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## Parameters and alarms

# MobicsFold V0201

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# 1) Machineparameters

## 1.1) Overview machine parameters

- 01 Folddistance 1st length with wheel
- 02 Folddistance 1st length, no wheel
- 03 Bypassdistance 1st length with wheel
- 04 Bypassdistance 1st length, no wheel
- 05 Folddistance 2nd lengthfold
- 06 Bypassdistance 2nd lengthfold
- 07 Folddistance extra lengthfold
- 08 Bypassdistance extra lengthfold
- 09 Bypass blowtime venturi extra length
- 10 Distance 1st cross to 2nd cross pc.
- 11 Folddistance 2nd crossfold
- 12 Distance to stacker 1
- 13 Distance to stacker 2
- 14 Distance to stacker 1, right side
- 15 Distance to stacker 2, right side
- 16 Decisionpoint make 2nd crossfold
- 17 Reserved
- 18 Reserved
- 19 Reserved
- 20 Minimum piece length
- 21 Moment fingers back extra lengthfold
- 22 Use first mechanical bypass
- 23 Use second mechanical bypass
- 24 Moment switch first bypass
- 25 Moment switch second bypass
- 26 Reserved
- 27 Reserved
- 28 Reserved
- 29 Reserved
- 30 Maximum length at small piece stacker
- 31 Conveyor time small piece stacker
- 32 Extra turn time small piece stacker
- 33 Delay start conveyor small piece stacker
- 34 Delay start knife small piece stacker
- 35 Relative speed AMD (%)
- 36 Distance 2nd length to stacker photocell
- 37 Reserved
- 38 Reserved
- 39 Reserved
- 40 Maximum length at sheet stacker
- 41 Conveyortime sheetstacker normal
- 42 Conveyortime sheetstacker with button
- 43 Extra turn time sheetstacker
- 44 Delay start conveyor sheetstacker
- 45 Time move conveyor up sheetstacker
- 46 Transporttime throw out piece at stacker
- 47 Delay stop transport/open stacker flaps
- 48 Time open flaps sheetstacker
- 49 Reserved
- 50 Ironer length
- 51 Maximum speed of feeder
- 52 Minimum speed of ironer
- 53 Maximum speed of ironer
- 54 Maximum speed of folder

55 Maximum speed of feeding unit beam  
56 Speed of central conveyor  
57 Length of central conveyor  
58 Max run time conveyor after stacker  
59 Run time put stack on central conveyor  
60 Max. piecelength at 1st lengthfold  
61 Max. piecelength at 2nd lengthfold  
62 Reserved  
63 Reserved  
64 Reserved  
65 Location to reject dirty pieces  
66 Location to reject broken pieces  
67 Maximum number of pieces in ironer  
68 Pieces until wax cloth warning  
69 Type of speedcontrol  
70 Handling of a crossfold alarm  
71 Speed of the crossfold  
72 Distance between pieces at stacker  
73 Reverse stacker selection  
74 Delay start knife 1st crossfold  
75 Time knife down 2nd crossfold  
76 Delay reverse 2nd cross after knife  
77 Time blowpipe 2nd crossfold  
78 Reserved  
79 Reserved  
80 Reaction time 1st lengthfold  
81 Reaction time 2nd lengthfold  
82 Reaction time extra lengthfold  
83 Reaction time 1st crossfold  
84 Reaction time 2nd crossfold  
85 Reaction time 3rd crossfold  
86 Reaction time knife sheetstacker  
87 Reaction time small piece stacker  
88 Reserved  
89 Reserved  
90 Pulse size ironercountwheel  
91 Pulse size maincountwheel  
92 Pulse size lanecountwheel  
93 Reserved  
94 Reserved  
95 Reset counters without password  
96 Automatic reset of warnings  
97 Always try to use 1st crossfold  
98 Stacker/conveyor work independent  
99 Reserved  
100 CAN-bus stationnumber this PLC  
101 CAN-bus baudrate  
102 Delay return to home screen  
103 Reserved  
104 Reserved  
105 Signal time if customer/article change  
106 Reserved  
107 Reserved  
108 Reserved  
109 Reserved  
110 Reserved

## **1.2) Machine parameters details**

### **01 Folddistance 1st length with wheel**

The distance from the photocell of the 1st lengthfold to the folding point of the first lengthfold on lanes with their own counting wheel.

### **02 Folddistance 1st length, no wheel**

The distance from the photocell of the 1st lengthfold to the folding point of the first lengthfold on lanes with no own counting wheel.

### **03 Bypassdistance 1st length with wheel**

The distance from the photocell of the 1st lengthfold to the bypass point of the first lengthfold on lanes with their own counting wheel.

### **04 Bypassdistance 1st length, no wheel**

The distance from the photocell of the 1st lengthfold to the bypass point of the first lengthfold on lanes with no own counting wheel.

### **05 Folddistance 2nd lengthfold**

The distance to the folding point of the 2nd lengthfold.

### **06 Bypassdistance 2nd lengthfold**

The distance to the bypass point of the 2nd lengthfold.

### **07 Folddistance extra lengthfold**

The distance from the 1<sup>st</sup> lengthfold to the folding point of the extra lengthfold. The extra lengthfold is the fold between the 1<sup>st</sup> and 2nd lengthfold.

### **08 Bypassdistance extra lengthfold**

The distance from the 1<sup>st</sup> lengthfold to the bypass point of the extra lengthfold. The extra lengthfold is the fold between the 1<sup>st</sup> and 2nd lengthfold.

### **09 Bypass blowtime venturi extra length**

Time/distance the venture of the extra lengthfold is activated in case of bypass. Time/distance in main countwheel pulses.

### **10 Distance 1st cross to 2nd cross pc.**

The distance from the stoppositionphotocell(s) of the 1st crossfold to the photocell of the 2nd crossfold. Use to adjust with measurement (together with parameter 71).

### **11 Folddistance 2nd crossfold**

The distance from the 2<sup>nd</sup> crossfold photocell to the folding point of the 2<sup>nd</sup> crossfold. Adjust only when the measured length is ok (see parameters 10 and 71).

### **12 Distance to stacker 1**

The distance from the photocell of the stacker(s) on the left or only side to the folding point of the 1st stacker (stacker 1).

### **13 Distance to stacker 2**

The distance from the photocell of the stacker(s) on the left or only side to the folding point of the 2nd stacker (stacker 2).

### **14 Distance to stacker 1, right side**

The distance from the photocell of the stacker(s) on the right feed-out side to the folding point of the 1st stacker (stacker 3).

### **15 Distance to stacker 2, right side**

The distance from the photocell of the stacker(s) on the right feed-out side to the folding point of the 2nd stacker (stacker 4).

#### **16 Decisionpoint make 2nd crossfold**

The moment the 2nd crossfold flap decides to fold the piece or not in case of an automatic fold. This is the moment the flap of the 2nd crossfold goes up in case of a no-fold.

#### **20 Minimum piece length**

The minimum length in cm a piece must have to be handled as a piece. This parameter can be used to suppress the photocell of the 1st lengthfold in case a belt covers this photocell accidentally.

#### **21 Moment fingers back extra lengthfold**

The moment before the foldposition that the fingers of the extra lengthfold are sent back. The higher the value, the earlier the fingers will go back.

#### **22 Use first mechanical bypass**

When this parameter is on 1, the program will determine if the mechanical bypass can be switched on. A value of 0 means that, in case of bypass, the blowpipes are used.

#### **23 Use second mechanical bypass**

When this parameter is on 1, the program will determine if the mechanical bypass can be switched on. A value of 0 means that, in case of bypass, the blowpipes are used.

#### **24 Moment switch first bypass**

The moment the bypass is switched on or off. The higher the value, the earlier the mechanical bypass will be switched.

#### **25 Moment switch second bypass**

The moment the bypass is switched on or off. The higher the value, the earlier the mechanical bypass will be switched.

#### **30 Maximum length at small piece stacker**

Maximum length in cm a piece can have at the small piece stackers. Pieces longer than this length will not be stacked.

#### **31 Conveyor time small piece stacker**

The time (steps of 0,01s) the conveyor of a small piece stacker is activated in case of shifting a stack.

#### **32 Extra turn time small piece stacker**

When the clamp of a small piece stacker passes the reed switch of the upper position, it will continue to turn for the time adjusted here, until it returns. Time is in steps of 0,01s.

