WM-4000 AUTOMATIC WRAPPER

Error Codes and Solutions

400 – 499

March 2015
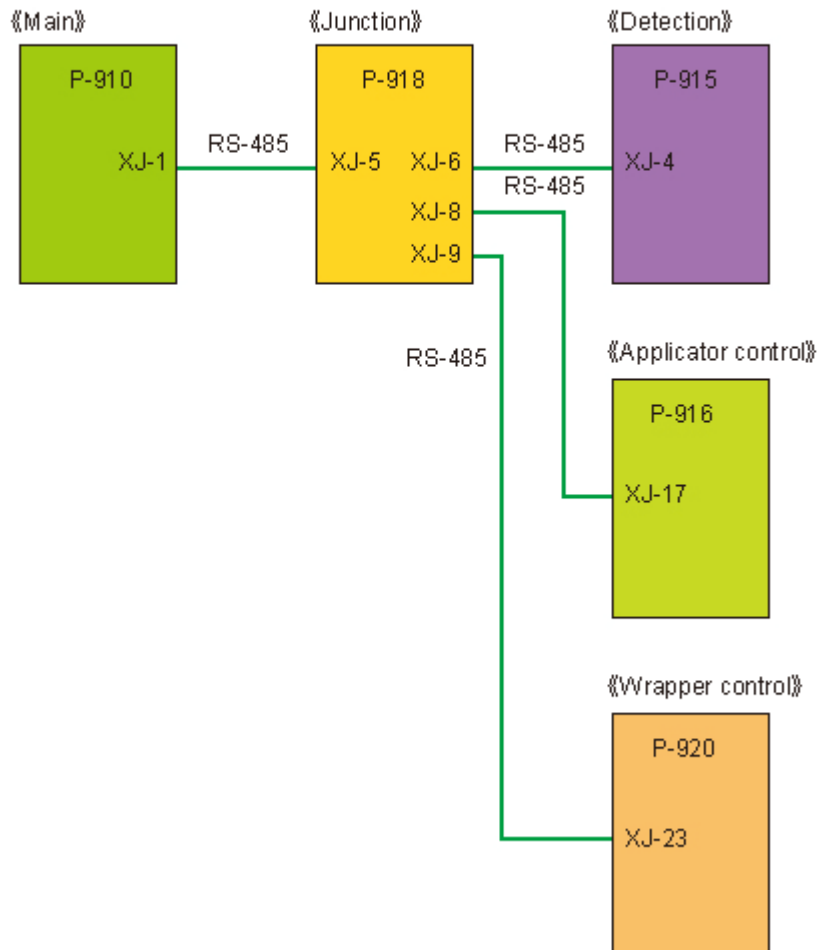
0401

```
┌────────────────────────────────────────────────┐
│              PACKING CONTROL PART                │
│  ┌────────────────────────────────────────────┐  │
│  │    THE WRAPPER IS NOT CONNECTED            │  │
│  └────────────────────────────────────────────┘  │
│                                                  │
│  *Confirm the connection with wrapper.          │
│  1)Press [RE-TRY] key.                          │
│  2)Press [OK] key if error is not canceled.     │
│  3)In this case, only the labeling is able       │
│     to operate.                                  │
│                                                  │
│                          ┌──────┐    ┌────────┐  │
│                          │  OK  │    │ RE-TRY │  │
│                          └──────┘    └────────┘  │
│  0401-0000                                       │
└────────────────────────────────────────────────┘
```

[Error content]	The wrapper is not connected.
[Detail]	Communication error after power has been turned ON. Communication phase is listed in the sub-error.
[Solution]	[OK] button: Cancel the error and continue. [Re-try] button: Re-check the connection with the wrapper.
[Remarks]	The wrapper is separated by pressing the [OK] button and only weighing and pricing can be performed.
[Cause]	Communication is not possible between boards P-910 ->P-918 ->P-920.
[Response]	Press the [Re-try] key to re-attempt communication.. If an error re-occurs, check the list below for probable causes. 1) Connector removed 2) Burned out harness 3) Board P-910 is faulty 4) Board P-918 is faulty 5) Board P-920 is faulty · This error can also occur when there is a closed circuit failure in the RS-485 line P-915 and P-916. Check this if this is not repaired by steps 1 through 5. · Connect P-915, P-916, and P-920 one by one and look for a closed circuit failure. Confirm with a drawing

0401

RS-485 Communication

《Main》 《Junction》 《Detection》

P-910 ── XJ-1 ──RS-485── XJ-5 ── P-918 ── XJ-6 ──RS-485── XJ-4 ── P-915

XJ-8 ──RS-485──

XJ-9

RS-485

《Applicator control》

P-916

XJ-17

《Wrapper control》

P-920

XJ-23

0402

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┌─────────────────────────────────────────────────────────┐
│              PACKING CONTROL PART                        │
├─────────────────────────────────────────────────────────┤
│                                                          │
│       THERE WAS NO RESPONSE FROM WRAPPER                 │
│                                                          │
│  *Confirm the connection with wrapper.                   │
│                                                          │
│  1)Press [RE-TRY] key.                                   │
│                                                          │
│  2)Press [OK] key if error is not canceled.              │
│                                                          │
│  3)In this case, only the labeling is able               │
│                                                          │
│     to operate.                                          │
│                                                          │
│                                                          │
│                              ┌──────┐      ┌────────┐    │
│                              │  OK  │      │ RE-TRY │    │
│                              └──────┘      └────────┘    │
│   0402-0000                                              │
└─────────────────────────────────────────────────────────┘
```
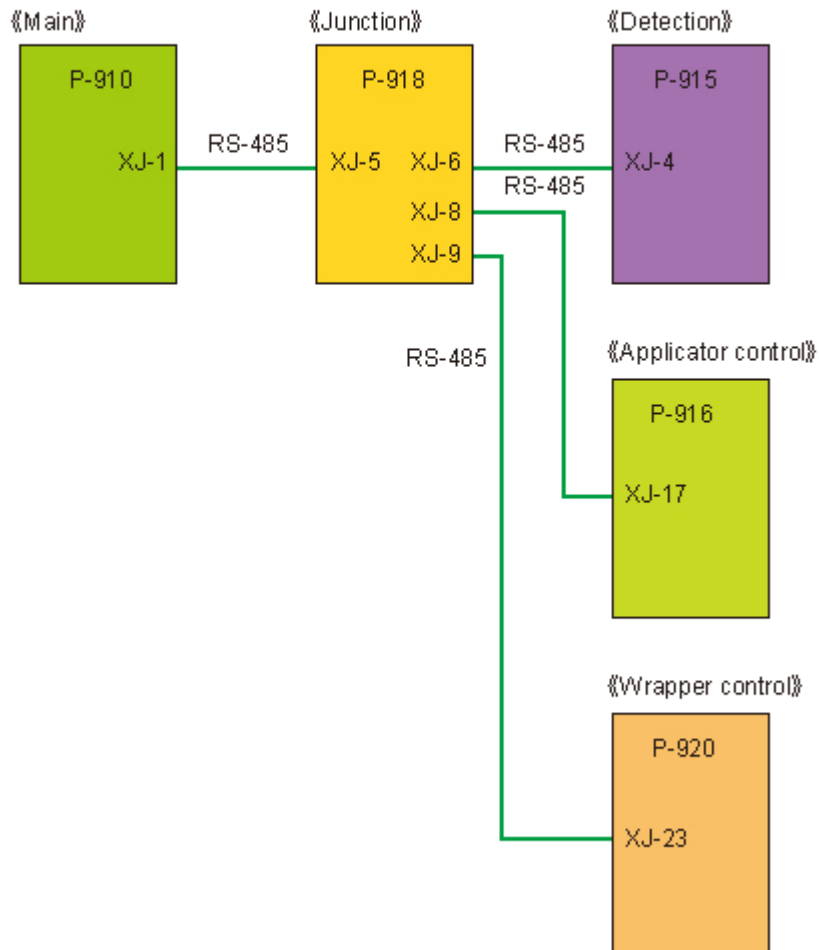
[Error content]	The wrapper is not responding
[Detail]	Communication error after power has been turned ON. Communication phase is listed in the sub-error.
[Solution]	[OK] button: Cancel the error and continue. [Re-try] button: Re-check the connection with the wrapper.
[Remarks]	The wrapper is separated by pressing the [OK] button and only weighing and pricing can be performed.
[Cause]	P-910<- P-918<- P-920（P-920 is not responding）
[Response]	Press the [Re-try] key to re-attempt communication.. If an error re-occurs, check the list below for probable causes. 1)Connector removed 2)Burned out harness 3)Board P-910 is faulty 4)Board P-918 is faulty 5)Board P-920 is faulty ・ This error can also occur when there is a closed circuit failure in the RS-485 line P-915 and P-916. Check this if this is not repaired by steps 1 through 5. ・ Connect P-915, P-916, and P-920 one by one and look for a closed circuit failure. Confirm with a drawing

0402
RS-485 Communication

《Main》
P-910
XJ-1

RS-485

《Junction》
P-918
XJ-5   XJ-6
XJ-8
XJ-9

RS-485

《Detection》
P-915
XJ-4

RS-485

RS-485

《Applicator control》
P-916
XJ-17

《Wrapper control》
P-920
XJ-23

0403

```
┌─────────────────────────────────────────────────┐
│           PACKING CONTROL PART                  │
├─────────────────────────────────────────────────┤
│        THE PROBLEM AROSE IN WRAPPER             │
│                                                 │
│ *Release should reswitch on the power after shutting off │
│  the power supply and  waiting for 10 seconds.  │
│ *Send command and receive command               │
│  does not match.                                │
│                                                 │
│                                                 │
│                                                 │
│                                                 │
│                                                 │
│  0403-0000                                      │
└─────────────────────────────────────────────────┘
```

[Error content]	Communication failure with the wrapper
[Detail]	Send command and receive command do not match
[Solution]	Restore power
[Remarks]	
[Cause]	Send command and receive command do not match The command sent to P–920 by P–910 and the command that returned from P–920 do not match.
[Response]	This does not occur during normal operation, but it is believed to occur from the effect of noise. Cancel by restoring power.

0406

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┌─────────────────────────────────────────────────────┐
│ ████████████ PACKING CONTROL PART ████████████        │
│                                                       │
│ ███ THE WRAPPER DETECTED THE INSTANT POWER FAILURE ███│
│                                                       │
│                                                       │
│ *Release should reswitch on the power after shutting off│
│  the power supply and  waiting for 10 seconds.        │
│                                                       │
│                                                       │
│                                                       │
│                                                       │
│                                                       │
│                                                       │
│                                                       │
│                                                       │
│                                                       │
│                                                       │
│  0406-0000                                            │
└─────────────────────────────────────────────────────┘
```

[Error content]	The wrapper control board (P-920) detected the CPU reset.
[Detail]	The console received power ON notification (status query) twice from the wrapper.
[Solution]	Restore power
[Remarks]	
[Cause]	Board P-920 was reset twice
[Response]	Restore power. If the error re-occurs, check the list below for probable causes. 1) Power to the power unit (AC 200V) is unstable 2) Check the power unit output voltage (DC 24V) 　　Power unit placement

0407

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┌────────────────────────────────────────────────────────────┐
│                    PACKING CONTROL PART                      │
│  ┌────────────────────────────────────────────────────────┐ │
│  │ THE INSTANT POWER FAILURE OCCURRED BY THE CONSOLE       │ │
│  └────────────────────────────────────────────────────────┘ │
│                                                              │
│   *Release should reswitch on the power after shutting off   │
│    the power supply and  waiting for 10 seconds.             │
│                                                              │
│                                                              │
│                                                              │
│                                                              │
│                                                              │
│                                                              │
│                                                              │
│                                                              │
│                                                              │
│   0407-0000                                                  │
└────────────────────────────────────────────────────────────┘
```

[Error content]	Console CPU (Board P-920) was reset
[Detail]	Received Power ON notification from the console twice.
[Solution]	Restore power
[Remarks]	
[Cause]	Board P-920 was reset twice
[Response]	Restore power. If the error re-occurs, check the list below for probable causes. 1) Power to the power unit (AC 200V) is unstable 2) Check the power unit output voltage (DC 24V) Power unit placement

0409

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┌─────────────────────────────────────────────────────────────┐
│                    PACKING CONTROL PART                      │
├─────────────────────────────────────────────────────────────┤
│         THERE WAS NO RESPONSE FROM WRAPPER                   │
│                                                             │
│  *Confirm the connection with wrapper.                      │
│  1)Press [RE-TRY] key.                                      │
│  2)Press [OK] key if error is not canceled.                 │
│  3)In this case, only the labeling is able                  │
│     to operate.                                             │
│                                                             │
│                                                             │
│                              ┌──────┐      ┌──────┐         │
│                              │  OK  │      │RE-TRY│         │
│                              └──────┘      └──────┘         │
│   0409-0000                                                  │
└─────────────────────────────────────────────────────────────┘
```

[Error content]	The wrapper is not connected
[Detail]	Communication error after power has been turned ON.
[Solution]	[OK] button: Cancel the error and continue. [Re-try] button: Re-check the connection with the wrapper.
[Remarks]	The wrapper is separated by pressing the [OK] button and only weighing and pricing can be performed.
[Cause]	P-910<- P-918<- P-920 (P-920 is not responding)
[Response]	Press the [Re-try] key to re-attempt communication. If the error re-occurs, check the list below for probable causes. 1. DC24V is not output by the U1 power unit. Output can be confirmed by checking the green LET on the power unit. View U1 power unit placement. 2. Remove both P-915 (XJ-4) and P-916 (XJ-17) and check if the same error is displayed. If the RS-485 communication line is unusable due to the failure of these two boards, error 0409-0017 appears. If the error content changes by removing these two boards, either P-915 or P-916 is faulty. Continue here if the error content changes. 3. Remove the connector (No communication with P-910 and P-920) 4. Harness burn-out (No communication with P-910 and P-920) 5. Board P-920 is faulty 6. Board P-918 is faulty 7. Board P-910 is faulty Confirm with a drawing

0409

U1 Power Supply Placement
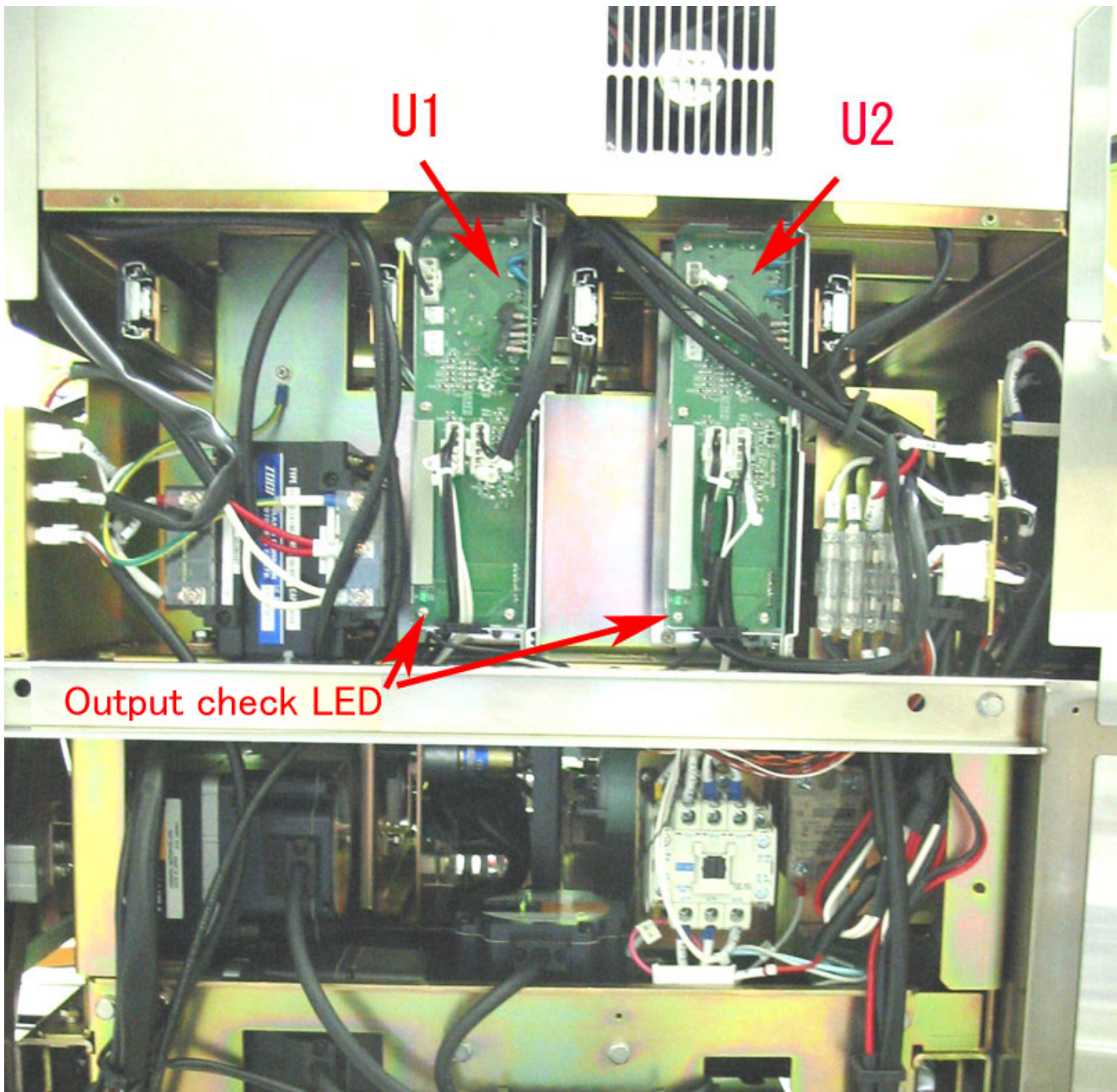
Continue here if the error content changes

1. Turn power OFF, connect P−916(XJ−17), restore power and check for an error. P−916 is faulty if error 0409−0017 is displayed.
2. Turn power OFF, connect P−915(XJ−4), restore power and check for an error. P−915 is faulty if error 0409−0017 is displayed.

0409

RS-485 Communication

《Main》

P-910

XJ-1 — RS-485 —

《Junction》

P-918

XJ-5   XJ-6 — RS-485 —

XJ-8 — RS-485 —

XJ-9

《Detection》

P-915

XJ-4

RS-485

《Applicator control》

P-916

XJ-17

《Wrapper control》

P-920

XJ-23

0410

```
PACKING CONTROL PART

THE LIFT MOTOR ERROR

《REMOVE THE FILM AND LABEL》
1)Press ENERGENCY switch, REMOVE
   item on lift and infeed conveyor.
2)Open the front cover and remove the label.

*Display goes back when the label is removed.
*Label feeds by pressing flashing yellow.

                                        1

                                                    RETURN
0410-0000
```
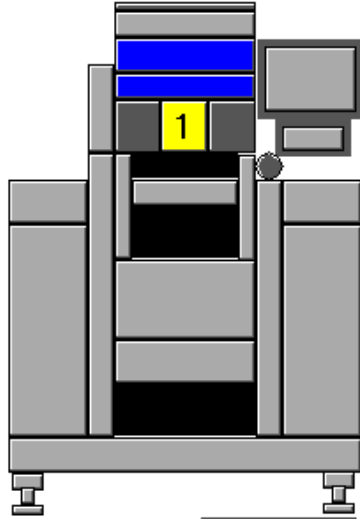
[Error content]	Lift motor error
[Detail]	Lift motor operation did not finish normally. Sub-error meanings are as follows: 0001 : Operation wasn't completed when the operation protection timer ran out.
[Solution]	[RETURN] button
[Remarks]	
[Cause]	There is a load on the lift drive motor and operation did not finish in the normal amount of time.
[Response]	Perform lift test in test mode and check the mechanism to confirm the motor can move freely.

0411

```
┌──────────────────────────────────────────────────┐
│                PACKING CONTROL PART                │
├──────────────────────────────────────────────────┤
│          THE RIGHT FILM PLUG MOTOR ERROR           │
│                                                    │
│  《REMOVE THE FILM AND LABEL》                      │
│  1)Press ENERGENCY switch, REMOVE                  │
│     item on lift and infeed conveyor.              │
│  2)Open the front cover and remove the label.      │
│                                                    │
│  *Display goes back when the label is removed.     │
│  *Label feeds by pressing flashing yellow.         │
│                                                    │
│                                        ┌────────┐  │
│  0411-0000                             │ RETURN │  │
│                                        └────────┘  │
└──────────────────────────────────────────────────┘
```
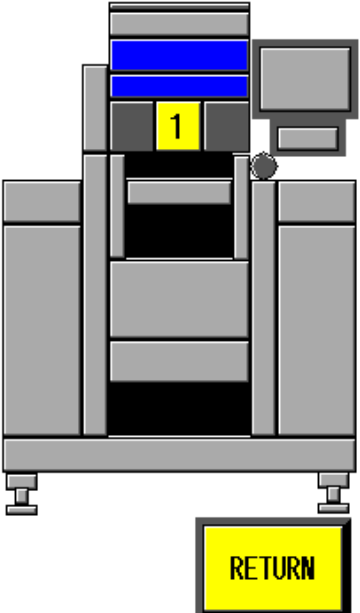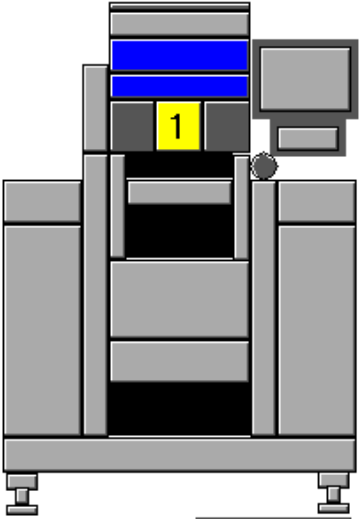
[Error content]	Film insert (right) motor error
[Detail]	Film insert (right) motor operation did not finish operation normally. Sub-error meanings are as follows:
	0001 — Operation wasn't completed when the operation protection timer ran out.
	0002 — Cannot detect speed pulse signal from the DCB motor (driver board).
	0003 — DCB motor alarm (overload)
	0004 — DCB motor alarm Determine by the number of blinks by the driver board LED
[Solution]	[RETURN] button
[Remarks]	Confirm DC Brushless driver board placement
[Cause]	Confirm that the right-hand film insert drive motor unit operates smoothly. The location of the failure can be determined by the number of times the LED blinks and the sub-error code.
[Response]	Respond to the sub-error code as necessary by the number of LED blinks.

0411

Find out the cause of failure from the blinking red LED on the DC brushless driver board.

Alarm LED	Alarm content
No light	Normal
Lit	Ground
Blinks twice	Electrical overload
Blinks three times	Lacking a phase
Blinks four times	Excess voltage
Blinks five times	Undervoltage
Blinks six times	Over-speed

0412

```
┌─────────────────────────────────────────────────────────┐
│              PACKING CONTROL PART                        │
├─────────────────────────────────────────────────────────┤
│        THE LEFT FILM PLUG MOTOR ERROR                    │
├─────────────────────────────────────────────────────────┤
│                                                          │
│ 《REMOVE THE FILM AND LABEL》                             │
│ 1)Press ENERGENCY switch, REMOVE                         │
│   item on lift and infeed conveyor.                      │
│ 2)Open the front cover and remove the label.             │
│                                                          │
│ *Display goes back when the label is removed.            │
│ *Label feeds by pressing flashing yellow.                │
│                                                          │
│                                              ┌────────┐  │
│                                              │ RETURN │  │
│  0412-0000                                   └────────┘  │
└─────────────────────────────────────────────────────────┘
```
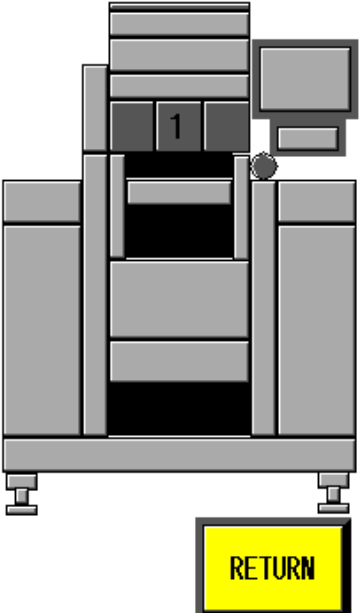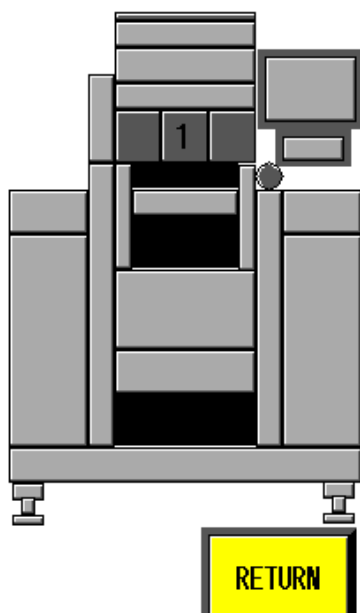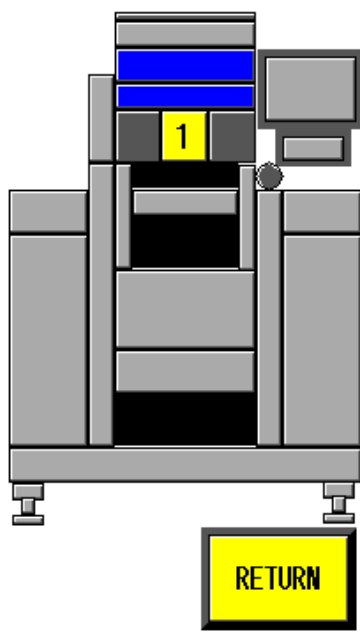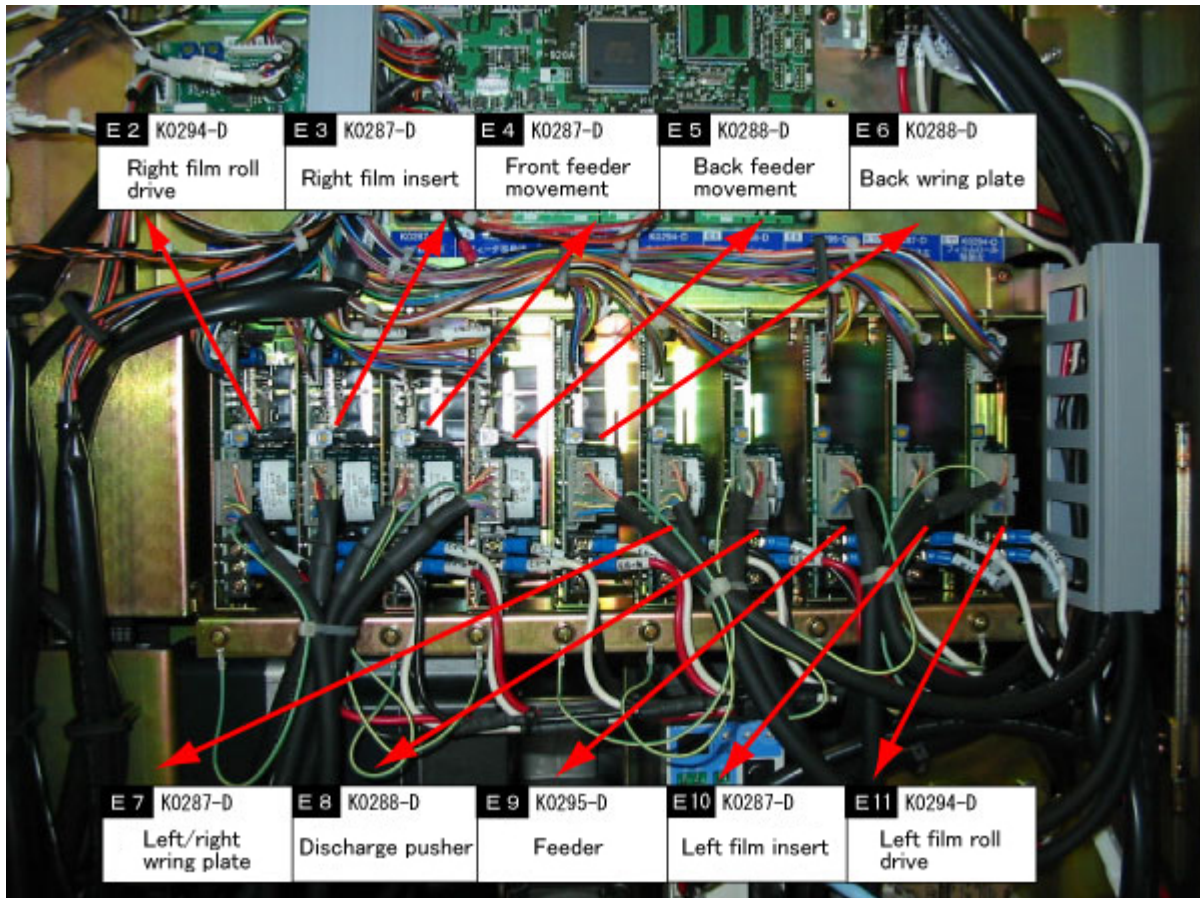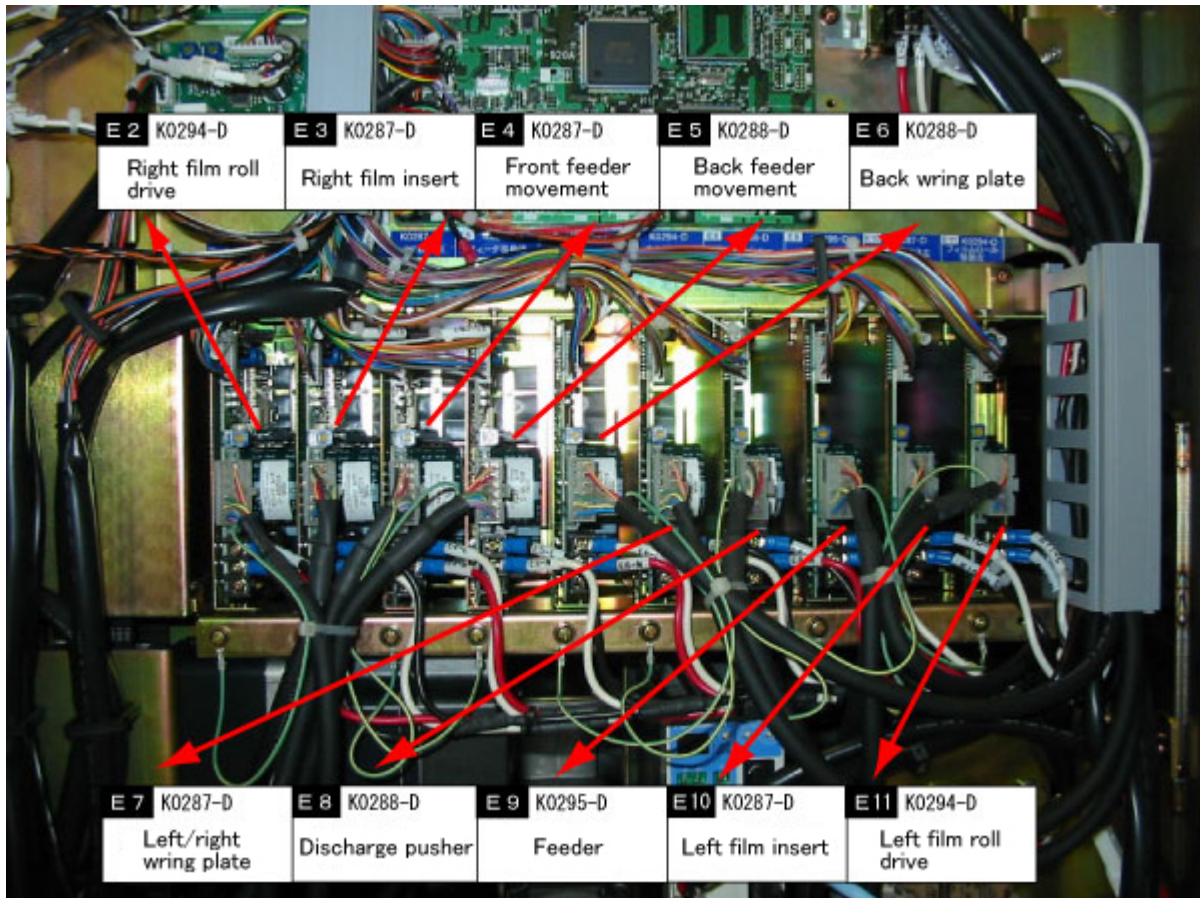
[Error content]	Film insert (left) motor error
[Detail]	Film insert (left) motor operation did not finish operation normally. Sub-error meanings are as follows:
	0001 — Operation wasn't completed when the operation protection timer ran out.
	0002 — Cannot detect speed pulse signal from the DCB motor (driver board).
	0003 — DCB motor alarm (overload)
	0004 — DCB motor alarm / Determine by the number of blinks by the driver board LED
[Solution]	[RETURN] button
[Remarks]	Confirm DC Brushless driver board placement
[Cause]	Confirm that the left-hand film insert drive motor unit operates smoothly. The location of the failure can be determined by the number of times the LED blinks and the sub-error code.
[Response]	Respond to the sub-error code as necessary by the number of LED blinks.

