Alarm and Function Testing Execution

KWE 4000  
CUK/CUT/CUC  
CPS

Cartoning machine   
Carton Print System

74xxxx

Customer

Country

Table of contents

1 Software version 13

2 Check HMI menu, buttons and switches 14

2.1 Spotcheck HMI 14

3 Access protection 15

3.1 Create new User 15

3.2 Log-in 18

3.3 Password rules 20

3.4 Password validity 24

3.5 Identical name: User and password 26

3.6 New password 28

3.7 Change of password 30

3.8 User-account disable 32

3.9 Disable time 34

3.10 Automatic log-out / log in again 36

4 Access protection 38

4.1 User configuration for validation 38

4.2 (Domain) Log-in 39

4.3 (Domain) Automatic log-out 41

4.4 (Domain) Log-out 42

5 Audit trail 43

5.1 Audit trail entries (parameter) 43

5.2 Audit trail entries 45

6 Version management for recipe 47

6.1 Version management in case of new recipe (product version) 47

6.2 Disable version (product data) 49

6.3 Enable version / batches for production 51

6.4 Create new recipe 53

6.5 Enable recipe version 56

6.6 Activate recipe 58

6.7 Disable recipe version 60

6.8 Delete recipe version 61

7 Batch Management 63

7.1 Create new batch 63

7.2 Start batch 65

7.3 Interrupt and resume batch 66

7.4 Complete batch 67

7.5 Batch history 68

7.6 Store batch data 69

7.7 Restore batch data 71

7.8 Delete batch data 73

7.9 Recalculation of batch data 75

7.10 History of batch data 77

7.11 Print recipe data 78

7.12 Print batch data 80

8 Reports and print outs 82

8.1 Recipe print out 82

8.2 Parameter: Machine settings 83

8.3 User right print out 84

9 Basic function 85

9.1 Boot IPC 85

9.2 Service: Clean Display 87

9.3 Service: Change system time 88

9.4 Alarmlists 89

9.5 Operating hours counter 90

9.6 Operating (V. 08.01) (Working V. 08.01) hours counter 91

9.7 Parameter limits 92

9.8 Parameter limits 94

9.9 HMI Language 95

10 Alarm Testing 96

10.1 Important Information 96

10.2 Test protocols - Function tests software switch operation mode 97

10.2.1 SWS 1: AUTOMATIC 97

10.2.2 SWS 2: SETUP 99

10.2.3 SWS 3: INCHING PANEL 101

10.2.4 SWS 4: INCHING CABLE 103

10.2.5 SWS 6: RELEASE STOP BRAKE 105

10.2.6 SWS 7: SET DRIVE ZERO 106

10.2.7 SWS 8: INCHING SINGLE AXIS 107

10.2.8 SWS 9: ROBOT: REFERENCE RUN 109

10.2.9 SWS 60: LINE MODE DOWNSTREAM EQUIPMENT 110

10.2.10 SWS 62: MACHINE: AUTOMATIC RESTART 112

10.2.11 SWS 63: LINE MODE UPSTREAM EQUIPMENT 114

10.2.12 SWS 70: BYPASS MODE 116

10.3 Test protocols - Function tests operating mode drives 117

10.3.1 SWS 1: PRODUCT CHAIN 117

10.3.2 SWS 2: INSERTION 118

10.3.3 SWS 3: PREINSERTION HORIZONTAL 119

10.3.4 SWS 4: PREINSERTION VERTICAL 120

10.3.5 SWS 5: CARTON TRANSPORT 121

10.3.6 SWS 6: CARTON CLOSURE 122

10.3.7 SWS 7: CARTON SETUP 123

10.3.8 SWS 8: LEAFLET DEVICE 124

10.3.9 SWS 9: LEAFLET GRIPPER 125

10.3.10 SWS 10: BEILEGER ? 126

10.3.11 SWS 11: INFEED 127

10.3.12 SWS 12: ROBOT 128

10.3.13 SWS 13: BOTTLE INFEED 129

10.3.14 SWS 14: Taststempel 130

10.3.15 SWS 15: MAIN DRIVE 131

10.3.16 SWS 16: INSERTION TABLE 132

10.3.17 SWS 17: CARTON ALIGNMENT 133

10.3.18 SWS 21: BOTTLE INFEED: SEPARIERRAD? 134

10.3.19 SWS 22: BOTTLE INFEED: SCHALTRAD? 135

10.3.20 SWS 23: BOTTLE INFEED: INSERTION? 136

10.3.21 SWS 25: INFEED: OVERHEAD CONVEYOR 137

10.3.22 SWS 54: ROBOT: DRILL AXIS 138

10.3.23 SWS 55: ROBOT: ? 139

10.3.24 DRIVE 63: ROBOT: INFEED BELT 140

10.4 Test protocols - Function tests software switches 141

10.4.1 SWS 50: COVER RAIL 141

10.4.2 SWS 52: MACHINE: COMPRESSED AIR 143

10.4.3 SWS 53: PERMANENT READING CODE 144

10.4.4 SWS 54: VACUUM 146

10.4.5 SWS 56: MACHINE INSIDE LIGHT OFF 147

10.4.6 SWS 100: INSERT DEFECTIVE PRODUCT 148

10.4.7 SWS 100: INSERT DEFECTIVE PRODUCT 150

10.4.8 SWS 101: PRODUCT OVERHEIGHT 152