#### **33 Delay start conveyor small piece stacker**

When a stack on a small piece stacker has reached the adjusted height, this is the delay before shifting the conveyor. This delay allows the clamp to return far enough before the conveyor is started. Steps of 0,01s.

#### **34 Delay start knife small piece stacker**

The delay between stopping the belts of a small piece stacker and starting the knife. Steps of 0,01s.

#### **35 Relative speed AMD (%)**

The relative speed of the belts of the small piece stackers, in relation to the speed of the main motor (value in %).

#### **36 Distance 2nd length to stacker photocell**

The distance in cm from the 2nd lengthfold to the photocell of the small piece stacker. In case of stackers with start/stopbelts, this parameter is also the moment the belts are started.

#### **40 Maximum length at sheet stacker**

Maximum length in cm a piece can have at the sheetstackers. Pieces longer than this length will not be stacked.

**41 Conveyortime sheetstacker normal**

The time (steps of 0,01s) the conveyor of a sheetstacker is activated in case of shifting a stack when the stacking height is reached.

**42 Conveyortime sheetstacker with button**

The time (steps of 0,01s) the conveyor of a sheetstacker is activated in case of shifting a stack when the button for feeding off is pushed.

**43 Extra turn time sheetstacker**

When the clamp of a sheetstacker passes the reed switch of the upper position, it will continue to turn for the time adjusted here, until it returns. Time is in steps of 0,01s.

**44 Delay start conveyor sheetstacker**

When a stack on a sheetstacker has reached the adjusted height, this is the delay before shifting the conveyor. This delay allows the piece to be on the stack before the conveyor is started. Steps of 0,01s.

**45 Time move conveyor up sheetstacker**

When shifting off, this is the time the conveyor is sent up, before the conveyor motor is started. Steps of 0,01s. Value 0 means don't wait with start of conveyor.

**46 Transporttime throw out piece at stacker**

When a piece is rejected at the sheetstacker, this is the time the motor is activated to throw out the piece. Steps of 0,01s.

**47 Delay stop transport/open stacker flaps**

The delay between stopping the motor and opening the flaps of the sheetstacker. Steps of 0,01s.

**48 Time open flaps sheetstacker**

The time the flaps of a sheetstacker will be activated to stack a piece. Steps of 0,01s.

**50 Ironer length**

The length of the ironer in centimeters. Is used for changing speed, changing program and for the reject system.

**51 Maximum speed of feeder**

The speed of the feeding machine when 10 Volts is sent to the inverter. Is the maximum speed the feeding machine can run.

**52 Minimum speed of ironer**

The speed of the ironer when 0V is sent to the inverter. This is the minimum speed the ironer can run when it's operating.

**53 Maximum speed of ironer**

The speed of the ironer when 10Volts is sent to the inverter. Is the maximum speed the ironer can run.

**54 Maximum speed of folder**

The maximum speed of the folding machine in steps of 0,1 meters/minute. Is used to be able to control the speed of the folder in the right way.

**55 Maximum speed of feeding unit beam**

The maximum speed of the beam of the feeding unit in 0,1 meters/minute. Is used to be able to control the speed during laying down in the right way.

**56 Speed of central conveyor**

The speed of the central conveyor in meters/minute. Is used to calculate when there are stacks in front of a telescope conveyor.

**57 Length of central conveyor**

The length of the central conveyor in steps of 10 cm.

**58 Max run time conveyor after stacker**

Maximum time conveyor after stacker runs. When no stack is detected with the photocell after running for this time, the conveyor stops. Steps of 0,01s.

**59 Run time put stack on central conveyor**

The time the telescopes are activated when putting a stack on the conveyor. In case of bufferbelts, the time the motor runs when a stack has to be put onto the conveyor. Steps of 0,01s.

**60 Max. piecelength at 1st lengthfold**

When, at the 1st lengthfold, a piece is detected which exceeds the length adjusted in this parameter, the folder will go in alarm. Steps of centimeters.

**61 Max. piecelength at 2nd lengthfold**

When, at the 2nd lengthfold, a piece is detected which exceeds the length adjusted in this parameter, the folder will go in alarm. Steps of centimeters.

**65 Location to reject dirty pieces**

The location where dirty pieces are rejected.

- 0 = Don't reject
- 1 = Drop at 1st lengthfold
- 2 = Don't crossfold
- 3 = Don't stack

**66 Location to reject broken pieces**

The location where broken pieces are rejected.

- 0 = Don't reject
- 1 = Drop at 1st lengthfold
- 2 = Don't crossfold
- 3 = Don't stack

**67 Maximum number of pieces in ironer**

The maximum number of pieces in the ironer. When the feeder has fed this number of pieces and no pieces were detected at the folder, the machine will be stopped. A value of 0 disables this watchdog function.

**68 Pieces until wax cloth warning**

This parameter indicates after how many pieces the machine should give a warning that it's time for the wax cloth. Value 0 means that the warning is disabled.

**69 Type of speedcontrol**

With this parameter the type of speed control can be configured.

- 0 = No speed control
- 1 = Folder follows ironer with ironer countwheel
- 2 = Folder controls complete ironer street

**70 Handling of a crossfold alarm**

Handling of a crossfold alarm.

- 0 = Stop on 1st fault.
- 1 = Stop on 2nd fault.

**71 Speed of the crossfold**

The speed of the crossfold in 0,1 m/min. Use this parameter to adjust the measured width (in combination with parameter 10).

**72 Distance between pieces at stacker**

Piece will wait at the 1st crossfold until the previous piece has passed this crossfold for the time adjusted in this parameter.



### **73 Reverse stacker selection**

A value of 0 means that in case of automatic stacker selection, the largest pieces will be stacked on the 2nd stacker. A value of 1 inverts this selection.

### **74 Delay start knife 1st crossfold**

The delay between stopping the belts of the 1st crossfold and starting the knife. So, this is the time the 1st crossfold belts need to stop (steps of 0,001s).

### **75 Time knife down 2nd crossfold**

The time the knife of the 2nd crossfold (only on center lane) is activated. Steps of 0,01s.

### **76 Delay reverse 2nd cross after knife**

Delay between starting the knife/blowpipe and reversing the belts of the 2nd crossfold. In case of a knife, the moment of reversing should be when knife reaches downposition. Steps of 0,001s.

### **77 Time blowpipe 2nd crossfold**

The time the blowpipe of the 2nd crossfold (only on center lane) is activated. Steps of 0,01s.

### **80 Reaction time 1st lengthfold**

The time the blowpipes of the 1st lengthfold need to make the fold. (0,001s). ATTENTION!!!  
By changing this parameter in the wrong way, the machine can stop working.

### **81 Reaction time 2nd lengthfold**

The time the blowpipes of the 2nd lengthfold need to make the fold. (0,001s). ATTENTION!!!  
By changing this parameter in the wrong way, the machine can stop working.

### **82 Reaction time extra lengthfold**

The time the blowpipes of the extra lengthfold need to make the fold. (0,001s). ATTENTION!!!  
By changing this parameter in the wrong way, the machine can stop working.

### **83 Reaction time 1st crossfold**

The time the belts of the 1st crossfold need to stop.(steps of 0,001s). ATTENTION!!!  
By changing this parameter in the wrong way, the machine can stop working.

### **84 Reaction time 2nd crossfold**

The time the belts of the 2nd crossfold need to reverse. (steps of 0,001s). ATTENTION!!!  
By changing this parameter in the wrong way, the machine can stop working.

### **85 Reaction time 3rd crossfold**

The time the knife of the 3rd crossfold needs to go to up. (steps of 0,001s). ATTENTION!!!  
By changing this parameter in the wrong way, the machine can stop working.

### **86 Reaction time knife sheetstacker**

The time the knife of the sheetstacker needs to go to up. (steps of 0,001s). ATTENTION!!!  
By changing this parameter in the wrong way, the machine can stop working.

### **87 Reaction time small piece stacker**

The time a small piece stacker needs to pick up a piece, in steps of 0,001s. ATTENTION!!!  
By changing this parameter in the wrong way, the stacker can stop functioning.

### **90 Pulse size ironercountwheel**

The size of a pulse of the ironer countwheel in steps of 0,1mm. ATTENTION!!! Changing this parameter can cause a complete machine stop.

### **91 Pulse size maincountwheel**

The size of a pulse of the main countwheel in micrometers. ATTENTION!!! Changing this parameter can cause a complete machine stop.