0412

Find out the cause of failure from the blinking red LED on the DC brushless driver board.

Alarm LED	Alarm content
No light	Normal
Lit	Ground
Blinks twice	Electrical overload
Blinks three times	Lacking a phase
Blinks four times	Excess voltage
Blinks five times	Undervoltage
Blinks six times	Over-speed

0413

```
PACKING CONTROL PART

THE RIGHT FILM ROLLER DRIVER MOTOR ERROR

《REMOVE THE FILM AND LABEL》
1)Press ENERGENCY switch, REMOVE
   item on lift and infeed conveyor.
2)Open the front cover and remove the label.

*Display goes back when the label is removed.
*Label feeds by pressing flashing yellow.

                                              RETURN

0413-0000
```
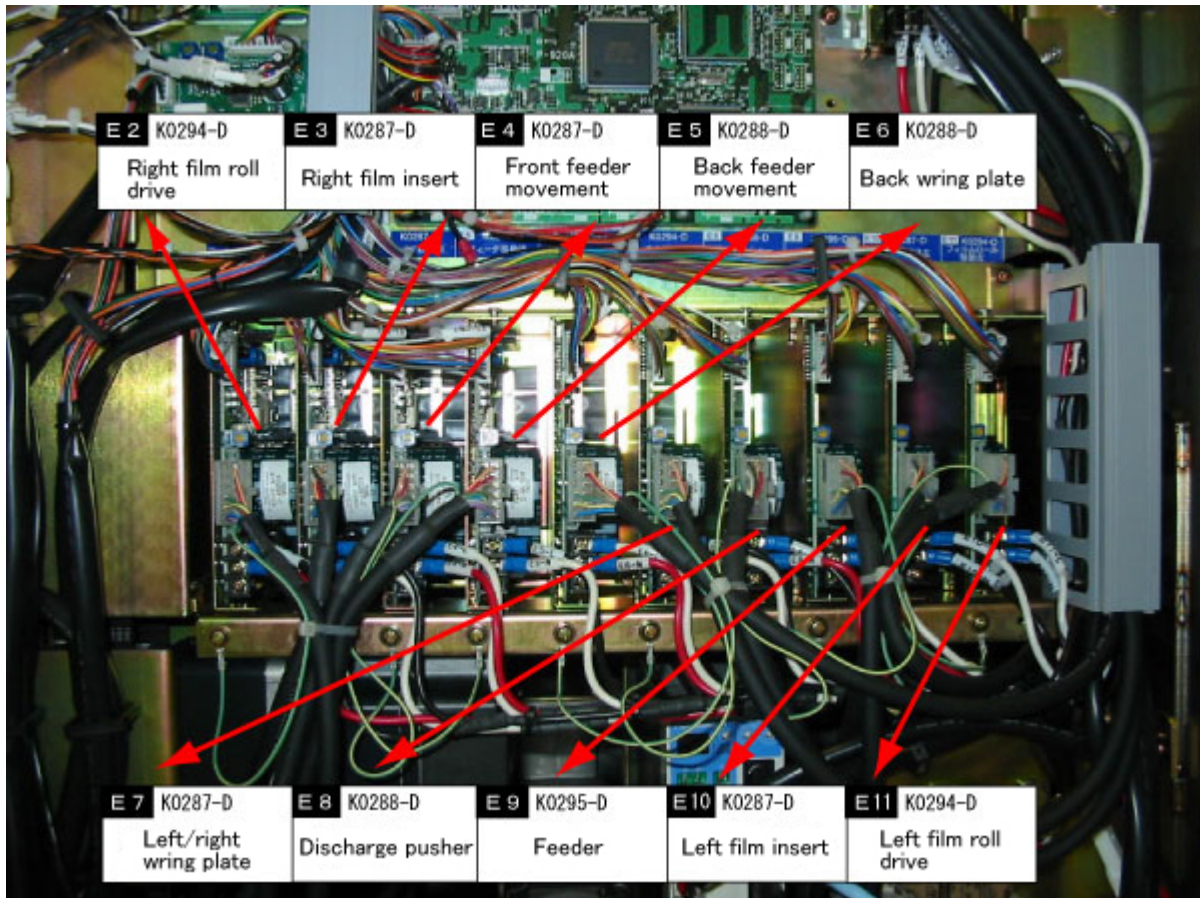
[Error content]	Film roll drive (right) motor error		
[Detail]	Film roll drive (right) motor operation did not finish operation normally. Sub-error meanings are as follows:		
	0001	Operation wasn't completed when the operation protection timer ran out.	
	0002	Cannot detect speed pulse signal from the DCB motor (driver board).	
	0003	DCB motor alarm (overload)	
	0004	DCB motor alarm Determine by the number of blinks by the driver board LED	
[Solution]	[RETURN] button		
[Remarks]	Confirm DC Brushless driver board placement		
[Cause]	Confirm that the film roll drive (right) motor unit operates smoothly. The location of the failure can be determined by the number of times the LED blinks and the sub-error code.		
[Response]	Respond to the sub-error code as necessary by the number of LED blinks.		

0413

Find out the cause of failure from the blinking red LED on the DC brushless driver board.

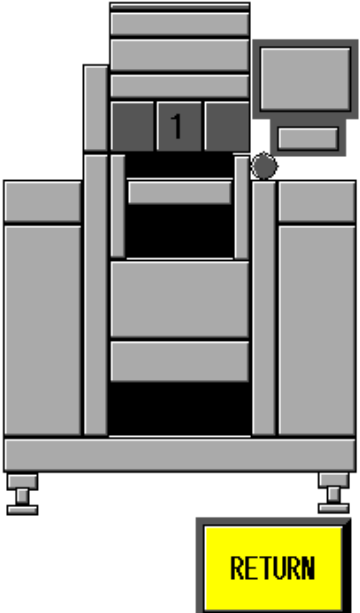| Alarm LED	Alarm content
No light	Normal
Lit	Ground
Blinks twice	Electrical overload
Blinks three times	Lacking a phase
Blinks four times	Excess voltage
Blinks five times	Undervoltage
Blinks six times	Over-speed
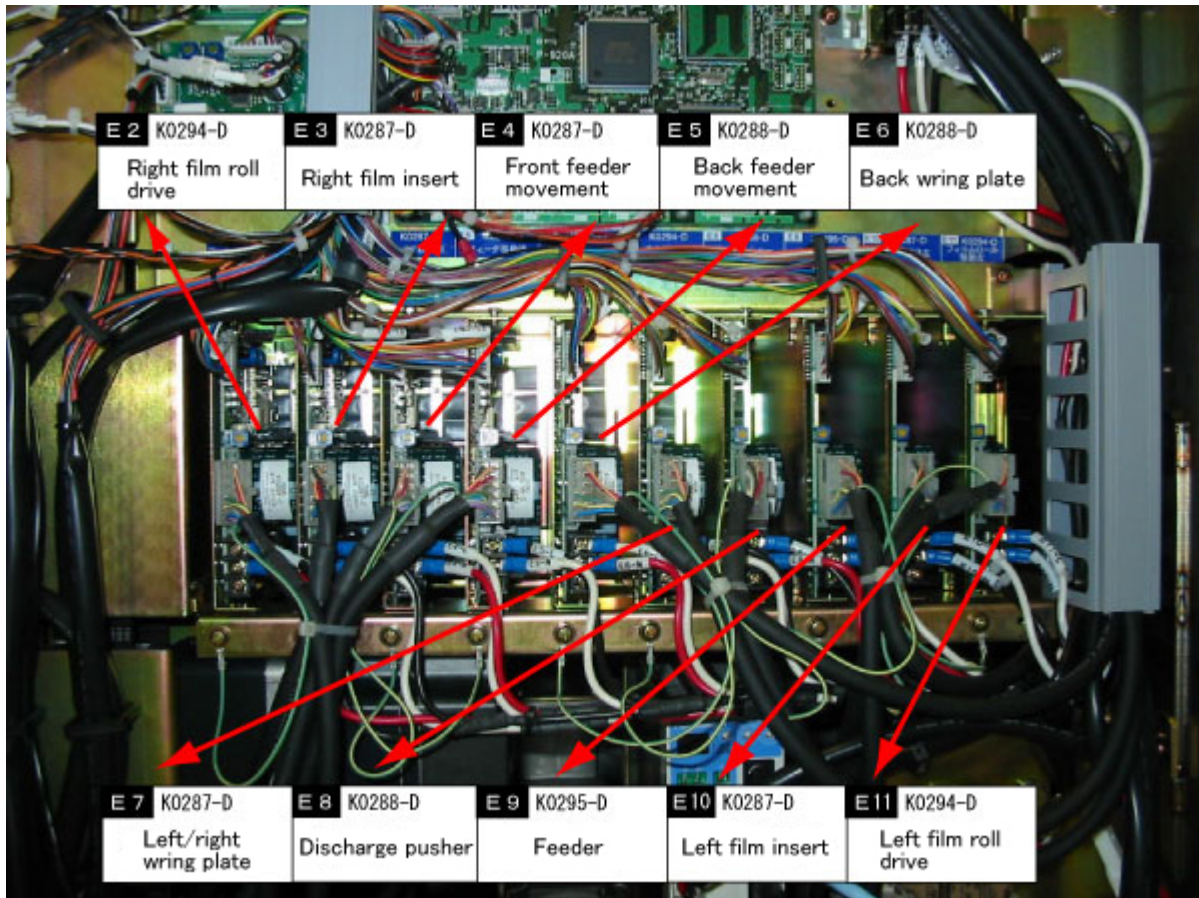
0414

```
PACKING CONTROL PART

THE LEFT FILM ROLLER DRIVER MOTOR ERROR

《REMOVE THE FILM AND LABEL》
1)Press ENERGENCY switch, REMOVE
   item on lift and infeed conveyor.
2)Open the front cover and remove the label.

*Display goes back when the label is removed.
*Label feeds by pressing flashing yellow.

                                              1

                                          RETURN
0414-0000
```
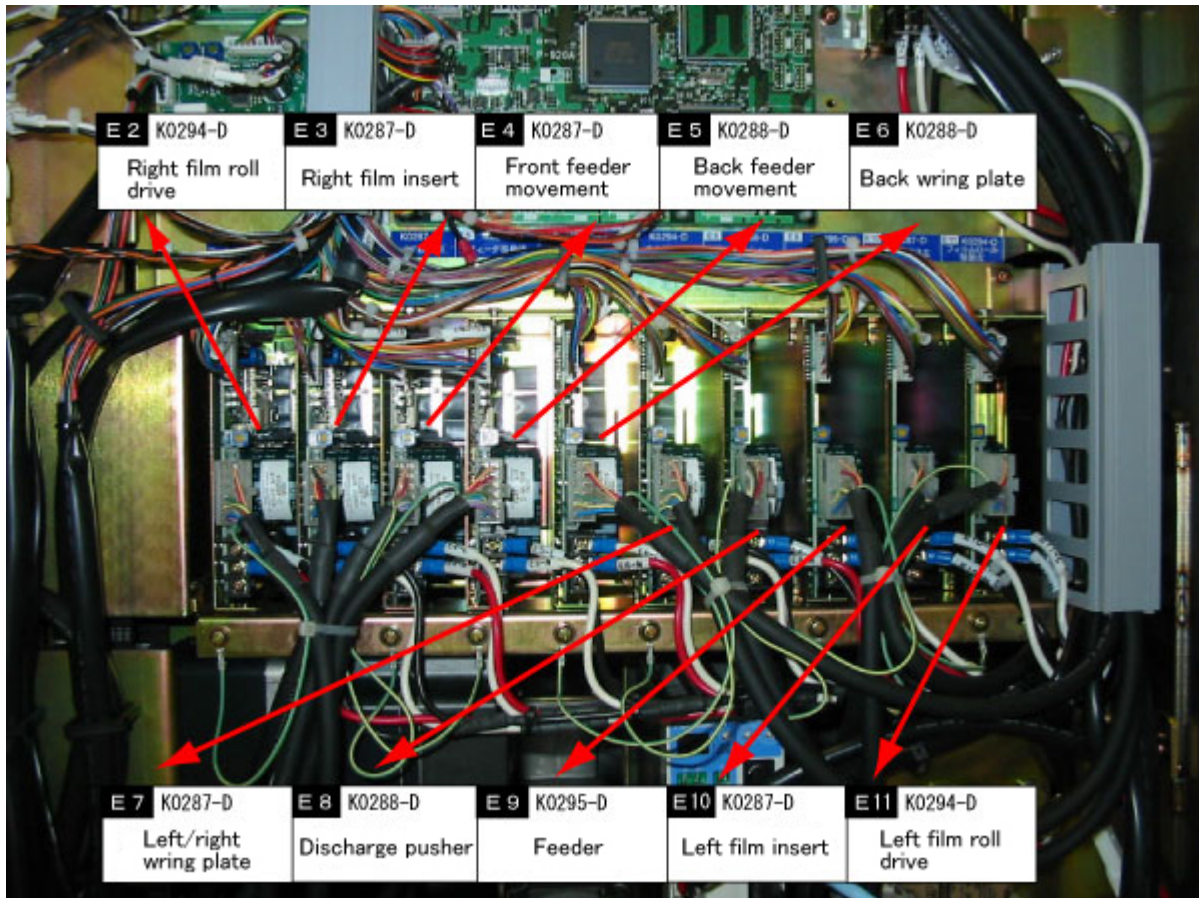
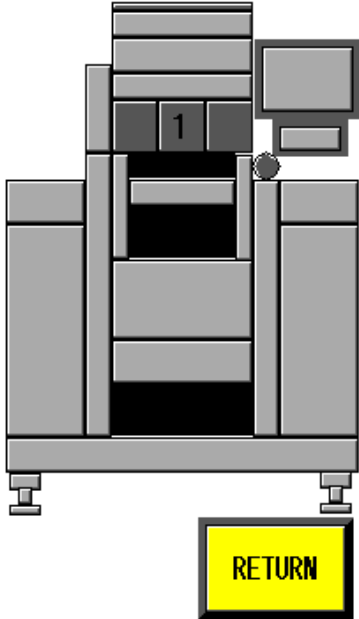| [Error content]	Film roll drive (left) motor error	
[Detail]	Film roll drive (left) motor operation did not finish operation normally. Sub-error meanings are as follows:	
	0001	Operation wasn't completed when the operation protection timer ran out.
	0002	Cannot detect speed pulse signal from the DCB motor (driver board).
	0003	DCB motor alarm (overload)
	0004	DCB motor alarm Determine by the number of blinks by the driver board LED
[Solution]	[RETURN] button	
[Remarks]	Confirm DC Brushless driver board placement	
[Cause]	Confirm that the film roll drive (left) motor unit operates smoothly. The location of the failure can be determined by the number of times the LED blinks and the sub-error code.	
[Response]	Respond to the sub-error code as necessary by the number of LED blinks.	

0414

Find out the cause of failure from the blinking red LED on the DC brushless driver board.

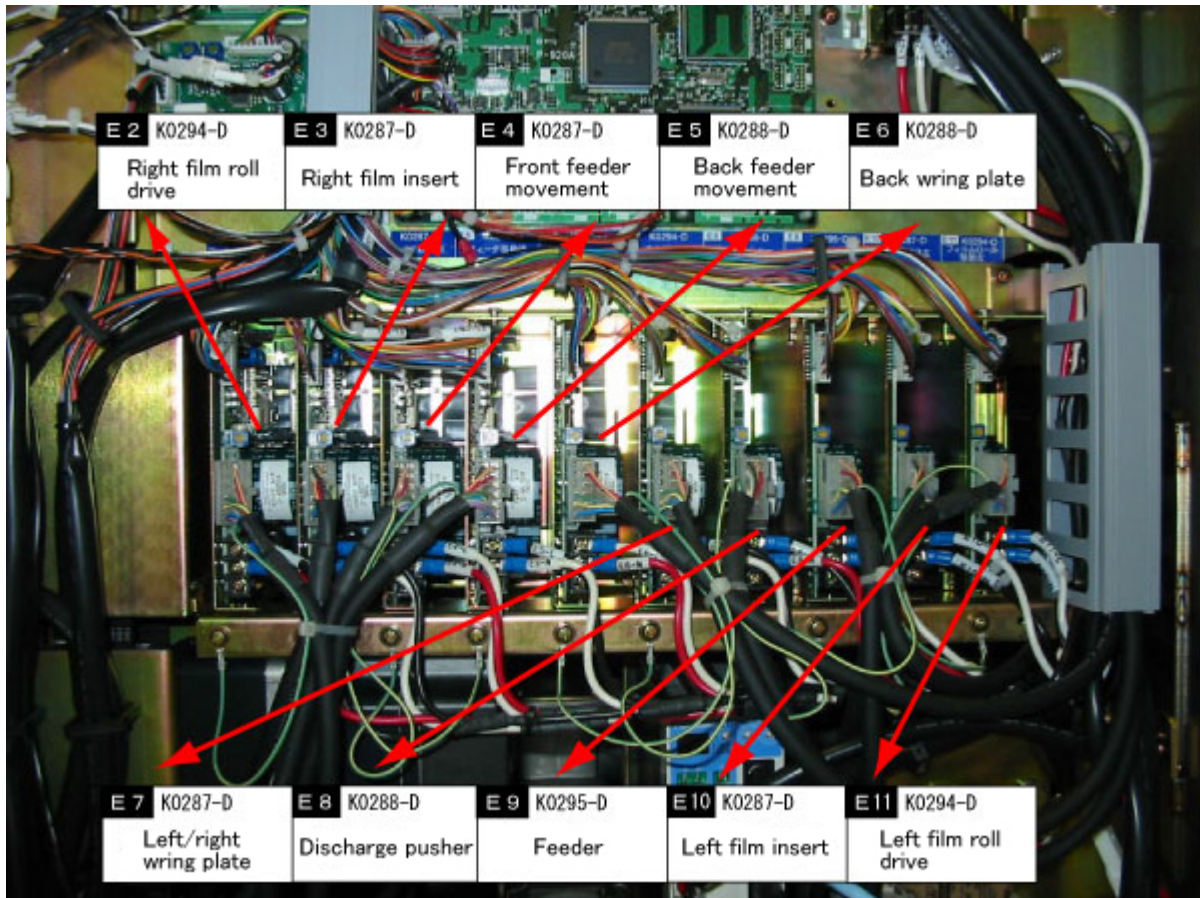| Alarm LED	Alarm content
No light	Normal
Lit	Ground
Blinks twice	Electrical overload
Blinks three times	Lacking a phase
Blinks four times	Excess voltage
Blinks five times	Undervoltage
Blinks six times	Over-speed

0415

PACKING CONTROL PART

THE BACK WRING MOTOR ERROR

《REMOVE THE FILM AND LABEL》

1)Press ENERGENCY switch, REMOVE
   item on lift and infeed conveyor.

2)Open the front cover and remove the label.

*Display goes back when the label is removed.
*Label feeds by pressing flashing yellow.

1

RETURN

0415-0000

[Error content]	Rear wrapping plate motor error		
[Detail]	Rear wrapping plate motor operation did not finish operation normally. Sub-error meanings are as follows:		
	0001	Operation wasn't completed when the operation protection timer ran out.	
	0002	Cannot detect speed pulse signal from the DCB motor (driver board).	
	0003	DCB motor alarm (overload)	
	0004	DCB motor alarm Determine by the number of blinks by the driver board LED	
[Solution]	[RETURN] button		
[Remarks]	Confirm DC Brushless driver board placement		
[Cause]	Confirm that the rear wrapping plate motor drive unit operates smoothly. The location of the failure can be determined by the number of times the LED blinks and the sub-error code.		
[Response]	Respond to the sub-error code as necessary by the number of LED blinks.		

0415

Find out the cause of failure from the blinking red LED on the DC brushless driver board.

Alarm LED	Alarm content
No light	Normal
Lit	Ground
Blinks twice	Electrical overload
Blinks three times	Lacking a phase
Blinks four times	Excess voltage
Blinks five times	Undervoltage
Blinks six times	Over-speed

0416

```
┌─────────────────────────────────────────────────────────┐
│                 PACKING CONTROL PART                     │
│  ┌───────────────────────────────────────────────────┐  │
│  │    THE LEFT AND RIGHT WRING MOTOR ERROR           │  │
│  └───────────────────────────────────────────────────┘  │
│                                                          │
│  《REMOVE THE FILM AND LABEL》                           │
│  1)Press ENERGENCY switch, REMOVE                        │
│     item on lift and infeed conveyor.                    │
│  2)Open the front cover and remove the label.            │
│                                                          │
│  *Display goes back when the label is removed.           │
│  *Label feeds by pressing flashing yellow.               │
│                                                          │
│                                          ┌──────────┐    │
│                                          │  RETURN  │    │
│                                          └──────────┘    │
│  0416-0000                                               │
└─────────────────────────────────────────────────────────┘
```
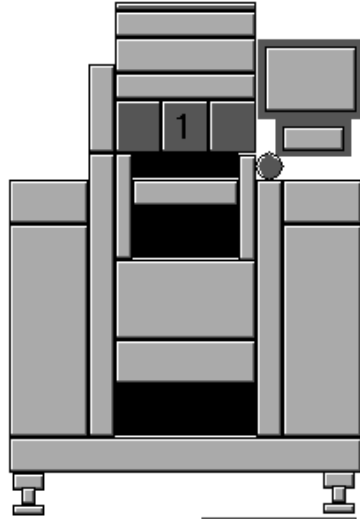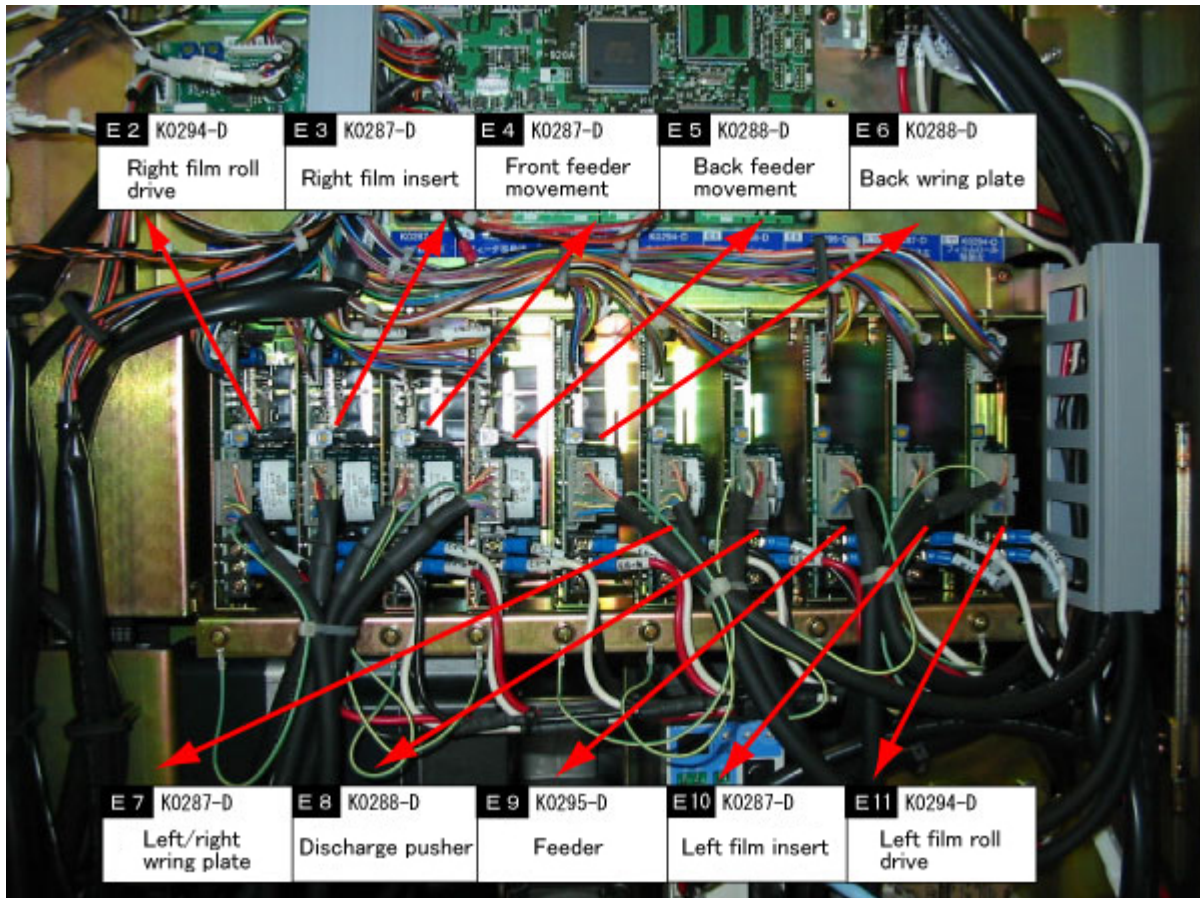
[Error content]	Side wrapping plate motor error	
[Detail]	Side wrapping plate motor operation did not finish operation normally. Sub-error meanings are as follows:	
	0001	Operation wasn't completed when the operation protection timer ran out.
	0002	Cannot detect speed pulse signal from the DCB motor (driver board).
	0003	DCB motor alarm (overload)
	0004	DCB motor alarm Determine by the number of blinks by the driver board LED
[Solution]	[RETURN] button	
[Remarks]	Confirm DC Brushless driver board placement	
[Cause]	Confirm that the side wrapping plate drive motor unit operates smoothly. The location of the failure can be determined by the number of times the LED blinks and the sub-error code.	
[Response]	Respond to the sub-error code as necessary by the number of LED blinks.	

0416

Find out the cause of failure from the blinking red LED on the DC brushless driver board.

Alarm LED	Alarm content
No light	Normal
Lit	Ground
Blinks twice	Electrical overload
Blinks three times	Lacking a phase
Blinks four times	Excess voltage
Blinks five times	Undervoltage
Blinks six times	Over-speed

0417

```
┌─────────────────────────────────────────────────────────┐
│                  PACKING CONTROL PART                    │
├─────────────────────────────────────────────────────────┤
│              THE OUTFEED MOTOR ERROR                     │
│                                                          │
│  《REMOVE THE FILM AND LABEL》                             │
│  1)Press ENERGENCY switch, REMOVE                        │
│    item on lift and infeed conveyor.                     │
│  2)Open the front cover and remove the label.            │
│                                                          │
│  *Display goes back when the label is removed.           │
│  *Label feeds by pressing flashing yellow.               │
│                                                          │
│                                             RETURN       │
│  0417-0000                                               │
└─────────────────────────────────────────────────────────┘
```
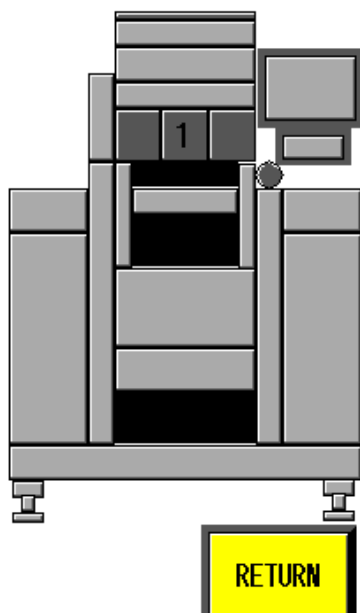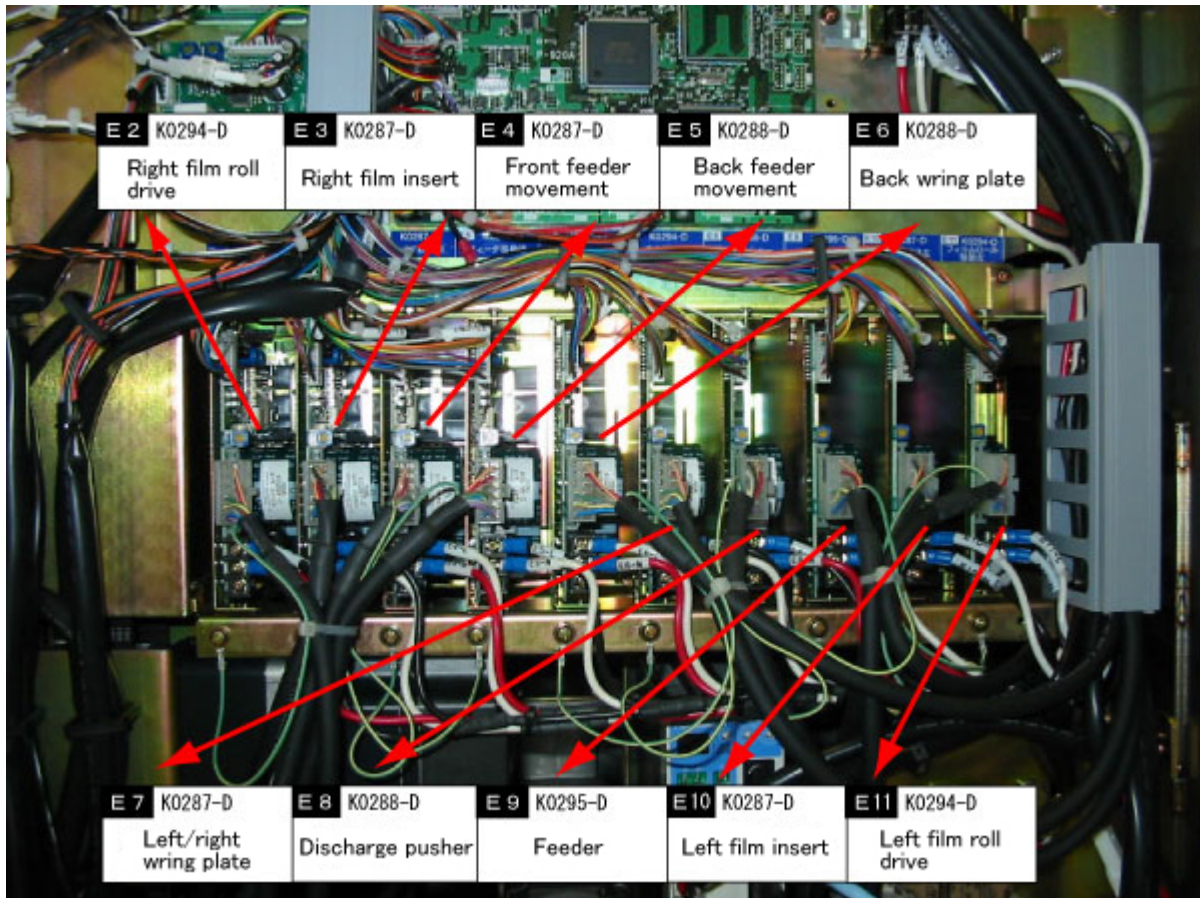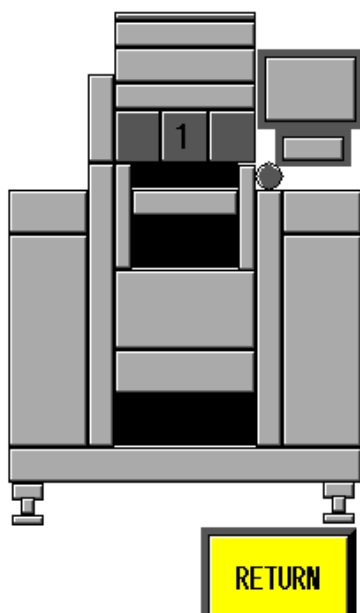
[Error content]	Discharge pusher motor error	
[Detail]	Discharge pusher motor operation did not finish operation normally. Sub-error meanings are as follows:	
	0001	Operation wasn't completed when the operation protection timer ran out.
	0002	Cannot detect speed pulse signal from the DCB motor (driver board).
	0003	DCB motor alarm (overload)
	0004	DCB motor alarm Determine by the number of blinks by the driver board LED
	0005	Began next item operation before the previous opertion was completed (unsuitable wrapper condition).
	0006	The next item stuck out before the previous operation was completed (unsuitable wrapper condition).
[Solution]	[RETURN] button	
[Remarks]	Confirm DC Brushless driver board placement	
[Cause]	Confirm that the discharge pusher motor operates smoothly. The location of the failure can be determined by the number of times the LED blinks and the sub-error code.	
[Response]	Respond to the sub-error code as necessary by the number of LED blinks.	

