

Alarm 31: Initialize fault

This is an initial check of the machine. It is only active when the power to the system is first turned on.

1. Start button's pressed
2. Delay of 8 seconds to allow the machine to return to its starting position.
3. Status is verified and an alarm is thrown if failed.

Registers monitored.

INPUTS		OUTPUTS			
FOOT SWITCH	X0	X1	CLOSE BAR	Y2	
BAR CLOSED	X2	X3	START	C270	
BAR UP	X4		RESET	Y10	
ALARM	X5		AUTOCAL	C207	
NOZZLE HOME	X9		NOZZLE POS	Y5	
NOZZLE EXTEND	X10		VAC	C317	
VAC ACHIEVED	C230		PURGE	Y4	
PSI IN	7	PSI	PSI OUT	7	PSI
TC	22.3	°C	BAND TEMP	26	°C

BACK

1. Start 1 (X1) – OFF
2. Start 2 (X0) – OFF
3. Bar Open (X4) – ON, Except on the PW33XX series.
4. Bar Closed (X2,X3) – OFF

Vacuum machines.

5. Nozzle HOME (X9) – ON
6. Nozzle Extended (X10) – OFF
7. Vacuum achieved – OFF

The main cause of this alarm is no compressed air to the machine. Restore air prior to powering on the machine should resolve the issue.

A failed or moved limit switch is the other cause. Check all registers listed against the PLC to determine which limit switch is causing the problem.

When identified, a good test is to use a magnet to trigger the limit switch to see if the input comes ON, on the PLC. If it reacts properly to the magnet, then the position is not correct.

If the limit switch does not respond to the magnet, it will need to be replaced.



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.