

Alarm 34: Bar move timeout

The jaw bar position is monitored constantly. If the jaw bar is open, the jaw open limit switch must be on.(except PW33XX machines). If the jaw bar is commanded to close, both limit switches need to be on before the time expires.

This alarm is controlled by BAR MOVE TMO on the delays screen. MENU\HMI SYSTEM\DELAYS Value range 0 – 9.999. The default is 2.000 seconds. This may need to be larger on some machines.

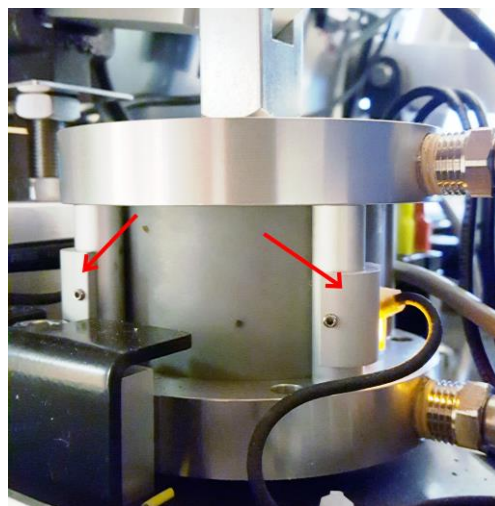
Cause

1. Incoming air pressure set below 4 psi.
Restore pressure to the machine.
2. Jaw open limit switch failed or out of position (x4).
Most of the limit switches we use have indicator lights on them. Use a magnet to see if the light comes on and the PLC is responding.
3. Jaw close limit switches out of position or failed (X2,X3).
Most of the limit switches we use have indicator lights on them. Use a magnet to see if the light comes on and the PLC is responding. If the limit switches are responding, then the position will need to be set.

We typically set the limit switches so that if an obstruction of 2mm or more are between the jaw bars the machine will not go into high pressure and this alarm will occur and the jaw bars will then return to the starting position.

The jaw close limit switches also should remain on when the machine goes into high pressure.

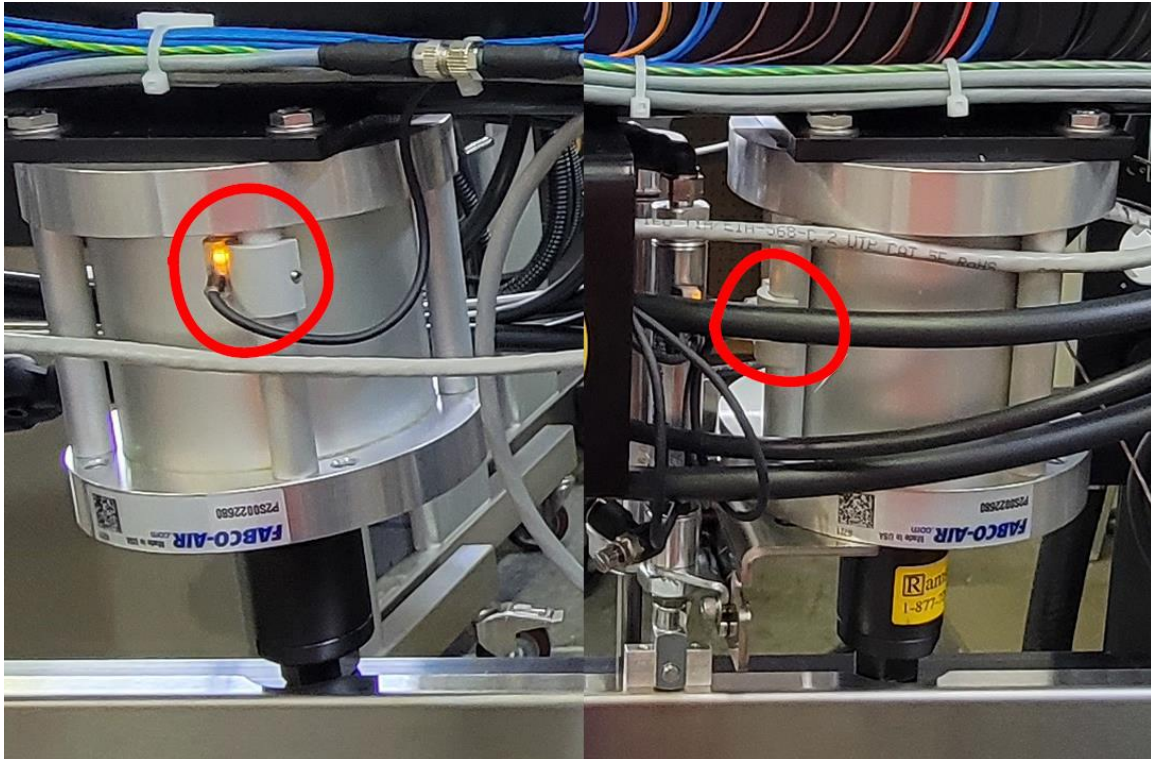
PW3400 series limit switch\’s location. The other cylinder has only one limit switch. 3 total.
PW4400 series machines are similar but the cylinder is extended at idle, so the jaw open limit switch is on the top instead of the bottom.



PW3000 series machines have only one limit switch to detect jaw close and it is usually located on the right of the machine.



PW5000 series machines have 3 limit switches. The 2 jaw close limit switches are on the outer cylinders. The Jaw open is located on one of the inner cylinders.



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.