**92 Pulse size lanecountwheel**

The size of a pulse of the lane countwheel in micrometers. ATTENTION!!! Changing this parameter can cause a complete machine stop.

**95 Reset counters without password**

When this parameter has a value of 1, counters per program can be reset without the need of a password.

**96 Automatic reset of warnings**

A value of 1 means that warnings are automatically reset when the next piece doesn't cause the warning. In case of a value of 0, warnings can only be reset with the startbutton on the control panel.

**97 Always try to use 1st crossfold**

A value of 1 means that the 1st crossfold will be made when possible (e.g. in case of 4 lanes and only lane 2 and 3 coupled). In case of value 0, all lanes have to be coupled to crossfold.

**98 Stacker/conveyor work independent**

A value of 1 means stacking/conveyor while conveyor/stacking busy. A value of 0 means that the conveyor and stacker will not wait for eachother to finish.

**100 CAN-bus stationnumber this PLC**

Stationnumber of this PLC. Every PLC in a CAN network has to have a unique stationnumber.

**101 CAN-bus baudrate**

Baudrate/communicationspeed of this PLC. Every PLC in a CAN network has to be adjusted to the same baudrate.

**102 Delay return to home screen**

When the main screen is not activated, and the screen isn't used for this time, the main screen will be activated again. Steps of seconds (0=disabled).

**105 Signal time if customer/article change**

In case of a machine with customer separation system, this parameter is the time a signal will be given in case of a customer/article change.

## 2) Program parameters, general adjustments

### 2.1) Overview program parameters, general adjustments

- 01 Lanecoupling lane 1 and 2
- 02 Lanecoupling lane 2 and 3
- 03 Lanecoupling lane 3 and 4
- 04 Lanecoupling lane 4 and 5
- 05 3-lane operation
- 06 Drop pieces at 1st lengthfold
- 07 Sensitivity crookedetection
- 08 Double pressure on lengthfolds
- 09 Pressrolls 1st lengthfold on
- 10 Machine speed
- 11 Relative speed feeder (%)
- 12 Relative speed folder (%)
- 13 Reserved
- 14 Hole compensation
- 15 Reserved

### 2.2) Program parameters, general adjustments details

#### 01 Lanecoupling lane 1 and 2

With this parameter, the lanecoupling between lane 1 and 2 can be (re)set. A value of 1 means that the lanes are coupled,

#### 02 Lanecoupling lane 2 and 3

With this parameter, the lanecoupling between lane 2 and 3 can be (re)set. A value of 1 means that the lanes are coupled,

#### 03 Lanecoupling lane 3 and 4

With this parameter, the lanecoupling between lane 3 and 4 can be (re)set. A value of 1 means that the lanes are coupled,

#### 04 Lanecoupling lane 4 and 5

With this parameter, the lanecoupling between lane 4 and 5 can be (re)set. A value of 1 means that the lanes are coupled,

#### 05 3-lane operation

In case of a 2- and 3-lane machine, this parameter is used to adjust if the current program is a 3-lane (value 1) program. When it's a 1- or 2-lane program, the value should be 0.

#### 06 Drop pieces at 1st lengthfold

When this parameter has a value of 1, all pieces will be dropped at the 1st lateral fold (e.g. in case of waxing program). In all other cases, the value should be 0.

#### 07 Sensitivity crookedetection

A value of 0 means that the crookedetection is disabled. The higher the value, the more the pieces can be crooked without being dropped at the 1st lateral fold.

#### 08 Double pressure on lengthfolds

When this parameter has a value of 1, the blowpipes of the lengthfolds will get double pressure, which can be used for heavy pieces.

**09 Pressrolls 1st lengthfold on**

When this parameter has a value of 1, the pressrolls at the 1st lengthfold will be down. Value 0 means that they will stay up.

**10 Machine speed**

When the machine is behind an ironer, this parameter is the ironer speed. In case of a stand-alone machine, this parameter is the speed of the folding machine.

**11 Relative speed feeder (%)**

The relative speed of the feeding machine in relation to the ironer (%).

**12 Relative speed folder (%)**

The relative speed of the folding machine in relation to the ironer (%).

**14 Hole compensation**

The maximum size of a hole to be corrected automatically is this parameter (cm). This is also the minimum distance between the pieces.

## 3) Program parameters, feed-unit adjustments

### 3.1) Overview program parameters, feed-unit adjustments

- 01 Feedunit enabled
- 02 Reserved
- 03 Delay close clamp
- 04 Delay start spreading
- 05 Time end-spread photocell covered
- 06 Moment start release cycle
- 07 Time clamps inside before release
- 08 Time clamps outside after release
- 09 Delay open clamps until clamps outside
- 10 Stoptime beam in backposition
- 11 Minimum width of pieces
- 12 Minimum distance between pieces
- 13 Speed of beam during laydown (%)
- 14 Moment bar up after start laydown
- 15 Reserved

### 3.2) Program parameters, feed-unit adjustments details

#### 01 Feedunit enabled

A value of 1 means that the feeding unit will be used in this program. If the value is 0, the feeding unit will be sent to the backposition.

#### 03 Delay close clamp

The time a photocell of a clamp should be covered until the clamp will be closed. Steps of 0,01s.

#### 04 Delay start spreading

The delay between the moment both clamps are closed and the moment the spreading starts. Steps of 0,01s.

#### 05 Time end-spread photocell covered

The time the end-spreading photocell must be covered. After this time, the spreading will be stopped. Used to adjust the tension of the spreading. Steps of 0,01s.

#### 06 Moment start release cycle

The delay between the moment the beam goes backwards and the moment the release cycle starts. Steps of 0,01s.

#### 07 Time clamps inside before release

The time the clamps move inside before the clamps are opened. Steps of 0,01s.

#### 08 Time clamps outside after release

The time the clamps move outside after they are opened. Steps of 0,01s.

#### 09 Delay open clamps until clamps outside

The delay between the moment the clamps are opened and the clamps are go outside. Steps of 0,01s.

#### 10 Stoptime beam in backposition

The stoptime of the beam in the backposition after laying down a piece. Steps of 0,01s.

**11 Minimum width of pieces**

The minimum time the spreading cylinder is activated, without checking the end of spreading photocell. Steps of 0,01s.

**12 Minimum distance between pieces**

The distance the trailing edge of the last piece should be passed the 1st lengthfold photocell, before the next piece will be layed down.

**13 Speed of beam during laydown (%)**

The speed of the beam when laying down a piece. Is percentage of the speed of the belts.

**14 Moment bar up after start laydown**

The moment the bar for spreading the piece goes up during the laydown cycle. A value of 0 disables this bar.

## 4) Program parameters, adjustments per lane

### 4.1) Overview program parameters, adjustments per lane

- 01 Number of lengthfolds
- 02 Fold with points outside
- 03 Reserved
- 04 Overlap 1st lengthfold
- 05 Overlap 2nd lengthfold
- 06 Overlap extra lengthfold
- 07 Limit 0 or 1 lengthfolds
- 08 Limit 1 or 2 lengthfolds
- 09 Limit 2 or 3 lengthfolds
- 10 Venturi extra lengthfold
- 11 Blowtime 1st lengthfold
- 12 Blowtime 2nd lengthfold
- 13 Blowtime extra lengthfold
- 14 Venturi extra length when folding
- 15 Stackheight small pieces
- 16 Stopposition small pieces
- 17 Use stopbelt small pieces
- 18 Conveyortime stacker
  
- 19 Reserved
- 20 Reserved

### 4.2) Program parameters, adjustments per lane details

#### 01 Number of lengthfolds

Nr of lateral folds:

- 0 = Bypass
- 1 = 1 lateral fold
- 2 = 2 lateral folds
- 3 = 3 lateral folds
- 4 = 1 fold on 2nd fold

#### 02 Fold with points outside

A value of 1 means that in case of 2 lateral folds, the 1st and extra lateral fold are made and the 2nd will be bypassed. In this way the points will be outside at the stacker.

#### 04 Overlap 1st lengthfold

The overlap or folding point of the first lateral fold. The standard value of this parameter is 100.

#### 05 Overlap 2nd lengthfold

The overlap or folding point of the 2nd lateral fold. The standard value of this parameter is 100.

#### 06 Overlap extra lengthfold

The overlap or folding point of the extra lateral fold. The standard value of this parameter is 100. The extra lateral fold is between the 1st and 2<sup>nd</sup> lateral fold.