10.4.9 SWS 102: STOP AT INSERTION DEFECTIVE PRODUCT 154

10.4.10 SWS 105: PRODUCT: MANUAL INSERTION 156

10.4.11 SWS 106: CONTINUOUS INSERTION 158

10.4.12 SWS 107: RELEASE PUSHER GUIDE RAIL 160

10.4.13 SWS 108: PRODUCT: SENSING WITH VISION SYSTEM 162

10.4.14 SWS 113: PRODUCT: STOP AT OVERHEIGHT 164

10.4.15 SWS 118: PRODUCT: INSERTION DEFECTIVE PRODUCT 166

10.4.16 SWS 119: CONTINUOUS PREINSERTION 168

10.4.17 SWS 120: PREINSERTION UPPER FRONT POSITION 170

10.4.18 SWS 121: PREINSERTION PLATE 1 DOWN 171

10.4.19 SWS 122: PREINSERTION PLATE 2 DOWN 173

10.4.20 SWS 123: PREINSERTION PLATE 3 DOWN 175

10.4.21 SWS 124: PREINSERTION PLATE 4 DOWN 177

10.4.22 SWS 125: PREINSERTION PLATE 5 DOWN 178

10.4.23 SWS 126: INSERTION TEST LEAFLET RELEASE 179

10.4.24 SWS 127: PREINSERTION 181

10.4.25 SWS 200: CODE READER CARTON 183

10.4.26 SWS 203: AIR BLAST CARTON 185

10.4.27 SWS 204: GLUEING 187

10.4.28 SWS 208: CONTINUOUS CALL CARTON 189

10.4.29 SWS 230: OUTFEED BELT: CONTINUOUS RUN 191

10.4.30 SWS 256: CHECK CARTON OPEN COVER FLAP 192

10.4.31 SWS 257: CHECK CARTON OPEN SIDE FLAP 194

10.4.32 SWS 300: LEAFLET DEVICE 196

10.4.33 SWS 301: LEAFLET: CODE READER FRONT 198

10.4.34 SWS 302: CODE READER LEAFLET REAR 200

10.4.35 SWS 303: CHECK LEAFLET PRESENT 202

10.4.36 SWS 307: CONTINUOUS CALL LEAFLET 204

10.4.37 SWS 320: MEASURE RUN LEAFLET 206

10.4.38 SWS 400: INFEED 1 208

10.4.39 SWS 401: BOTTLE INFEED: RUN EMPTY 210

10.4.40 SWS 402: INFEED 1: CHANGING DIRECTION ROTARY TABLE 212

10.4.41 SWS 404: BOTTLE INFEED: ROTARY TABLE 214

10.4.42 SWS 405: BOTTLE INFEED: CALL PRODUCT 216

10.4.43 SWS 410: ROBOT: JOG 218

10.4.44 SWS 411: ROBOT: JOG FORWARD 219

10.4.45 SWS 412: ROBOT: JOG BACKWARD 220

10.4.46 SWS 413: ROBOT: SET POSITION 221

10.4.47 SWS 900: INSERTER 222

10.4.48 SWS 901: CODE READER 223

10.4.49 SWS 902: INSERTER: CONTINUOUS CALL 225

10.4.50 SWS 2001: HIGH CARTON 227

10.4.51 SWS 2001: INFEED: CHECK LABEL INHALER 229

10.4.52 SWS 2002: INFEED: CHECK CAP INHALER 231

10.4.53 SWS 2003: INFEED: CHECK CAP INHALER - TEACH 233

10.4.54 SWS 2004: INFEED: CHECK CAP INHALER - CALIBRATION 234

10.4.55 SWS 2005: INFEED: CHECK POSITION INHALER 235

10.5 Test protocols - Messages (ME) 237

10.5.1 ME 40: OPERATING MODE: AUTOMATIC 237

10.5.2 ME 41: OPERATING MODE: SETUP 238

10.5.3 ME 42: OPERATING MODE: INCHING MODE PANEL 239

10.5.4 ME 43: OPERATING MODE: INCHING MODE CABLE FRONT 240

10.5.5 ME 44: MACHINE: REFERENCE RUN 241

10.5.6 ME 47: OPERATING MODE: JOG MODE SINGLE AXES 242

10.5.7 ME 48: OPERATING MODE: INCHING MODE CABLE BACK 243

10.5.8 ME 105: MACHINE: MANUAL INSERT ENABLED 244

10.5.9 ME 106: MACHINE: SPEED HAS BEEN REDUCED 245

10.5.10 ME 160: MACHINE: OPERATIONAL 246

10.5.11 ME 161: MOTION CONTROL: WAIT UNTIL OPERATIONAL 247

10.5.12 ME 362: LEAFLET: MEASURING RUN ACTIVE 248

10.5.13 ME 363: LEAFLET: PREPARE MEASURING RUN 249

10.5.14 ME 447: INFEED 1: RUN TO EMPTY 250

10.5.15 ME 447: BOTTLE INFEED: RUN TO EMPTY 251

10.5.16 ME 447: VIAL INFEED: RUN TO EMPTY 252

10.5.17 ME 547: INFEED 2: RUN EMPTY 253

10.5.18 ME 551: INFEED: UPSTREAM MACHINE: NOT READY 254

10.5.19 ME 647: INFEED 3: RUN EMPTY 255

10.5.20 ME 2010: INFEED: CHECK CAP INHALER: TEACH PROCEDURE SUCCESSFUL 256

10.5.21 ME 2011: INFEED: CHECK CAP INHALER: CALIBRATION PROCEDURE SUCCESSFUL 257

10.6 Test protocols - Warnings (WA) 258

10.6.1 WA 5: MACHINE: COMPRESSED AIR SWITCHED OFF 258

10.6.2 WA 27: CONTROL-PC: M-GUARD ENABLED 259

10.6.3 WA 28: CONTROL-PC: REMOTE MAINTENANCE ENABLED 260

10.6.4 WA 29: OPERATOR: NO USER LOGGED IN 261

10.6.5 WA 198: MACHINE: DRIVE BRAKE(S) RELEASED 262

10.6.6 WA 220: CARTON: PREWARNING LOW STOCK 263

10.6.7 WA 232: GLUE UNIT: PREWARNING LOW GLUE LEVEL 264