0417

Find out the cause of failure from the blinking red LED on the DC brushless driver board.

Alarm LED	Alarm content
No light	Normal
Lit	Ground
Blinks twice	Electrical overload
Blinks three times	Lacking a phase
Blinks four times	Excess voltage
Blinks five times	Undervoltage
Blinks six times	Over-speed

0418

```
┌─────────────────────────────────────────────────────────┐
│                  PACKING CONTROL PART                     │
│  ┌─────────────────────────────────────────────────────┐ │
│  │              THE FEEDER MOTOR ERROR                  │ │
│  └─────────────────────────────────────────────────────┘ │
│                                                           │
│  《REMOVE THE FILM AND LABEL》                            │
│  1)Press ENERGENCY switch, REMOVE                         │
│     item on lift and infeed conveyor.                     │
│  2)Open the front cover and remove the label.             │
│                                                           │
│  *Display goes back when the label is removed.            │
│  *Label feeds by pressing flashing yellow.                │
│                                                           │
│                                              ┌─────────┐  │
│                                              │ RETURN  │  │
│     0418-0000                                └─────────┘  │
└─────────────────────────────────────────────────────────┘
```
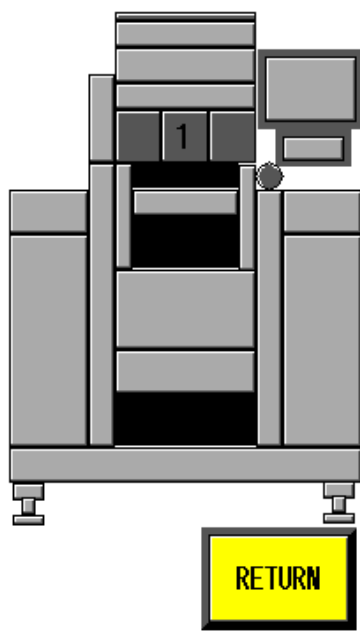
[Error content]	Feeder motor error	
[Detail]	Feder motor operation did not finish operation normally. Sub-error meanings are as follows:	
	0001	Operation wasn't completed when the operation protection timer ran out.
	0002	Cannot detect speed pulse signal from the DCB motor (driver board).
	0003	DCB motor alarm (overload)
	0004	DCB motor alarm Determine by the number of blinks by the driver board LED
[Solution]	[RETURN] button	
[Remarks]	Confirm DC Brushless driver board placement	
[Cause]	Confirm that the feeder drive motor unit operates smoothly. The location of the failure can be determined by the number of times the LED blinks and the sub-error code.	
[Response]	Respond to the sub-error code as necessary by the number of LED blinks.	

0418

Find out the cause of failure from the blinking red LED on the DC brushless driver board.

Alarm LED	Alarm content
No light	Normal
Lit	Ground
Blinks twice	Electrical overload
Blinks three times	Lacking a phase
Blinks four times	Excess voltage
Blinks five times	Undervoltage
Blinks six times	Over-speed

0419

```
PACKING CONTROL PART

THE FRONT FEEDER MOVEMENT MOTOR ERROR

《REMOVE THE FILM AND LABEL》
1)Press ENERGENCY switch, REMOVE
   item on lift and infeed conveyor.
2)Open the front cover and remove the label.

*Display goes back when the label is removed.
*Label feeds by pressing flashing yellow.

                                          1

                                          RETURN

0419-0000
```
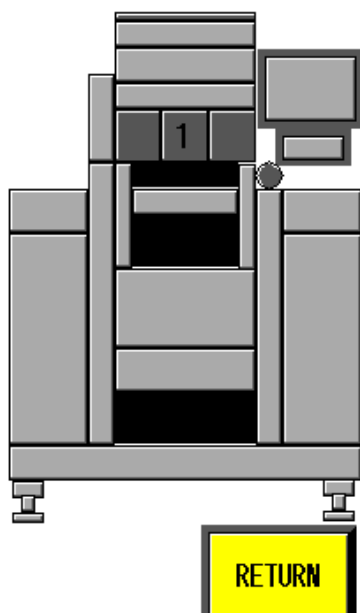
[Error content]	Feeder mover (front) motor error	
[Detail]	Feeder mover (front) motor operation did not finish operation normally. Sub-error meanings are as follows:	
	0001	Operation wasn't completed when the operation protection timer ran out.
	0002	Cannot detect speed pulse signal from the DCB motor (driver board).
	0003	DCB motor alarm (overload)
	0004	DCB motor alarm Determine by the number of blinks by the driver board LED
[Solution]	[RETURN] button	
[Remarks]	Confirm DC Brushless driver board placement	
[Cause]	Confirm that the feeder mover (front) motor operates smoothly. The location of the failure can be determined by the number of times the LED blinks and the sub-error code.	
[Response]	Respond to the sub-error code as necessary by the number of LED blinks.	

0419

Find out the cause of failure from the blinking red LED on the DC brushless driver
board.

Alarm LED	Alarm content
No light	Normal
Lit	Ground
Blinks twice	Electrical overload
Blinks three times	Lacking a phase
Blinks four times	Excess voltage
Blinks five times	Undervoltage
Blinks six times	Over-speed

0420

```
              PACKING CONTROL PART

         THE BACK FEEDER MOVEMENT MOTOR ERROR

  《REMOVE THE FILM AND LABEL》
  1)Press ENERGENCY switch, REMOVE
     item on lift and infeed conveyor.
  2)Open the front cover and remove the label.


  *Display goes back when the label is removed.
  *Label feeds by pressing flashing yellow.



                                           RETURN

     0420-0000
```
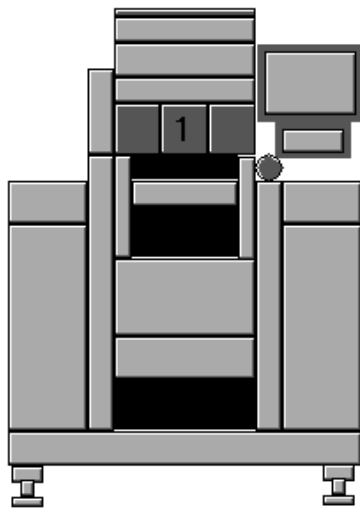
[Error content]	Feeder mover (rear) motor error
[Detail]	Feeder mover (rear) motor operation did not finish operation normally. Sub-error meanings are as follows:
	0001 Operation wasn't completed when the operation protection timer ran out.
	0002 Cannot detect speed pulse signal from the DCB motor (driver board).
	0003 DCB motor alarm (overload)
	0004 DCB motor alarm Determine by the number of blinks by the driver board LED
[Solution]	[RETURN] button
[Remarks]	Confirm DC Brushless driver board placement
[Cause]	Confirm that the feeder mover (rear) motor operates smoothly. The location of the failure can be determined by the number of times the LED blinks and the sub-error code.
[Response]	Respond to the sub-error code as necessary by the number of LED blinks.

0420

Find out the cause of failure from the blinking red LED on the DC brushless driver board.

Alarm LED	Alarm content
No light	Normal
Lit	Ground
Blinks twice	Electrical overload
Blinks three times	Lacking a phase
Blinks four times	Excess voltage
Blinks five times	Undervoltage
Blinks six times	Over-speed

0421

```
                    PACKING CONTROL PART

                    INFEED MOTOR ERROR

《REMOVE THE FILM AND LABEL》
1)Press ENERGENCY switch, REMOVE
   item on lift and infeed conveyor.
2)Open the front cover and remove the label.


*Display goes back when the label is removed.
*Label feeds by pressing flashing yellow.

                                                  1



                                            RETURN

0421-0000
```
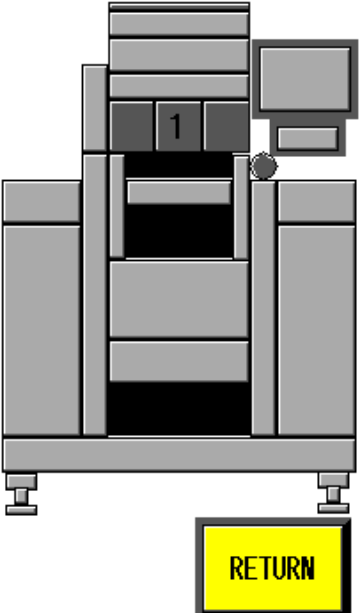
[Error content]	Infeed bar motor error		
[Detail]	Infeed bar motor operation did not finish operation normally. Sub-error meanings are as follows:		
		0001	Operation wasn't completed when the operation protection timer ran out.
		0256+	Stepping motor is out of sync. The value displays the location of the detected synchronization problem.
[Solution]	[RETURN] button		
[Remarks]			
[Cause]	Confirm that the infeed bar motor operates smoothly. Check the motor drive switching power voltage. Input AC 200V Output DC 24V		
[Response]	Respond according to the sub-error code.		

0422

```
PACKING CONTROL PART

THE CENTERING MOTOR ERROR

《REMOVE THE FILM AND LABEL》
1)Press ENERGENCY switch, REMOVE
   item on lift and infeed conveyor.
2)Open the front cover and remove the label.

*Display goes back when the label is removed.
*Label feeds by pressing flashing yellow.

                                          1

                                      RETURN
0422-0000
```

[Error content]	Centering motor error
[Detail]	Centering motor operation did not finish operation normally. Sub-error meanings are as follows: 0001：Operation wasn't completed when the operation protection timer ran out.
[Solution]	[RETURN] button
[Remarks]	
[Cause]	Confirm that the centering motor operates smoothly. Check the motor drive switching power voltage. Input AC 200V Output DC 24V
[Response]	Exchange the motor or power switch according to the error.

0423

[Error content]	Lift changeover motor error	
[Detail]	Lift changeover motor operation did not finish operation normally. Sub-error meanings are as follows:	
	0001	Operation wasn't completed when the operation protection timer ran out.
	0010	Lift changeover motor sensor abnormality (Both large and small are preventing light transmission).
	0020	Lift changeover motor sensor abnormality (Changeover destination not found).
	*Sub-error 0010, 0020 are supported after J0501C	
[Solution]	[RETURN] button	
[Remarks]		
[Cause]	0001	Operation wasn't completed when the operation protection timer ran out. Motor does not operate smoothly.
	0010	Lift changeover motor sensor abnormality (Both large and small are preventing light transmission). Dust or dirt is preventing light from reaching the sensor
	0020	Lift changeover motor sensor abnormality (Changeover destination not found). Faulty sensor
[Response]	Respond accrding to the sub-error.	

0424

```
PACKING CONTROL PART

THE OUTFEED CONVEYER MOTOR ERROR

《REMOVE THE FILM AND LABEL》
1)Press ENERGENCY switch, REMOVE
   item on lift and infeed conveyor.
2)Open the front cover and remove the label.

*Display goes back when the label is removed.
*Label feeds by pressing flashing yellow.

                                              1

                                         RETURN
0424-0000
```
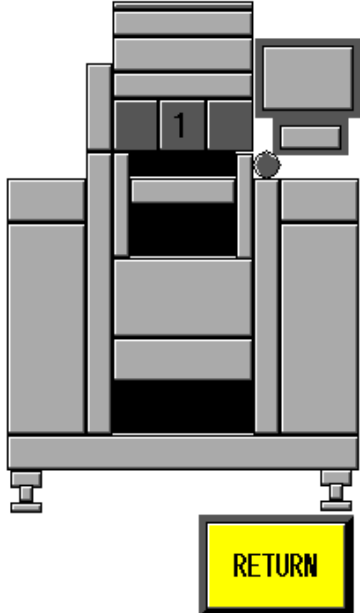
[Error content]	Discharge conveyor motor error
[Detail]	An error occurred in the stock conveyor attached to the wrapper. Discharge conveyor motor operation did not finish operation normally. Sub-error meanings are as follows:
	0001 Operation wasn't completed when the operation protection timer ran out.
	0002 Lift changeover motor sensor abnormality (Both large and small are preventing light transmission).
	0004 DCB motor alarm Determine by the number of blinks by the driver board LED
[Solution]	[RETURN] button
[Remarks]	
[Cause]	Confirm that the discharge conveyor motor operates smoothly. The location of the failure can be determined by the number of times the LED blinks and the sub-error code.
[Response]	Respond to the sub-error code as necessary by the number of LED blinks.

0424

Find out the cause of failure from the blinking red LED on the DC brushless driver board.

Alarm LED	Alarm content
No light	Normal
Lit	Ground
Blinks twice	Electrical overload
Blinks three times	Lacking a phase
Blinks four times	Excess voltage
Blinks five times	Undervoltage
Blinks six times	Over-speed

0430

[Error content]	Servo controller error
[Detail]	Recoverable servo controller error. Sub-error displays alarm type.
[Solution]	[RETURN] button
[Remarks]	Matsushita: Sub-errors start in the 600's. ・ Servo display (26: acceleration protection) ->Display EMZ 0430-0626 Refer to the servo manual by the last two digits
[Cause]	Refer to the manual
[Response]	Refer to the manual

0430

Viewing the causes and history of an alarm

• You can view the latest 14 alarms including the current one.

```
Err.  --
```

Alarm Code No. (if no errors are occurring, -- is displayed)

```
Err    : Current alarm
E-0    : No.0 alarm (the latest (current) alarm)
E-1    : No.1 alarm
E 13   : No.13 alarm (the oldest alarm)
```

• ⊗ ⊘ To select any alarm event you wanted, press UP or DOWN button for access to the desired alarm No.

(⊘ Pressing DOWN will move to older alarms.)

<Notes>

1. If an alarm which is stored in the history memory is occurring, the alarm is given E-0 (Error-0).

2. The alarm history cannot be deleted.

Alarm Numbers and Functions

Alarm Code No.	Function	Alarm Code No.	Function
1 1	Undervoltage, control power	2 7	Command pulse saler error
1 2	Overvoltage	2 8	External scale error
1 3	Undervoltage, main power	2 9	Error counter over flow
1 4	Overcurrent	3 5	External scale disconnection error
1 5	Overheat	3 6	EEPROM parameter error
1 6	Overload	3 7	EEPROM check code error
1 8	Regenerative discharge	3 8	Overtravel inhibit input error
2 0	Encoder A/B phase error	4 0	Absolute system down error
2 1	Encoder communication error	4 1	Absolute counter over flow error
2 2	Encoder connection error	4 2	Absolute over-speed error
2 3	Encoder communication data error	4 4	Absolute single-turn counter error
2 4	Position error	4 5	Absolute multi-turn counter error
2 5	Hybrid error	4 7	Absolute status error
2 6	Overspeed	Other than the above	Other errors

Appendixes

0431

```
┌─────────────────────────────────────────────────┐
│              PACKING CONTROL PART                 │
├─────────────────────────────────────────────────┤
│           THE SERVO CONTROLLER ERROR              │
│                                                   │
│  *Release should reswitch on the power after shutting off │
│   the power supply and  waiting for 10 seconds.   │
│                                                   │
│                                                   │
│                                                   │
│   0431-0000                                       │
└─────────────────────────────────────────────────┘
```

〔Error content〕	Servo controller error
〔Detail〕	Recoverable servo controller error. There is a parameter anomaly when sub-errors 0002 and 0003 are displayed. 0100 is a communication error with the servo controller. Additional sub-errors display the alarm type (refer to the remarks).
〔Solution〕	Restore power
〔Remarks〕	Mitsubishi: Sub-error has been converted to a hexidecimal number. ・ Servo display (A10: Undervoltage) -> Display EMZ 0430-0016 ・ Servo display (A33: Overvoltage) -> Display EMZ 0430-0051 （16×3+3＝51） Matsushita: Sub-errors start in the 600's. ・ Servo display (26: acceleration protection) ->Display EMZ 0430-0626 Refer to the servo manual by the last two digits In the event of error 0431-0000 Response when an error is displayed when the emergency stop was pressed during lift operation
〔Cause〕	Refer to the manual
〔Response〕	Refer to the manual

0431

Viewing the causes and history of an alarm

• You can view the latest 14 alarms including the current one.

$$Err. \quad - -$$

Alarm Code No. (if no errors are occurring, -- is displayed)

Err : Current alarm

$E-0$: No.0 alarm (the latest (current) alarm)

$E-1$: No.1 alarm

$E13$: No.13 alarm (the oldest alarm)

• ⊗ ⊗   To select any alarm event you wanted, press UP or DOWN button for access to the desired alarm No.

(⊗ Pressing DOWN will move to older alarms.)

<Notes>

1. If an alarm which is stored in the history memory is occurring, the alarm is given E-0 (Error-0).

2. The alarm history cannot be deleted.

Alarm Numbers and Functions

Alarm Code No.	Function	Alarm Code No.	Function
1 1	Undervoltage, control power	2 7	Command pulse saler error
1 2	Overvoltage	2 8	External scale error
1 3	Undervoltage, main power	2 9	Error counter over flow
1 4	Overcurrent	3 5	External scale disconnection error
1 5	Overheat	3 6	EEPROM parameter error
1 6	Overload	3 7	EEPROM check code error
1 8	Regenerative discharge	3 8	Overtravel inhibit input error
2 0	Encoder A/B phase error	4 0	Absolute system down error
2 1	Encoder communication error	4 1	Absolute counter over flow error
2 2	Encoder connection error	4 2	Absolute over-speed error
2 3	Encoder communication data error	4 4	Absolute single-turn counter error
2 4	Position error	4 5	Absolute multi-turn counter error
2 5	Hybrid error	4 7	Absolute status error
2 6	Overspeed	Other than the above	Other errors

Appendixes

0431

Situation

This error occurs in machines equipped with Matsushita servos.

During lift operation error 0431-0000 occurred after pressing the emergency stop button and then pressing the on-screen [RETRUN] button. The power must be turned off and turned back on to recover from this error.

(This error does not indicate faulty servo controller hardware)

Cause

An undervoltage alarm occurs in the servo controller when the lift is stopped by pressing the emergency stop button during operation.

The wrapper software detects an alarm signal from the servo, performs emergency stop processing, receives error clearing protocol from the main software, and sends alarm clearing protocol for the servo.

The servo, receiving alarm clearing protocol from the wrapper, clears the alarm, however, **approx. 300ms are required in this alarm clearing operation in Matsushita servos.**

The wrapper software allows for a 50ms time delay. However, the servo is in a state of alarm and the alarm is re-detected.

This was acknowledged as an unnecessary error by the main software. This time the error is in relation to the servo alarm, however, as the servo alarm retrieved was 0 (no alarm), and was processed as an unrecognized servo alarm (error 431) by the wrapper software, the condition is such that it can only be cleared by turning off the power and turning it back on.

＊This condition will not occur in Mitsubishi servos as time is not a factor in clearing alarms.

Contents of the software revision

　Software: Supported by J0576D (Wrapper software: J-0577C)
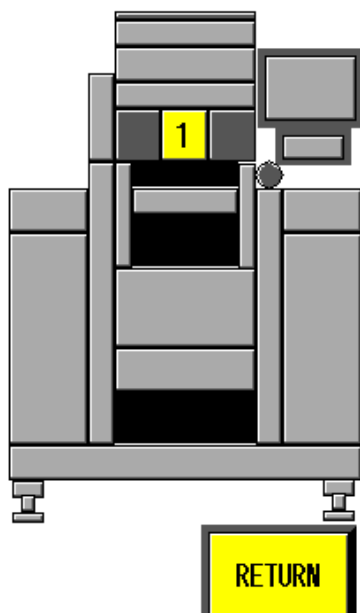
Changes the time allowed for Matsushita servo alarm clearing from 50ms to 400ms (100ms margin) and supports false servo alarm detection prevention.
Supports servo alarm 0 (no alarm) and makes normal error clearing possible.

0432

0432-0000

[Error content]	The lift reached the upper limit.
[Detail]	The upper limit configured for the servo controller was surpassed when the lift was raised.
[Solution]	[RETURN] button
[Remarks]	The upper limit (upper position) of the lift needs to be reconfigured.
[Cause]	The upper limit position configured for the servo controller has been surpassed.
[Response]	Reconfigure the upper limit (upper position) of the lift.

0433

```
PACKING CONTROL PART

THE LIFT ARRIVED AT THE MINIMUM LIMIT

*Need not to reset the upper limit of printer

                                    1

                                              RETURN

0433-0000
```

[Error content]	The lift reached the lower limit.
[Detail]	Occurs when the board detecting lift position switches off the lower limit sensor.
[Solution]	[RETURN] button
[Remarks]	The lower limit (original position) of the lift needs to be reconfigured (confirmed).
[Cause]	1. The board detecting lift position switched off the lower limit sensor 2. Lift lower limit sensor (proxy switch) anomaly
[Response]	1. Reconfigure (confirm) the lower limit (original position) of the lift 2. Check the lift lower limit sensor (proxy switch)
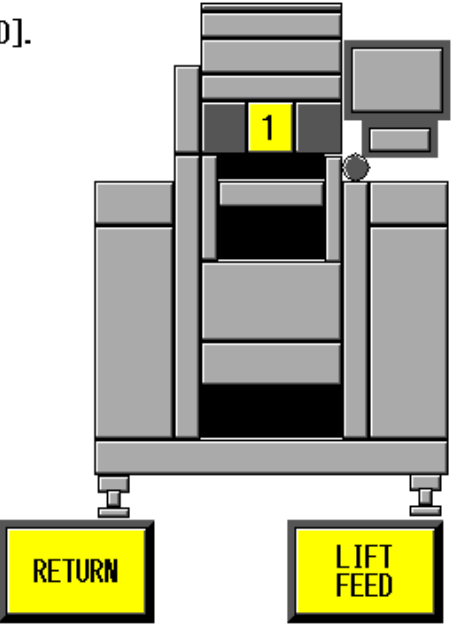
0434

```
PACKING CONTROL PART

A FOREIGN SUBSTANCE IS BIT UNDER LIFT

1)Move up the lift by pressing [LIFT FEED].
2)Turn off the power and remove
   the foreign object.

                                            1

                              RETURN      LIFT
                                          FEED
0434-0000
```

[Error content]	A foreign object is caught under the lift
[Detail]	This occurs when the servo controller detects an overload caused by a foreign object caught under the lift.
[Solution]	[RETURN] button -> Restore operation lift inching -> Lift inching operation
[Remarks]	Use lift inching to get rid of something caught under the lift.
[Cause]	A foreign object caught under the lift is causing an overload.
[Response]	Check the overload condition and remove the object by restore operation lift inching -> Lift inching operation

0435

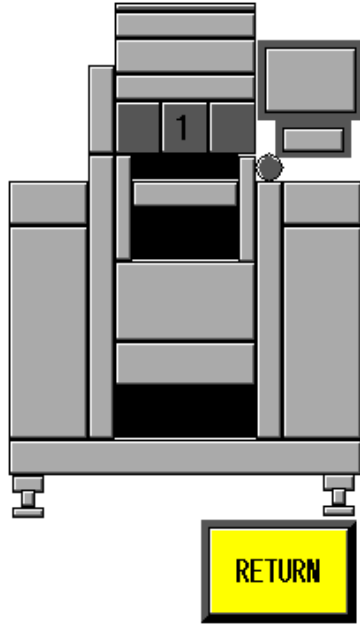PACKING CONTROL PART
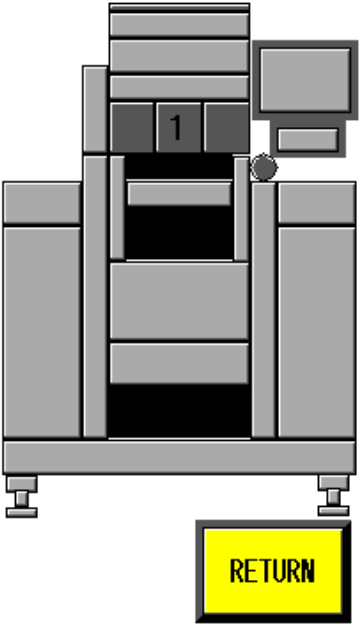
THE SERVO CONTROLLER IS ABNORMAL

《REMOVE THE FILM AND LABEL》

1)Press ENERGENCY switch, REMOVE
   item on lift and infeed conveyor.

2)Open the front cover and remove the label.

*Display goes back when the label is removed.

*Label feeds by pressing flashing yellow.

RETURN

0435-0000

[Error content]	The servo controller is abnormal
[Detail]	Occurs when intermittent discontinuity or undervoltage are detected in the servo controller.
[Solution]	[RETURN] button
[Remarks]	
[Cause]	Intermittent discontinuity or undervoltage in the servo controller power source
[Response]	Check the servo controller power source.

0436

```
┌─────────────────────────────────────────────┐
│            PACKING CONTROL PART               │
├─────────────────────────────────────────────┤
│                                               │
│     THE PARAMETER OF SERVO IS MISMATCH        │
│                                               │
│  *Release should reswitch on the power after  │
│   shutting off                                │
│   the power supply and  waiting for 10        │
│   seconds.                                    │
│                                               │
│                                               │
│                                               │
│                                               │
│                                               │
│                                               │
│   0436-0000                                   │
└─────────────────────────────────────────────┘
```

[Error content]	Servo parameter mismatch
[Detail]	The parameters saved in the servo controller do not match the fixed FROM parameters in the wrapper. The wrapper will refresh the content saved in the servo controller. The power must be switched off and turned back on after rewriting.
[Solution]	Restore power
[Remarks]	
[Cause]	The parameters saved in the servo controller do not match the fixed FROM parameters in the wrapper. The wrapper will refresh servo controller parameters.
[Response]	The wrapper will automatically rewrite the content saved in the servo controller. Restore power after shutting it off and waiting for 10 seconds.

0437

```
┌─────────────────────────────────────────────────────┐
│              PACKING CONTROL PART                    │
│ ┌─────────────────────────────────────────────────┐ │
│ │ LOST UP/STARTING POSITION ADJUSTMENT OF THE LIFT│ │
│ └─────────────────────────────────────────────────┘ │
│                                                       │
│  *Adjust the position of lift upper and origin.      │
│                                                       │
│                                                       │
│                                                       │
│                                            ┌───────┐  │
│                                            │  OK   │  │
│                                            └───────┘  │
│  0437-0000                                            │
└─────────────────────────────────────────────────────┘
```
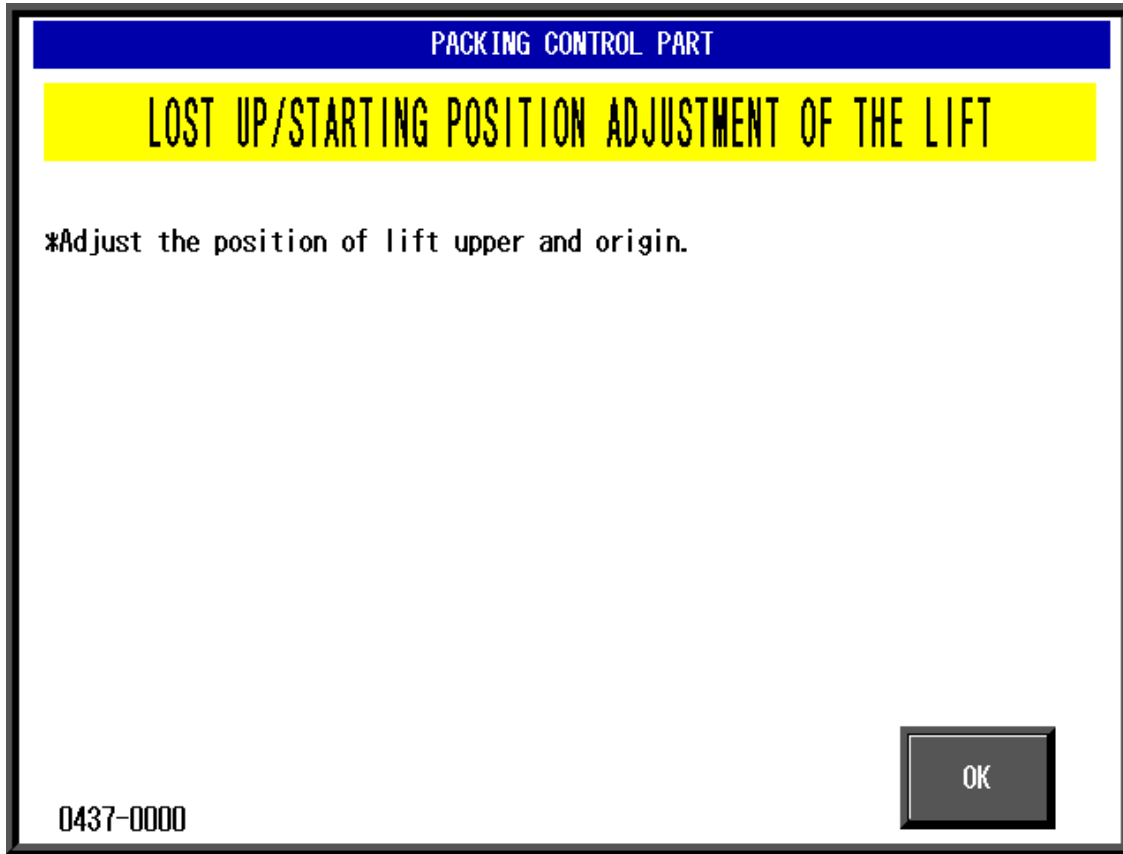
[Error content]	The up and original positions of the lift have been lost
[Detail]	Position data saved in the servo controller conflicts with the configuration saved in the wrapper E2ROM. Additionally, up and original position adjustment has not been performed (Invariably occurs during the first operation after assembly)
[Solution]	[OK] button
[Remarks]	The up and original lift positions need to be reconfigured
[Cause]	Position data saved in the servo controller conflicts with the configuration saved in the wrapper E2ROM.
[Response]	Reconfigure the up and original lift positions.