#### 07 Limit 0 or 1 lengthfolds

Pieces shorter than the value in this parameter will be folded 0 times, pieces longer will be folded 1 time minimum. Value is in centimeters.

**08 Limit 1 or 2 lengthfolds**

Pieces shorter than the value in this parameter will be folded 1 times, pieces longer will be folded twice minimum. Value is in centimeters.

**09 Limit 2 or 3 lengthfolds**

Pieces shorter than the value in this parameter will be folded twice pieces longer will be folded 3 times. Value is in centimeters.

**11 Blowtime 1st lengthfold**

The time the blowpipe of the 1st lateral fold is activated when folding. Steps of 0,01s.

**12 Blowtime 2nd lengthfold**

The time the blowpipe of the 2nd lateral fold is activated when folding. Steps of 0,01s.

**13 Blowtime extra lengthfold**

The time the blowpipe of the extra lateral fold is activated when folding. Steps of 0,01s.

**14 Venturi extra length when folding**

Value 1 means that the venturi of the extra lengthfold is used when folding, otherwise the venturi isn't used, to reduce rinkles in the piece.

**15 Stackheight small pieces**

The stacking height of the small piece stackers. When the stack reaches this number of pieces, the conveyor will shift. A value of 0 means no stacking.

**16 Stopposition small pieces**

In case of stopbelts at the small piece stacker, this parameter is the moment the belts are stopped. In case of no stopbelts, this parameter is the moment the stacker is started.

**17 Use stopbelt small pieces**

Enable/disable the stopbelts of the small piece stackers. A value of 0 means that the stopbelts aren't used, a value of 1 will activate the function of the stopbelts.

**18 Conveyortime stacker**

The time (steps of 0,01s) the conveyor of a small piece stacker is activated in case of shifting a stack.



## **5) Program parameters, adjustments crossfold**

### **5.1) Overview program parameters, adjustments crossfold**

- 01 Number of crossfolds
- 02 Stackfunction
- 03 Stackheight 1st stacker
- 04 Stackheight 2nd stacker
- 05 Limit 1 or 2 crossfolds
- 06 Overlap 2nd crossfold
- 07 Limit stacker 1 or 2
- 08 Overlap 1st stacker
- 09 Overlap 2nd stacker
- 10 Stopposition 1st crossfold
- 11 Sensitivity crookdetection
- 12 Knifetime 1st crossfold
- 13 Conveyortime stacker(s)
- 14 Pick-up moment 2nd crossfold
- 15 Delay return knife stacker

### **5.2) Program parameters, adjustments crossfold details**

#### **01 Number of crossfolds**

Number of crossfolds:

- 0 = No crossfolds
- 1 = 1 crossfolds
- 2 = 2 crossfolds

Attention!! The crossfold made at the stacker is not included.

#### **02 Stackfunction**

Sheetstacker to use:

- 0 = Don't stack
- 1 = Use stacker 1
- 2 = Use stacker 2
- 3 = Automatic on length
- 4 = Automatic on width
- 5 = Sequential

#### **03 Stackheight 1st stacker**

The stacking height of the 1st sheetstacker. When the stack reaches this number of pieces, the conveyor will shift.

#### **04 Stackheight 2nd stacker**

The stacking height of the 2nd sheetstacker. When the stack reaches this number of pieces, the conveyor will shift.

#### **05 Limit 1 or 2 crossfolds**

The limit for 1 or 2 crossfolds in cm. In case of a piece smaller than this limit, the 2nd crossfold will be bypassed.

#### **06 Overlap 2nd crossfold**

The overlap or folding point of the second crossfold. The standard value of this parameter is 100.

**07 Limit stacker 1 or 2**

The limit for the stacker selection in cm. When the stackfunction is adjusted to 3 or 4, a stacker will be selected using the value of this parameter.

**08 Overlap 1st stacker**

The overlap or folding point of the 1st sheetstacker. The standard value of this parameter is 100.

**09 Overlap 2nd stacker**

The overlap or folding point of the 2nd sheetstacker. The standard value of this parameter is 100.

**10 Stopposition 1st crossfold**

The stopposition at the 1st crossfold. The higher the value of this parameter, the later the belts will stop.

**11 Sensitivity crookdetection**

A value of 0 means that the crookdetection at the 1<sup>st</sup> crossfold is disabled. The higher the value, the more the pieces can be crooked without being dropped at the 1st crossfold.

**12 Knifetime 1st crossfold**

This is the time the knife of the 1st crossfold is activated, in steps of 0,01s.

**13 Conveyortime stacker(s)**

The time (steps of 0,01s) the conveyor of a sheetstacker is activated in case of shifting a stack when the stacking height is reached.

**14 Pick-up moment 2nd crossfold**

The moment the flap of the 2<sup>nd</sup> crossfold goes up to pick-up the front of the piece and make the fold.

**15 Delay return knife stacker**

The time the knife of the stacker will stay in the upper position before it's sent back. Steps of 10ms (0,01s).

## 6) Alarms

### 001 EMERGENCY STOP

One of the emergency stops on the machine is/has been pushed. When no emergency switch is active anymore, the emergency stop can be reset with the 'reset' button.

### 002 MOTOR THERMICAL OFF

The thermal protection of one of the motors is active. Check if the concerning motor is jammed and release the protection again.

### 003 VARAN-BUS ERROR

The connection with one or more backplanes on the varan IO-bus is lost. As soon as connection is re-established, message will disappear.

### 004 ALARM FEEDING BEAM

While the feeding beam was moving, the sensor for front or back position wasn't covered in the estimated time. This can be caused by a jam.

### 006 ERROR INVERTER MAINMOTOR

The frequency inverter of the main motor is in alarm (motor stuck?). Reset can be done by switching off the inverter with the emergency stop and wait for about 20 seconds.

### 007 ERROR INVERTER STOPBELTS

One of the inverters of the stopbelts is in alarm (motor stuck?). Reset can be done by switching off the inverter with the emergency stop and wait for about 20 seconds.

### 010 PCE.TOO LATE 2nd CROSS

A piece didn't arrive at the photocell of the 2nd crossfold (directly underneath the 1st crossfold of the middle lane). This can be caused by a jam in the crossfold.

### 011 PCE.TOO LATE, STACKER LEFT

A piece didn't arrive at the photocell of the stackers on the left (or only) side. This can be caused by a jam in the crossfold.

### 012 PCE.TOO LATE, STACKER RIGHT

A piece didn't arrive at the photocell of the stackers on the right side. This can be caused by a jam in the crossfold.

### 013 2nd CROSSPC. COVERED TOO LONG

The photocell of the 2nd crossfold (directly underneath the 1st crossfold of the middle lane) is covered too long. In most cases this is caused by a jammed piece.

### 014 STACKPC.COVERED TOO LONG

The photocell of the stacker(s) on the left (or only) side is covered too long. In most cases this is caused by a jammed piece.

### 015 STACKPC.COVERED TOO LONG

The photocell of the stacker(s) on the right side is covered too long. In most cases this is caused by a jammed piece.

### 016 PCE TOO LATE STACKER 1

A piece arrived too late at the stopposition photocell of the 1st stacker. This can be caused by a jam at the stacker.

### 017 PCE TOO LATE STACKER 2

A piece arrived too late at the stopposition photocell of the 2nd stacker. This can be caused by a jam at the stacker.

**018 PCE TOO LATE STACKER 3**

A piece arrived too late at the stopposition photocell of the 3rd stacker. This can be caused by a jam at the stacker.

**019 PCE TOO LATE STACKER 4**

A piece arrived too late at the stopposition photocell of the 4th stacker. This can be caused by a jam at the stacker.

**021 SHEET STUCK 1ST LENGTH LN1**

The photocell of the 1st lengthfold has measured a length longer than the maximum adjusted in the parameters. Can be caused by a jammed sheet at the photocell or counting wheel.

**022 SHEET STUCK 1ST LENGTH LN2**

The photocell of the 1st lengthfold has measured a length longer than the maximum adjusted in the parameters. Can be caused by a jammed sheet at the photocell or counting wheel.

**023 SHEET STUCK 1ST LENGTH LN3**

The photocell of the 1st lengthfold has measured a length longer than the maximum adjusted in the parameters. Can be caused by a jammed sheet at the photocell or counting wheel.