10.6.8 WA 300: LEAFLET: PREWARNING LOW STOCK 265

10.6.9 WA 380: TURRET MAGAZINE: MINIMAL SUPPLY 266

10.6.10 WA 381: TURRET MAGAZINE: NOT IN OPERATION MODE 267

10.6.11 WA 400: INFEED 1: MINIMAL SUPPLY 268

10.6.12 WA 400: VIAL INFEED: MINIMAL SUPPLY 269

10.6.13 WA 480: ROBOT: DRIVE AXIS X POSITION LIMIT + 270

10.6.14 WA 481: ROBOT: DRIVE AXIS X POSITION LIMIT - 271

10.6.15 WA 482: ROBOT: DRIVE AXIS Y POSITION LIMIT + 272

10.6.16 WA 483: ROBOT: DRIVE AXIS Y POSITION LIMIT - 273

10.6.17 WA 484: ROBOT: DRIVE AXIS Z POSITION LIMIT + 274

10.6.18 WA 485: ROBOT: DRIVE AXIS Z POSITION LIMIT - 275

10.6.19 WA 500: INFEED 2: MINIMAL SUPPLY 276

10.6.20 WA 600: INFEED 3: MINIMAL SUPPLY 277

10.6.21 WA 980: INSERTER: TURRET MAGAZINE: MINIMAL SUPPLY 278

10.6.22 WA 981: INSERTER: TURRET MAGAZINE: NOT IN OPERATION MODE 279

10.7 Test protocols - Faults (FLT) 280

10.7.1 FLT 3: OPERATOR: NORMAL STOP ACTUATED 280

10.7.2 FLT 4: OPERATOR: WRONG OPERATING MODE SELECTED 281

10.7.3 FLT 5: COMPRESSED AIR: MONITORING INLET PRESSURE 282

10.7.4 FLT 6: ETHERCAT: FAULT + VARIABLE 283

10.7.5 FLT 7: COMPRESSED AIR: MONITORING SAFE SHUTDOWN 285

10.7.6 FLT 9: FAULT PROFIBUS + VARIABLE 286

10.7.7 FLT 11: MOTION DRIVES: OVERLOAD POWER SUPPLY 287

10.7.8 FLT 16: HANDWHEEL IS ENGAGED 288

10.7.9 FLT 17: OPERATOR: OPERATING MODE CHANGE 289

10.7.10 FLT 20: BATCH CONTROL: PARTIAL BATCH OBTAINED 290

10.7.11 FLT 21: BATCH CONTROL: COMPLETE BATCH OBTAINED 291

10.7.12 FLT 22: VACUUM: OVERLOAD PUMP 292

10.7.13 FLT 23: VACUUM: MONITORING NEGATIVE PRESSURE 293

10.7.14 FLT 26: CONTROL CABINET: FAULT SAFETY PLC 294

10.7.15 FLT 30: MACHINE: WAS RACED BACKWARDS 295

10.7.16 FLT 35: CONTROL CABINET: MONITORING MAIN SWITCH 296

10.7.17 FLT 41: CONTROL CABINET LEFT: OVERTEMPERATURE 297

10.7.18 FLT 42: CONTROL CABINET RIGHT: OVERTEMPERATURE 298

10.7.19 FLT 43: CONTROL CABINET: VOLTAGE MONITORING 299

10.7.20 FLT 78: EMERGENCY STOP: SAFETY RELAY NOT ACTIVE 300

10.7.21 FLT 79: LINE EMERGENCY STOP ACTUATED 301

10.7.22 FLT 81: EMERGENCY STOP ACTUATED: OPERATING PANEL 302

10.7.23 FLT 83: GUARD BASIC MACHINE: SAFETY RELAY NOT ACTIVE 303

10.7.24 FLT 86: GUARD OPEN: BOTTOM 304

10.7.25 FLT 86: GUARD 8 OPEN 305

10.7.26 FLT 87: GUARD OPEN: CARTON BELT 306

10.7.27 FLT 87: GUARD 7 OPEN 307

10.7.28 FLT 88: GUARD OPEN: INSERTION REAR 308

10.7.29 FLT 89: GUARD OPEN: DISCHARGE FRONT 309

10.7.30 FLT 90: GUARD OPEN: CONTROL CABINET SWIVELED OFF LEFT 310

10.7.31 FLT 91: GUARD OPEN: CONTROL CABINET SWIVELED OFF RIGHT 311

10.7.32 FLT 96: GUARD OPEN: HANDWHEEL 312

10.7.33 FLT 100: GUARD OPEN: PRODUCT CHAIN 1 313

10.7.34 FLT 100: GUARD 3 OPEN 314

10.7.35 FLT 104: GUARD OPEN: INFEED 315

10.7.36 FLT 110: PRODUCT SENSING: CONSECUTIVE FAULT EXCESS HEIGHT 316

10.7.37 FLT 111: PRODUCT SENSING: CONSECUTIVE FAULT 318

10.7.38 FLT 112: PRODUCT SENSING: SENSOR MONITORING 320

10.7.39 FLT 113: PRODUCT SENSING: SENSOR MONITORING EXCESS HEIGHT 321

10.7.40 FLT 120: INSERTION: SAFETY SENSOR 322

10.7.41 FLT 121: INSERTION: DEFECTIVE PRODUCT STOPPED PLEASE REMOVE 323

10.7.42 FLT 123: INSERTION: OVERLOAD 325

10.7.43 FLT 124: GUARD OPEN: SLIDE IN 326

10.7.44 FLT 126: INSERTION: OVERLOAD PREINSERTION 327

10.7.45 FLT 173: INSERTION: SLIDE IN 1 NOT IN POSITION 328

10.7.46 FLT 174: INSERTION: SLIDE IN 2 NOT IN POSITION 329

10.7.47 FLT 175: INSERTION: SLIDE IN 3 NOT IN POSITION 330

10.7.48 FLT 176: INSERTION: SLIDE IN 4 NOT IN POSTION 331

10.7.49 FLT 177: INSERTION: SLIDE IN 5 NOT IN POSTION 332

10.7.50 FLT 178: MOTION DRIVE SLIDE IN TABLE: FAULT FLT 179: MOTION DRIVE SLIDE IN TABLE + VARIABLE 333

10.7.51 FLT 186: MOTION DRIVE HORIZONTAL PRESINSERTION: FAULT FLT 192: MOTION DRIVE HORIZONTAL PRESINSERTION + VARIABLE 335