0440

```
PACKING CONTROL PART

THE EMERGENCY STOP SWITCH WAS PUSHED

《REMOVE THE FILM AND LABEL》
1)Press ENERGENCY switch, REMOVE
   item on lift and infeed conveyor.
2)Open the front cover and remove the label.


*Display goes back when the label is removed.
*Label feeds by pressing flashing yellow.

                                        1

                                              RETURN

0440-0000
```
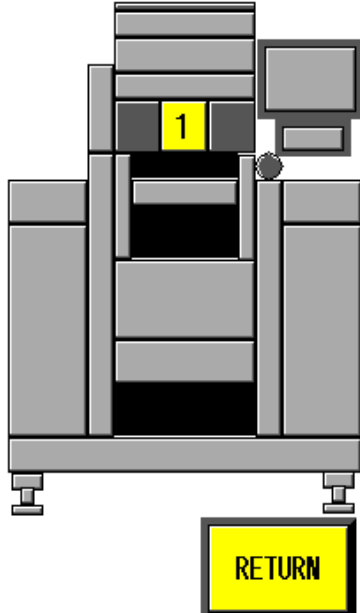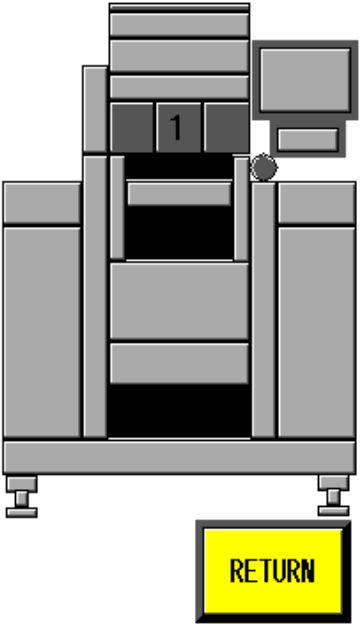
[Error content]	The emergency stop switch was pushed during operation.
[Detail]	Occurs when the emergency stop switch is pushed while the wrapper is operating.
[Solution]	Press the [RETURN] button after releasing the emergency stop switch
[Remarks]	
[Cause]	1. The emergency stop switch was pushed during operation 2. Emergency stop switch abnormality
[Response]	1. Press the [RETURN] button after releasing the emergency stop switch 2. Check emergency stop switch operation

0441

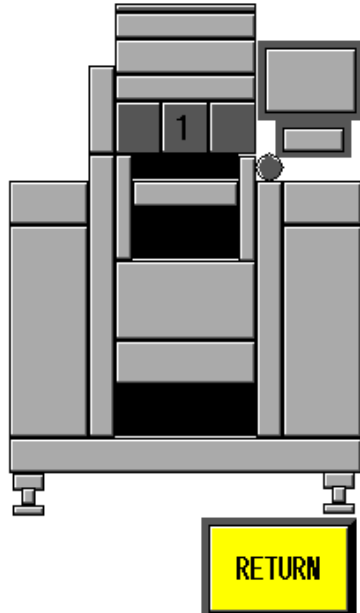PACKING CONTROL PART

THE RIGHT FILM REMOVAL DOOR WAS OPENED
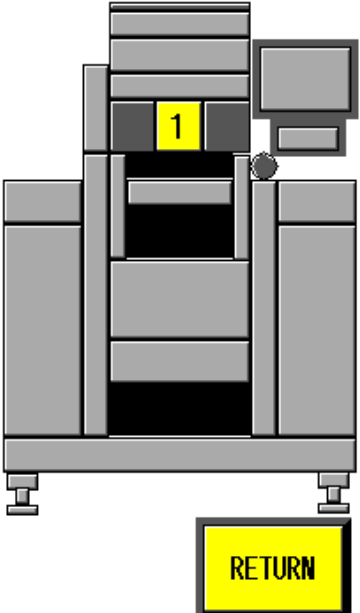
《REMOVE THE FILM AND LABEL》

1)Press ENERGENCY switch, REMOVE

  item on lift and infeed conveyor.

2)Open the front cover and remove the label.

*Display goes back when the label is removed.

*Label feeds by pressing flashing yellow.

1

RETURN

0441-0000

[Error content]	The right film removal door was opened during operation.
[Detail]	Occurs when the right film removal door is opened while the wrapper is operating.
[Solution]	Press the [RETURN] button after closing the right film removal door
[Remarks]	
[Cause]	1. The right film removal door was opened during operation 2. Right film removal door abnormality
[Response]	1. Press the [RETURN] button after closing the right film removal door 2. Check right film removal door safety switch operation

0442


```
                    PACKING CONTROL PART

        THE LEFT FILM REMOVAL DOOR WAS OPENED

《REMOVE THE FILM AND LABEL》
1)Press ENERGENCY switch, REMOVE
   item on lift and infeed conveyor.
2)Open the front cover and remove the label.


*Display goes back when the label is removed.
*Label feeds by pressing flashing yellow.
                                            RETURN
   0442-0000
```
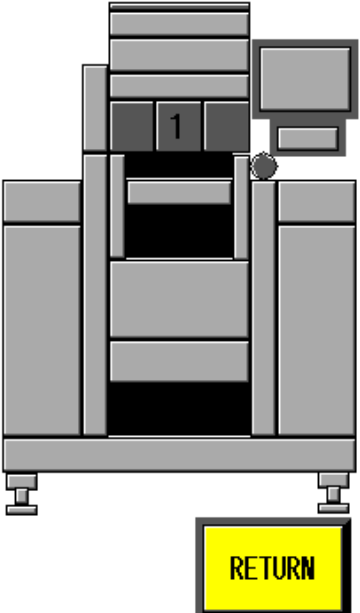
[Error content]	The left film removal door was opened during operation.
[Detail]	Occurs when the left film removal door is opened while the wrapper is operating.
[Solution]	Press the [RETURN] button after closing the left film removal door
[Remarks]	
[Cause]	1. The left film removal door was opened during operation 2. Left film removal door abnormality
[Response]	1. Press the [RETURN] button after closing the left film removal door 2. Check left film removal door safety switch operation

0443

PACKING CONTROL PART

FILM COVER IS OPENED
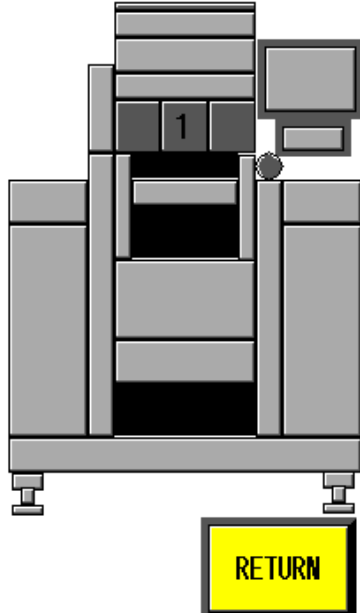
《REMOVE THE FILM AND LABEL》
1)Press ENERGENCY switch, REMOVE
   item on lift and infeed conveyor.
2)Open the front cover and remove the label.

*Display goes back when the label is removed.
*Label feeds by pressing flashing yellow.

1

RETURN

0443-0000

[Error content]	The right film replacement cover was opened during operation.
[Detail]	Occurs when the right film replacement cover is opened while the wrapper is operating.
[Solution]	Press the [RETURN] button after closing the right film replacement cover
[Remarks]	
[Cause]	1. The right film replacement cover was opened during operation. 2. Right film replacement cover safety switch abnormality
[Response]	1. Press the [RETURN] button after closing the right film replacement cover 2. Check right film replacement cover safety switch operation

0444

PACKING CONTROL PART
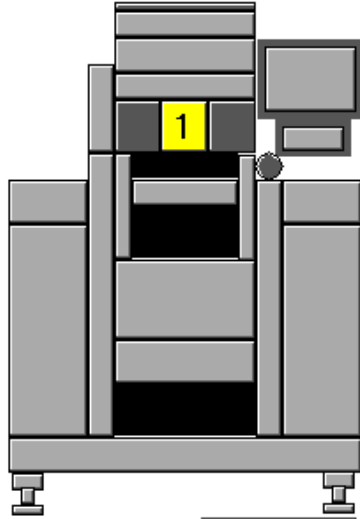
THE LEFT FILM EXCHANGE DOOR WAS OPENED

《REMOVE THE FILM AND LABEL》

1)Press ENERGENCY switch, REMOVE
   item on lift and infeed conveyor.

2)Open the front cover and remove the label.

*Display goes back when the label is removed.
*Label feeds by pressing flashing yellow.

1

RETURN

0444-0000

[Error content]	The left film replacement cover was opened during operation.
[Detail]	Occurs when the left film replacement cover is opened while the wrapper is operating.
[Solution]	Press the [RETURN] button after closing the left film replacement cover
[Remarks]	
[Cause]	1. The left film replacement cover was opened during operation. 2. Left film replacement cover safety switch abnormality
[Response]	1. Press the [RETURN] button after closing the left film replacement cover 2. Check left film replacement cover safety switch operation

0445
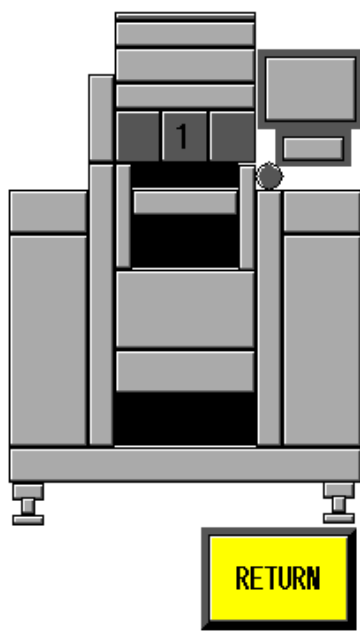

PACKING CONTROL PART

THE FRONT COVER WAS OPENED

《REMOVE THE FILM AND LABEL》

1)Press ENERGENCY switch, REMOVE
   item on lift and infeed conveyor.

2)Open the front cover and remove the label.

*Display goes back when the label is removed.

*Label feeds by pressing flashing yellow.

RETURN

0445-0000

[Error content]	The front cover was opened during operation.
[Detail]	Occurs when the front cover is opened while the wrapper is operating.
[Solution]	Press the [RETURN] button after closing the front cover
[Remarks]	
[Cause]	1. The front cover was opened during operation. 2. Front cover safety switch abnormality
[Response]	1. Press the [RETURN] button after closing the front cover 2. Check front cover safety switch operation

0446

[Error content]	The infeed bottom cover was opened during operation.
[Detail]	Occurs when the infeed bottom cover is opened while the wrapper is operating.
[Solution]	Press the [RETURN] button after closing the infeed bottom cover.
[Remarks]	
[Cause]	1. The infeed bottom cover was opened during operation. 2. Infeed bottom cover safety switch abnormality
[Response]	1. Press the [RETURN] button after closing the infeed bottom cover. 2. Check infeed bottom cover safety switch operation.

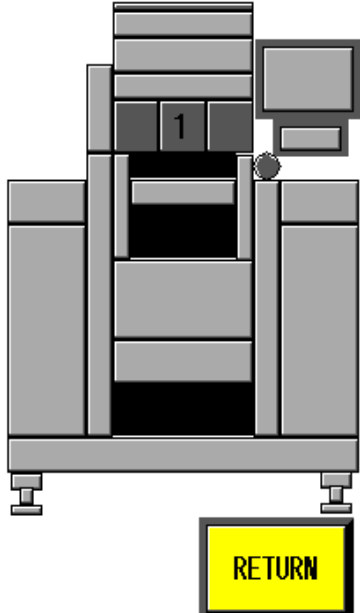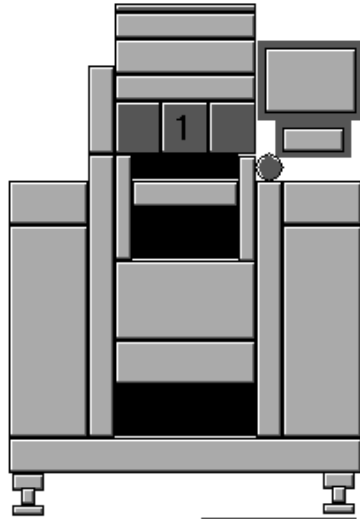0447

```
PACKING CONTROL PART

INFEED COVER IS OPENED

《REMOVE THE FILM AND LABEL》
1)Press ENERGENCY switch, REMOVE
   item on lift and infeed conveyor.
2)Open the front cover and remove the label.


*Display goes back when the label is removed.
*Label feeds by pressing flashing yellow.

                                              1




                                         RETURN

   0447-0000
```

[Error content]	The infeed unit cover was opened during operation.
[Detail]	Occurs when the infeed unit cover is opened while the wrapper is operating.
[Solution]	Press the [RETURN] button after setting the infeed unit cover.
[Remarks]	
[Cause]	1. The infeed unit cover was opened during operation. 2. Infeed unit cover safety switch abnormality
[Response]	1. Press the [RETURN] button after setting the infeed unit cover. 2. Check infeed unit drawer safety switch operation

0448

[Error content]	A hand was put into the wrapper during operation.
[Detail]	Occurs when a hand or foreign object is detected entering the infeed unit while the wrapper is operating.
[Solution]	[RETURN] button
[Remarks]	
[Cause]	Occurs when a hand or foreign object is detected entering the infeed unit while the wrapper is operating. The infeed unit safety sensor is dirty.
[Response]	Clean the infeed unit safety sensor

0449

```
┌─────────────────────────────────────────────────┐
│          PACKING CONTROL PART                   │
├─────────────────────────────────────────────────┤
│      DO NOT PUT HAND INTO THE WRAPPER           │
├─────────────────────────────────────────────────┤
│ *Do not insert your hand into the outfeed.      │
│ 《REMOVE THE FILM AND LABEL》                    │
│ 1)Press ENERGENCY switch, REMOVE                │
│    item on lift and infeed conveyor.            │
│ 2)Open the front cover and remove the label.    │
│                                                 │
│ *Display goes back when the label is removed.   │
│ *Label feeds by pressing flashing yellow.       │
│                                                 │
│                                     ┌─────────┐ │
│  0449-0000                          │ RETURN  │ │
│                                     └─────────┘ │
└─────────────────────────────────────────────────┘
```

[Error content]	A hand was put into the wrapper during operation.
[Detail]	Occurs when a hand or foreign object is detected entering the infeed unit while the wrapper is operating.
[Solution]	[RETURN] button
[Remarks]	
[Cause]	
[Response]	

0450
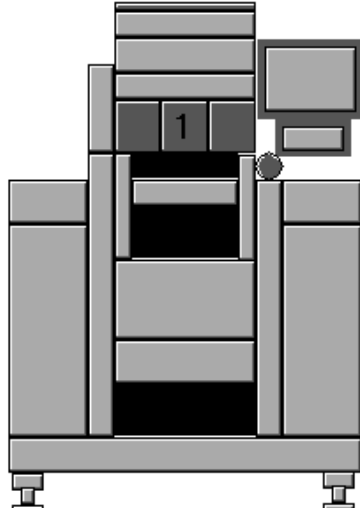
```
PACKING CONTROL PART

THE OUTFEED HAS PULLED UP

《REMOVE THE FILM AND LABEL》
1)Press ENERGENCY switch, REMOVE
   item on lift and infeed conveyor.
2)Open the front cover and remove the label.


*Display goes back when the label is removed.
*Label feeds by pressing flashing yellow.

                                              1


                                        RETURN

0450-0000
```

[Error content]	The discharge unit has tipped up during operation.
[Detail]	This occurs when the discharge unit tips up while the wrapper is operating.
[Solution]	Press the [RETURN] button after lowering the discharge unit
[Remarks]	
[Cause]	1. The discharge unit has tipped up during operation. 2. Discharge unit tip sensor abnormality
[Response]	1. Lower the discharge unit. 2. Check discharge unit tip sensor operation

0451
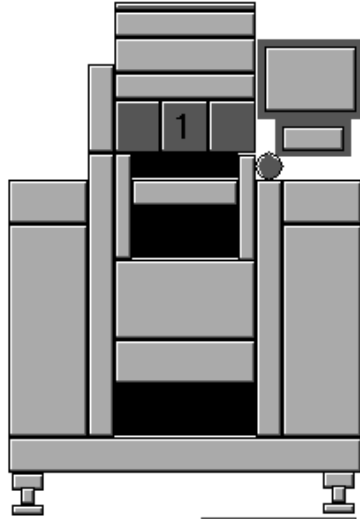

PACKING CONTROL PART

THE PRINTER #4 IS PULLED OUT

《REMOVE THE FILM AND LABEL》
1)Press ENERGENCY switch, REMOVE
   item on lift and infeed conveyor.
2)Open the front cover and remove the label.

*Display goes back when the label is removed.
*Label feeds by pressing flashing yellow.

RETURN

0451-0000

[Error content]	Printer #4 has been pulled out during operation.
[Detail]	This occurs when printer #4 is pulled out while the wrapper is operating.
[Solution]	Press the [RETURN] button after setting printer #4
[Remarks]	
[Cause]	1. Printer #4 has been pulled out during operation. 2. Under printer pull out sensor (S320) abnormality
[Response]	1. Press the [RETURN] button after setting printer #4 2. Check Under printer pull out sensor (S320) operation

0452
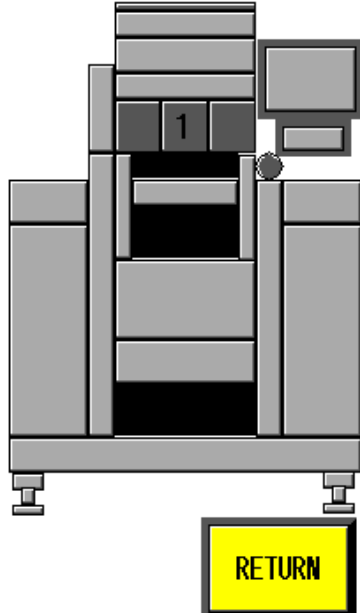


```
PACKING CONTROL PART

THE ROLLER PART WAS OPENED

《REMOVE THE FILM AND LABEL》
1)Press ENERGENCY switch, REMOVE
   item on lift and infeed conveyor.
2)Open the front cover and remove the label.

*Display goes back when the label is removed.
*Label feeds by pressing flashing yellow.

                                    RETURN
0452-0000
```

[Error content]	The roller unit was opened during operation.
[Detail]	This occurs when the roller unit is opened while the wrapper is operating.
[Solution]	Press the [RETURN] button after setting the roller unit
[Remarks]	
[Cause]	1. The roller unit was opened during operation. 2. Bottom label roller sensor malfunction
[Response]	1. Press the [RETURN] button after setting the roller unit 2. Check bottom label roller sensor operation

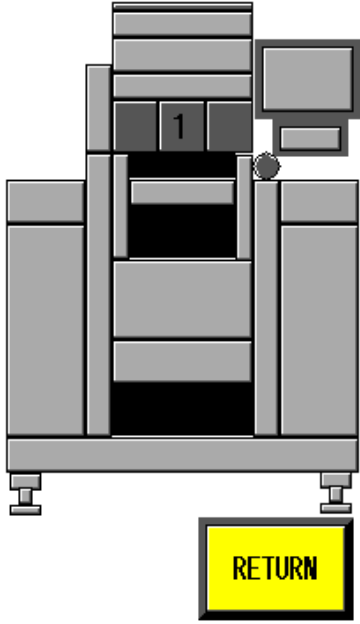0460

```
PACKING CONTROL PART

ITEMS WERE NOT THROWN IN

《REMOVE THE FILM AND LABEL》
1)Press ENERGENCY switch, REMOVE
   item on lift and infeed conveyor.
2)Open the front cover and remove the label.

*Display goes back when the label is removed.
*Label feeds by pressing flashing yellow.

                                          RETURN
0460-0000
```

[Error content]	Item was not input.
[Detail]	An infeed item was not detected on the lift when the wrapper completed one operation cycle. In addition, an item was not detected on the lift when it was raised.
[Solution]	[RETURN] button
[Remarks]	This only occurs in variations equipped with b−label printers
[Cause]	An infeed item was not detected on the lift when the wrapper completed one operation cycle. In addition, an item was not detected on the lift when it was raised.
[Response]	1. Check that items are infeed normally. 2. Check the commodity on lift detection sensor.

0461


```
PACKING CONTROL PART

THE RIGHT-HAND SIDE FILM OVER ERROR

《REMOVE THE FILM AND LABEL》
1)Press ENERGENCY switch, REMOVE
   item on lift and infeed conveyor.
2)Open the front cover and remove the label.


*Display goes back when the label is removed.
*Label feeds by pressing flashing yellow.

                                           1

                                      RETURN
0461-0000
```
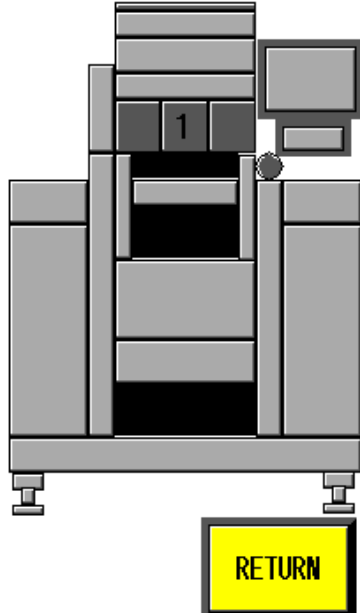
[Error content]	Right-hand side film over error
[Detail]	The right-hand side film detection board fell when film was sent from the right side. The right-hand side film detection board fell while the film was being removed.
[Solution]	[RETURN] button
[Remarks]	Remove film after recovery procedures.
[Cause]	1. The right-hand side film detection board fell when film was sent from the right side. The right-hand side film detection board fell while the film was being removed.
[Response]	1. Check right-hand film detection sensor The right-hand film detection sensor is receiving light. The detection board fell due to waste, etc. 2. Check film over sensor operation

0462


```
PACKING CONTROL PART

THE LEFT-HAND SIDE FILM OVER ERROR

《REMOVE THE FILM AND LABEL》
1)Press ENERGENCY switch, REMOVE
  item on lift and infeed conveyor.
2)Open the front cover and remove the label.


*Display goes back when the label is removed.
*Label feeds by pressing flashing yellow.

                                              RETURN

0462-0000
```
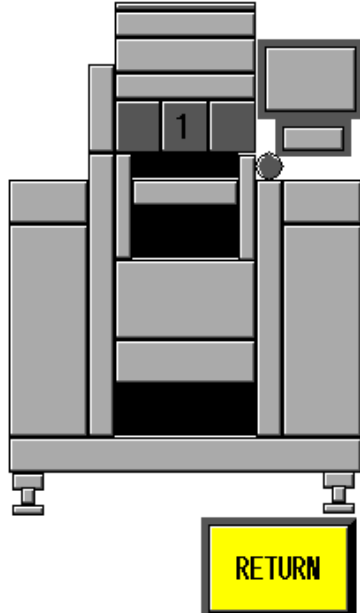
[Error content]	Left-hand side film over error
[Detail]	The left-hand side film detection board fell when film was sent from the left side. The left-hand side film detection board fell while the film was being removed.
[Solution]	[RETURN] button
[Remarks]	Remove film after recovery procedures.
[Cause]	1. The left-hand side film detection board fell when film was sent from the left side. The left-hand side film detection board fell while the film was being removed.

[Response]	1. Check left-hand film detection sensor
	   The left-hand film detection sensor is receiving light.
	   The detection board fell due to waste, etc.
	2. Check film over sensor operation

0463

PACKING CONTROL PART

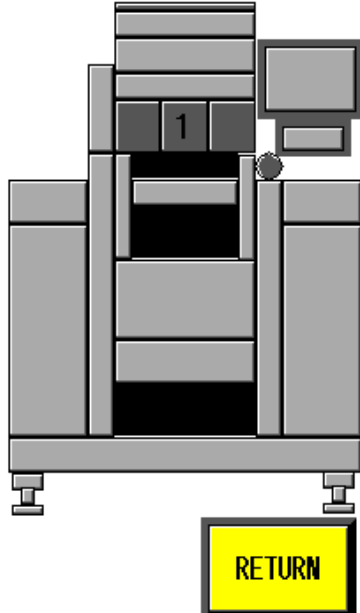## THE RIGHT-HAND SIDE FILM WAS LOST

*Check the right film.
《REMOVE THE FILM AND LABEL》
1)Press ENERGENCY switch, REMOVE
   item on lift and infeed conveyor.
2)Open the front cover and remove the label.

*Display goes back when the label is removed.
*Label feeds by pressing flashing yellow.

1

RETURN

0463-0000

[Error content]	Right-hand side film was lost.
[Detail]	Occurs when right-hand side film is lost.
[Solution]	[RETURN] button (Film needs to be set after returning)
[Remarks]	
[Cause]	1. Right-hand side film was lost. 2. Right-hand film detection sensor malfunction.
[Response]	1. Set right-hand film. 2. Check right-hand film detection sensor operation

0464

PACKING CONTROL PART

THE LEFT-HAND SIDE FILM WAS LOST

*Check the left film.

《REMOVE THE FILM AND LABEL》

1)Press ENERGENCY switch, REMOVE
   item on lift and infeed conveyor.

2)Open the front cover and remove the label.

*Display goes back when the label is removed.

*Label feeds by pressing flashing yellow.

RETURN

0464-0000

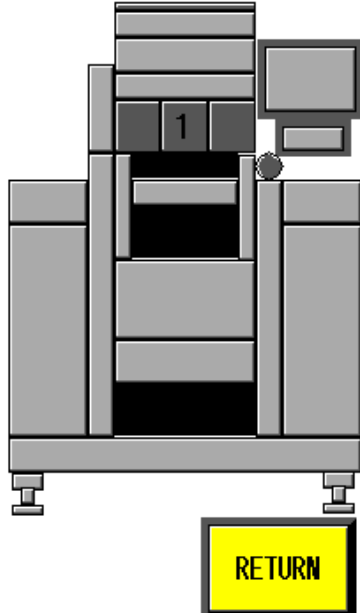| [Error content]	Left-hand side film was lost.
[Detail]	Occurs when left-hand side film is lost.
[Solution]	[RETURN] button (Film needs to be set after returning)
[Remarks]	
[Cause]	1. Left-hand side film was lost. 2. Left-hand film detection sensor malfunction.
[Response]	1. Set left-hand film. 2. Check left-hand film detection sensor operation

0465

PACKING CONTROL PART

THE RIGHT SIDE FILM WAS NOT SUPPLIED

*Check the right film.

《REMOVE THE FILM AND LABEL》

1)Press ENERGENCY switch, REMOVE
  item on lift and infeed conveyor.

2)Open the front cover and remove the label.

*Display goes back when the label is removed.
*Label feeds by pressing flashing yellow.

1

RETURN

0465-0000

[Error content]	Right side film was not supplied.
[Detail]	Right side film was sent, but the right side film detection board did not fall down.
[Solution]	Press the [RETURN] button after checking the right side film.
[Remarks]	The error will not be displayed by selection ″No″ in film error machine settings.
[Cause]	Right side film was sent, but the right side film detection board did not fall down.
[Response]	1. Check right side film detection board operation. 2. The sensor receives light by falling down. Consequently, it can be considered that garbage has become stuck to the sensor. 3. The sensor is faulty

0466

PACKING CONTROL PART

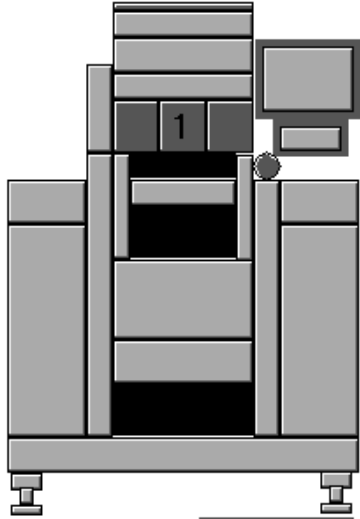**THE LEFT SIDE FILM WAS NOT SUPPLIED**

*Check the left film.

《REMOVE THE FILM AND LABEL》

1)Press ENERGENCY switch, REMOVE
   item on lift and infeed conveyor.

2)Open the front cover and remove the label.

*Display goes back when the label is removed.

*Label feeds by pressing flashing yellow.

1

RETURN

0466-0000

[Error content]	Left side film was not supplied.
[Detail]	Left side film was sent, but the left side film detection board did not fall down.
[Solution]	Press the [RETURN] button after checking the left side film.
[Remarks]	The error will not be displayed by selection ″No″ in film error machine settings.
[Cause]	Left side film was sent, but the left side film detection board did not fall down.
[Response]	1. Check left side film detection board operation. 2. The sensor receives light by falling down. Consequently, it can be considered that garbage has become stuck to the sensor. 3. The sensor is faulty

0467

```
                PACKING CONTROL PART

           FILM LOADING WENT WRONG

*Check the film on the RIGHT side.
*Remove film and press [RETURN] key
*Reload the film again.




                                        RETURN
0467-0000
```
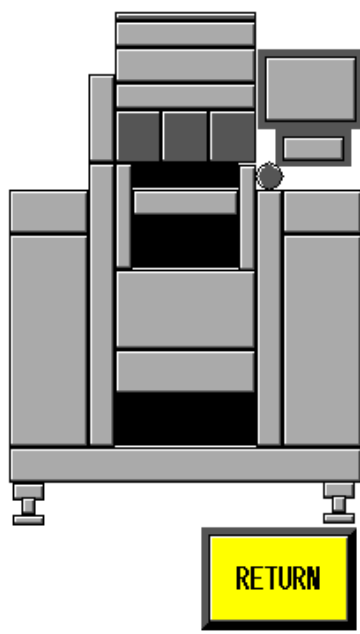
[Error content]	Film Loading went Wrong.
[Detail]	Film transport could not complete successfully. Sub error No. 0000:Right 0001:Left
[Solution]	Press the [RETURN] button after checking film.
[Remarks]	
[Cause]	
[Response]	

0468

```
┌─────────────────────────────────────────────────────┐
│              PACKING CONTROL PART                     │
│                                                       │
│       PASTING TIMING WAS UNDETECTABLE                 │
│                                                       │
│  *Press [PLU] key to outfeed the tray inside.         │
│  *Return the mahcine with following procedure.        │
│  《REMOVE THE FILM AND LABEL》                         │
│  1)Press ENERGENCY switch, REMOVE                     │
│     item on lift and infeed conveyor.                 │
│  2)Open the front cover and remove the label.         │
│                                                       │
│  *Display goes back when the label is removed.        │
│  *Label feeds by pressing flashing yellow.            │
│                                                       │
│                                          RETURN       │
│   0468-0000                                           │
└─────────────────────────────────────────────────────┘
```
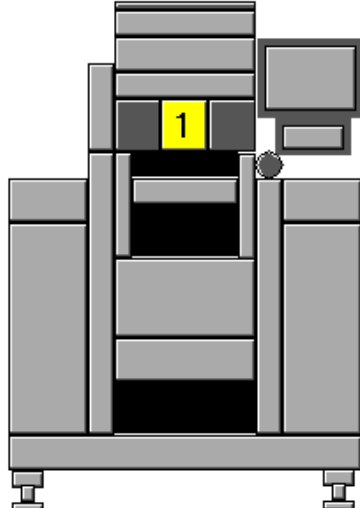
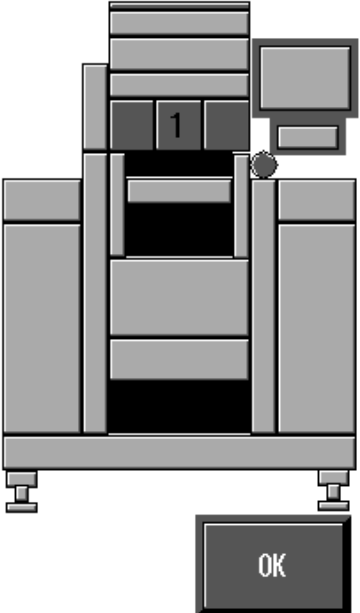| [Error content]	Pasting timing was undetectable.
[Detail]	Occurs when items with bottom labels cannot be detected by the tray detection sensor regardless of the timing after being pushed by the pusher.
[Solution]	[RETURN] button
[Remarks]	This only occurs in variations with b-label printers attached
[Cause]	Pasting timing was undetectable.
[Response]	1. Check b-label tray pasting timing sensor 2. Abnormality between the label sensor <- ->P-922 (XJ-1)

0469

PACKING CONTROL PART

THE STOCK PART IS NOT SET

*PLU with B-Label
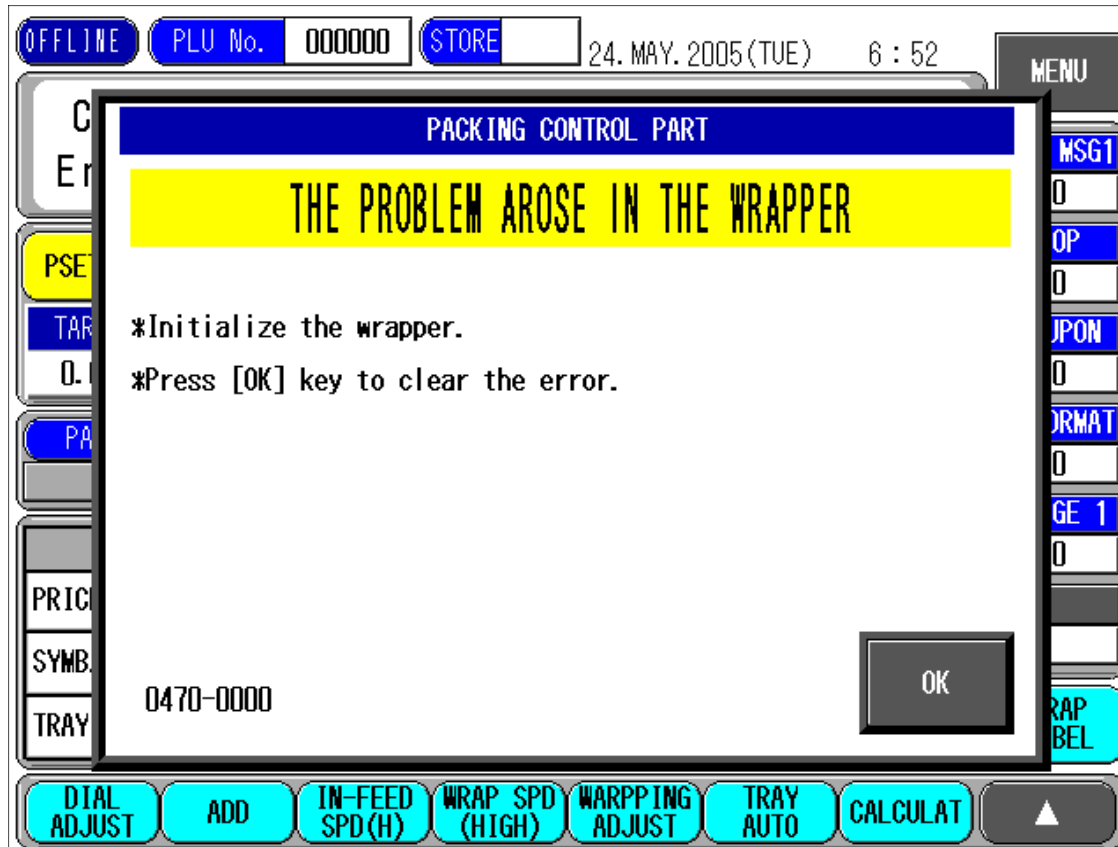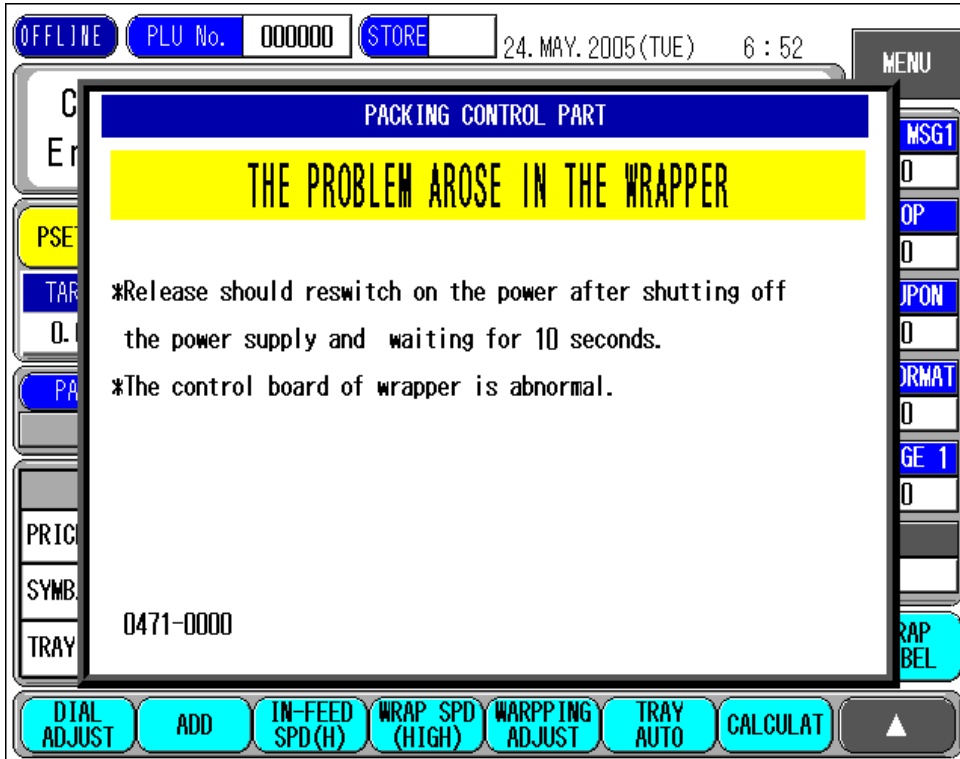 It is necessary to set a stock part.
*Set it to clear error.