**024 SHEET STUCK 1ST LENGTH LN4**

The photocell of the 1st lengthfold has measured a length longer than the maximum adjusted in the parameters. Can be caused by a jammed sheet at the photocell or counting wheel.

**025 SHEET STUCK 1ST LENGTH LN5**

The photocell of the 1st lengthfold has measured a length longer than the maximum adjusted in the parameters. Can be caused by a jammed sheet at the photocell or counting wheel.

**026 PCE LATE 2ND LENGTH LANE 1**

A piece didn't arrive at the 2<sup>nd</sup> lateral fold of lane 1. This can be caused by a jam in the lengthfold. Because this happened 2 times, the machine is stopped.

**027 PCE LATE 2ND LENGTH LANE 2**

A piece didn't arrive at the 2<sup>nd</sup> lateral fold of lane 2. This can be caused by a jam in the lengthfold. Because this happened 2 times, the machine is stopped.

**028 PCE LATE 2ND LENGTH LANE 3**

A piece didn't arrive at the 2<sup>nd</sup> lateral fold of lane 3. This can be caused by a jam in the lengthfold. Because this happened 2 times, the machine is stopped.

**029 PCE LATE 2ND LENGTH LANE 4**

A piece didn't arrive at the 2<sup>nd</sup> lateral fold of lane 4. This can be caused by a jam in the lengthfold. Because this happened 2 times, the machine is stopped.

**030 PCE LATE 2ND LENGTH LANE 5**

A piece didn't arrive at the 2<sup>nd</sup> lateral fold of lane 5. This can be caused by a jam in the lengthfold. Because this happened 2 times, the machine is stopped.

**031 SHEET STUCK 2ND LENGTH LN1**

The photocell of the 2nd lengthfold has measured a length longer than the maximum adjusted in the parameters. Can be caused by a jammed sheet at the photocell or counting wheel.

**032 SHEET STUCK 2ND LENGTH LN2**

The photocell of the 2nd lengthfold has measured a length longer than the maximum adjusted in the parameters. Can be caused by a jammed sheet at the photocell or counting wheel.

**033 SHEET STUCK 2ND LENGTH LN3**

The photocell of the 2nd lengthfold has measured a length longer than the maximum adjusted in the parameters. Can be caused by a jammed sheet at the photocell or counting wheel.

**034 SHEET STUCK 2ND LENGTH LN4**

The photocell of the 2nd lengthfold has measured a length longer than the maximum adjusted in the parameters. Can be caused by a jammed sheet at the photocell or counting wheel.

**035 SHEET STUCK 2ND LENGTH LN5**

The photocell of the 2nd lengthfold has measured a length longer than the maximum adjusted in the parameters. Can be caused by a jammed sheet at the photocell or counting wheel.

**036 IRONER JAMMED LANE 1**

The feeder has been feeding pieces which never arrived at the folder. This can be caused by a jam in the ironer

or at the 1st lateral fold.

**037 IRONER JAMMED LANE 2**

The feeder has been feeding pieces which never arrived at the folder. This can be caused by a jam in the ironer or at the 1st lateral fold.

**038 IRONER JAMMED LANE 3**

The feeder has been feeding pieces which never arrived at the folder. This can be caused by a jam in the ironer or at the 1st lateral fold.

**039 IRONER JAMMED LANE 4**

The feeder has been feeding pieces which never arrived at the folder. This can be caused by a jam in the ironer or at the 1st lateral fold.

**040 IRONER JAMMED LANE 5**

The feeder has been feeding pieces which never arrived at the folder. This can be caused by a jam in the ironer or at the 1st lateral fold.

**041 PCE TOO LATE LENGTHPC. LANE 2**

A piece didn't arrive at the lengthcheck photocell of the 1st crossfold of lane 2. Cause can be a jam in the lengthfold. Because this is the 2nd time, the machine stops.

**042 PCE TOO LATE LENGTHPC. MIDDLE**

A piece didn't arrive at the lengthcheck photocell of the 1st crossfold in the middle. Cause can be a jam in the lengthfold. Because this is the 2nd time, the machine stops.

**043 PCE TOO LATE LENGTHPC. LANE 3**

A piece didn't arrive at the lengthcheck photocell of the 1st crossfold of lane 3. Cause can be a jam in the lengthfold. Because this is the 2nd time, the machine stops.

**044 PCE TOO LATE STOPPC. LANE 2**

A piece didn't arrive at the stopposition photocell of the 1st crossfold of lane 2. Cause can be a jam in the lengthfold. Because this is the 2nd time, the machine stops.

**045 PCE TOO LATE STOPPC. MIDDLE**

A piece didn't arrive at the stopposition photocell of the 1st crossfold in the middle. Cause can be a jam in the lengthfold. Because this is the 2nd time, the machine stops.

**046 PCE TOO LATE STOPPC. LANE 3**

A piece didn't arrive at the stopposition photocell of the 1st crossfold of lane 3. Cause can be a jam in the lengthfold. Because this is the 2nd time, the machine stops.

**051 PIECE TOO LATE STACKER LANE 1**

Two pieces didn't arrive (in time) at the photocell of the stacker of lane 1. Cause can be a jam in the lengthfold. After checking the machine can be restarted with the startbutton.

**052 PIECE TOO LATE STACKER LANE 2**

Two pieces didn't arrive (in time) at the photocell of the stacker of lane 2 Cause can be a jam in the lengthfold. After checking the machine can be restarted with the startbutton.

#### **053 PIECE TOO LATE STACKER LANE 3**

Two pieces didn't arrive (in time) at the photocell of the stacker of lane 3 Cause can be a jam in the lengthfold. After checking the machine can be restarted with the startbutton.

#### **054 PIECE TOO LATE STACKER LANE 4**

Two pieces didn't arrive (in time) at the photocell of the stacker of lane 4 Cause can be a jam in the lengthfold. After checking the machine can be restarted with the startbutton.

#### **055 PIECE TOO LATE STACKER LANE 5**

Two pieces didn't arrive (in time) at the photocell of the stacker of lane 5. Cause can be a jam in the lengthfold. After checking the machine can be restarted with the startbutton.

#### **056 CLAMP NOT HOME STACKER LANE 1**

When a piece arrived at the stacker, the clamp was not in home position. Because this happened two times, this can be caused by a jam at the stacker, so the machine is stopped.

#### **057 CLAMP NOT HOME STACKER LANE 2**

When a piece arrived at the stacker, the clamp was not in home position. Because this happened two times, this can be caused by a jam at the stacker, so the machine is stopped.

#### **058 CLAMP NOT HOME STACKER LANE 3**

When a piece arrived at the stacker, the clamp was not in home position. Because this happened two times, this can be caused by a jam at the stacker, so the machine is stopped.

#### **059 CLAMP NOT HOME STACKER LANE 4**

When a piece arrived at the stacker, the clamp was not in home position. Because this happened two times, this can be caused by a jam at the stacker, so the machine is stopped.

#### **060 CLAMP NOT HOME STACKER LANE 5**

When a piece arrived at the stacker, the clamp was not in home position. Because this happened two times, this can be caused by a jam at the stacker, so the machine is stopped.

#### **061 CLAMP NOT UP STACKER LANE 1**

The clamp of the small piece stacker did not reach the reedswitch for the upper position in time. Because this is the 2nd time, the machine stops.

#### **062 CLAMP NOT UP STACKER LANE 2**

The clamp of the small piece stacker did not reach the reedswitch for the upper position in time. Because this is the 2nd time, the machine stops.

#### **063 CLAMP NOT UP STACKER LANE 3**

The clamp of the small piece stacker did not reach the reedswitch for the upper position in time. Because this is the 2nd time, the machine stops.

#### **064 CLAMP NOT UP STACKER LANE 4**

The clamp of the small piece stacker did not reach the reedswitch for the upper position in time. Because this is the 2nd time, the machine stops.

#### **065 CLAMP NOT UP STACKER LANE 5**

The clamp of the small piece stacker did not reach the reedswitch for the upper position in time. Because this is the 2nd time, the machine stops.

#### **071 CLAMP NOT HOME SHEETSTACKER 1**

The last piece at the 1st sheetstacker couldn't be stacked because the clamp wasn't in the home position. Because this is the 2nd time, the machine is stopped.

#### **072 CLAMP NOT HOME SHEETSTACKER 2**

The last piece at the 2nd sheetstacker couldn't be stacked because the clamp wasn't in the home position. Because this is the 2nd time, the machine is stopped.

