

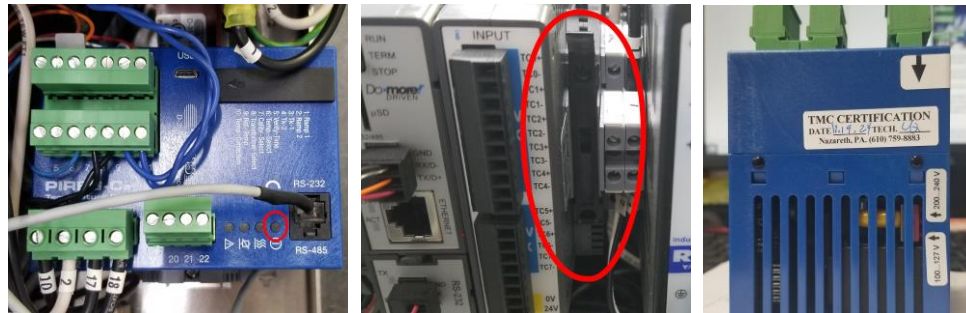
## Alarm 32: Communication fault

Each machine has a communication link between the PLC and heat seal controller. If this link is interrupted for more than 3 seconds this alarm will trigger.

This alarm cannot be disabled.

### Cause

1. The heat seal controller is not powered on.



Restore power to the heat seal controller. There is a fuse or breaker for the heat seal controller. Replace the fuse or reset the breaker.

If the heat seal controller has just been replaced, Make sure the voltage selection switch on the heat seal controller is set to the appropriate voltage. Default is 200VAC

2. The heat seal controller is set to the wrong baud rate.

This happens when a new controller is introduced. The baud rate from factory is only 9600. Power down the machine and re-start. (Power must be turned off completely. This alarm will trigger a re-initialization of the heat seal controller.)

(Security may need to be disabled to properly initialize the controller.)

3. Component failure.

Follow the cable from the Heat seal controller to the PLC. Where the cable connects to the PLC there should be lights which display the send and receive of the data port.



- a. Check the cable first for a broken wire.
- b. Observe the lights. Both should look like they are on solid. If they are both off, the communication module is likely the cause. If just the send is on, it is likely the cable.
- c. If just the send is on, it could be the heat seal controller. This is unlikely.

4. Mismatched components.

There are 2 different setups. RS232 and RS485. They are not interchangeable.

Standard Machine software version 6.50 or newer is RS485. The data cable can be identified with a heat shrunk resistor near the RJ12 connection. The module is also labeled.



*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.*