Reg037**





60) Problem : **A61 A ANOMALY DISCHARGED PIECE MAX LENGTH ON TABLE 1CFRH**

Uguale A49 cambiare linea



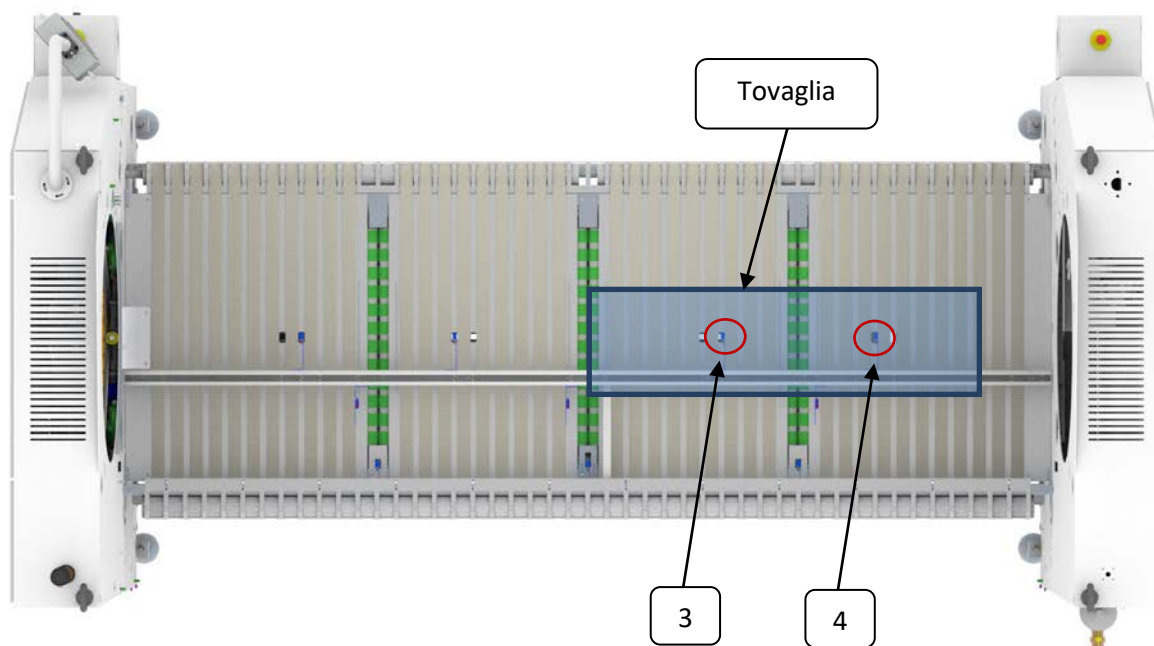


61) Problem : **A62 ANOMALY DISCHARGED PIECE FOR STOP CONTROL ON CROSSFOLDS**
TABLE LRH

This alarm happens when the position of stop of the piece on crossfold table isn't correct.
The pieces have to stop under the photocels 3-4. If this doesn't happen the piece is discharged and the alarm is generated

Possible solution:

- b) Set the Reg022 in order that the piece stops under the photocels written above





62) Problem : **A63 ANOMALY DISCHARGED PIECE FOR FOLLOWING PIECE ON CROSSFOLDS TABLE LRH**

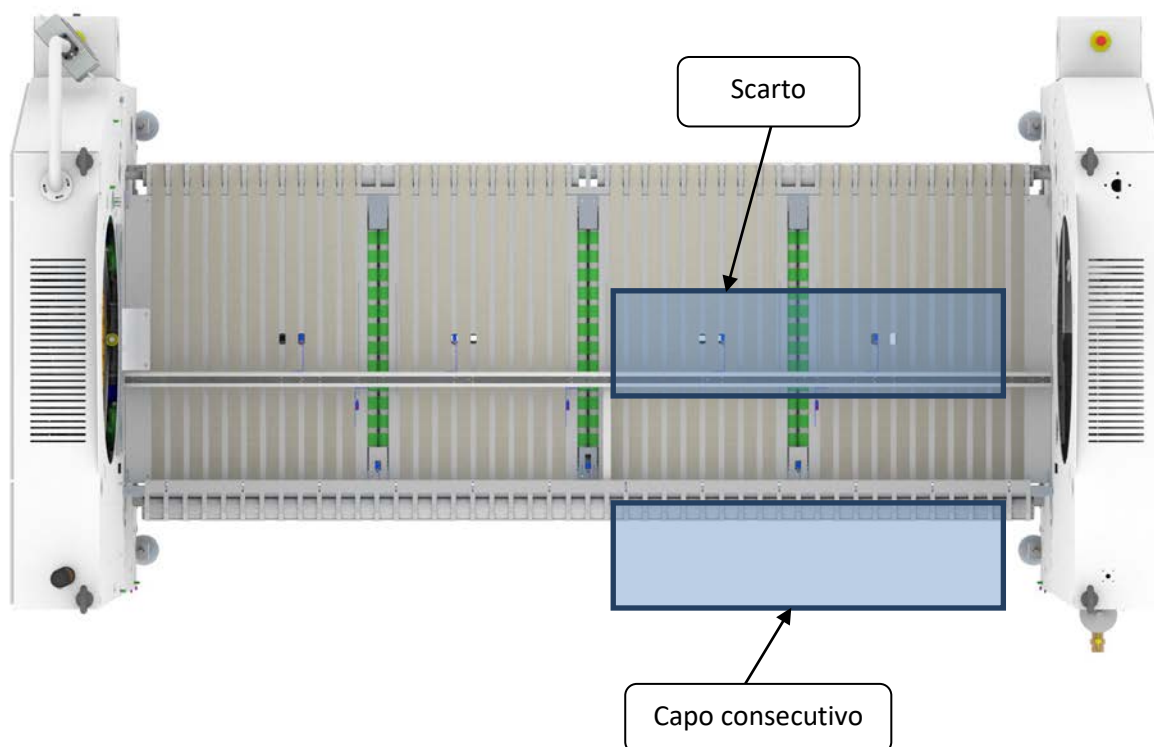
This alarm happens when on the crossfold table right lane there are more consecutive pieces. So to avoid jam problems the machine discharges the first piece of the series.

The reasons can be:

- a) Machine jam
- b) Semaphore times not correct

Possible solution:

- a) Increase the distance between a piece and another during the feeding phase
- b) Check the set values on **Reg028** e **Reg029**
- c) Decrease **Reg038**





63) Problem : **A97>>>A18 ANOMALIA SEMPRE ATTIVA FOTOCELLULA ...**

This alarm happens when with the program 0 (sensors control) one sensor is on, abnormal condition with the program 0 because this program isn't a working program and for this reason there shouldn't any piece in progress in the machine

The reasons can be:

- a) Sensor or photocel dirty
- b) Sensor or photocel not in line
- c) Piece jammed in the machine

To identify the active sensor use the **MAPPA FOTOCELLULE**

And by the page **Test Input** of the touchscreen identify the sensor/photocel active



Sensor not active



Sensor active

64) Problem : **M01 EMERGENCY ON**

65) Problem : **M02 PERFORM EMERGENCY RECOVERY**

66) Problem : **M03 PERFORM CYCLE START**

67) Problem : **M04 STOP AUTOMATIC CYCLE STOP AFTER COOLING**