1

OK

0469-0000

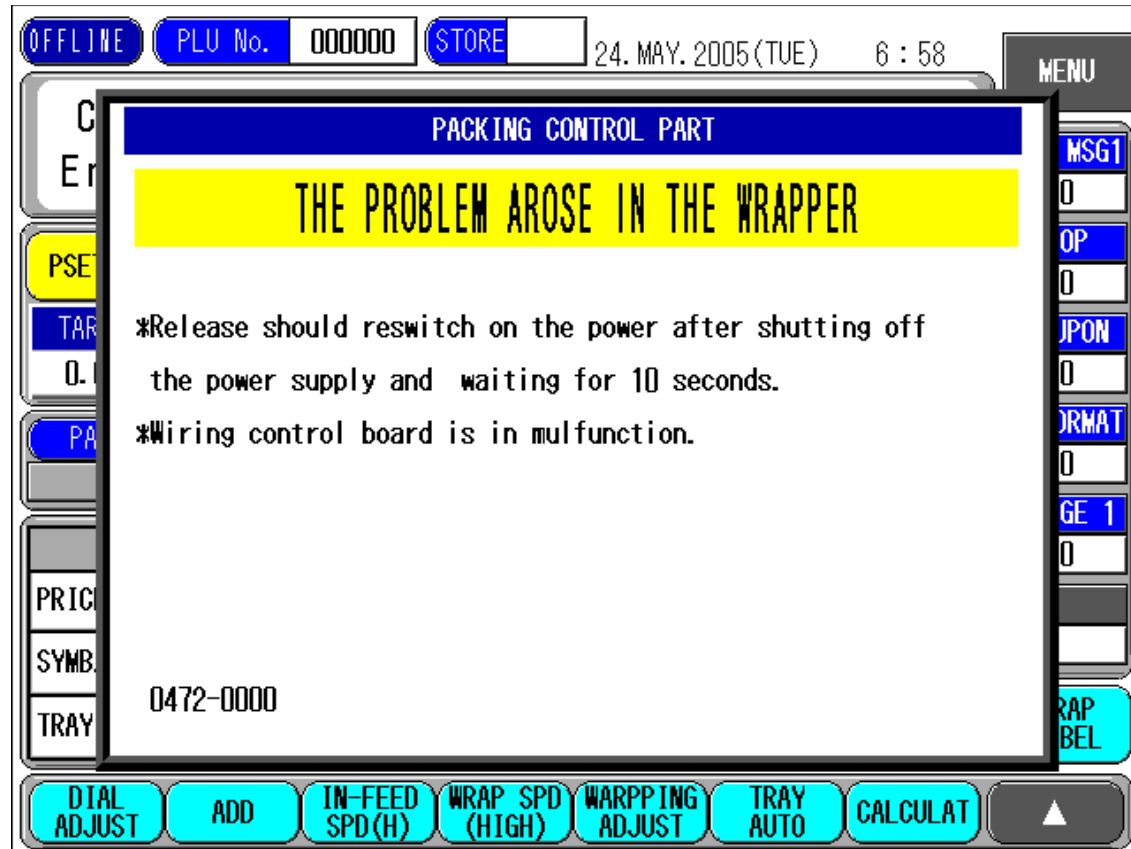| [Error content]	Stock is folded when the wrapper attempted operation for a product with a bottom label
[Detail]	1. Stock is folded when the wrapper attempted operation for a product with a bottom label 2. Folding sensor is faulty
[Solution]	Set stock
[Remarks]	This only occurs in variations with b–label printers
[Cause]	Stock is folded when the wrapper attempted operation for a product with a bottom label
[Response]	1. Set stock 2. Check folding sensor operation

0470

```
OFFLINE   PLU No.  000000   STORE        24.MAY.2005(TUE)    6:52      MENU

       C┌──────────────────────────────────────────────────┐      MSG1
       E│              PACKING CONTROL PART                 │      0
        │                                                   │      OP
  PSE   │     THE PROBLEM AROSE IN THE WRAPPER              │      0
  TAR   │                                                   │      UPON
  0.    │  *Initialize the wrapper.                         │      0
        │  *Press [OK] key to clear the error.              │      RMAT
  PA    │                                                   │      0
        │                                                   │      GE 1
        │                                                   │      0
  PRIC  │                                                   │
  SYMB  │                              ┌──────────┐         │
        │   0470-0000                  │    OK    │         │      RAP
  TRAY  │                              └──────────┘         │      BEL
        └──────────────────────────────────────────────────┘
  DIAL      ADD    IN-FEED  WRAP SPD WARPPING   TRAY    CALCULAT   ▲
  ADJUST           SPD(H)   (HIGH)   ADJUST     AUTO
```

[Error content]	Wrapper is not initialized.
[Detail]	Wrapper E2ROM is not initialized (Stored E2ROM checksum error).
[Solution]	[OK] button
[Remarks]	Initialize wrapper in test mode wrapper settings after cancelling the error.
[Cause]	E2ROM checksum stored for the wrapper error.
[Response]	1. Initialize wrapper in test mode wrapper settings. 2. If the same error re-occurs, P-920 malfunction

0471

```
OFFLINE  PLU No. 000000  STORE      24.MAY.2005(TUE)   6:52      MENU
```

```
┌─────────────────────────────────────────────────────────┐
│              PACKING CONTROL PART                       │
├─────────────────────────────────────────────────────────┤
│        THE PROBLEM AROSE IN THE WRAPPER                 │
├─────────────────────────────────────────────────────────┤
│  *Release should reswitch on the power after shutting off│
│   the power supply and  waiting for 10 seconds.         │
│  *The control board of wrapper is abnormal.             │
│                                                          │
│                                                          │
│     0471-0000                                            │
└─────────────────────────────────────────────────────────┘
```

```
DIAL    ADD   IN-FEED  WRAP SPD  WARPPING  TRAY   CALCULAT   ▲
ADJUST        SPD(H)   (HIGH)    ADJUST    AUTO
```

| [Error content]	Wrapper control board (P–920) is abnormal	
[Detail]	Abnormality occurred in the wrapper control board. Sub-error meanings are as follows:	
	0000	Wiring LSI (Parent 1) abnormality.
	0001	Wiring LSI (Parent 2) abnormality. Currently does not occur in Parent 1.
	0002	External RAM abnormality
	0003	E2ROM writing abnormality
	0999	High speed, external CPU reset interrupt
[Solution]	Restore power	
[Remarks]		
[Cause]	0000	Wiring LSI (Parent 1) abnormality.
	0001	Wiring LSI (Parent 2) abnormality. Currently does not occur in Parent 1.
	0002	External RAM abnormality
	0003	E2ROM writing abnormality
	0999	High speed, external CPU reset interrupt
[Response]	0000	Wiring LSI (Parent 1) abnormality. (P–920 malfunction)
	0001	Wiring LSI (Parent 2) abnormality. Currently does not occur in Parent 1.
	0002	External RAM abnormality
	0003	E2ROM writing abnormality (P–920 malfunction)
	0999	High speed, external CPU reset interrupt (Restart, if the error re-occurs, P–920 malfunction)

0472

```
OFFLINE    PLU No.   000000   STORE          24.MAY.2005(TUE)    6:58        MENU

  C                    PACKING CONTROL PART                           MSG1
  E                                                                    0
                  THE PROBLEM AROSE IN THE WRAPPER                     OP
 PSE                                                                   0
                                                                      UPON
 TAR     *Release should reswitch on the power after shutting off      0
 0.       the power supply and  waiting for 10 seconds.               ORMAT
 PA      *Wiring control board is in mulfunction.                      0
                                                                      GE 1
                                                                       0
PRIC
SYMB
         0472-0000                                                    RAP
TRAY                                                                  BEL

  DIAL        ADD     IN-FEED   WRAP SPD  WARPPING    TRAY    CALCULAT   ▲
 ADJUST              SPD(H)    (HIGH)    ADJUST     AUTO
```

[Error content]	Wrapper wiring board abnormality
[Detail]	A communication abnormality occurred in the wiring communication LSI Parent (wrapper control board: P-920) and child (board: P-921 or P-922). Sub-error represents address bit mask of the location of the abnormality. Locations of abnormalities are as follows:

	0001-0255	Communication is abnormal with one of the following: Film roll control (right) (P-922) Feeder mover control (rear) (P-922) Feeder mover control (front) (P-922)
	0257-0511	Communication is abnormal with one of the following: Heater control (P-922) Bottom applicator (P-922) PS-EMZ (P-922 x 2 boards)
	0513-0767	Communication is abnormal with one of the following: Infeed unit (P-921) Film roll control (left) (P-922)

0472

[Solution]	Restore power
[Remarks]	
[Cause]	Location overview by sub-error Click the error number below to learn the detailed location. 0472-0001-0255 0472-0257-0511 0472-0513-0767
[Response]	Respond according to the contents of the sub-error.

Location overview by sub-error
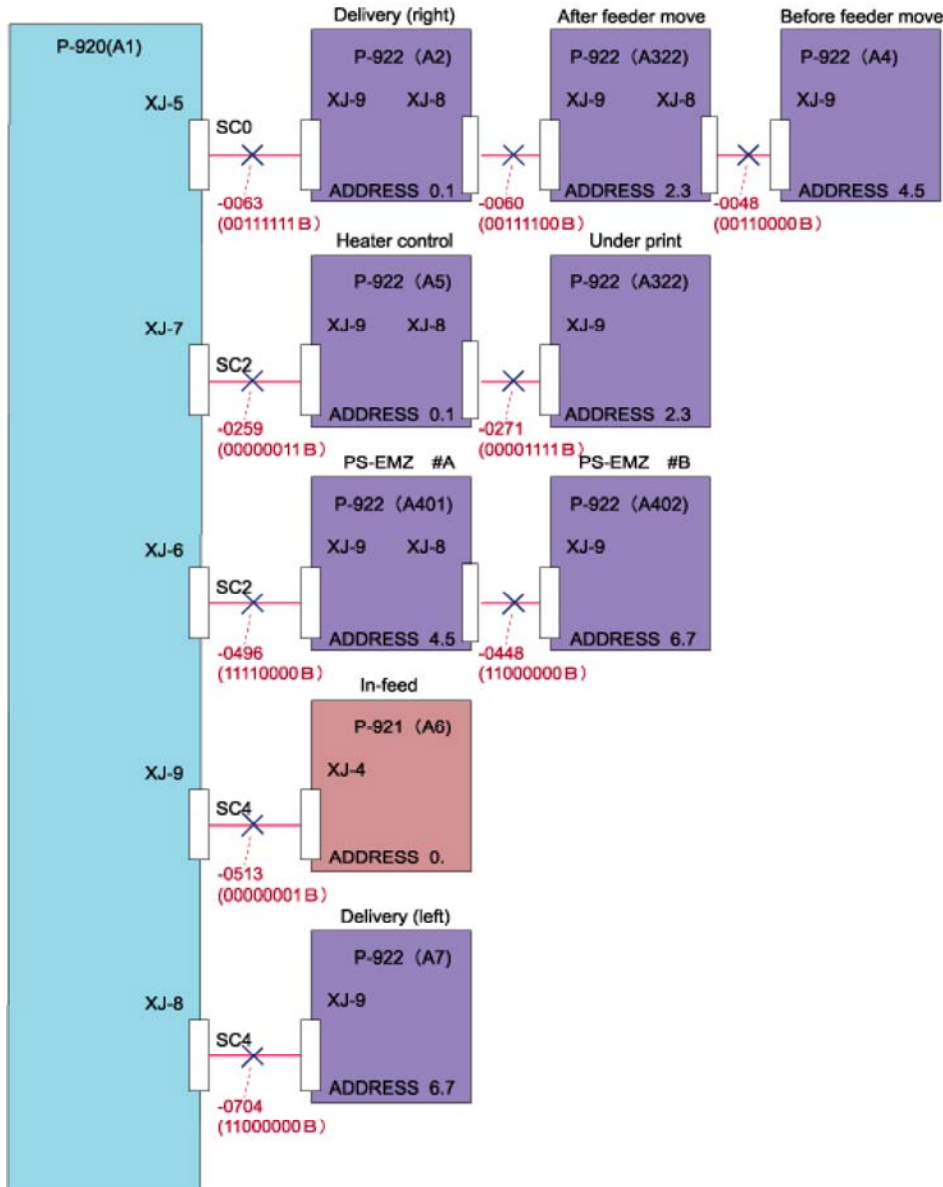
0472
Error list 0472-0001 – 0255

● indicates possibility of failure.

Error number	Between A1, A2	A2	Between A2, A3	A3	Between A3,A4	A4
0472-0001		●				
-0002		●				
-0003		●				
-0004				●		
-0005		●		●		
-0006		●		●		
-0007		●		●		
-0008				●		
-0009		●		●		
-0010		●		●		
-0011		●		●		
-0012				●		
-0013		●		●		
-0014		●		●		
-0015		●		●		
-0016						●
-0017		●				●
-0018		●				●
-0019		●				●
-0020				●		●
-0021		●		●		●
-0022		●		●		●
-0023		●		●		●
-0024				●		●
-0025		●		●		●
-0026		●		●		●
-0027		●		●		●
-0028				●		●
-0029		●		●		●

0472

Error number	Between A1, A2	A2	Between A2, A3	A3	Between A3,A4	A4
−0030		●		●		●
−0031		●		●		●
−0032						●
−0033		●				●
−0034		●				●
−0035		●				●
−0036				●		●
−0037		●		●		●
−0038		●		●		●
−0039		●		●		●
−0040				●		●
−0041		●		●		●
−0042		●		●		●
−0043		●		●		●
−0044				●		●
−0045		●		●		●
−0046		●		●		●
−0047		●		●		●
−0048					●	●
−0049		●			●	●
−0050		●			●	●
−0051		●			●	●
−0052				●	●	●
−0053		●		●	●	●
−0054		●		●	●	●
−0055		●		●	●	●
−0056				●	●	●
−0057		●		●	●	●
−0058		●		●	●	●
−0059		●		●	●	●
−0060			●	●	●	●
−0061		●	●	●	●	●

0472

Error number	Between A1, A2	A2	Between A2, A3	A3	Between A3,A4	A4
−0062		●	●	●	●	●
−0063	●	●	●	●	●	●
−0064	●	●	●	●	●	●
:	:	:	:	:	:	:
−0255	●	●	●	●	●	●
A1：P−920*(Wrapper board)　A2：P−922*(Sub−board Right delivery)						
A3：P−922*(Sub−board feeder mover (rear))　A4：P−922*(Sub−board feeder mover (front))						
*Correctly set sub−board DIPSW.						

0472
Error list 0472-0257 – 0511

● indicates possibility of failure.

Error number	Between A1,A5	A5	Between A5,A322	A322	Between A1,A401	A401	Between A401,A402	A402
0472-0257		●						
-0258		●						
-0259		●						
-0260				●				
-0261		●		●				
-0262		●		●				
-0263		●		●				
-0264				●				
-0265		●		●				
-0266		●		●				
-0267		●		●				
-0268			●	●				
-0269		●	●	●				
-0270		●	●	●				
-0271	●	●	●	●				
-0272						●		
-0273		●				●		
-0274		●				●		
-0275		●				●		
-0276				●		●		
-0277		●		●		●		
-0278		●		●		●		
-0279		●		●		●		
-0280				●		●		
-0281		●		●		●		
-0282		●		●		●		
-0283		●		●		●		
-0284			●	●		●		
-0285		●	●	●		●		

0472

Error number	Between A1,A5	A5	Between A5,A322	A322	Between A1,A401	A401	Between A401,A402	A402
−0286		●	●	●		●		
−0287	●	●	●	●		●		
−0288						●		
−0289		●				●		
−0290		●				●		
−0291		●				●		
−0292				●		●		
−0293		●		●		●		
−0294		●		●		●		
−0295		●		●		●		
−0296				●		●		
−0297		●		●		●		
−0298		●		●		●		
−0299		●		●		●		
−0300			●	●		●		
−0301		●	●	●		●		
−0302		●	●	●		●		
−0303	●	●	●	●		●		
−0304						●		
−0305		●				●		
−0306		●				●		
−0307		●				●		
−0308				●		●		
−0309		●		●		●		
−0310		●		●		●		
−0311		●		●		●		
−0312				●		●		
−0313		●		●		●		
−0314		●		●		●		
−0315		●		●		●		
−0316			●	●		●		
−0317		●	●	●		●		

0472

Error number	Between A1,A5	A5	Between A5,A322	A322	Between A1,A401	A401	Between A401,A402	A402
−0318		●	●	●		●		
−0319	●	●	●	●		●		
−0320								●
−0321		●						●
−0322		●						●
−0323		●						●
−0324				●				●
−0325		●		●				●
−0326		●		●				●
−0327		●		●				●
−0328				●				●
−0329		●		●				●
−0330		●		●				●
−0331		●		●				●
−0332			●	●				●
−0333		●	●	●				●
−0334		●	●	●				●
−0335	●	●	●	●				●
−0336						●		●
−0337		●				●		●
−0338		●				●		●
−0339		●				●		●
−0340				●		●		●
−0341		●		●		●		●
−0342		●		●		●		●
−0343		●		●		●		●
−0344				●		●		●
−0345		●		●		●		●
−0346		●		●		●		●
−0347		●		●		●		●
−0348			●	●		●		●
−0349		●	●	●		●		●
−0350		●	●	●		●		●

0472

Error number	Between A1,A5	A5	Between A5,A322	A322	Between A1,A401	A401	Between A401,A402	A402
−0351	●	●	●	●		●		●
−0352						●		●
−0353		●				●		●
−0354		●				●		●
−0355		●				●		●
−0356				●		●		●
−0357		●		●		●		●
−0358		●		●		●		●
−0359		●		●		●		●
−0360				●		●		●
−0361		●		●		●		●
−0362		●		●		●		●
−0363		●		●		●		●
−0364			●	●		●		●
−0365		●	●	●		●		●
−0366		●	●	●		●		●
−0367	●	●	●	●		●		●
−0368						●		●
−0369		●				●		●
−0370		●				●		●
−0371		●				●		●
−0372				●		●		●
−0373		●		●		●		●
−0374		●		●		●		●
−0375		●		●		●		●
−0376				●		●		●
−0377		●		●		●		●
−0378		●		●		●		●
−0379		●		●		●		●
−0380			●	●		●		●
−0381		●	●	●		●		●
−0382		●	●	●		●		●

0472

Error number	Between A1,A5	A5	Between A5,A322	A322	Between A1,A401	A401	Between A401,A402	A402
−0383	●	●	●	●		●		●
−0384								●
−0385		●						●
−0386		●						●
−0387		●						●
−0388				●				●
−0389		●		●				●
−0390		●		●				●
−0391		●		●				●
−0392				●				●
−0393		●		●				●
−0394		●		●				●
−0395		●		●				●
−0396			●	●				●
−0397		●	●	●				●
−0398		●	●	●				●
−0399	●	●	●	●				●
−0400						●		●
−0401		●				●		●
−0402		●				●		●
−0403		●				●		●
−0404				●		●		●
−0405		●		●		●		●
−0406		●		●		●		●
−0407		●		●		●		●
−0408				●		●		●
−0409		●		●		●		●
−0410		●		●		●		●
−0411		●		●		●		●
−0412			●	●		●		●
−0413		●	●	●		●		●
−0414		●	●	●		●		●
−0415	●	●	●	●		●		●

0472

Error number	Between A1,A5	A5	Between A5,A322	A322	Between A1,A401	A401	Between A401,A402	A402
−0416						●		●
−0417		●				●		●
−0418		●				●		●
−0419		●				●		●
−0420				●		●		●
−0421		●		●		●		●
−0422		●		●		●		●
−0423		●		●		●		●
−0424				●		●		●
−0425		●		●		●		●
−0426		●		●		●		●
−0427		●		●		●		●
−0428			●	●		●		●
−0429		●	●	●		●		●
−0430		●	●	●		●		●
−0431	●	●	●	●		●		●
−0432						●		●
−0433		●				●		●
−0434		●				●		●
−0435		●				●		●
−0436				●		●		●
−0437		●		●		●		●
−0438		●		●		●		●
−0439		●		●		●		●
−0440				●		●		●
−0441		●		●		●		●
−0442		●		●		●		●
−0443		●		●		●		●
−0444			●	●		●		●
−0445		●	●	●		●		●
−0446		●	●	●		●		●
−0447	●	●	●	●		●		●
−0448							●	●

0472

Error number	Between A1,A5	A5	Between A5,A322	A322	Between A1,A401	A401	Between A401,A402	A402
−0449		●					●	●
−0450		●					●	●
−0451		●					●	●
−0452				●			●	●
−0453		●		●			●	●
−0454		●		●			●	●
−0455		●		●			●	●
−0456				●			●	●
−0457		●		●			●	●
−0458		●		●			●	●
−0459		●		●			●	●
−0460			●	●			●	●
−0461		●	●	●			●	●
−0462		●	●	●			●	●
−0463	●	●	●	●			●	●
−0464						●	●	●
−0465		●				●	●	●
−0466		●				●	●	●
−0467		●				●	●	●
−0468				●		●	●	●
−0469		●		●		●	●	●
−0470		●		●		●	●	●
−0471		●		●		●	●	●
−0472				●		●	●	●
−0473		●		●		●	●	●
−0474		●		●		●	●	●
−0475		●		●		●	●	●
−0476			●	●		●	●	●
−0477		●	●	●		●	●	●
−0478		●	●	●		●	●	●
−0479	●	●	●	●		●	●	●
−0480						●	●	●
−0481		●				●	●	●
−0482		●				●	●	●

0472

Error number	Between A1,A5	A5	Between A5,A322	A322	Between A1,A401	A401	Between A401,A402	A402
−0483		●				●	●	●
−0484				●		●	●	●
−0485		●		●		●	●	●
−0486		●		●		●	●	●
−0487		●		●		●	●	●
−0488				●		●	●	●
−0489		●		●		●	●	●
−0490		●		●		●	●	●
−0491		●		●		●	●	●
−0492			●	●		●	●	●
−0493		●	●	●		●	●	●
−0494		●	●	●		●	●	●
−0495	●	●	●	●		●	●	●
−0496					●	●	●	●
−0497		●			●	●	●	●
−0498		●			●	●	●	●
−0499		●			●	●	●	●
−0500				●	●	●	●	●
−0501		●		●	●	●	●	●
−0502		●		●	●	●	●	●
−0503		●		●	●	●	●	●
−0504				●	●	●	●	●
−0505		●		●	●	●	●	●
−0506		●		●	●	●	●	●
−0507		●		●	●	●	●	●
−0508			●	●	●	●	●	●
−0509		●	●	●	●	●	●	●
−0510		●	●	●	●	●	●	●
−0511	●	●	●	●	●	●	●	●

A1：P-920*(Wrapper board)　A5：P-922*(Sub-board heater control)　A322：P-922*(Sub-board bottom applicator)

A401：P-922*(Sub-board PS-EMZ #A)　A402：P-922*(Sub-board PS-EMZ #B)

*Correctly set sub-board DIPSW.

*Sub-board combination selected for corresponding machine type.

0472
Error list 0472-0513 – 0767

● indicates possibility of failure.

Error number	Between A1,A6	A6	Between A1,A7	A7
0472-0513	●	●		
-0514	●	●	●	●
:	:	:	:	:
-0575	●	●	●	●
-0576				●
-0577	●	●		●
-0578	●	●	●	●
:	:	:	:	:
-0639	●	●	●	●
-0640				●
-0641	●	●		●
-0642	●	●	●	●
:	:	:	:	:
-0703	●	●	●	●
-0704			●	●
-0705	●	●	●	●
-0706	●	●	●	●
:	:	:	:	:
-0767	●	●	●	●

A1：P-920*(Wrapper board)
A6：P-921*(Sub board Infeed)

A7：P-922*(Sub-board Left delivery)

*Correctly set sub-board DIPSW.

*Sub-board combination set for corresponding machine type.

0473

PACKING CONTROL PART

THE PROBLEM AROSE AT SEAL HEATER

*Front outfeed heater is abnormal.

*Front outfeed heater is out of use.
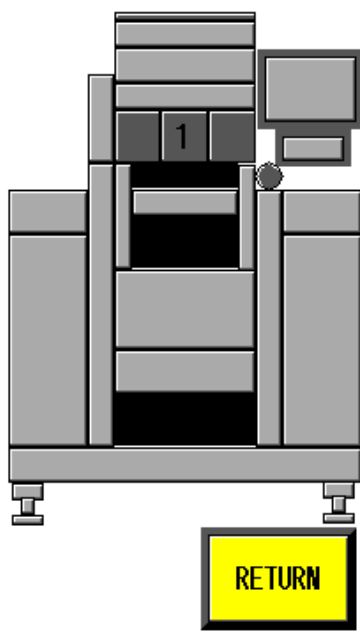
《REMOVE THE FILM AND LABEL》

1)Press ENERGENCY switch, REMOVE

　item on lift and infeed conveyor.

2)Open the front cover and remove the label.

*Display goes back when the label is removed.

*Label feeds by pressing flashing yellow.

1

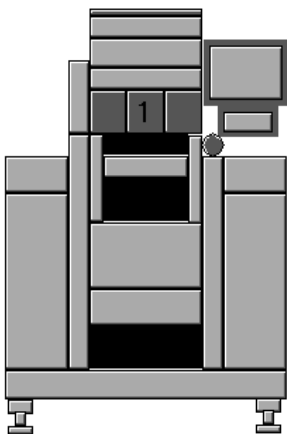RETURN

0473-0000

[Error content]	Front discharge heater abnormality
[Detail]	An abnormality occurred in either the front heater or the thermostat monitoring the front heater temperature. Sub-error meanings are as follows: <table><tr><td>0000</td><td>The heater temperature does not rise while heating (Thermostat value does not change)</td></tr><tr><td>0001</td><td>Thermostat abnormality (Disconnection or short circuit)</td></tr></table>
[Solution]	[RETURN] button
[Remarks]	The heater is switched OFF when this error occurs.
[Cause]	An abnormality occurred in either the front heater or the thermostat monitoring the front heater temperature.
[Response]	Service or replace front heater and/or thermostat monitoring the front heater temperature.

0474

[Error content]	Rear discharge heater abnormality		
[Detail]	An abnormality occurred in either the rear heater or the thermostat monitoring the rear heater temperature.		
	0000	The heater temperature does not rise while heating (Thermostat value does not change).	
	0001	Thermostat abnormality (Disconnection or short circuit)	
[Solution]	[RETURN] button		
[Remarks]	The heater is switched OFF when this error occurs.		
[Cause]	An abnormality occurred in either the rear heater or the thermostat monitoring the rear heater temperature.		
[Response]	Service or replace rear heater and/or thermostat monitoring the rear heater temperature.		

0475
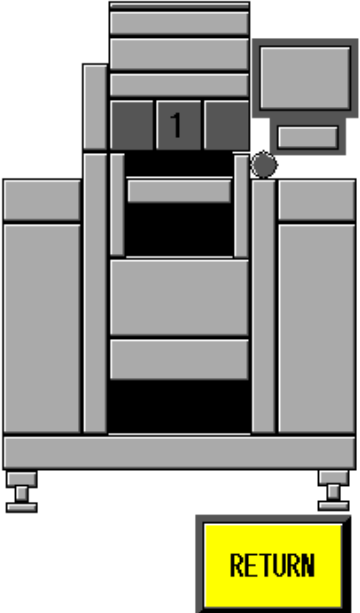

```
PACKING CONTROL PART

THE LIFT CONTACTS THE FEEDER

*The stretch is not enough.
《REMOVE THE FILM AND LABEL》
1)Press ENERGENCY switch, REMOVE
   item on lift and infeed conveyor.
2)Open the front cover and remove the label.


*Display goes back when the label is removed.
*Label feeds by pressing flashing yellow.

                                                    RETURN
   0475-0000
```

[Error content]	Incorrect lift size selection.
[Detail]	The rear feeder is in a position where it may come in contact with the lift when it is raised. Sub-error meanings are as follows: 0000 — Error occurs when small lift is selected (Not enough stretch). 0001 — Error occurs when large lift is selected (Lift selection is unsuitable or not enough stretch).
[Solution]	[RETURN] button
[Remarks]	Lift selection, amount of stretch (fine adjustment) are necessary after cancelling the error. (This error does not occur with the pre-set default wrapper condition values).
[Cause]	The rear feeder is in a position where it may come in contact with the lift when it is raised.
[Response]	Select lift, set appropriate stretch (fine adjustment) after cancelling error.