10.7.52 FLT 187: MOTION DRIVE VERTICAL PREINSERTION: FAULT FLT 193: MOTION DRIVE VERTICAL PREINSERTION + VARIABLE 337

10.7.53 FLT 188: MOTION DRIVE INSERTION: FAULT FLT 191: MOTION DRIVE INSERTION + VARIABLE 339

10.7.54 FLT 196: MOTION DRIVE MAIN DRIVE: FAULT FLT 198: MOTION DRIVE MAIN DRIVE + VARIABLE 341

10.7.55 FLT 200: MACHINE: JAM AT DISCHARGE 343

10.7.56 FLT 201: DOWNSTREAM: STOP FROM MACHINE 1 344

10.7.57 FLT 203: DOWNSTREAM: STOP FROM MACHINE 2 346

10.7.58 FLT 210: GUARD OPEN: CARTON MAGAZINE 348

10.7.59 FLT 210: GUARD 6 OPEN 349

10.7.60 FLT 212: GUARD OPEN: DISCHARGE TOP 350

10.7.61 FLT 212: GUARD 9 OPEN 351

10.7.62 FLT 213: CARTON: OVERLOAD SIDE FLAP FOLDER 352

10.7.63 FLT 219: CARTON BELT: LOWER POSITION NOT REACHED 353

10.7.64 FLT 220: CARTON: STOCK AT THE END 354

10.7.65 FLT 221: MACHINE: COVER RAIL OPEN 355

10.7.66 FLT 222: CARTON: CONSECUTIVE FAULT CROSSCHECK 356

10.7.67 FLT 223: CARTON: PICKUP CHECK 358

10.7.68 FLT 224: CARTON BELT: OVERLOAD 359

10.7.69 FLT 225: CARTON: CONSECUTIVE FAULT CODE READER 360

10.7.70 FLT 226: CARTON: FAULT CODE READER 361

10.7.71 FLT 227: CARTON: SENSOR MONITORING CROSSCHECK 362

10.7.72 FLT 230: GLUE UNIT: OPERATING TEMPERATURE NOT REACHED 363

10.7.73 FLT 231: GLUE UNIT: DEVICE NOT READY 364

10.7.74 FLT 232: GLUE UNIT: GLUE LEVEL IS TOO LOW 365

10.7.75 FLT 235: GLUE STATION 1: SENSOR MONITORING CARTON SENSING 366

10.7.76 FLT 250: CARTON REJECT 1: BIN OVERFILL 367

10.7.77 FLT 251: CARTON REJECT 1: CROSS CHECK 368

10.7.78 FLT 254: CARTON REJECT 1: SENSOR MONITORING CROSS CHECK 369

10.7.79 FLT 256: PRODUCT CHAIN: OVERFILL REJECT 371

10.7.80 FLT 270: CARTON: OPEN FLAP: SENSOR MONITORING COVER FLAP REAR 372

10.7.81 FLT 271: CARTON: OPEN FLAP: SENSOR MONITORING COVER FLAP FRONT 373

10.7.82 FLT 272: CARTON: OPEN FLAP: SENSOR MONITORING SIDE FLAP REAR 374

10.7.83 FLT 273: CARTON: OPEN FLAP: SENSOR MONITORING SIDE FLAP FRONT 375

10.7.84 FLT 277: OUTFEED BELT 1: OVERLOAD 376

10.7.85 FLT 285: MOTION DRIVE CARTON SETUP: FAULT FLT 288: MOTION CARTON SETUP + VARIABLE 377

10.7.86 FLT 289: CARTON: OPEN FLAP: CONSECUTIVE FAULT COVER FLAP 379

10.7.87 FLT 294: CARTON: OPEN FLAP: CONSECUTIVE FAULT SIDE FLAP 381

10.7.88 FLT 300: LEAFLET: STOCK AT THE END 382

10.7.89 FLT 301: LEAFLET: CROSS CHECK IN PRODUCT CHAIN 383

10.7.90 FLT 302: LEAFLET: CROSS CHECK REJECT 385

10.7.91 FLT 304: LEAFLET: CONSECUTIVE FAULT CROSS CHECK IN UNIT 386

10.7.92 FLT 305: LEAFLET: STOP AFTER MEASURE RUN 388

10.7.93 FLT 307: LEAFLET: SENSOR MONITORING STOCK AT THE END 389

10.7.94 FLT 310: GUARD OPEN: LEAFLET UNIT FRONT 390

10.7.95 FLT 311: GUARD OPEN: LEAFLET UNIT TOP 391

10.7.96 FLT 312: GUARD OPEN: LEAFLET UNIT REAR 392

10.7.97 FLT 315: GUARD OPEN: LEAFLET UNIT BOTTOM LEFT 393

10.7.98 FLT 315: GUARD 4 OPEN 394

10.7.99 FLT 316: GUARD OPEN: LEAFLET UNIT BOTTOM RIGHT 395

