

Q:C07-2C- ? ，運轉之後出現“102”異常碼

1. 週期近接在送袋過程中來兩次

- (1) 檢查週期近接是否故障,多送信號
- (2) 檢查週期近接,凸輪是否鎖緊
- (3) 檢查週期近接,凸輪的感應距離是否太遠(正常為 2MM~3MM)
- (4) 檢查凸輪是否凹洞或未真圓
- (5) 檢查所有近接間距是否夠寬,至少要 10MM

2. 參數有誤，檢查“參數 1”～“參數 4”的內參數值是否正確。

檢查步驟：

- A. 按住“FUN”鍵再按“ENTER”鍵後一起放開，輸入 1(參數 1)再按“ENTER”鍵，會顯示目前設定值，請記錄並比較原隨機資料設定值是否相同
- B. 按“ENTER”鍵，回到原畫面
- C. 參數 2 ~ 4 同 A,B 步驟。

修改步驟：

- A. 按住“FUN”鍵再按“ENTER”鍵後一起放開，輸入 4286 再按“ENTER”鍵，螢幕會閃三下。
- B. 按住“FUN”鍵再按“ENTER”鍵後一起放開，輸入 1(參數 1)再按“ENTER”鍵，輸入機械廠出廠“參數 1”之內設定值，再按“ENTER”鍵，螢幕會閃三下，表示修改“參數 1”完成。
- C. 參數 2 ~ 4 同 B 步驟。
- D. 請關閉電源後一段時間再重新開電。

3. 有先出現“13”異常碼(印刷袋)，之後才出現“102”：

則為 LS(袋長)設定值比實際印刷點(袋長)太長，請實際袋長加 2mm 再測試。

4. LS(袋長)增加超過某長度時才会有異常：請更換同規格同控制模式的伺服驅動器。

5. 檢查參數 9700 之內記憶值是否在 100 以內：

如果內記憶值超過 100 以上時，請設定內記憶值為 0。

修改步驟：

- A. 按住“FUN”鍵再按“ENTER”鍵後一起放開，輸入 4286 再按“ENTER”鍵，螢幕會閃三下。
- B. 按住“FUN”鍵再按“ENTER”鍵後一起放開，輸入 9700(參數 9700)，再“ENTER”鍵，輸入“0”，再按“ENTER”鍵，螢幕會閃三下，表示修改“參數 9700”完成。
- C. 請關閉電源後一段時間再重新開電。

6.SS (每分鐘張數)增加超過某張數時，才會有異常：

則增加近接與近接的間隔加大(間隔=3*D, D為近接直徑)。

7.零點較準 OFFSET 未調整好，“9702”重新調整。

步驟：

A. 按住“FUN”鍵再按“ENTER”鍵後一起放開，輸入 4286 再按“ENTER”鍵，螢幕會閃三下。

B. 按住“FUN”鍵再按“ENTER”鍵後一起放開，輸入 9702(參數 9702)，再“ENTER”鍵，輸入 修改值如註 1：

註 1: 假設原設定值為 “0”，且送料膠輪偷跑方向為送袋方向則鍵入 “9001” (代表-1)

假設原設定值為 “0”，且送料膠輪偷跑方向為送袋反方向則鍵入 “1”

C. 再按“ENTER”鍵，螢幕會閃三下，表示修改“參數 9702”完成，並且目視伺服送料膠輪是否為靜止，無則重覆 B. 的動作。

D. 若無法使伺服送料膠輪為靜止，則選擇，送料膠輪偷跑方向為送袋反方向的值為設定值

8. 伺服傳動皮帶鬆動，造成伺服倒拉請調整皮帶。

9. 將靜電關掉不使用時，看是否正常。

10. 量伺服的馬達出線端子 U1.V1.W1 是否有 AC3~5V 的電壓，此時伺服驅動器為制動，用手轉伺服馬達送料輪看是否能轉動，若能轉動則為伺服驅動器故障。

11.Q: 啟動後空切兩張出現 102

A: 檢查週期進接信號是否正常，

1. 按寸動檢查週期近是否會閃滅

有閃滅為電腦車故障

無閃滅檢查下一步

2. 將週期信號接線拆除，檢查 A03 的燈號是否有亮

有亮檢查下一步，

無亮為週期進接故障請更換周期進接

12. 更換 伺服控制線

以上檢測完還會出現錯誤訊號 102 時，請將“機種編號”紀錄下來並與本公司技服人員聯絡。

Q:C07-2- ? displays "102" abnormal code after start operate.