0476
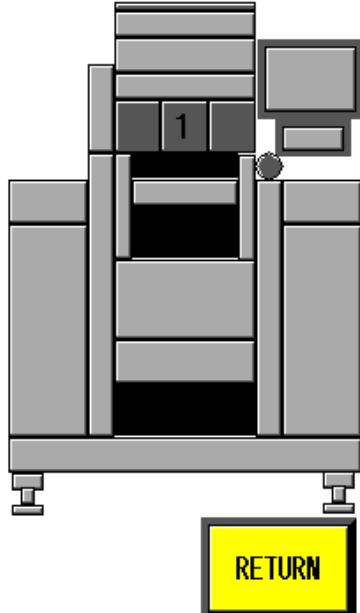
```
┌─────────────────────────────────────────────────────────┐
│              PACKING CONTROL PART                         │
│  ┌─────────────────────────────────────────────────────┐ │
│  │       INJECTION TRAY DIFFERS FROM SETTING           │ │
│  └─────────────────────────────────────────────────────┘ │
│                                                           │
│  *Check tray and tray no.                                 │
│  《REMOVE THE FILM AND LABEL》                             │
│  1)Press ENERGENCY switch, REMOVE                         │
│     item on lift and infeed conveyor.                     │
│  2)Open the front cover and remove the label.             │
│                                                           │
│                                                           │
│  *Display goes back when the label is removed.            │
│  *Label feeds by pressing flashing yellow.                │
│                                                           │
│                                              ┌─────────┐  │
│    0476-0000                                 │ RETURN  │  │
│                                              └─────────┘  │
└─────────────────────────────────────────────────────────┘
```

[Error content]	Tray settings and infeed tray are different.
[Detail]	The wrapper detected the narrow-side dimensions of the infeed tray are more than 50mm larger than the selected tray. The narrow-side dimensions detected by the wrapper are shown in the sub-error.
[Solution]	[RETURN] button
[Remarks]	
[Cause]	There was a difference of greater than 50mm between the tray infeed by the scale unit and the near-side measurements by the commodity on-lift detection sensor. In case of this error, it can be considered that the commodity on lift sensor is soiled.
[Response]	· Clean the commodity on lift detection sensor. · Adjust commodity on lift detection sensor sensitivity.

0477

```
PACKING CONTROL PART

FEEDER IS NOT AT INITIAL POSITION

《REMOVE THE FILM AND LABEL》
1)Press ENERGENCY switch, REMOVE
   item on lift and infeed conveyor.
2)Open the front cover and remove the label.


*Display goes back when the label is removed.
*Label feeds by pressing flashing yellow.
```
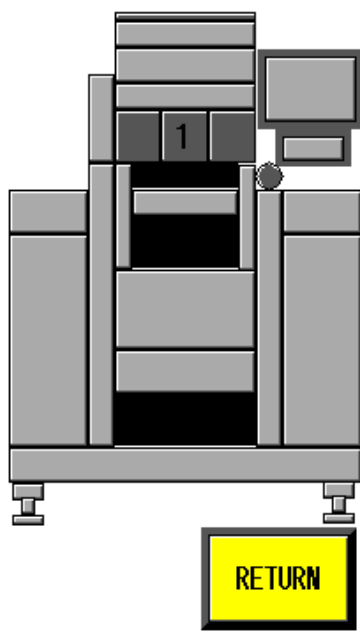
1

```
                                          RETURN

0477-0000
```

[Error content]	Feeder is not in its original position.
[Detail]	The feeder bar was not in its original position when the wrapper started feeder operations (excluding return operation).
[Solution]	[RETURN] button
[Remarks]	
[Cause]	Feeder is not in its original position.
[Response]	Check feeder original position sensor.

0478


```
PACKING CONTROL PART

THE RIGHT PLUG OPENING/CLOSING ARE NOT SET

*Open the right film exchange cover.
 set the insertion plate.
《REMOVE THE FILM AND LABEL》
1)Press ENERGENCY switch, REMOVE
   item on lift and infeed conveyor.
2)Open the front cover and remove the label.

*Display goes back when the label is removed.
*Label feeds by pressing flashing yellow.

                                        1

                                    RETURN

0478-0000
```
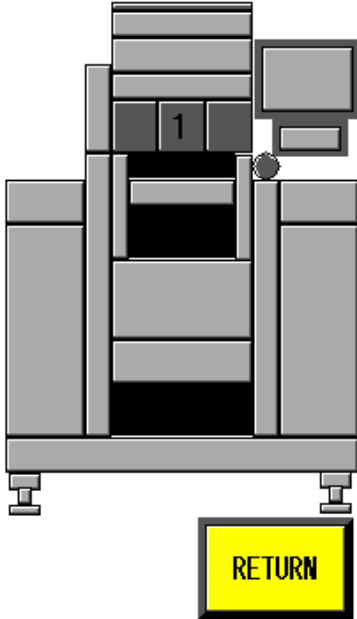
[Error content]	Right insert open/close is not set.
[Detail]	Right film exchange door is closed, but right film insert open/close is open.
[Solution]	Press the [RETURN] button after setting insert plate
[Remarks]	
[Cause]	1. Right film exchange door is closed, but right film insert open/close is open. 2. Film insert open right sensor is not receiving light.
[Response]	1. Close right insert open/close. 2. Check film insert open right sensor.

0479

PACKING CONTROL PART
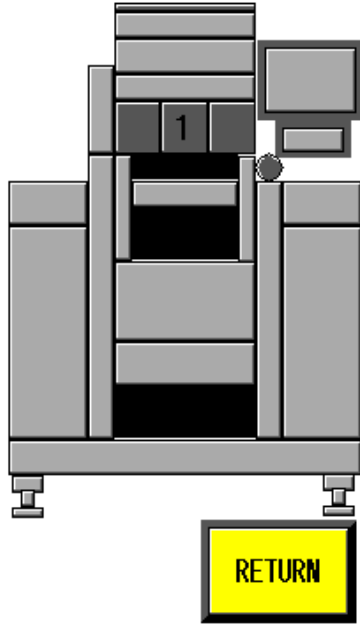
THE LEFT PLUG OPENING/CLOSING ARE NOT SET

*Open the left film exchange cover.
 set the insertion plate.
《REMOVE THE FILM AND LABEL》
1)Press ENERGENCY switch, REMOVE
   item on lift and infeed conveyor.
2)Open the front cover and remove the label.

*Display goes back when the label is removed.
*Label feeds by pressing flashing yellow.

RETURN

0479-0000

[Error content]	Left insert open/close is not set.
[Detail]	Left film exchange door is closed, but left film insert open/close is open.
[Solution]	Press the [RETURN] button after setting insert plate
[Remarks]	
[Cause]	1. Left film exchange door is closed, but left film insert open/close is open. 2. Film insert open left sensor is not receiving light.
[Response]	1. Close left insert open/close. 2. Check film insert open left sensor.

0480

```
┌─────────────────────────────────────────────┐
│          PACKING CONTROL PART                │
│                                              │
│           THE FILM REMAINS                   │
│                                              │
│ 1)Open film release cover and check          │
│    the position of the following film belt.  │
│                                              │
│ 2)Remove the tray and lebel.                 │
│ 3)Close film release cover.                  │
│ 3)Close film release cover.                  │
│ 4)Press [RETURN] key.                        │
│                                              │
│                                    RETURN    │
│  0480-0000                                   │
└─────────────────────────────────────────────┘
```

[Error content]	Film is remaining.
[Detail]	The film sensor board is knocked over when the film started to be sent. The bit mask shows the knocked over sensor location. Number and location correlation are as follows: <table><tr><td>0001</td><td>Rear right</td></tr><tr><td>0002</td><td>Front right</td></tr><tr><td>0004</td><td>Rear left</td></tr><tr><td>0008</td><td>Front left</td></tr></table> (Ex.) If remaining film were detected in the rear right and front right, the sub-error would be 0003.
[Solution]	Press the [RETURN] button after removing film
[Remarks]	
[Cause]	The film sensor board is knocked over when the film started to be sent.
[Response]	<table><tr><td>0001</td><td>Service rear right film over sensor</td></tr><tr><td>0002</td><td>Service front right film over sensor</td></tr><tr><td>0004</td><td>Service rear left film over sensor</td></tr><tr><td>0008</td><td>Service front left film over sensor</td></tr></table> (Ex.) Compound error If remaining film was detected in the rear right and front right, the sub error would be 0003. In the event of compound errors, the sum of the numbers is displayed.
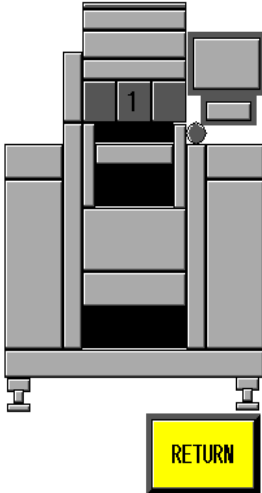
0481

```
┌─────────────────────────────────────────────┐
│             PACKING CONTROL PART              │
│                                               │
│        THE S CUTTER HAS NOT RETURNED          │
│                                               │
│ *Open film release cover (Right side) & check │
│   if there is any foreign object at cutter.   │
│ 《REMOVE THE FILM AND LABEL》                  │
│ 1)Press ENERGENCY switch, REMOVE              │
│    item on lift and infeed conveyor.          │
│ 2)Open the front cover and remove the label.  │
│                                               │
│ *Display goes back when the label is removed. │
│ *Label feeds by pressing flashing yellow.     │
│                                               │
│                                   ┌─────────┐ │
│                                   │  RETURN │ │
│  0481-0000                        └─────────┘ │
└─────────────────────────────────────────────┘
```

[Error content]	The cutter has not returned to its original position.	
[Detail]	The cutter has not returned to its original position when starting cutter operation. Or, the cutter solenoid is pulling, but the original position sensor is not receiving light. Sub-error meanings are as follows:	
	0000	Right cutter has not returned to its original position during operation.
	0001	Left cutter has not returned to its original position during operation.
	0002	Original position sensor is not receiving light during right cutter operation.
	0003	Original position sensor is not receiving light during left cutter operation.
[Solution]	Press the [RETURN] button after checking for foreign objects	
[Remarks]		
[Cause]	0000	Right cutter has not returned to its original position during operation.
	0001	Left cutter has not returned to its original position during operation.
	0002	Original position sensor is not receiving light during right cutter operation.
	0003	Original position sensor is not receiving light during left cutter operation.
[Response]	0000	Check right cutter original point sensor
	0001	Check left cutter original point sensor
	0002	Check right cutter original point sensor
	0003	Check left cutter original point sensor

0482

PACKING CONTROL PART
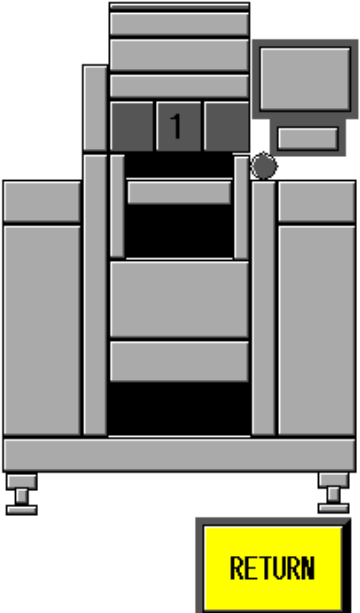
THE S PLUG BOARD HAS NOT RETURNED

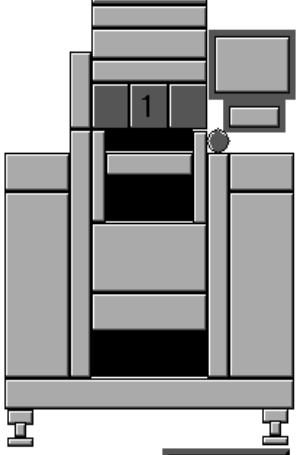*Open the right film exchange cover.
 check the insertion plate.
《REMOVE THE FILM AND LABEL》
1)Press ENERGENCY switch, REMOVE
   item on lift and infeed conveyor.
2)Open the front cover and remove the label.

*Display goes back when the label is removed.
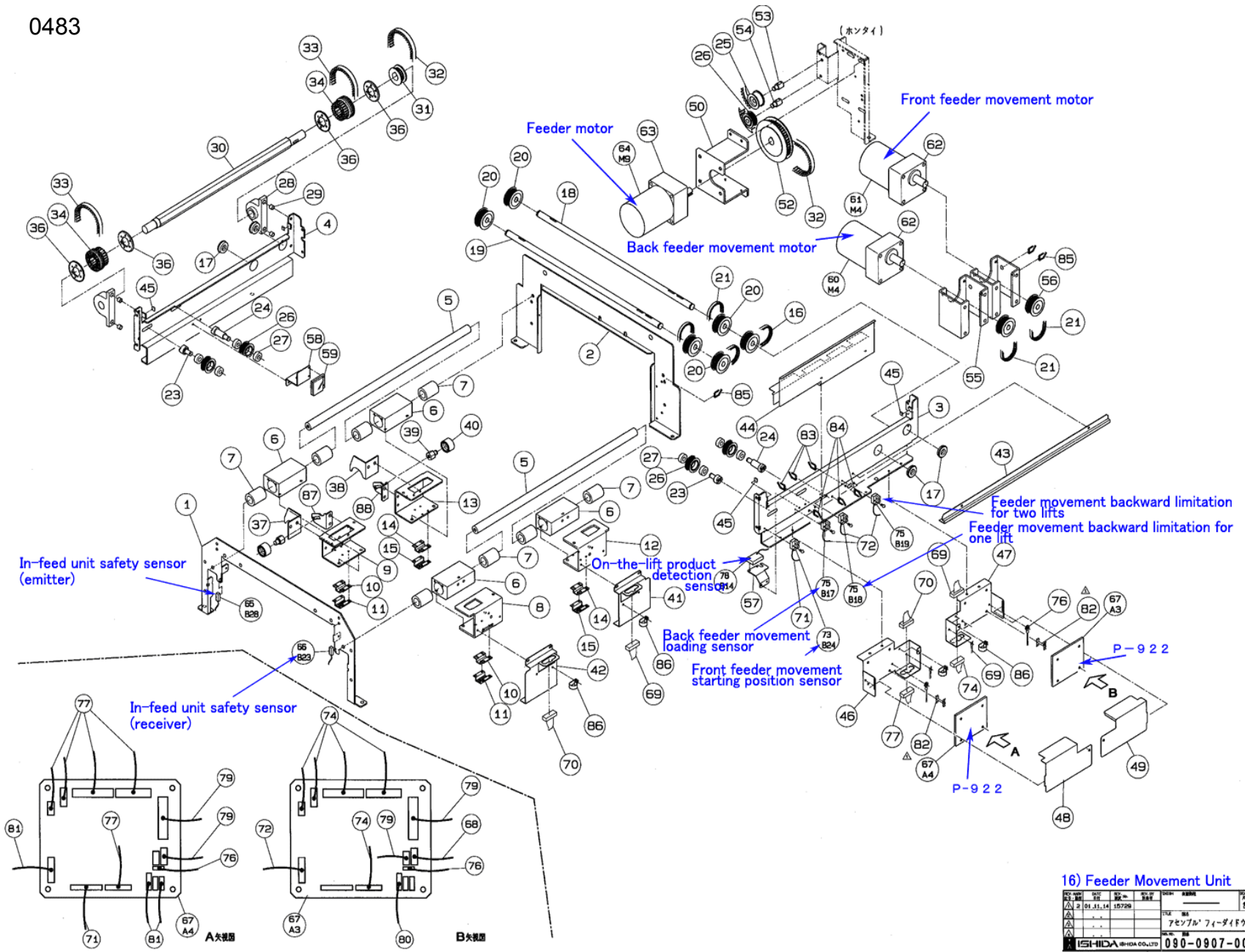*Label feeds by pressing flashing yellow.

RETURN

0482-0000

[Error content]	Insert plate has not returned to its original point.
[Detail]	The cutter can't be switched on as the insert plate has not returned to its original position when cutter operation started. Sub-error meanings are as follows:
	0000 Right side insert plate did not return to its original position.
	0001 Left side insert plate did not return to its original position.
[Solution]	Press the [RETURN] button after checking the insert plate
[Remarks]	This error occurs when the film does not correctly contact the insert plate during film loading and it is allowed to operate without the gripper being able to lift the film.
[Cause]	The cutter can't be switched on as the insert plate has not returned to its original position when cutter operation started.
[Response]	Return the insert plate to its original position.

0483

```
PACKING CONTROL PART

THE SENSOR AFTER FEEDER IS ABNORMAL

《REMOVE THE FILM AND LABEL》
1)Press ENERGENCY switch, REMOVE
   item on lift and infeed conveyor.
2)Open the front cover and remove the label.

*Display goes back when the label is removed.
*Label feeds by pressing flashing yellow.

                                              RETURN
0483-0000
```

[Error content]	Sensor positioned behind the feeder is abnormal.
[Detail]	An impossible input combination has occurred in the sensor detecting the rear feeder position. The sub-error displays the input conditions. · Feeder move loading sensor (rear) · Feeder move original point sensor (front) · Feeder move rear retraction limit sensor (small) (Small lift impact boundary) · Feeder move rear retraction limit sensor (large) (large lift impact boundary) Check the location of each sensor.
[Solution]	[RETURN] button
[Remarks]	An impossible input combination has occurred in the sensor detecting the rear feeder position (original position, small lift impact boundary, large lift impact boundary,). Sub-error displays the input conditions for each sensor. Sub-error contents are as follows:

0000	All sensors are not receiving light. Original point, large lift boundary are disconnected.
0020	Only the small lift boundary sensor is emitting light. Original point, large lift boundary sensor input is disconnected or small lift boundary sensor input is shorted.
0420	Only the original point sensor is not receiving light. Original point sensor input is disconnected or small lift boundary sensor input is shorted.

* The above error modes are only malfunctions in 1 location.

0483

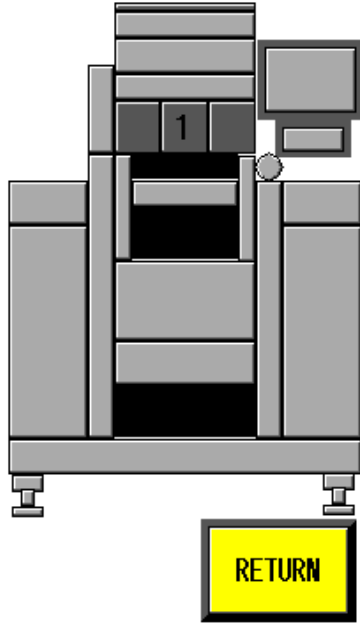|	
[Cause]	An impossible input combination has occurred in the sensor detecting the rear feeder position.
[Response]	Check the following sensors: ・ Feeder move loading sensor (rear) ・ Feeder move original point sensor (front) ・ Feeder move rear retraction limit sensor (small) (Small lift impact boundary) ・ Feeder move rear retraction limit sensor (large) (large lift impact boundary)

0483

Feeder motor

Front feeder movement motor

Back feeder movement motor

In-feed unit safety sensor (emitter)

In-feed unit safety sensor (receiver)

On-the-lift product detection sensor

Feeder movement backward limitation for two lifts

Feeder movement backward limitation for one lift

Back feeder movement loading sensor

Front feeder movement starting position sensor

P-922

16) Feeder Movement Unit

090-0907-001

0484

```
PACKING CONTROL PART

THE HEATER SAFETY GUARD IS UP

*At the heater safety cover
 check if there is any foreign object.
*Press EMERGENCY switch after checking,
 And release it.
*Press [RETURN] key after completion

                                    1

                                         RETURN

0484-0000
```

[Error content]	Heater safety guard is raised
[Detail]	The heater safety guard was had not returned to its original position when wrapper operation began.
[Solution]	[RETURN] button
[Remarks]	
[Cause]	The heater safety guard was had not returned to its original position when wrapper operation began.
[Response]	Check safety guard original point sensor and respond accordingly.

0485
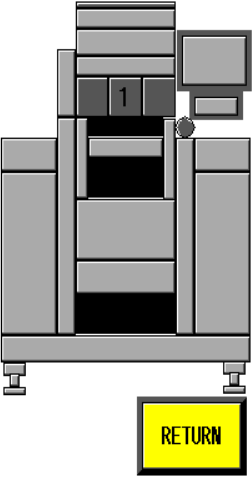
[Error content]	Electromagnetic contact auxiliary contact abnormality The P-920 platform is monitors whether the electromagnetic switch is open or closed in the auxiliary switch for the electromagnetic contact via P-921 and P-922. An abnormality has occurred in the results of monitoring.
[Detail]	An abnormality occurred between the electromagnetic contact auxiliary contact input opening and closing the power line and each cover switch open/ closed condition while waiting for the wrapper or during operation. This electromagnetic switch is blocking the power line (AC 200V, DC 24V). For example, if the electromagnetic switch auxiliary contact is open and each cover safety switch and the emergency stop switch are closed and this abnormality continues for 5 seconds, this error occurs. The switch location where the abnormality occurred is displayed in the sub-error as below. A specific location is displayed for all sub-codes other than 0000. Check the operation of that switch.

0000	No cover is open
0016	Right film replacement cover is open
0032	Left film removal cover is open
0064	Right film removal cover is open
0128	Emergency stop switch ON
0256	Infeed unit is pulled out
0512	Infeed bottom cover open
1024	Front cover open
2048	Left film replacement cover open

[Resolution]	[RETURN] button
[Response]	1)In the case of 0485-0000 　　　See a further detailed explanation 2)In the case of errors other than 0485-0000 　　Confirm corresponding emergency stop or safety switch is operating normally.
[Remarks]	It is not an actual failure, however, this error occurs easily when a cover is half-way closed. (Classification is possible after J-501H).

0485

Detailed explanation of error 0485-0000.

This error is also displayed when DC 24V is not output due to switching power (U2) malfunction. Check the switching power first. There is no problem if the green LED is illuminated.

View U2 power unit placement.

Next, one of the two causes below can be considered.
This occurs when 1-2 of the 8 switches between S2 and S9 are closed although the electromagnetic contactor is open. However, the emergency stop switch is between YE-2.
Confirming the open/closed condition of S2-S9, P-920 monitors the open/closed condition of each switchbetween S1-2 through P-921, P-922.

Specific example (1)
This is explained using the example of a bad electrical contact between 3-4 of the right film removal cover (S6). By definition, S6 connection 1-2 is closed. At this point, an abnormality occurs in switch S6.
Because 3-4 is open in switch S6, DC 24V is not applied to the energized side of the electromagnetic contact. Because of this, the electromagnetic contact auxiliary contact is opened.
For this reason, although all switches from S2 to S9 are closed, error 0485-0000 occurs because the electromagnetic contact auxiliary contact is open.
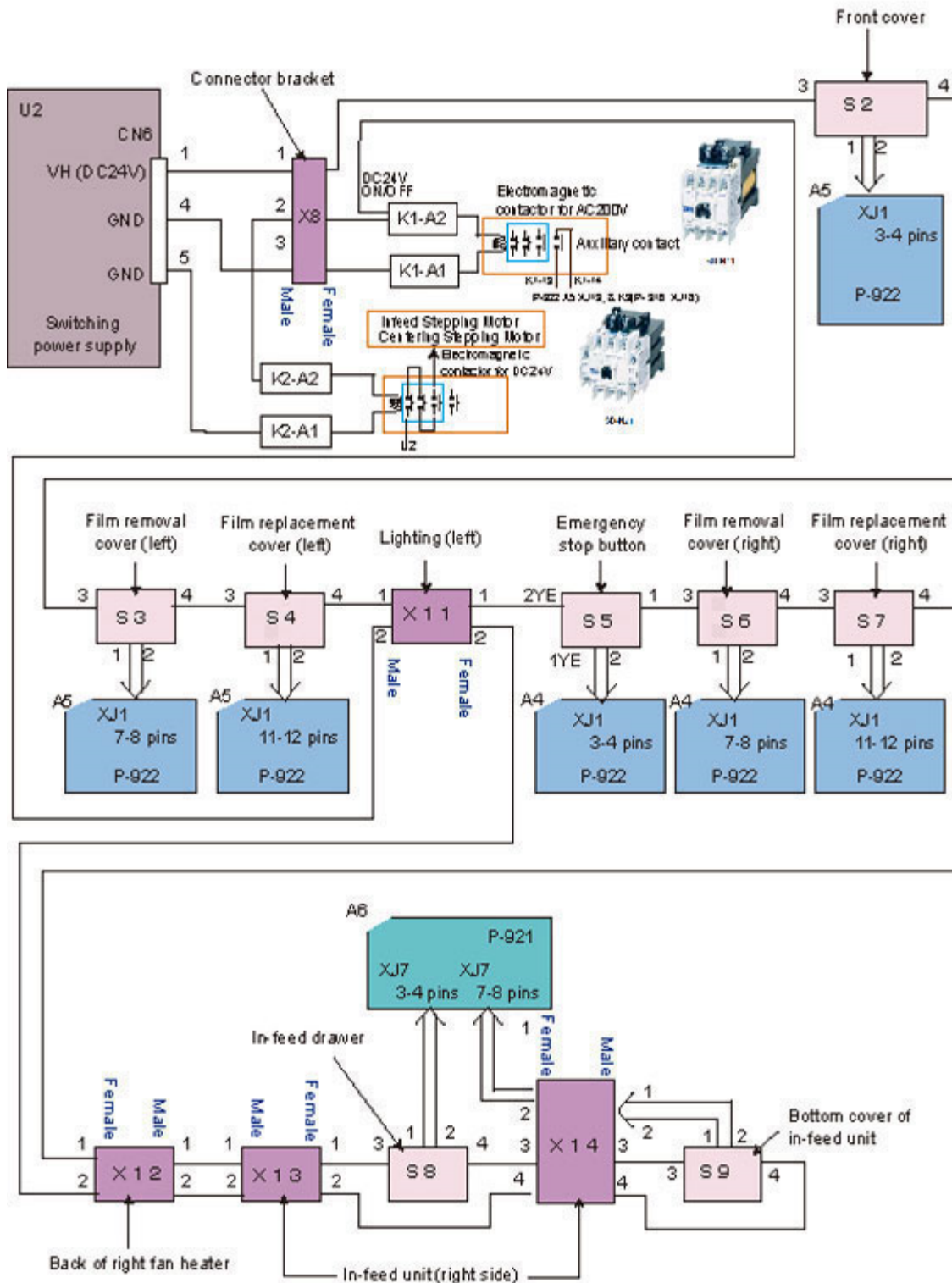
Specific example (2)
In normal conditions with all switches from S2 to S9 closed, this error occurs in the event of the electromagnetic contact auxiliary contact is open. The electromagnetic contact is energized, but the abnormality of the open auxiliary contact causes error 0485-0000.
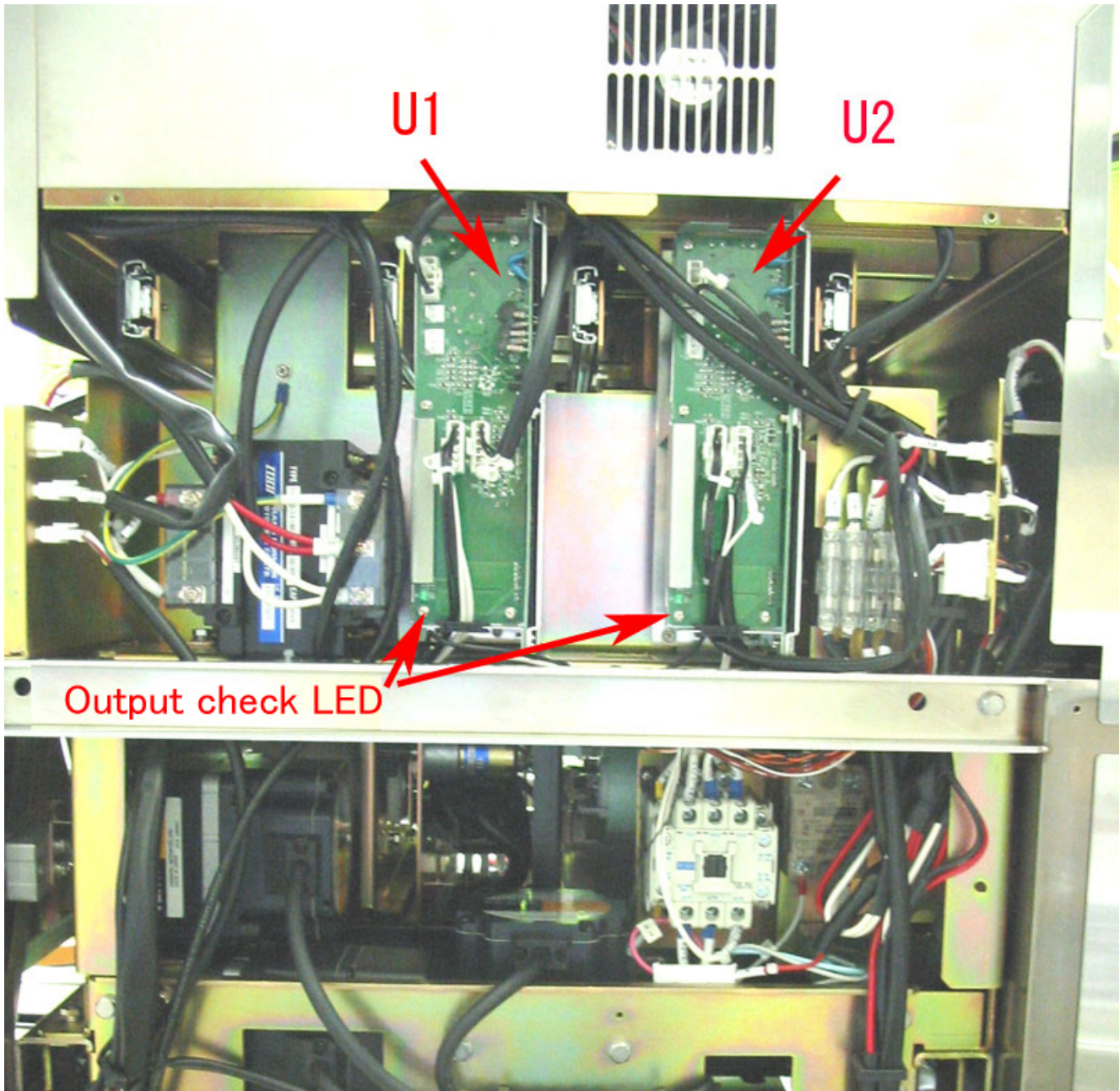Identify the location of malfunction

0485

Safety switch of Motor Drive

Front cover

Connector bracket

U2
CN6
VH (DC24V)
GND
GND
Switching power supply

X8
Male
Female

DC24V ON/OFF
K1-A2
K1-A1
Electromagnetic contactor for AC200V
Auxiliary contact

3 S 2 4
1 2
A5
XJ1
3-4 pins
P-922

Infeed Stepping Motor
Centering Stepping Motor
Electromagnetic contactor for DC24V
K2-A2
K2-A1
U2

Film removal cover (left)	Film replacement cover (left)	Lighting (left)	Emergency stop button	Film removal cover (right)	Film replacement cover (right)