10.7.100 FLT 316: GUARD 5 OPEN 396

10.7.101 FLT 317: GUARD LEAFLET UNIT: SAFETY RELAY NOT ACTIVE 397

10.7.102 FLT 320: LEAFLET: CONSECUTIVE FAULT CODE READER FRONT 398

10.7.103 FLT 321: LEAFLET: CONSECUTIVE FAULT CODE READER REAR 400

10.7.104 FLT 322: LEAFLET: CONSECUTIVE FAULT CROSS CHECK IN CARTON 402

10.7.105 FLT 324: LEAFLET: FAULT CODE READER REAR 404

10.7.106 FLT 325: LEAFLET: SENSOR MONITORING CROSS CHECK IN CARTON 405

10.7.107 FLT 326: LEAFLET: SENSOR MONITORING CROSS CHECK IN UNIT 406

10.7.108 FLT 327: LEAFLET: SENSOR MONITORING CROSS CHECK IN PRODUCT CHAIN 407

10.7.109 FLT 328: LEAFLET UNIT: END POSITION NOT REACHED BELOW 408

10.7.110 FLT 329: LEAFLET UNIT: ONE END POSITION DRIVE COUPLING NOT REACHED 409

10.7.111 FLT 330: LEAFLET UNIT: END POSITION NOT REACHED THE TOP 410

10.7.112 FLT 331: LEAFLET UNIT: NOT SWIVELED IN 411

10.7.113 FLT 347: LEAFLET: SENSOR MONITORING CODE READER REAR 412

10.7.114 FLT 382: MOTION DRIVE LEAFLET UNIT: FAULT FLT 380: MOTION DRIVE LEAFLET UNIT + VARIABLE 413

10.7.115 FLT 390: LEAFLET UNIT: NOT READY 415

10.7.116 FLT 391: LEAFLET UNIT: OVERLOAD DRIVE EJECT 416

10.7.117 FLT 410: ROBOT: GUARD OPEN: BELT 1 417

10.7.118 FLT 412: ROBOT: EMERGENCY STOP ACTUATED 418

10.7.119 FLT 412: TLT: EMERGENCY STOP ACTUATED 419

10.7.120 FLT 413: VIAL INFEED: GUARD: SAFETY RELAY NOT ACTIVE 420

10.7.121 FLT 413: TLT: GUARD: SAFETY RELAY NOT ACTIVE 421

10.7.122 FLT 417: VIAL INFEED: GUARD OPEN 422

10.7.123 FLT 418: VIAL INFEED: GUARD OPEN: FRONT 423

10.7.124 FLT 421: ROBOT: GUARD OPEN: FRONT LEFT 424

10.7.125 FLT 422: ROBOT: GUARD OPEN: FRONT RIGHT 425

10.7.126 FLT 423: VIAL INFEED: EMERGENCY STOP: SAFETY RELAIS NOT ACTIVE 426

10.7.127 FLT 430: VIAL INFEED: BELT 1: OVERLOAD 427

10.7.128 FLT 431: BOTTLE INFEED: ROTARY TABLE: OVERLOAD 428

10.7.129 FLT 433: BOTTLE INFEED: INLET: OVERLOAD 429

10.7.130 FLT 439: BOTTLE INFEED: ROTARY TABLE: FAULT 430

10.7.131 FLT 441: VIAL INFEED: BELT 1: FAULT 431

10.7.132 FLT 443: VIAL INFEED: PRODUCT TIPPED OVER 432

10.7.133 FLT 443: BOTTLE INFEED: PRODUCT TIPPED OVER 433

10.7.134 FLT 444: VIAL INFEED: PRODUCT SENSING: CONSECUTIVE FAULT 434

10.7.135 FLT 446: VIAL INFEED: PRODUCT NOT TIPPED OVER 436

10.7.136 FLT 456: ROBOT: PRODUCT NOT PICKED UP 437

10.7.137 FLT 457: ROBOT: VACUUM: FAULT 438

10.7.138 FLT 460: TLT: NOT READY 440

10.7.139 FLT 461: TLT: GUARD OPEN: TRANSFER/TLT FAULT RESET 441

10.7.140 FLT 463: TLT: WRONG OPERATION MODE 442

10.7.141 FLT 464: TLT: FAULT SPEED TOO HIGH 443

10.7.142 FLT 472: VIAL INFEED: TRANSFER WHEEL: OVERLOAD 444

10.7.143 FLT 473: ROBOT: NO PRODUCT 445

10.7.144 FLT 474: BOTTLE INFEED: SENSOR MONITORING PRODUCT TIPPED OVER 447

10.7.145 FLT 476: TLT: PRODUCT CHAIN NOT EMPTY 449

10.7.146 FLT 512: INFEED: EMERGENCY STOP ACTUATED 450

10.7.147 FLT 514: INFEED: GUARD OPEN: PRODUCT CHAIN 1 451

10.7.148 FLT 517: INFEED: GUARD OPEN 452

