

Alarm 36: Heatup fault

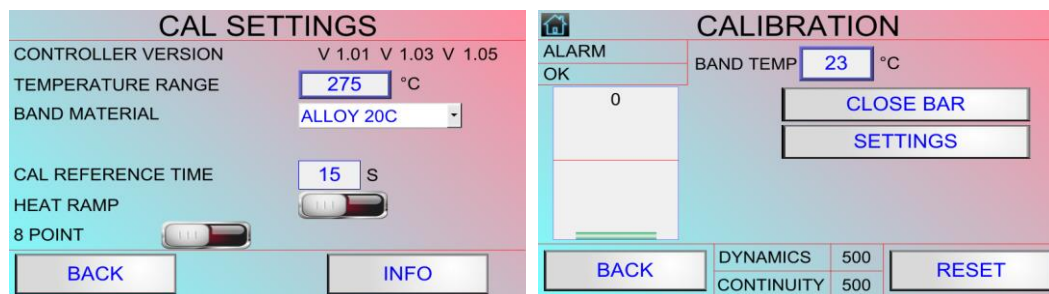
This alarm will trigger if the heat seal band fails to reach temperature in time. This is monitoring the heat phase of the sealing cycle only.

This alarm is controlled by HEAT TMO on the delays screen. MENU\HMI SYSTEM\DELAYS
Value range 0 – 9.999. The default is 5.00 seconds.

This alarm is disabled when all alarms are disabled.

Cause

1. Alarm delay set too low.
It takes from .4 seconds to 1 second for the heat seal band to heat to temperature. (Higher temperatures may require more time) A setting of less than 1 second will trigger this alarm.
2. Heat seal controller is not initialized properly.
Go to settings MENU\CALIBRATE\SETTINGS. Just going to this screen will prompt the machine to re-initialize the controller. Then go to MENU\CALIBRATE and run an Autocal.



3. Transformer voltage set too low. (this is unlikely unless the lowest tap is used and the band length has been lengthened greatly)



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.