3 S 3 4
1 2
A5
XJ1
7-8 pins
P-922

3 S 4 4
1 2
A5
XJ1
11-12 pins
P-922

1 X 11 1
2 2
Male Female

2YE
S 5
1YE 2
A4
XJ1
3-4 pins
P-922

3 S 6 4
1 2
A4
XJ1
7-8 pins
P-922

3 S 7 4
1 2
A4
XJ1
11-12 pins
P-922

A6
P-921
XJ7   XJ7
3-4 pins 7-8 pins

In-feed drawer

Female Male Male Female

1 X 12 2
2

1 X 13 2
2

3 S 8 4
1 2

Female
1 X 14 2
3   4
Male

1
2
Bottom cover of in-feed unit

1 S 9 2
3   4

Back of right fan heater

In-feed unit (right side)
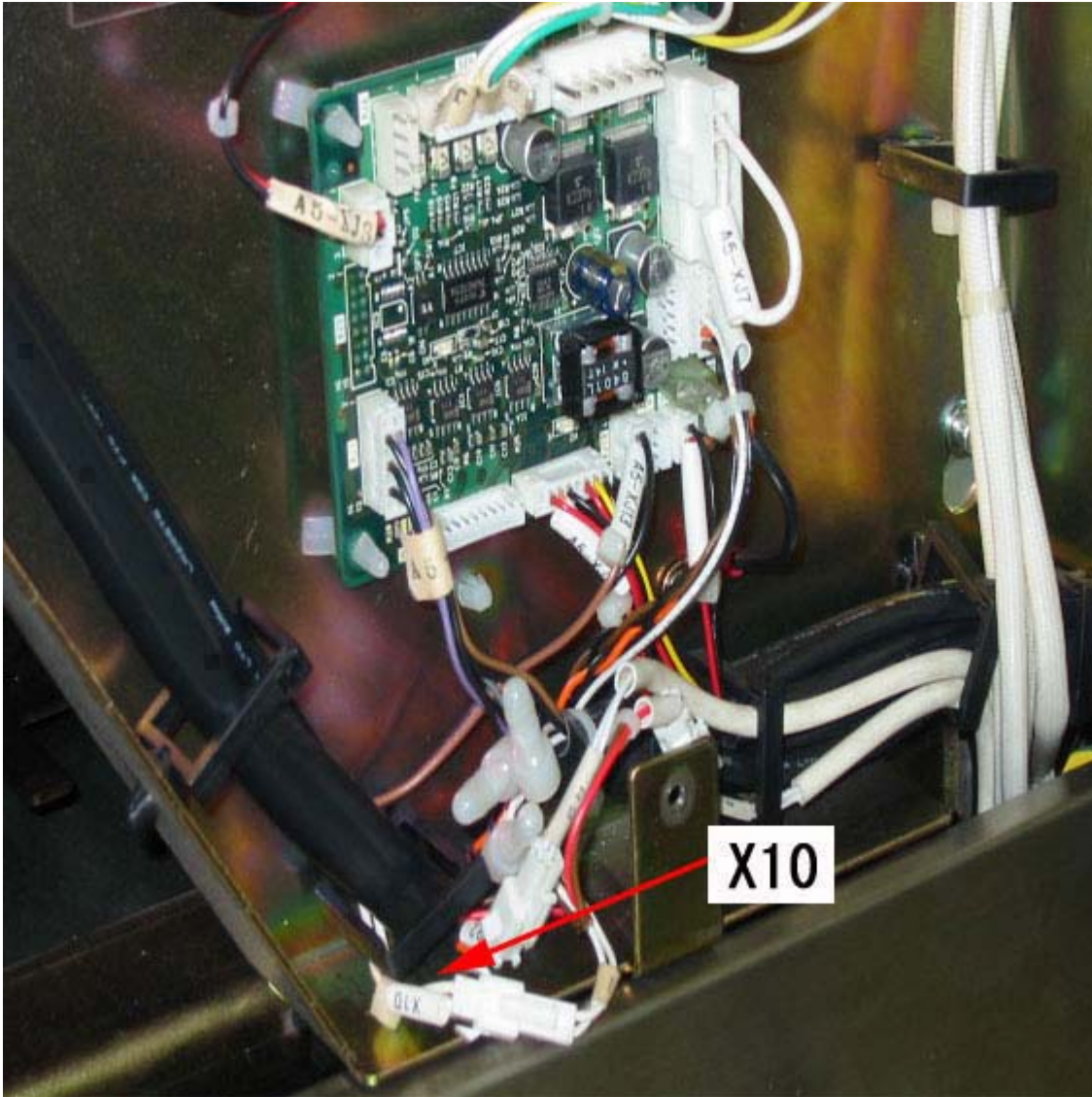
0485

U1

U2

Output check LED

0485

Identifying the location of malfunction 1 (In the event of a bad connection between S2-S9)

1. Turn the wrapper OFF.
2. Remove connector X10. As this connector is not used for NV and S machines, remove connector X11.
   Confirm the location of each connector X8, X10, X11, X12, X13, X14
3. The following is an explanation for when X10 is removed.
4. Close all covers.
5. Release the emergency stop switch.
6. Check that the X-10 male-side connector (1-2 pin) has continuity. As switches S2-S9 are connected in series, there will be continuity if it is normal. This explains in the case of no continuity. If there is continuity, continue to "Identifying the location of malfunction 2."
7. Connect connector X10, and remove connector X11.
8. Check that the X11 female-side connector (1-2 pin) has continuity. This explains in the case of continuity.
9. In this case, there is a bad connection somewhere in safety switch S2, S3, or S4.
10. Check continuity in 3-4 of safety switches S2, S3, and S4, the safety switch without continuity is the location of the malfunction. 3-4 can be identified by its harness numbering.
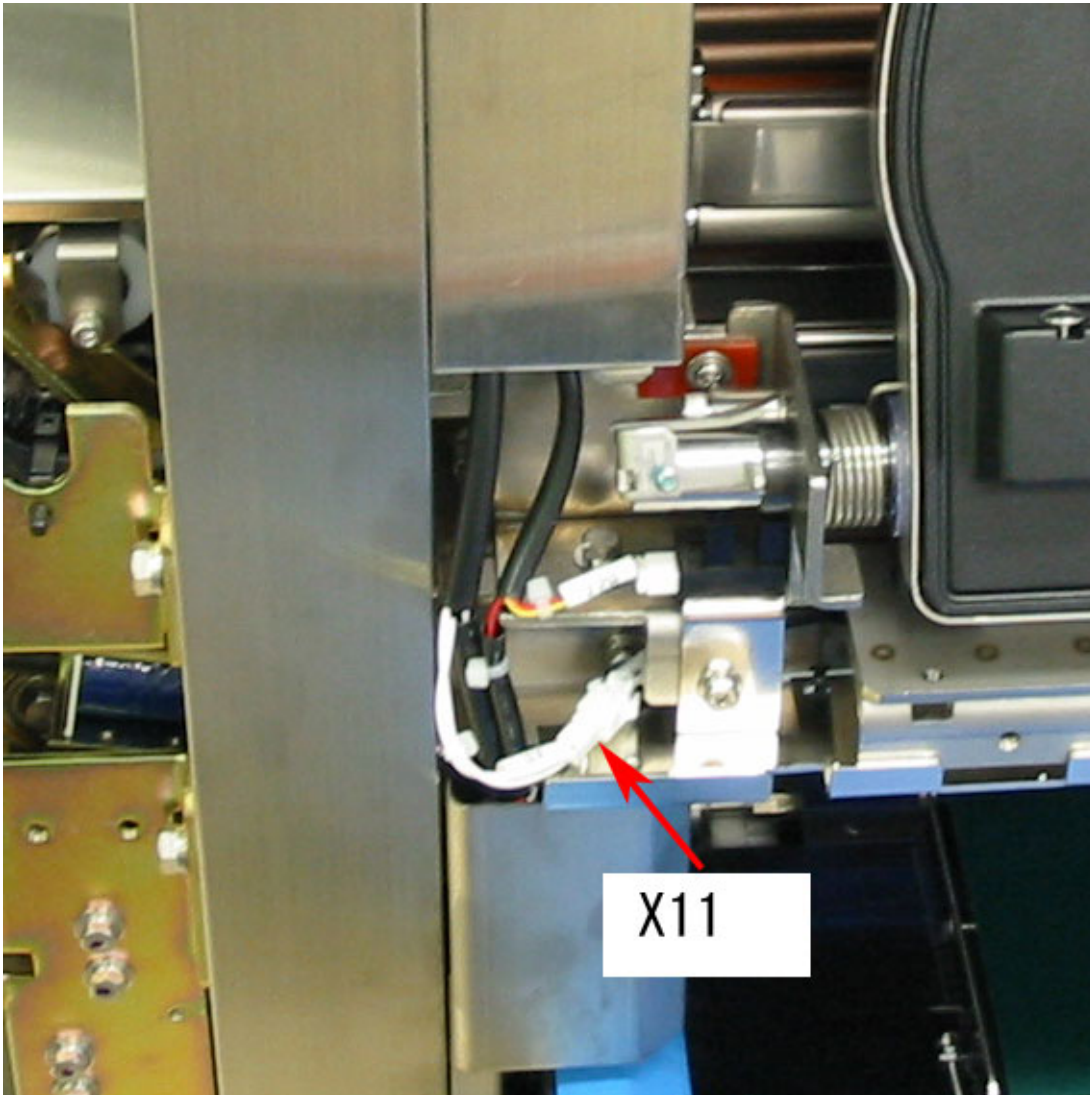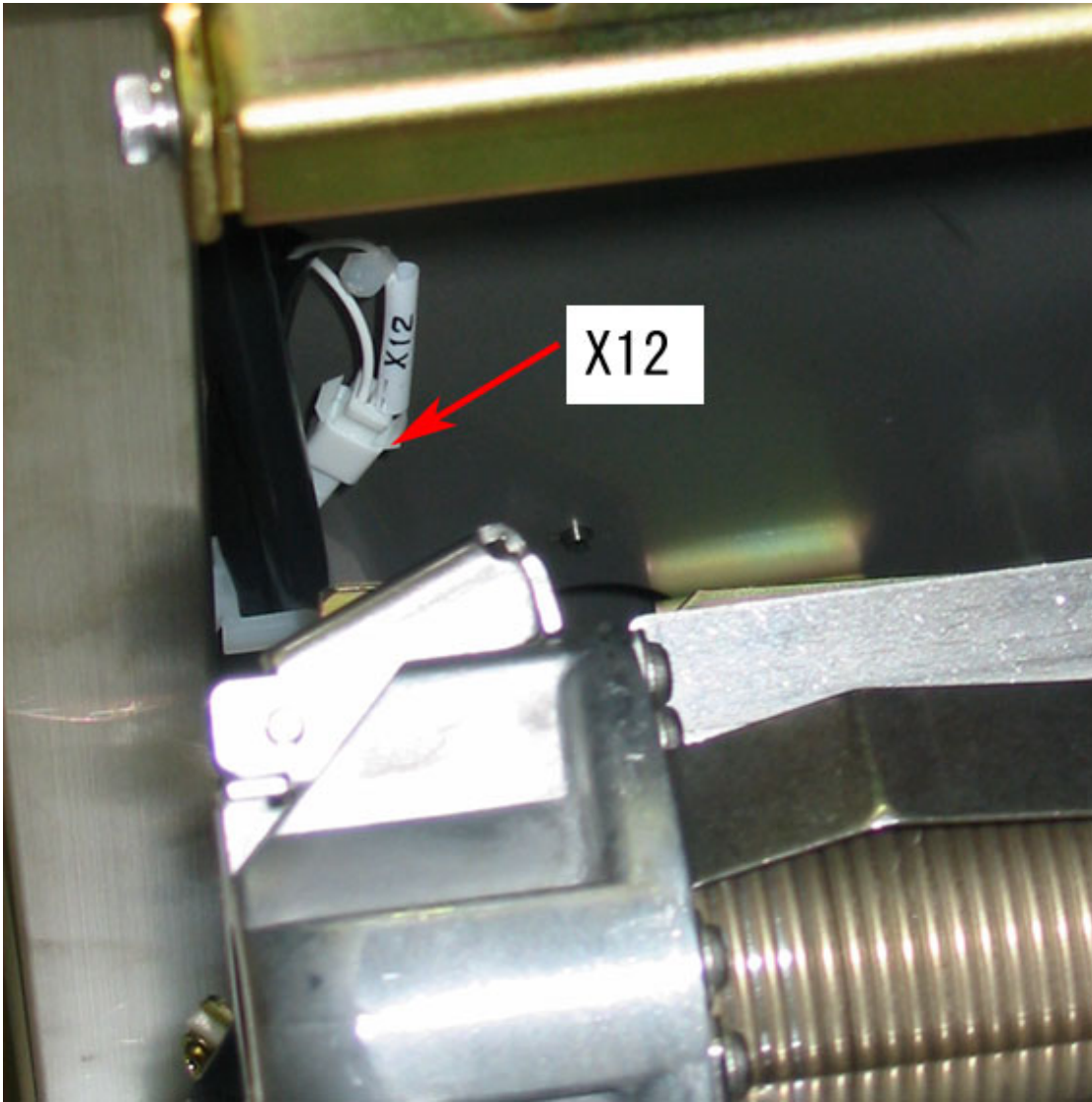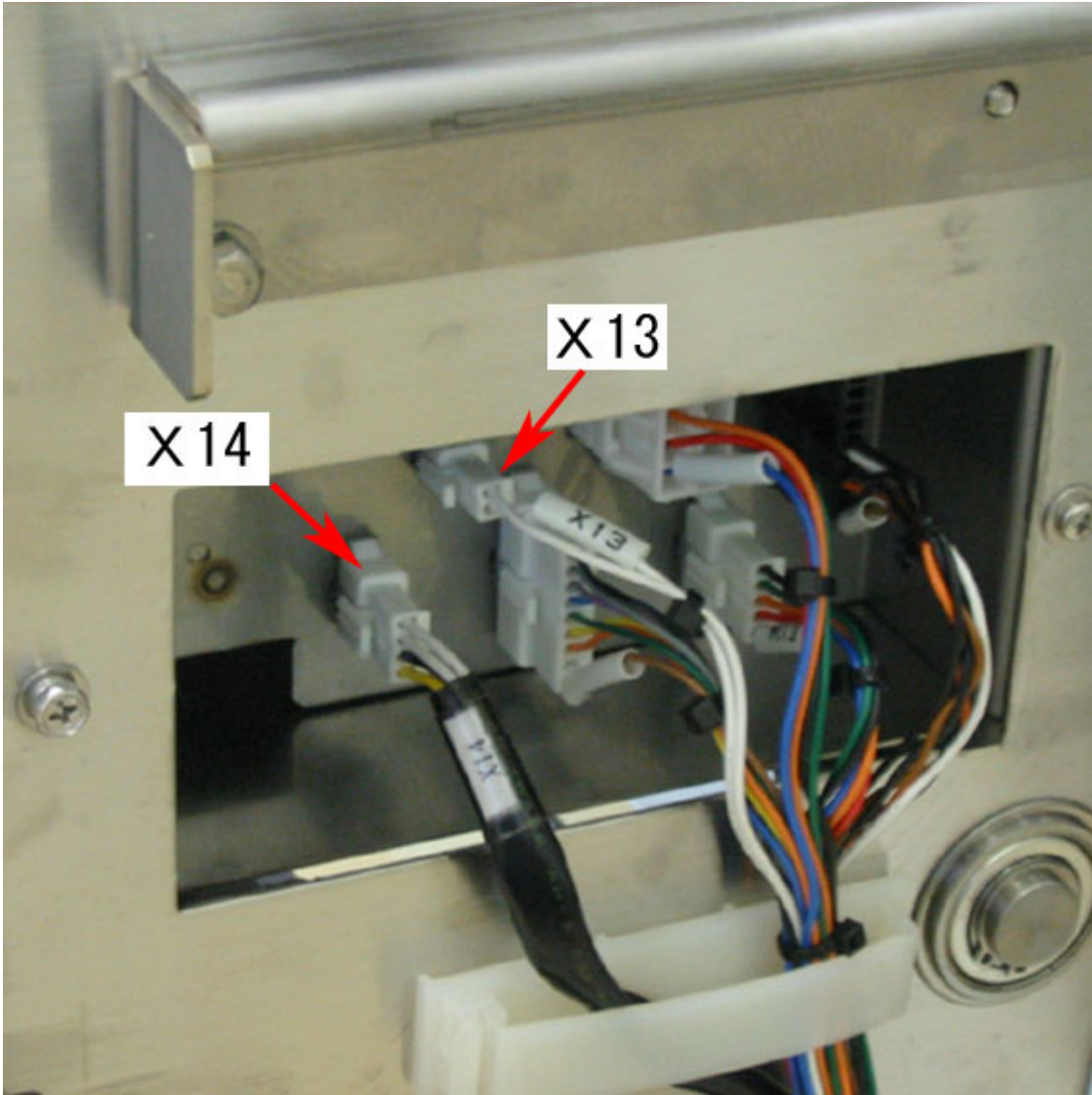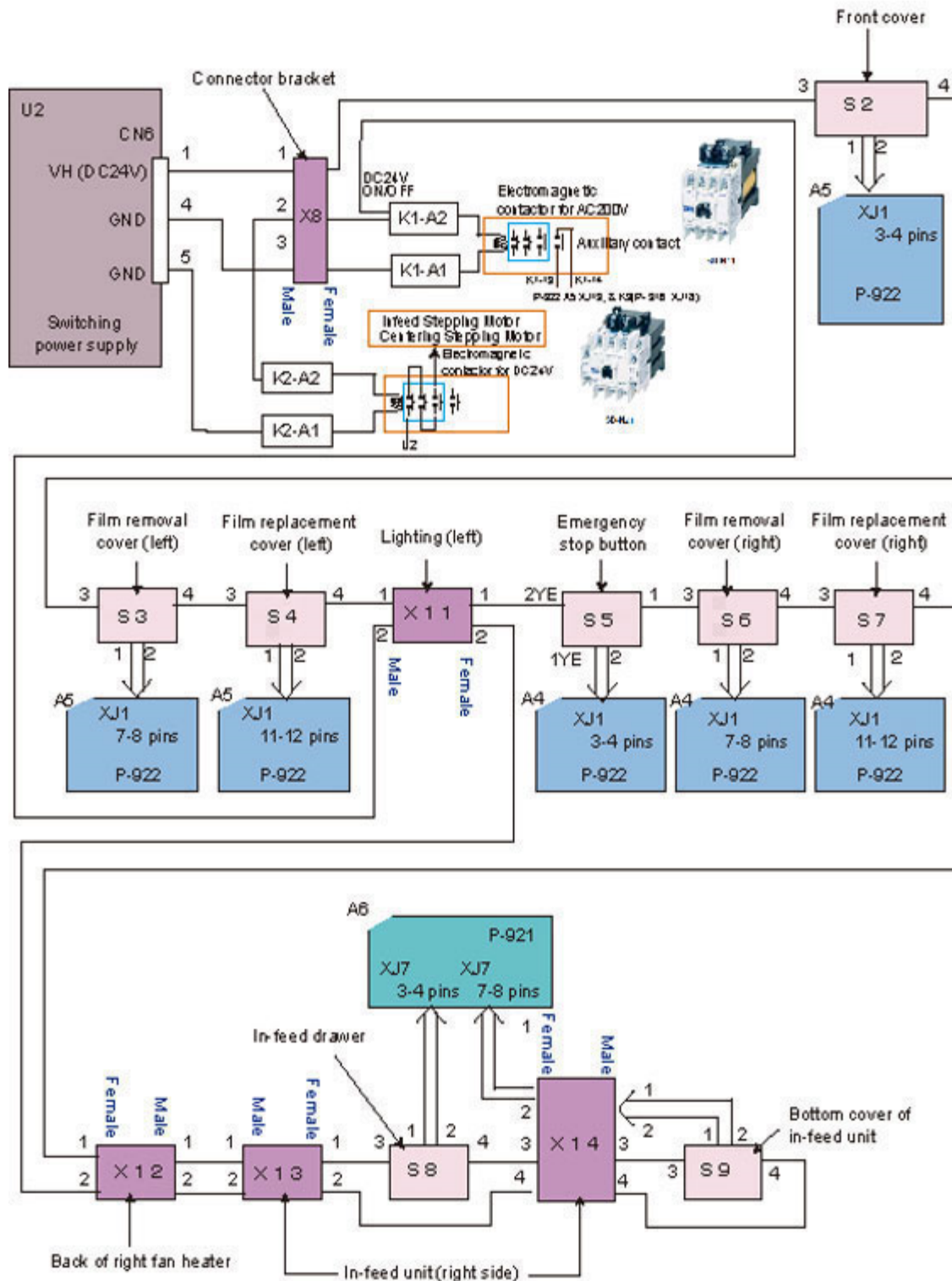
0485
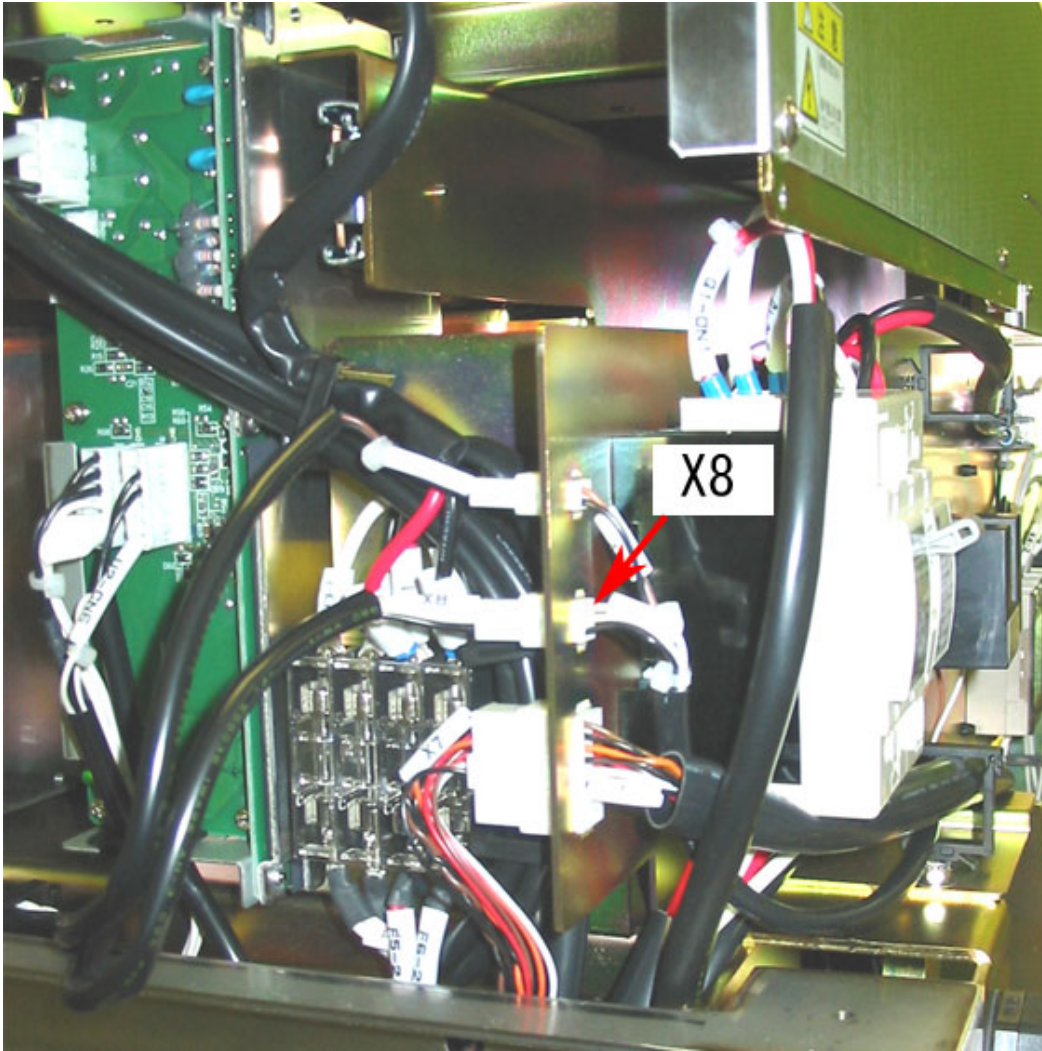
0485

0485

0485

0485

0485

Specifying a fault location (#2)

(For poor contact at the auxiliary contact of the electromagnetic contactor)
1. Turn OFF the power supply of the main body
2. Switches from S2 to S9 operate normally because there is conduction between pins 1 and 2 of the X10 male side connector
3. Connect the X10 connector
4. Confirm whether there is conduction at the auxiliary contact of the electromagnetic contactor.
5. Connect harnesses (K1-13 and K1-14) connecting with the auxiliary contact of the AC200V electromagnetic contactor.
6. If 0485-0000 error does not appear when the power supply is turned ON, a loose connection is occurring at the auxiliary contact of the electromagnetic contactor. Replace with a new AC200V electromagnetic contactor.
7. Turn OFF the main power if the error does not disappear.
8. Return harnesses connecting with the auxiliary contact of the AC200V electromagnetic contactor to their original positions.
9. Then, connect harnesses (K2-13 and K2-14) connecting with the auxiliary contact of the DC24V electromagnetic contactor.
10. If 0485-0000 error does not appear when the power supply is turned ON, a loose connection is occurring at the auxiliary contact of the electromagnetic contactor. Replace with a new DC24V electromagnetic contactor.

0485

Safety switch of Motor Drive

0485

電磁接触器の補助接点は下記の〇印部分です。
Auxiliary contact of the electromagnetic contactor is Yes marked section below.

0485

connect harnesses
K1-13 and K1-14
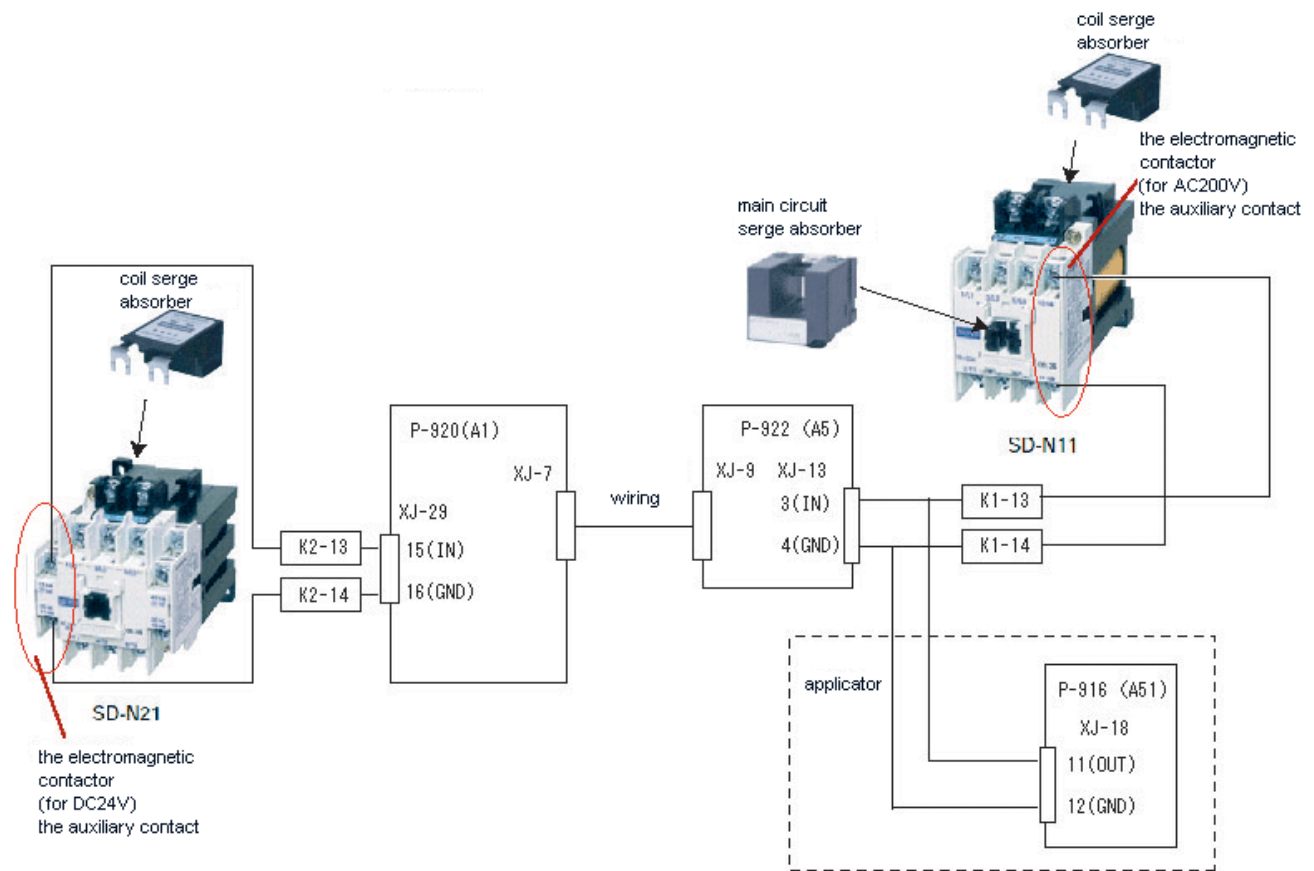
0485
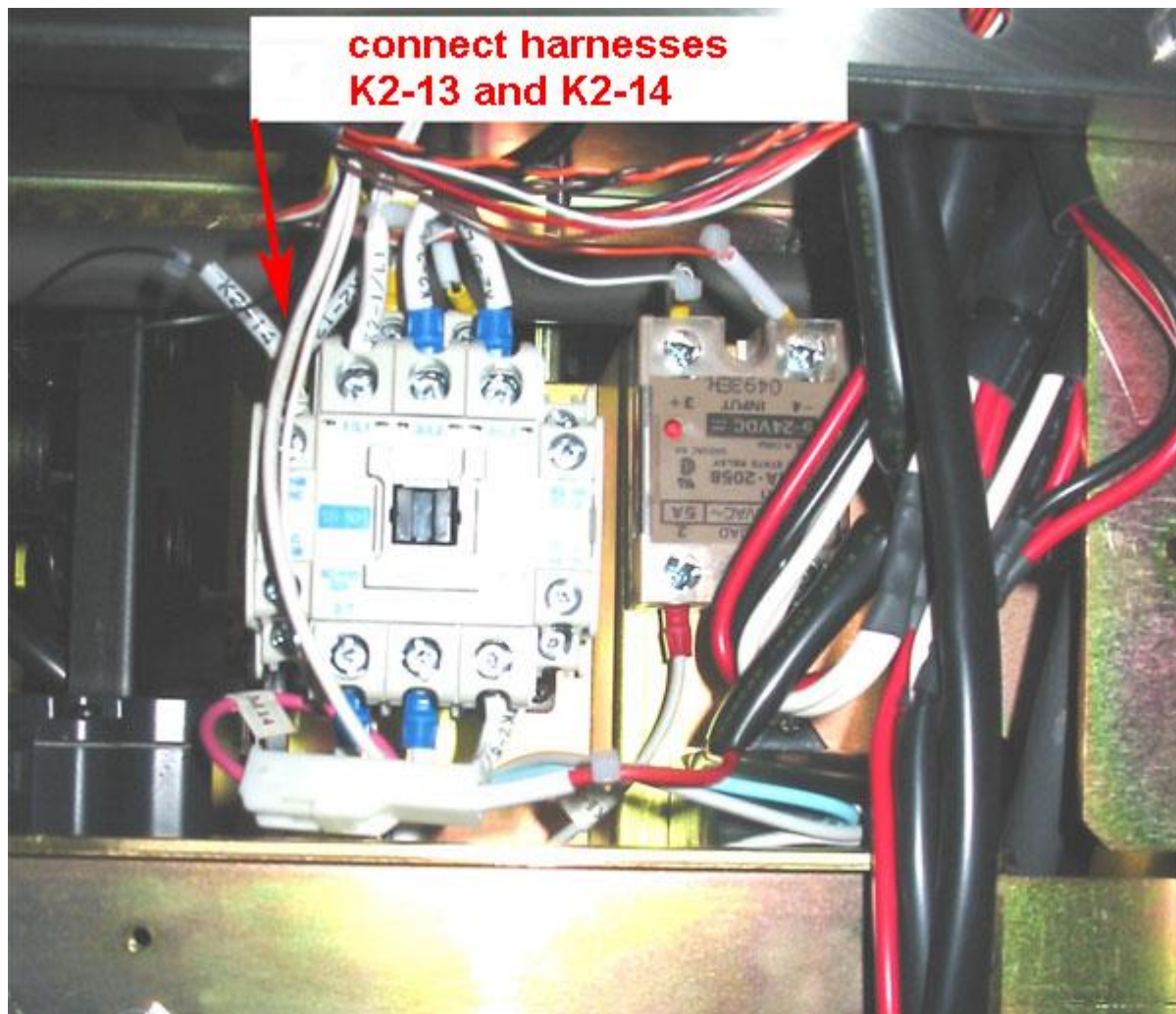
0486

PACKING CONTROL PART

CHECK INSIDE OF WRAPPER

*Remove the item, If the item is
 remaining on the lift.
《REMOVE THE FILM AND LABEL》
1)Press ENERGENCY switch, REMOVE
   item on lift and infeed conveyor.
2)Open the front cover and remove the label.