**073 CLAMP NOT HOME SHEETSTACKER 3**

The last piece at the 3rd sheetstacker couldn't be stacked because the clamp wasn't in the home position. Because this is the 2nd time, the machine is stopped.

**074 CLAMP NOT HOME SHEETSTACKER 4**

The last piece at the 4th sheetstacker couldn't be stacked because the clamp wasn't in the home position. Because this is the 2nd time, the machine is stopped.

**075 CLAMP TOO LATE SHEETSTACKER 1**

The clamp of the 1st sheetstacker did not reach the reedswitch for the upper position in the estimated time. Because this is the 2nd time, the machine is stopped.

**076 CLAMP TOO LATE SHEETSTACKER 2**

The clamp of the 2nd sheetstacker did not reach the reedswitch for the upper position in the estimated time. Because this is the 2nd time, the machine is stopped.

**077 CLAMP TOO LATE SHEETSTACKER 3**

The clamp of the 3rd sheetstacker did not reach the reedswitch for the upper position in the estimated time. Because this is the 2nd time, the machine is stopped.

**078 CLAMP TOO LATE SHEETSTACKER 4**

The clamp of the 4th sheetstacker did not reach the reedswitch for the upper position in the estimated time. Because this is the 2nd time, the machine is stopped.

**083 Wax cloth request**

The number of pieces until the ironer should be waxed is done. When waxing is done, this message can be reset with the startbutton on this panel.

**085 Piece too late, 2nd cross**

A piece didn't arrive at the photocell of the 2nd crossfold (directly underneath the 1st crossfold of the middle lane). This can be caused by a jam in the crossfold.

**086 Piece too late, stacker left**

A piece didn't arrive at the photocell of the stacker(s) on the left (or only) side. Cause can be a jam in the crossfold. If this happens twice, the machine will stop.

**087 Piece too late, stacker right**

A piece didn't arrive at the photocell of the stacker(s) on the right

side. Cause can be a jam in the crossfold. If this happens twice, the machine will stop.

**088 2nd crosspc. covered too long**

The photocell of the 2nd crossfold (directly underneath the 1st crossfold of the middle lane) is covered too long. In most cases this is caused by a jammed piece.

**089 Stackerpc. covered too long**

The photocell of the stacker(s) on the left (or only) side is covered too long. In most cases this is caused by a jammed piece.

**090 Stackerpc. covered too long**

The photocell of the stacker(s) on the right side is covered too long. In most cases this is caused by a jammed piece.

**091 Time-out stoppos. stacker 1**

A piece arrived too late at the stopposition photocel of the 1st stacker. Cause can be jam at the stacker. If this happens twice, the machine will stop.

**092 Time-out stoppos. stacker 2**

A piece arrived too late at the stopposition photocel of the 2nd stacker. Cause can be jam at the stacker. If this happens twice, the machine will stop.

**093 Time-out stoppos. stacker 3**

A piece arrived too late at the stopposition photocel of the 3rd stacker. Cause can be jam at the stacker. If this happens twice, the machine will stop.

**094 Time-out stoppos. stacker 4**

A piece arrived too late at the stopposition photocel of the 4th stacker. Cause can be jam at the stacker. If this happens twice, the machine will stop.

**096 Piece too late 2nd length lane 1**

A piece didn't arrive at the 2<sup>nd</sup> lateral fold of lane 1. This can be caused by a jam in the lengthfold. When this happens 2 times, the machine will be stopped.

**097 Piece too late 2nd length lane 2**

A piece didn't arrive at the 2<sup>nd</sup> lateral fold of lane 2. This can be caused by a jam in the lengthfold. When this happens 2 times, the machine will be stopped.

**098 Piece too late 2nd length lane 3**

A piece didn't arrive at the 2<sup>nd</sup> lateral fold of lane 3. This can be caused by a jam in the lengthfold. When this happens 2 times, the machine will be stopped.

**099 Piece too late 2nd length lane 4**

A piece didn't arrive at the 2<sup>nd</sup> lateral fold of lane 4. This can be caused by a jam in the lengthfold. When this happens 2 times, the machine will be stopped.

**100 Piece too late 2nd length lane 5**

A piece didn't arrive at the 2<sup>nd</sup> lateral fold of lane 5. This can be caused by a jam in the lengthfold. When this happens 2 times, the machine will be stopped.

**101 Piece too early 2nd length lane1**

A piece arrived too early at the photocell of the 2nd lateral fold of lane 1. This can happen when a piece is static.

**102 Piece too early 2nd length lane2**

A piece arrived too early at the photocell of the 2nd lateral fold of lane 2. This can happen when a piece is static.

**103 Piece too early 2nd length lane3**

A piece arrived too early at the photocell of the 2nd lateral fold of lane 3. This can happen when a piece is static.

**104 Piece too early 2nd length lane4**

A piece arrived too early at the photocell of the 2nd lateral fold of lane 4. This can happen when a piece is static.

**105 Piece too early 2nd length lane5**

A piece arrived too early at the photocell of the 2nd lateral fold of lane 5. This can happen when a piece is static.

**106 Piece too late lengthpc. lane 2**

A piece didn't arrive at the lengthcheck photocell of the 1st crossfold of lane 2. This can be caused by a jam in the lengthfold. If this happens twice, the machine stops.

**107 Piece too late lengthpc. middle**

A piece didn't arrive at the lengthcheck photocell of the 1st crossfold in the middle. Cause can be a jam in the lengthfold. If this happens twice, the machine stops.



**108 Piece too late lengthpc. lane 3**

A piece didn't arrive at the lengthcheck photocell of the 1st crossfold of lane 3. This can be caused by a jam in the lengthfold. If this happens twice, the machine stops.

**109 Piece too late stoppc. lane 2**

A piece didn't arrive at the stopposition photocell of the 1st crossfold of lane 2. Cause can be a jam in the lengthfold. If this happens twice, the machine will stop.

**110 Piece too late stoppc. middle**

A piece didn't arrive at the stopposition photocell of the 1st crossfold in the middle. Cause can be a jam in the lengthfold. If this happens twice, the machine will stop.

**111 Piece too late stoppc. lane 3**

A piece didn't arrive at the stopposition photocell of the 1st crossfold of lane 3. Cause can be a jam in the lengthfold. If this happens twice, the machine will stop.

**112 Error telescope sheetstacker 1**

While moving the telescope at the 1st stacker, the sensor for the end-position was detected too late. This can be because the telescope jammed.

**113 Error telescope sheetstacker 2**

While moving the telescope at the 2nd stacker, the sensor for the end-position was detected too late. This can be because the telescope jammed.

**114 Error telescope sheetstacker 3**

While moving the telescope at the 3rd stacker, the sensor for the end-position was detected too late. This can be because the telescope jammed.

**115 Error telescope sheetstacker 4**

While moving the telescope at the 4th stacker, the sensor for the end-position was detected too late. This can be because the telescope jammed.

**116 Piece too late stacker lane 1**

A piece didn't arrive (in time) at the photocell of the stacker of lane 1. This can be caused by a jam in the lengthfold. When this happens 2 times, the machine will be stopped.

**117 Piece too late stacker lane 2**

A piece didn't arrive (in time) at the photocell of the stacker of lane 2. This can be caused by a jam in the lengthfold. When this happens 2 times, the machine will be stopped.

**118 Piece too late stacker lane 3**

A piece didn't arrive (in time) at the photocell of the stacker of lane 3. This can be caused by a jam in the lengthfold. When this happens 2 times, the machine will be stopped.

**119 Piece too late stacker lane 4**

A piece didn't arrive (in time) at the photocell of the stacker of lane 4. This can be caused by a jam in the lengthfold. When this happens 2 times, the machine will be stopped.

**120 Piece too late stacker lane 5**

A piece didn't arrive (in time) at the photocell of the stacker of lane 5. This can be caused by a jam in the lengthfold. When this happens 2 times, the machine will be stopped.

**121 Clamp not home, stacker lane 1**

The last piece at the small piece stacker of lane 1 couldn't be stacked because the clamp wasn't in the home position. When this happens 2 times, the machine will be stopped.

**122 Clamp not home, stacker lane 2**

The last piece at the small piece stacker of lane 2 couldn't be stacked because the clamp wasn't in the home position. When this happens 2 times, the machine will be stopped.

