

## **Alarm 30: Nozzle fault**

The vacuum nozzle ball slide on vacuum machines is always monitored. If the limit switches do not function properly the alarm will be triggered.

This alarm is controlled by NOZ MOV TMO on the delays screen.  
MENU\HMI SYSTEM\DELAYS\VACUUM  
Value range 0 – 9.999. The default is 0.6 seconds.

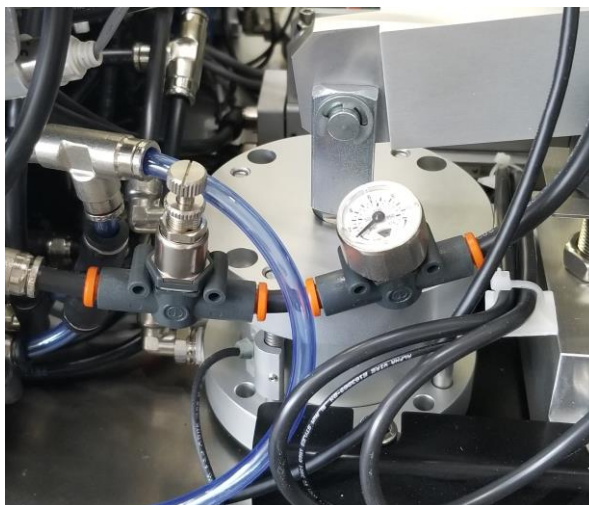
This alarm is disabled when all alarms are disabled.

### **Cause**

1. Nozzle got stuck between the jaw bars.
  - a. Low pressure set too high.  
The default low pressure is 7psi. 10psi is reasonable.
  - b. Nozzle dragging on jaw bar.
    - The black foam rubber may need to be replaced.
    - The gripper bars may be too far apart. Loosen the bolts securing the gripper bar. Hold the gripper bars to make them as close to each other as possible while re-tightening the bolts. These bolts should be tight to prevent the bars from moving apart from each other.



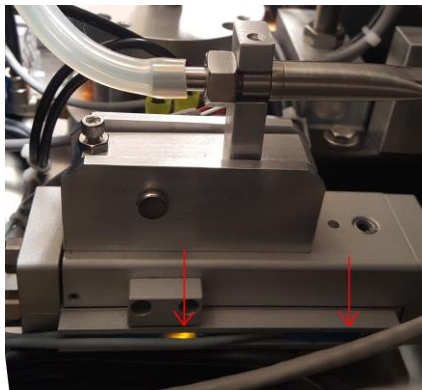
- c. Sample being vacuumed is sticky.
- Rotate the nozzle/s slightly to reduce the contact area
  - Reduce the vacuum level if possible
  - Increase the pressure to the ball slide. 40 - 60PSI is default.



2. Nozzle prevented from retracting fully.
  - a. Remove obstructions from the ball slide. Hoses and wires should be routed away from the ball slide.



3. Moved or faulty limit switch.
  - a. Check the limit switch functionality. (X9,X10) Y5 is the command for the ball slide.



*Disconnect all electrical and compressed air sources from the Heat Sealer before doing any maintenance work. Only qualified technicians should perform this work. Improper installation of the components may result in serious personal injury and damage to equipment. Call PackworldUSA Ltd if further information is needed.*