10.7.149 FLT 530: INFEED: BELT 1: OVERLOAD 453

10.7.150 FLT 532: INFEED: BELT 2: OVERLOAD 454

10.7.151 FLT 541: INFEED: BELT 1: FAULT 455

10.7.152 FLT 542: INFEED: BELT 2: FAULT 457

10.7.153 FLT 551: INFEED: BELT 1: PRODUCT JAM (INHALER) 459

10.7.154 FLT 554: INFEED 2: WRONG POSITION PRODUCT 461

10.7.155 FLT654: INFEED 3: WRONG POSITION PRODUCT 462

10.7.156 FLT 902: INSERTER: CONSECUTIVE FAULT CODE READER 463

10.7.157 FLT 903: INSERTER: CONSECUTIVE FAULT CROSS CHECK 464

10.7.158 FLT 904: INSERTER: GUARD OPEN: HANDOVER 466

10.7.159 FLT 907: INSERTER: NOT OPERATIONAL 467

10.7.160 FLT 922: INSERTER: EMERGENCY STOP ACTUATED 468

10.7.161 FLT 943: INSERTER: CABINET: VOLTAGE MONITORING 469

10.7.162 FLT 947: INSERTER: SENSOR MONITORING CODE READER 470

10.7.163 FLT 1242: MOTION DRIVE CARTON ALIGNMENT: FAULT FLT 1243: MOTION DRIVE CARTON ALIGNMENT + VARIABLE 471

10.7.164 FLT 1246: CARTON: SENSOR MONITORING CHECK CODE 473

10.7.165 FLT 1247: INSERTION: SENSOR MONITORING SAFETY SENSOR 474

10.7.166 FLT 1250: DISCHARGE BELT SLIDE IN: FAULT 475

10.7.167 FLT 1251: DISCHARGE BELT OPPOSITE SLIDE IN: FAULT 476

10.7.168 FLT 1443: ROBOT: CABINET: VOLTAGE MONITORING 477

10.7.169 FLT 1515: INFEED: BELT 2: PRODUCT JAM (FLOWPACK) 478

10.7.170 FLT 1516: INFEED: BELT 1: PRODUCT REJECT (INHALER): BIN OVERFILL 480

10.7.171 FLT 1517: INFEED: BELT 2: PRODUCT REJECT (FLOWPACK): BIN OVERFILL 482

10.7.172 FLT 1518: INFEED: BELT 1: PRODUCT REJECT (INHALER): CROSS CHECK 484

10.7.173 FLT 1519: INFEED: BELT 2: PRODUCT REJECT (FLOWPACK): CROSS CHECK 486

10.7.174 FLT 1543: INFEED: CABINET VOLTAGE MONITORING 488

10.7.175 FLT 2001: GUARD OPEN: BIN OVERFILL 489

10.7.176 FLT 2001: GUARD OPEN: SLIDE IN TOP 490

10.7.177 FLT 2002: PRODUCT CHAIN GUARD: SAFETY RELAY NOT ACTIVE 491

10.7.178 FLT 2002: INFEED: CHECK LABEL INHALER: CONSECUTIVE FAULT 492

10.7.179 FLT 2003: GUARD OPEN: SLIDE IN BOTTOM 494

10.7.180 FLT 2004: INFEED: OVERHEAD CONVEYOR NOT IN LOWER POSITION 495

10.7.181 FLT 2005: CARTON REJECT 1: CROSS CHECK CARTON REJECTED 496

10.7.182 FLT 2006: CARTON REJECT 1: SENSOR MONITORING CROSS CHECK CARTON REJECTED 498

10.7.183 FLT 2007: INFEED: CONSECUTIVE FAULT CHECK POSITION INHALER 499

10.7.184 FLT 2008: INFEED: CHECK POSITION INHALER: DEVICE NOT READY 501

10.7.185 FLT 2009: INFEED: CHECK POSITION INHALER: SENSOR MONITORING 502

10.7.186 FLT 2010: INFEED: CHECK CAP INHALER: DEVICE NOT READY 503

10.7.187 FLT 2011: INFEED: CHECK CAP INHALER: TEACH PROCEDURE NOT SUCCESSFUL 504

10.7.188 FLT 2012: INFEED: CHECK CAP INHALER: CALIBRATION PROCEDURE NOT SUCCESSFUL 505

10.7.189 FLT 2013: INFEED: CHECK CAP INHALER: SENSOR MONITORING 506

10.7.190 FLT 2016: INFEED: CROSS CHECK EJECT BELT 1 (INHALER): SENSOR MONITORING 507

10.7.191 FLT 2017: INFEED: CROSS CHECK EJECT BELT 2 (FLOWPACK): SENSOR MONITORING 508