**123 Clamp not home, stacker lane 3**

The last piece at the small piece stacker of lane 3 couldn't be stacked because the clamp wasn't in the home position. When this happens 2 times, the machine will be stopped.

**124 Clamp not home, stacker lane 4**

The last piece at the small piece stacker of lane 4 couldn't be stacked because the clamp wasn't in the home position. When this happens 2 times, the machine will be stopped.

**125 Clamp not home, stacker lane 5**

The last piece at the small piece stacker of lane 5 couldn't be stacked because the clamp wasn't in the home position. When this happens 2 times, the machine will be stopped.

**126 Knife too late up, stacker lane 1**

While stacking a piece, the knife of the small piece stacker wasn't in the upper position in the estimated time. Check if the conveyor is up, and if the reedswitch and valve still work ok.

**127 Knife too late up, stacker lane 2**

While stacking a piece, the knife of the small piece stacker wasn't in the upper position in the estimated time. Check if the conveyor is up, and if the reedswitch and valve still work ok.

**128 Knife too late up, stacker lane 3**

While stacking a piece, the knife of the small piece stacker wasn't in the upper position in the estimated time. Check if the conveyor is up, and if the reedswitch and valve still work ok.

**129 Knife too late up, stacker lane 4**

While stacking a piece, the knife of the small piece stacker wasn't in the upper position in the estimated time. Check if the conveyor is up, and if the reedswitch and valve still work ok.

**130 Knife too late up, stacker lane 5**

While stacking a piece, the knife of the small piece stacker wasn't in the upper position in the estimated time. Check if the conveyor is up, and if the reedswitch and valve still work ok.

**131 Clamp up too late, stacker lane 1**

The clamp of the small piece stacker did not reach the reedswitch for the upper position in the estimated time. When this happens 2 times, the machine will be stopped.

**132 Clamp up too late, stacker lane 2**

The clamp of the small piece stacker did not reach the reedswitch for the upper position in the estimated time. When this happens 2 times, the machine will be stopped.

**133 Clamp up too late, stacker lane 3**

The clamp of the small piece stacker did not reach the reedswitch for the upper position in the estimated time. When this happens 2 times, the machine will be stopped.

**134 Clamp up too late, stacker lane 4**

The clamp of the small piece stacker did not reach the reedswitch for the upper position in the estimated time. When this happens 2 times, the machine will be stopped.

**135 Clamp up too late, stacker lane 5**

The clamp of the small piece stacker did not reach the reedswitch for the upper position in the estimated time. When this happens 2 times, the machine will be stopped.

**136 Error telescope stacker lane 1**

While moving the telescope of the 1st small piece stacker, the sensor for the end-position was detected too late. This can be because the telescope jammed.

**137 Error telescope stacker lane 2**

While moving the telescope of the 2nd small piece stacker, the sensor for the end-position was detected too late. This can be because the telescope jammed.

**138 Error telescope stacker lane 3**

While moving the telescope of the 3rd small piece stacker, the sensor for the end-position was detected too late. This can be because the telescope jammed.

**139 Error telescope stacker lane 4**

While moving the telescope of the 4th small piece stacker, the sensor for the end-position was detected too late. This can be because the telescope jammed.

**140 Error telescope stacker lane 5**

While moving the telescope of the 5th small piece stacker, the sensor for the end-position was detected too late. This can be because the telescope jammed.

**141 Clamp not home, sheetstacker 1**

The last piece at the 1st sheetstacker couldn't be stacked because the clamp wasn't in the home position. When this happens 2 times, the machine will be stopped.

**142 Clamp not home, sheetstacker 2**

The last piece at the 2nd sheetstacker couldn't be stacked because the clamp wasn't in the home position. When this happens 2 times, the machine will be stopped.

**143 Clamp not home, sheetstacker 3**

The last piece at the 3th sheetstacker couldn't be stacked because the clamp wasn't in the home position. When this happens 2 times, the machine will be stopped.

**144 Clamp not home, sheetstacker 4**

The last piece at the 4th sheetstacker couldn't be stacked because the clamp wasn't in the home position. When this happens 2 times, the machine will be stopped.

**145 Knife too late up, sheetstacker 1**

While stacking a piece, the knife of the 1st sheetstacker wasn't in the upper position in the estimated time. Check if conveyor is up, and if reedswitch and valve still work ok.

**146 Knife too late up, sheetstacker 2**

While stacking a piece, the knife of the 2nd sheetstacker wasn't in the upper position in the estimated time. Check if conveyor is up, and if reedswitch and valve still work ok.

**147 Knife too late up, sheetstacker 3**

While stacking a piece, the knife of the 3rd sheetstacker wasn't in the upper position in the estimated time. Check if conveyor is up, and if reedswitch and valve still work ok.

**148 Knife too late up, sheetstacker 4**

While stacking a piece, the knife of the 4th sheetstacker wasn't in the upper position in the estimated time. Check if conveyor is up, and if reedswitch and valve still work ok.

**149 Clamp up too late, sheetstacker 1**

The clamp of the 1st sheetstacker did not reach the reedswitch for the upper position in the estimated time. When this happens 2 times, the machine will be stopped.

**150 Clamp up too late, sheetstacker 2**

The clamp of the 2nd sheetstacker did not reach the reedswitch for the upper position in the estimated time. When this happens 2 times, the machine will be stopped.

**151 Clamp up too late, sheetstacker 3**

The clamp of the 3th sheetstacker did not reach the reedswitch for the upper position in the estimated time. When this happens 2 times, the machine will be stopped.

**152 Clamp up too late, sheetstacker 4**

The clamp of the 3th sheetstacker did not reach the reedswitch for the upper position in the estimated time. When this happens 2 times, the machine will be stopped.

**156 Piece too long 1st cross lane 2**

The last piece at the 1st crossfold of lane 2 was too long (in stopposition, the lengthcheck photocell was covered). The piece will not be crossfolded.

**157 Piece too long 1st crossfold**

The last piece at the 1st crossfold in the middle lane was too long (in stopposition, the lengthcheck photocell was covered). The piece will not be crossfolded.

**158 Piece too long 1st cross lane 3**

The last piece at the 1st crossfold of lane 3 was too long (in stopposition, the lengthcheck photocell was covered). The piece will not be crossfolded.

**159 Pieces too close 1st cross lane 2**

While a piece was waiting at the 1st crossfold of lane 2, the next piece was already coming. The which was waiting will not be crossfolded.

**160 Pieces too close 1st cross middle**

While a piece was waiting at the 1st crossfold in the middle lane, the next piece was already coming. The piece which was waiting will not be crossfolded.

**161 Pieces too close 1st cross lane 3**

While a piece was waiting at the 1st crossfold of lane 3, the next piece was already coming. The which was waiting will not be crossfolded.

**162 Pcs.too close at stacker**

While a piece was waiting to be stacked at stacker 1 or 2, the next piece already arrived at the stacker. The piece which was waiting, will be thrown out.

**163 Pcs.too close at stacker**

While a piece was waiting to be stacked at stacker 3 or 4, the next piece already arrived at the stacker. The piece which was waiting, will be thrown out.

**166 Piece too short, 1st length lane 1**

The photocell of the 1st lengthfold of lane 1 has detected a piece which was shorter than the limit in the machine parameters. This can be caused by a belt accidentally covering the photocell.

**167 Piece too short, 1st length lane 2**

The photocell of the 1st lengthfold of lane 2 has detected a piece which was shorter than the limit in the machine parameters. This can be caused by a belt accidentally covering the photocell.

**168 Piece too short, 1st length lane 3**

The photocell of the 1st lengthfold of lane 3 has detected a piece which was shorter than the limit in the machine parameters. This can be caused by a belt accidentally covering the photocell.

**169 Piece too short, 1st length lane 4**

The photocell of the 1st lengthfold of lane 4 has detected a piece which was shorter than the limit in the machine parameters. This can be caused by a belt accidentally covering the photocell.

**170 Piece too short, 1st length lane 5**

The photocell of the 1st lengthfold of lane 5 has detected a piece which was shorter than the limit in the machine parameters. This can be caused by a belt accidentally covering the photocell.

**171 Piece too long, 1st length lane 1**

On lane 1 a piece was detected which was too long for the machine to be able to fold in the middle. Therefore, the folds will not be in the middle.

**172 Piece too long, 1st length lane 2**

On lane 2 a piece was detected which was too long for the machine to be able to fold in the middle. Therefore, the folds will not be in the middle.