1.Circulate proximity sensor comes twice during bag feeding

Please check if the circulate proximity sensor has failed which led to double signal.

Please check if the cam of circulate proximity sensor has locked properly.

Please check if the distance of cam has been too far(normally:2MM~3MM)

Please check if the cam has depressed or not been a complete circle.

Please check if all the space between proximity sensors are enough(at least 10MM)

2.Parameter fault. Please check if Parameter“1,2,3,4,6,7”are setting correctly.

Steps for Checking :

A. Press“FUN”and“ENTER”together and then release. Enter “1”(Para. 1) and then press “ENTER”. The current setting will display, please record it and make sure if it is matched with the reference data.

B. Press“ENTER”to return to the main menu

C. Please follow step A & B to check Para. 2~4.

Steps for Reset :

A. Press“FUN”and“ENTER”together and then release. Enter “4286”and “ENTER”, the screen will flash three times.

B. Press “FUN”and“ENTER”together and then release. Enter “1”(Para.1) and then press “ENTER”. The screen will flash three times and the “Para.1”setting has completed.

C. Please follow step A & B to reset.

D. Please turn off the power for a while and restart the power.

3. Displays abnormal code“13”(printing bag) before abnormal code“102” appears:

LS(Length Setting) is too much longer then the actual printing mark, please measure the actual length of bag and add 2 mm to test.

4.Abnormal appear when LS(Length Setting) increase to an amount of length:

Please replace the servo driver with same specification and control mode.

5.Please check if the memory of Para. 9700 is with 100:

If the internal memory has over 100, please set as “0”

Steps for reset :

A. Press “FUN”and “ENTER”together and release. Enter “4286” and “ENTER”,

the screen will flash three times.

B. Press “FUN” and “ENTER” together and release. Enter “9700” (Para. 9700) and press “ENTER”. Enter “0” and “ENTER”, the screen will flash three times and the “Para. 9700” setting has completed.

C. Please turn off the power for a while and restart the power.

6. Abnormal appear when SS (pcs/sec.) increase to an amount of quantity:

Increase the spaces between each proximity sensor(Space = 3xD(Diameter))

7. OFFSET needs to adjust, please reset parameter 『9702』

Steps for reset:

A. Press “FUN” and “ENTER” together and release. Enter “4286” and “ENTER”, the screen will flash three times.

B. Press “FUN” and “ENTER” together and release. Enter “9702” (Para. 9702) and press “ENTER”. The setting value, please refer to [Note 1].

[Note 1]: If the original setting is “0” and the feeding roller runs toward feeding direction, please set this parameter as “9001”(-1)

If the original setting is “0” and the feeding roller runs opposite direction of feeding, please set this parameter as “1”

C. Press “ENTER”, the screen will flash three times . Please make sure the roller stays still, if not, please repeat the setting step B.

D. If the roller still can't stop running, please set the running direction of feeding roller as reverse.

8. Please check if the belt of sever has loosened, please adjust it.

9. Please turn off the static electricity and check if the machine is normal

10. When driver is under “Hold” status (Yaskawa driver will display “run”), the feeding roller should not be able to turn by hand. If the roller is turnable, the driver may be damaged.

11. If all testaments above are normal; for our further determination, please provide us following number:

Please find a pink label on the door of control box and tell us the serial no. & model no.
Thank you!

12. Replace the server control cable