10.7.192 FLT 2025: GRASP-IN PROTECTION INFEED 1 (67B16) 509

10.7.193 FLT 2026: STEP NUMBER NOT REACHED INF. 1 (67M12) FLT 2030: HOME POSITION INFEED 1 (67M12) 510

10.7.194 FLT 2027: STEP NUMBER NOT REACHED INF. 1 (67M13) FLT 2031: HOME POSITION INFEED 1 (67M13) 511

10.7.195 FLT 2028: STEP NUMBER NOT REACHED INF. 1 (67M14) FLT 2032: HOME POSITION INFEED 1 (67M14) 512

10.7.196 FLT 2029: STEP NUMBER NOT REACHED INF. 1 (67M15) FLT 2033: HOME POSITION INFEED 1 (67M15) 513

10.7.197 FLT 2034: GUARD DOOR INFEED - RUNNING IN TOP - OPEN 514

10.7.198 FLT 2035: GUARD DOOR INFEED - RUNNING IN BOTTOM - OPEN 515

10.7.199 FLT 2036: GUARD DOOR INFEED - FRONT LEFT - OPEN (67S202) 516

10.7.200 FLT 2037: GUARD DOOR INFEED - FRONT CENTER - OPEN (67S203) 517

10.7.201 FLT 2038: GUARD DOOR INFEED - FRONT RIGHT - OPEN (67S204) 518

10.7.202 FLT 2039: GUARD DOOR INFEED - REAR RIGHT - OPEN (67S206) 519

10.7.203 FLT 2040: GUARD DOOR INFEED - REAR LEFT - OPEN (67S205) 520

10.7.204 FLT 2044: PRODUCT BACKUP AT INFEED FEED 2 521

10.7.205 FLT 2045: ACCELERATION BELT 2 NOT LOCKED (67B290) 522

10.7.206 FLT 2046: STEP NUMBER NOT REACHED INF. 2 (67M22) FLT 2050: HOME POSITION INFEED 2 (67M22) 523

10.7.207 FLT 2047: STEP NUMBER NOT REACHED INF. 2 (67M23) FLT 2051: HOME POSITION INFEED 2 (67M23) 525

10.7.208 FLT 2048: STEP NUMBER NOT REACHED INF. 2 (67M24) FLT 2052: HOME POSITION INFEED 2 (67M24) 527

10.7.209 FLT 2049: STEP NUMBER NOT REACHED INF. 2 (67M25) FLT 2053: HOME POSITION INFEED 2 (67M25) 529

10.7.210 FLT 2055: PRODUCT BACKUP AT INFEED FEED 3 531

10.7.211 FLT 2056: ACCELERATION BELT 3 NOT LOCKED (67B390) 532

10.7.212 FLT 2057: STEP NUMBER NOT REACHED INF. 3 (67M32) FLT 2061: HOME POSITION INFEED 3 (67M32) 533

10.7.213 FLT 2058: STEP NUMBER NOT REACHED INF. 3 (67M33) FLT 2062: HOME POSITION INFEED 3 (67M33) 535

10.7.214 FLT 2059: STEP NUMBER NOT REACHED INF. 3 (67M34) FLT 2063: HOME POSITION INFEED 3 (67M34) 537

10.7.215 FLT 2060: STEP NUMBER NOT REACHED INF. 3 (67M35) FLT 2064: HOME POSITION INFEED 3 (67M35) 539

10.8 Test protocols - Function tests software switch (SWS) 541

10.8.1 SWS 101: HEATER ON 541

10.8.2 SWS 102: FORMING AIR 542

10.8.3 Leerformular für zukünftige Tests 543

11 Notes 545

1. Alarm Testing
   1. Important Information

The following table lists the fault messages, warning messages and messages which are displayed on the  
control panel but can be simulated only by program changes and are therefore not tested.

|  |  |
| --- | --- |
|  | **WARNING** |
|  | **To perform a test procedure, it may be necessary to start the machine while the doors are open and the door contact switches are  bridged.**  **Safety functions are non-activ.**  **Severe injuries may result.**  ► Only authorized/trained persons are allowed to run the machine.  ► Special attention must be given and care taken when working in  the danger zone without protection. |