**173 Piece too long, 1st length lane 3**

On lane 3 a piece was detected which was too long for the machine to be able to fold in the middle. Therefore, the folds will not be in the middle.

**174 Piece too long, 1st length lane 4**

On lane 4 a piece was detected which was too long for the machine to be able to fold in the middle. Therefore, the folds will not be in the middle.

**175 Piece too long, 1st length lane 5**

On lane 5 a piece was detected which was too long for the machine to be able to fold in the middle. Therefore, the folds will not be in the middle.

**177 Piece too long, sheetstacker 1**

The last piece at the 1st sheetstacker hasn't been stacked, because the piece was longer than the adjusted limit in the machine parameters.

**178 Piece too long, sheetstacker 2**

The last piece at the 2nd sheetstacker hasn't been stacked, because the piece was longer than the adjusted limit in the machine parameters.

**179 Piece too long, sheetstacker 3**

The last piece at the 3th sheetstacker hasn't been stacked, because the piece was longer than the adjusted limit in the machine parameters.

**180 Piece too long, sheetstacker 4**

The last piece at the 4th sheetstacker hasn't been stacked, because the piece was longer than the adjusted limit in the machine parameters.

**181 Piece too long, stacker lane 1**

The last piece at the small piece stacker of lane 1 hasn't been stacked, because the piece was longer than the adjusted limit in the machine parameters.

**182 Piece too long, stacker lane 2**

The last piece at the small piece stacker of lane 2 hasn't been stacked, because the piece was longer than the adjusted limit in the machine parameters.

**183 Piece too long, stacker lane 3**

The last piece at the small piece stacker of lane 3 hasn't been stacked, because the piece was longer than the adjusted limit in the machine parameters.

**184 Piece too long, stacker lane 4**

The last piece at the small piece stacker of lane 4 hasn't been stacked, because the piece was longer than the adjusted limit in the machine parameters.

**185 Piece too long, stacker lane 5**

The last piece at the small piece stacker of lane 5 hasn't been stacked, because the piece was longer than the adjusted limit in the machine parameters.

**186 Conveyor full stacker**

After shifting the conveyor of the stacker, the photocell for the stacking height was still covered. This can be caused by a full conveyor.

**191 Conveyor busy stacker lane 1**

The last piece at the small piece stacker of lane 1 couldn't be stacked, because the conveyor was still busy with shifting a stack.

**192 Conveyor busy stacker lane 2**

The last piece at the small piece stacker of lane 2 couldn't be stacked, because the conveyor was still busy with shifting a stack.

**193 Conveyor busy stacker lane 3**

The last piece at the small piece stacker of lane 3 couldn't be stacked, because the conveyor was still busy with shifting a stack.

**194 Conveyor busy stacker lane 4**

The last piece at the small piece stacker of lane 4 couldn't be stacked, because the conveyor was still busy with shifting a stack.

**195 Conveyor busy stacker lane 5**

The last piece at the small piece stacker of lane 5 couldn't be stacked, because the conveyor was still busy with shifting a stack.

**196 Pieces too close, stacker lane 1**

The last piece at the small piece stacker of lane 1 couldn't be stacked because the stacker was still busy with stacking the previous piece.

**197 Pieces too close, stacker lane 2**

The last piece at the small piece stacker of lane 2 couldn't be stacked because the stacker was still busy with stacking the previous piece.

**198 Pieces too close, stacker lane 3**

The last piece at the small piece stacker of lane 3 couldn't be stacked because the stacker was still busy with stacking the previous piece.

**199 Pieces too close, stacker lane 4**

The last piece at the small piece stacker of lane 4 couldn't be stacked because the stacker was still busy with stacking the previous piece.

**200 Pieces too close, stacker lane 5**

The last piece at the small piece stacker of lane 5 couldn't be stacked because the stacker was still busy with stacking the previous piece.

**201 Conveyor busy stacker 1**

The last piece at the 1st sheetstacker couldn't be stacked, because the conveyor was still busy with shifting a stack.

**202 Conveyor busy stacker 2**

The last piece at the 2nd sheetstacker couldn't be stacked, because the conveyor was still busy with shifting a stack.

**202 Conveyor busy stacker 3**

The last piece at the 3rd sheetstacker couldn't be stacked, because the conveyor was still busy with shifting a stack.

**204 Conveyor busy stacker 4**

The last piece at the 4th sheetstacker couldn't be stacked, because the conveyor was still busy with shifting a stack.

**208 Battery almost empty**

The battery in the PLC is almost empty. It has to be replaced every year. Replace the battery as soon as possible to prevent loss of data.

**209 CPU temperature too high**

The temperature of the PLC-processor is too high. Reason can be a broken fan or a too high environment temperature.

**213 Piece crooked crossfold**

At the 1st crossfold a piece is detected which was crooked. This piece will not be folded, but dropped at the 1st crossfold.

**214 Piece crooked lane 2**

At the 1st lateral fold of lane 2 a piece is detected which was crooked. This piece will not be folded, but dropped at the 1st lateral fold.

**215 Piece crooked lane 3**

At the 1st lateral fold of lane 3 a piece is detected which was crooked. This piece will not be folded, but dropped at the 1st lateral fold.

**216 Wait until clamps home**

The feeding unit can't be used because the clamps aren't in the home position, yet.

**221 Wait until stacker done, lane 1**

A piece is ready on the stopbelts of the small piece stacker. As soon as the clamp of the stacker is in homeposition again, the piece can be stacked.

**222 Wait until stacker done, lane 2**

A piece is ready on the stopbelts of the small piece stacker. As soon as the clamp of the stacker is in homeposition again, the piece can be stacked.

**223 Wait until stacker done, lane 3**

A piece is ready on the stopbelts of the small piece stacker. As soon as the clamp of the stacker is in homeposition again, the piece can be stacked.

**224 Wait until stacker done, lane 4**

A piece is ready on the stopbelts of the small piece stacker. As soon as the clamp of the stacker is in homeposition again, the piece can be stacked.

**225 Wait until stacker done, lane 5**

A piece is ready on the stopbelts of the small piece stacker. As soon as the clamp of the stacker is in homeposition again, the piece can be stacked.

**226 Hole detected in piece lane 1**

Within the adjusted distance the 1st lengthphotocell has been covered twice. The program will correct this as a hole.

**227 Hole detected in piece lane 2**

Within the adjusted distance the 1st lengthphotocell has been covered twice. The program will correct this as a hole.

**228 Hole detected in piece lane 3**

Within the adjusted distance the 1st lengthphotocell has been covered twice. The program will correct this as a hole.

**229 Hole detected in piece lane 4**

Within the adjusted distance the 1st lengthphotocell has been covered twice. The program will correct this as a hole.

**230 Hole detected in piece lane 5**

Within the adjusted distance the 1st lengthphotocell has been covered twice. The program will correct this as a hole.

**236 Piece dirty lane 1**

On lane 1 a piece is/was rejected because for this piece the button for dirty pieces was pushed.

**237 Piece dirty lane 2**

On lane 2 a piece is/was rejected because for this piece the button for dirty pieces was pushed.

**238 Piece dirty lane 3**

On lane 3 a piece is/was rejected because for this piece the button for dirty pieces was pushed.

**239 Piece dirty lane 4**

On lane 1 a piece is/was rejected because for this piece the button for dirty pieces was pushed.

**240 Piece dirty lane 5**

On lane 5 a piece is/was rejected because for this piece the button for dirty pieces was pushed.

**241 Piece broke lane 1**

On lane 1 a piece is/was rejected because for this piece the button for broken pieces was pushed.

**242 Piece broke lane 2**

On lane 2 a piece is/was rejected because for this piece the button for broken pieces was pushed.

**243 Piece broke lane 3**

On lane 3 a piece is/was rejected because for this piece the button for broken pieces was pushed.

**244 Piece broke lane 4**

On lane 4 a piece is/was rejected because for this piece the button for broken pieces was pushed.

**245 Piece broke lane 5**

On lane 5 a piece is/was rejected because for this piece the button for broken pieces was pushed.

**251 New program in ironer**

On the feeding side, a new program has been chosen. This program change is now delayed through the ironer. After the program is switched, this notification will disappear.

**253 Waiting for start**

The machine is waiting for a start signal to be given by the startbutton on this touchscreen.

**255 Operating**

The machine is running, no alarms or other notifications.