*Display goes back when the label is removed.
*Label feeds by pressing flashing yellow.

0486-0000

RETURN

[Error content]	Commodity is remaining on the lift.
[Detail]	There was a commodity on the lift when each of the following operations was started (completed). ・ Wrapping the first commodity is attempted. ・ Attempts to send film. ・ Film loading is attempted. ・ Return operation is attempted (Lift is in its original position). ・ After completion of return operation.
[Solution]	Press the [RETURN] button after removing the commodity
[Remarks]	
[Cause]	Commodity is remaining on the lift.
[Response]	Press the [RETURN] button after removing the commodity.

0487

```
PACKING CONTROL PART

THE B-LABEL ISSUE DID NOT MEET

《REMOVE THE FILM AND LABEL》
1)Press ENERGENCY switch, REMOVE
   item on lift and infeed conveyor.
2)Open the front cover and remove the label.

*Display goes back when the label is removed.
*Label feeds by pressing flashing yellow.

                                    1

                                RETURN

0487-0000
```

[Error content]	Label application timing for a product with a b-label was achieved, but printer solenoid did not allow the ON signal.
[Detail]	Same as above
[Solution]	[RETURN]
[Remarks]	・This only occurs in variations with b-label printers ・Check signal line between the wrapper and b-label printer. Wiring [P-910:XJ1 - P-922:XJ13]
[Cause]	1. B-label pasting signal was not confirmed. 2. The wrapped product was not delivered to the discharge conveyor.
[Response]	1. In the case of a disconnected signal wire between the wrapper and b-label board, connect the wire. 2. Respond by investigating the reason why the product was not sent.

0488

```
PACKING CONTROL PART

A LABELING SIGNAL HAS NOT BEEN CHECKED

*Press [PLU] key to outfeed the tray inside.
*Return the mahcine with following procedure.
《REMOVE THE FILM AND LABEL》
1)Press ENERGENCY switch, REMOVE
   item on lift and infeed conveyor.
2)Open the front cover and remove the label.


*Display goes back when the label is removed.
*Label feeds by pressing flashing yellow.

                                    1

                                    RETURN
0488-0000
```
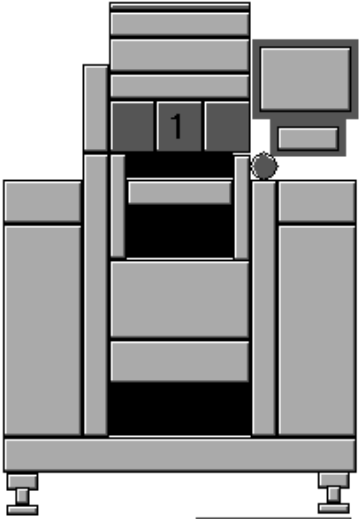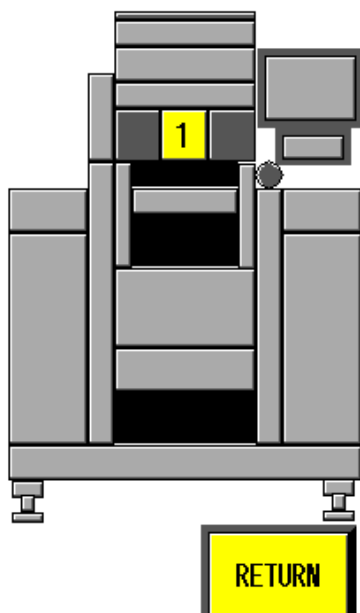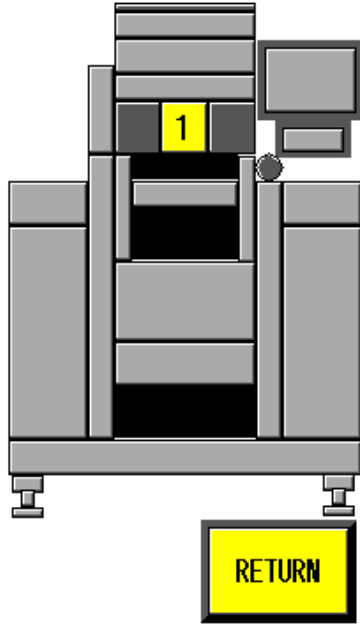
[Error content]	Bottom label pasting signal could not be confirmed.
[Detail]	Pasting signal line between the wrapper and b–label board disconnected. Wiring [P–910：XJ11 – P–922:XJ13]
[Solution]	[RETURN] button
[Remarks]	Possible to discharge products in the wrapper by pressing the [PLU] key
[Cause]	1. Bottom label pasting signal could not be confirmed. 2. The wrapped product was not sent to the discharge conveyor.
[Response]	1. In the case of a disconnected signal wire between the wrapper and b–label board, connect the wire. 2. Respond by investigating the reason why the product was not sent.

0490

```
OFFLINE   PLU No.  000000   STORE         24. MAY. 2005(TUE)    7 : 04      MENU

C                    PACKING CONTROL PART                               MSG1
Er                                                                      0

PSE                DURING FILM LOADING                                  OP
                                                                        0
TAR             Film loading.... Wait for a while.                     JPON
0.                                                                      0
PA      *Wait moment.                                                  RMAT
                                                                        0

                                                                       GE 1
PRIC                                                                    0
SYMB
TRAY         0490-0000                                                 RAP
                                                                       BEL

DIAL     ADD    IN-FEED  WRAP SPD WARPPING  TRAY   CALCULAT   ▲
ADJUST          SPD(H)   (HIGH)   ADJUST    AUTO
```
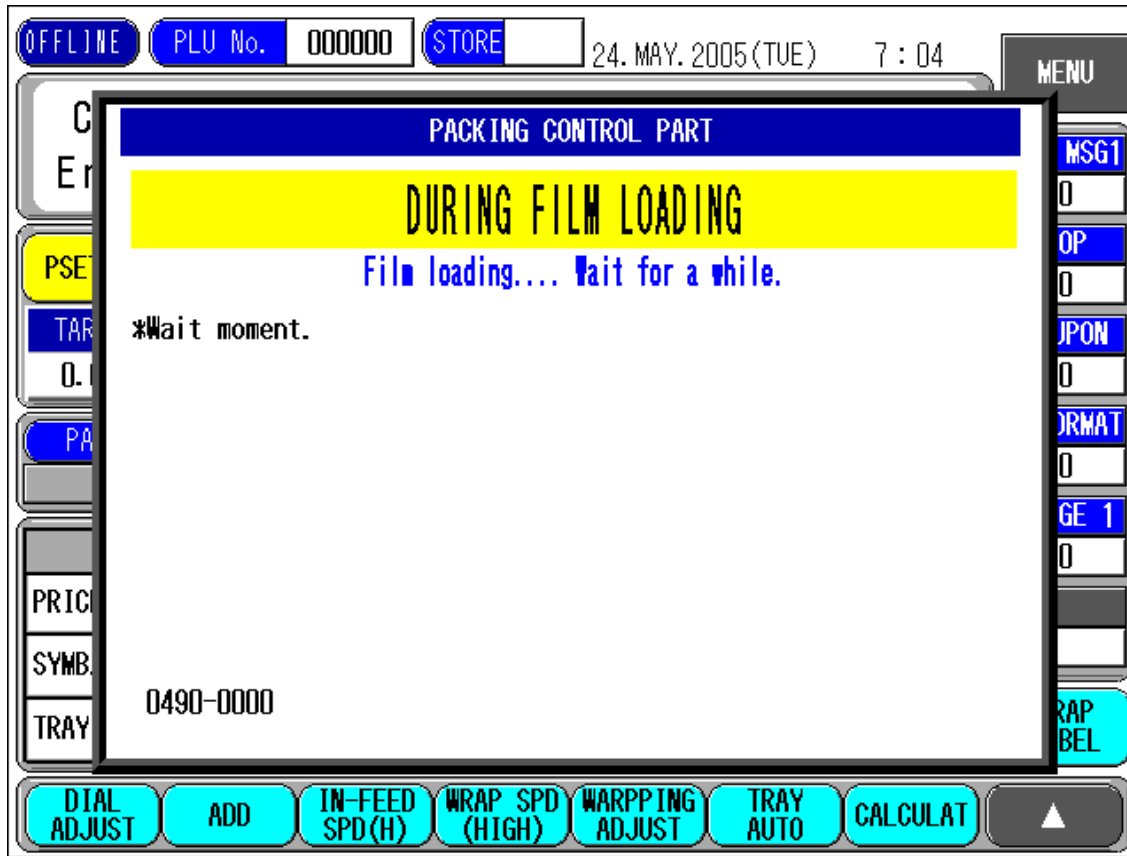
[Error content]	Initiating film loading
[Detail]	Film loading operation initiated after film loading procedure completion. Film loading operation began after pressing the film set button.
[Solution]	Ends automatically after film loading has completed
[Remarks]	
[Cause]	Film loading initiated.
[Response]	Ends automatically after film loading has completed.

0491

```
PACKING CONTROL PART

FILM LOADING WAS COMPLETED

1)Open RIGHT film removal door.
2)Remove the film.
3)Close film removal door and release.

                                            1

0491-0000
```

[Error content]	Film loading was completed.
[Detail]	Film loading was completed.
[Solution]	Open the film removal door, remove film, and close the door
[Remarks]	
[Cause]	Film loading was completed.
[Response]	Open the film removal door, remove film, and close the door

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PACKING CONTROL PART

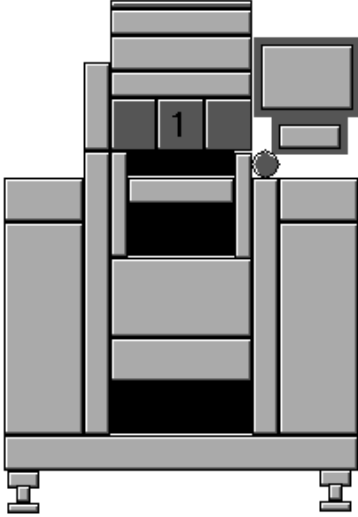## FILM REMOVAL OPERATION WAS COMPLETED

1)Open RIGHT film removal door.

2)Remove the film.

3)Close film removal door and release.

1

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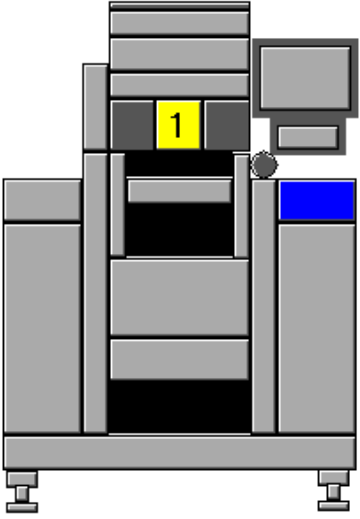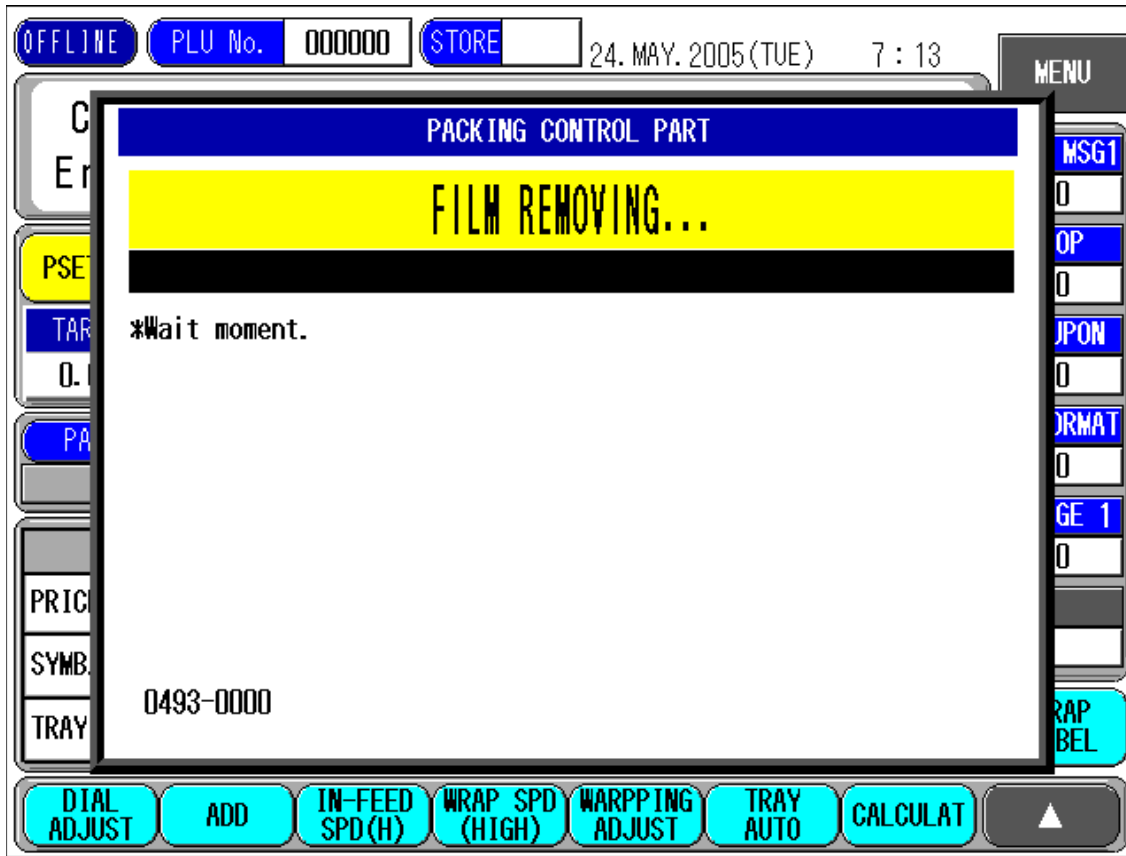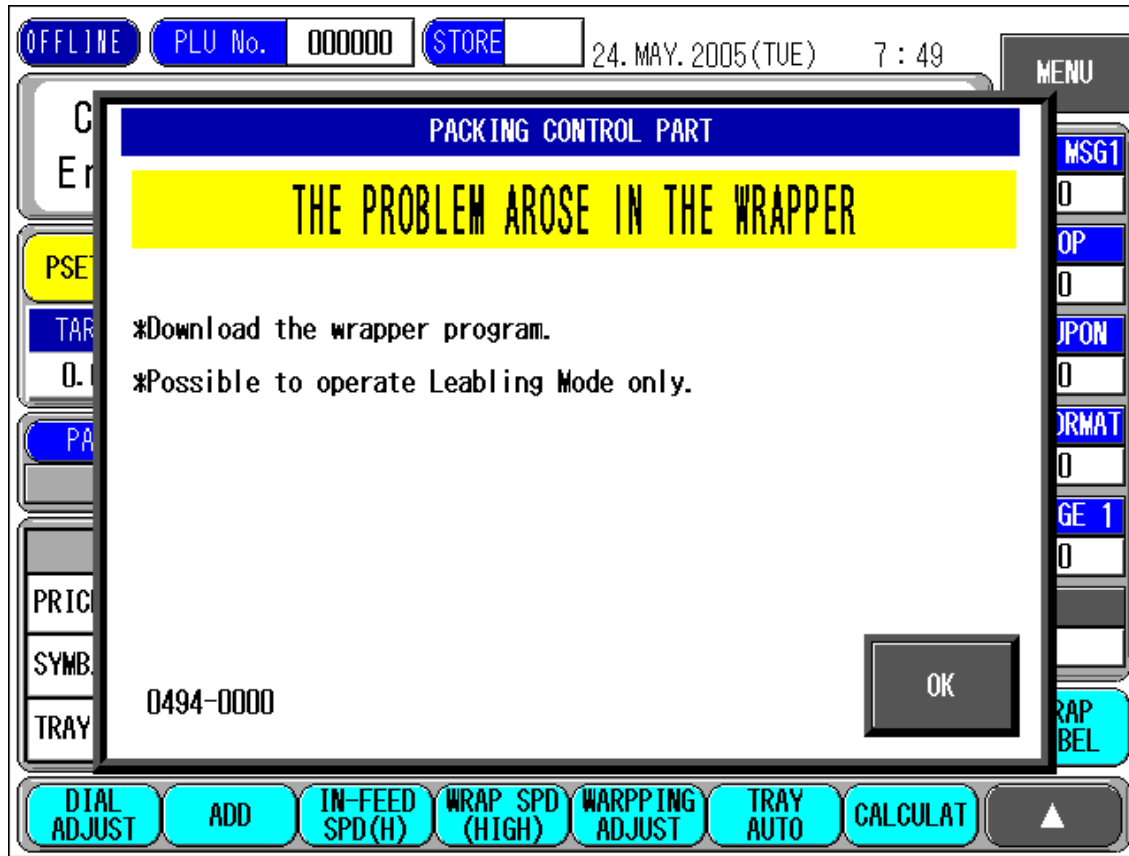| [Error content]	Film removal operation was completed.
[Detail]	
[Solution]	Open RIGTH(LEFT) film removal door. Remove the filme. Close filme removal door and release.
[Remarks]	
[Cause]	
[Response]	

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```
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   C                      PACKING CONTROL PART                          MSG1
   E                                                                    0
                        FILM REMOVING...                                OP
  PSE                                                                   0

  TAR                                                                   JPON
  0.      *Wait moment.                                                 0

  PA                                                                    ORMAT
                                                                        0

                                                                        GE 1
                                                                        0
 PRIC

 SYMB
                   0493-0000                                            RAP
 TRAY                                                                   BEL

   DIAL       ADD     IN-FEED   WRAP SPD  WARPPING    TRAY    CALCULAT   ▲
  ADJUST             SPD(H)    (HIGH)    ADJUST      AUTO
```

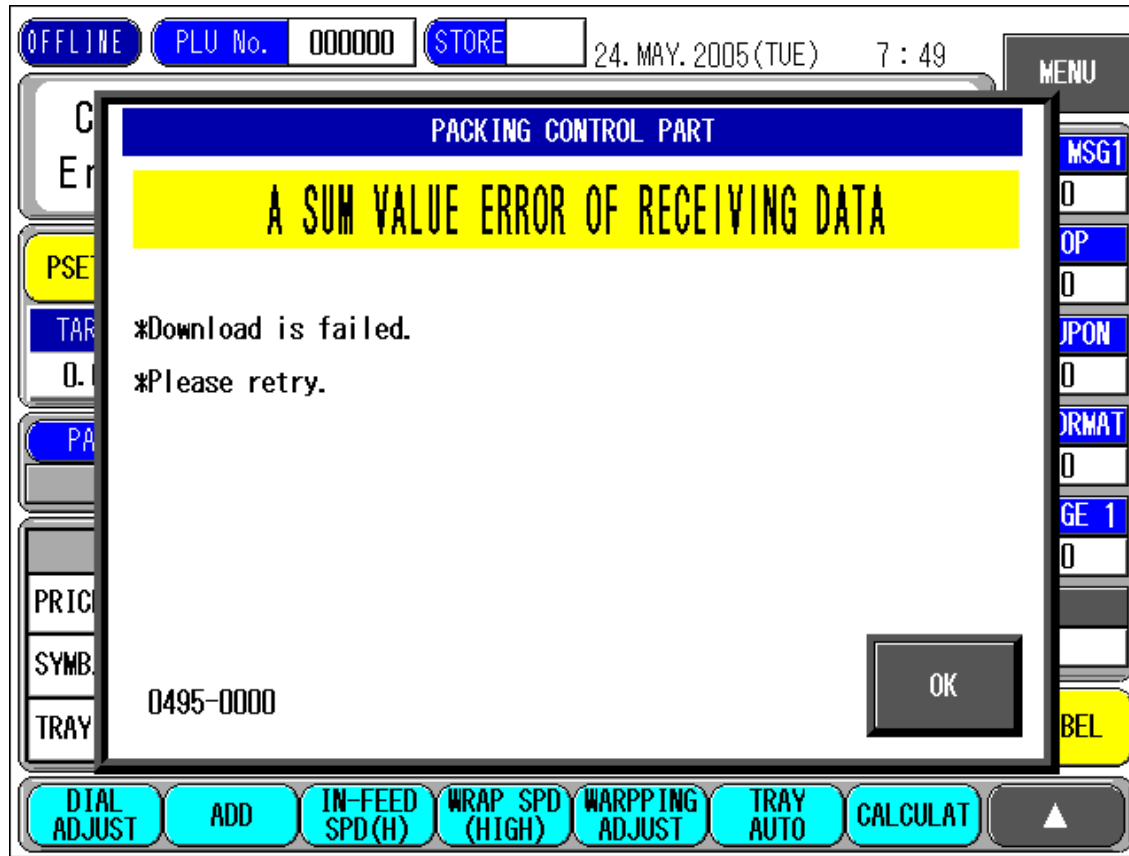| [Error content]	Removing film
[Detail]	Return necessary (when film removal is needed) and necessary film removal when film removal operation has begun.
[Solution]	Ends automatically after film is removed
[Remarks]	
[Cause]	Return necessary (when film removal is needed) and necessary film removal when film removal operation has begun.
[Response]	Ends automatically after film is removed.

0494

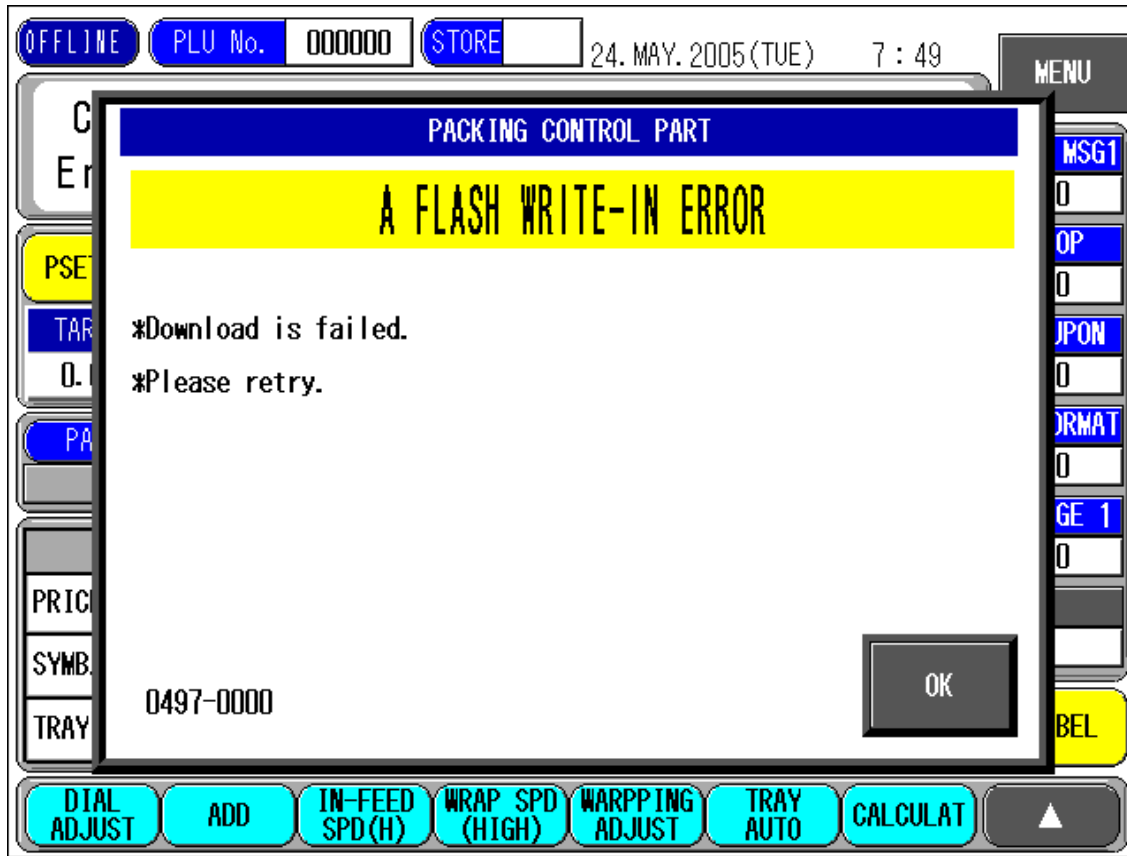| [Error content]	Wrapper application program is not installed.
[Detail]	Wrapper application program is not installed (Not downloaded correctly). Sub-error meanings are as follows:
	0000 Application program checksum doesn't match.
	0001 Failure transitioning to the application.
[Solution]	[OK] button
[Remarks]	Need to download wrapper application program.
[Cause]	Wrapper application program is not installed (Not downloaded correctly)
[Response]	Download wrapper application program.

0495

```
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┌─────────────────────────────────────────────────────────────────┐
│ C │              PACKING CONTROL PART                      │ MSG1 │
│ E │                                                        │ 0    │
│   │       A SUM VALUE ERROR OF RECEIVING DATA              │ OP   │
│PSE│                                                        │ 0    │
│TAR│   *Download is failed.                                 │JPON  │
│0. │   *Please retry.                                       │ 0    │
│PA │                                                        │RMAT  │
│   │                                                        │ 0    │
│   │                                                        │GE 1  │
│   │                                                        │ 0    │
│PRIC│                                                       │      │
│SYMB│                                                       │      │
│    │   0495-0000                           ┌───────┐       │      │
│TRAY│                                       │  OK   │       │ BEL  │
│    │                                       └───────┘       │      │
└─────────────────────────────────────────────────────────────────┘
 DIAL    ADD   IN-FEED  WRAP SPD WARPPING  TRAY   CALCULAT   ▲
 ADJUST        SPD(H)   (HIGH)   ADJUST    AUTO
```

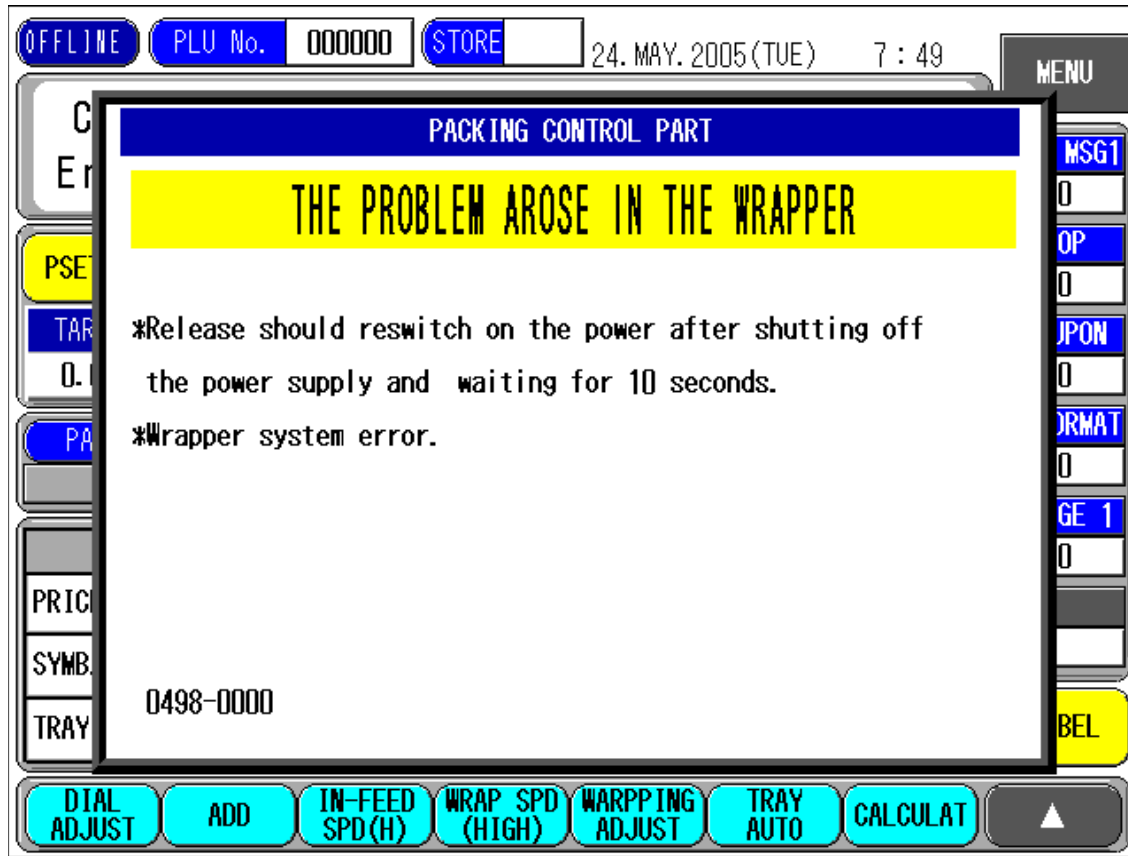| [Error content]	Data sum downloaded from the wrapper is abnormal
[Detail]	The program data sum value received from the wrapper is different from the sum value in the message.
[Solution]	[OK] button
[Remarks]	Needs to be re-downloaded
[Cause]	The program data sum value received from the wrapper is different from the sum value in the message.
[Response]	Re-download.

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PACKING CONTROL PART

FLASH ROM WRITE-IN BUSY ERROR

*Download is failed.

*Please retry.

0496-0000

OK

DIAL ADJUST	ADD	IN-FEED SPD(H)	WRAP SPD (HIGH)	WARPPING ADJUST	TRAY AUTO	CALCULAT	▲

[Error content]	Flash ROM write condition exceeded the specified time amount
[Detail]	Does not change even if the flash ROM write condition exceeds the specified time amount in wrapper application program download.
[Solution]	[OK] button
[Remarks]	Need to re-download.
[Cause]	Flash ROM write error in program data received by the wrapper.
[Response]	Re-download. If the same error re-occurs, the P-920 board can be considered malfunctioning.

0497

[Error content]	Flash ROM write-in error in wrapper program download.		
[Detail]	An error occurred when writing program data received from the wrapper to the flash ROM. Sub-error meaning are as follows:		
	0001	Flash ROM erasure failure.	
	0002	Application program flash ROM write-in failure.	
	0003	Application program sum value flash ROM write-in error.	
	0004	Message sequence extending to flash ROM write-in is mismatched.	
	0005	Received a download command even though it is not in boot mode (during application program operation).	
[Solution]	[OK] button		
[Remarks]	Need to re-download.		
[Cause]	An error occurred when writing program data received from the wrapper to the flash ROM.		
[Response]	Re-download. If the same error re-occurs, the P-920 board can be considered malfunctioning.		

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PACKING CONTROL PART

THE PROBLEM AROSE IN THE WRAPPER

*Release should reswitch on the power after shutting off
 the power supply and waiting for 10 seconds.
*Wrapper system error.

0498-0000

| DIAL ADJUST | ADD | IN-FEED SPD(H) | WRAP SPD (HIGH) | WARPPING ADJUST | TRAY AUTO | CALCULAT | ▲ |

[Error content]	Wrapper system error
[Detail]	A malfunction occurred in the wrapper program.
[Solution]	Clear by restoring power
[Remarks]	
[Cause]	P-920 program operation abnormality
[Response]	In the case of inoperability after restoring power, download the wrapper program.