* Please note that some fault messages, warnings or messages may contain a variable which is

generated e.g. from the servo drive or profibus and gives further information about this device. The variable depends on the actual fault and therefore may vary.

|  |  |
| --- | --- |
| **Message number** | **Message text** |
| ME 0162 | MOTION CONTROL: DATA TRANSMISSION TO MOTION DRIVES |

|  |  |
| --- | --- |
| **Warning number** | **Warning text** |
| WA 0015 | CONTROL-PC: USED DISK SPACES EXCEEDS 80 % |
| WA 1024 | HARD DRIVE CAPACITY 80% |

|  |  |
| --- | --- |
| **Fault number** | **Fault text** |
| FLT 0008 | HMI: FAULT COMMUNICATION TO CONTROL |
| FLT 0012 | MOTION CONTROLLER: -400: COMMUNICATION ERROR |
| FLT 0013 | MACHINE: REFERENCE NOT SET TO ZERO |
| FLT 0015 | CONTROL PC:USED DISK SPACE EXCEEDS 90% |
| FLT 0070 | FAULT ABSOLUTE TRANSMITTER SUN WHEEL ROTOR |
| FLT 0462 | TLT: SERIAL COMMUNICATION ERROR |
| FLT 0733 | FAULT SYNCHRONIZATION TRANSFER UNIT |
| FLT 1024 | HARD DRIVE CAPACITY 90% |

* 1. Test protocols - Faults (FLT)
     1. FLT 3: OPERATOR: NORMAL STOP ACTUATED

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Press “Stop” |
| Consequence | * Fault message is displayed on control panel |
| Comments | * None |
| Acknowledgement | * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 4: OPERATOR: WRONG OPERATING MODE SELECTED

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in setup mode |
| Required operations | * Activate SWS 4 “Inching cable“ |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Activate SWS 2 “Setup” * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 5: COMPRESSED AIR: MONITORING INLET PRESSURE

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is running |
| Required operations | * Close the compressed air supply |
| Consequence | * Machine stops * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * Caution: defective leaflet and carton conveyance possible |
| Acknowledgement | * Open the compressed air supply * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Machine stops | x |
|  | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 6: ETHERCAT: FAULT + VARIABLE

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode * Guard doors are bridged |
| Required operations | * Press “Start” * Disconnect ethernet plug |
| Consequence | * Machine stops * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * Observe without fail! Control Cabinet door is open! * Additionally other fault messages are displayed on control panel * The variable contains further information about ethercat connection |
| Acknowledgement | * Reconnect ethernet plug * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Machine stops | x |
|  | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 7: COMPRESSED AIR: MONITORING SAFE SHUTDOWN

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Disconnect "=CAR1.Q95-Q01“ |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Reconnect "=CAR1.Q95-Q01“ |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 9: FAULT PROFIBUS + VARIABLE

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Press “Start” * Disconnect profibus plug |
| Consequence | * Machine stops * Fault message is displayed on control panel * Machine cannot be started as long as fault is active * Further fault messages (“variable”) are displayed |
| Comments | * Observe without fail! Control Cabinet door is open! * Additionally other fault messages are displayed on control panel |
| Acknowledgement | * Reconnect profibus plug * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Machine stops | x |
|  | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 11: MOTION DRIVES: OVERLOAD POWER SUPPLY

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Disconnect input "=CAR1.K00-KI04:10“ |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Reconnect input |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 16: HANDWHEEL IS ENGAGED

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in setup mode |
| Required operations | * Pull out the hand wheel |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Pull in the hand wheel * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |  |
| --- | --- | --- | --- |
| **Results comply** |  | yes/no  x | Date/Initials  x |
| **Results approved** |  | Date/Initials  x | |

* + 1. FLT 17: OPERATOR: OPERATING MODE CHANGE

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Change over to setup mode |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 20: BATCH CONTROL: PARTIAL BATCH OBTAINED

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Partial batch is defined and started * Machine is ready in automatic mode |
| Required operations | * Press “Start” |
| Consequence | * Machine runs until the defined quantity of good products of the partial batch is obtained * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Machine runs until the defined quantity of good products of the partial batch is obtained | x |
|  | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 21: BATCH CONTROL: COMPLETE BATCH OBTAINED

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Complete batch is defined and started * Machine is ready in automatic mode |
| Required operations | * Press “Start” * Machine runs until it reaches the batch size |
| Consequence | * Machine stops when the defined quantity of good products of the batch size is obtained * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Machine stops when the defined quantity of good products of the batch size is obtained | x |
|  | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 22: VACUUM: OVERLOAD PUMP

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Switch off protective motor switch “=CAR1.G05-Q10“ |
| Consequence | * Machine stops * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Switch on protective motor switch “=CAR1.G05-Q10“ * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Machine stops | x |
|  | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 23: VACUUM: MONITORING NEGATIVE PRESSURE

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is running in automatic mode |
| Required operations | * Activate SWS 54 “Machine vacuum” * Disconnect sensor “=CAR1.G05-B80“ |
| Consequence | * Machine stops * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Reconnect sensor “=CAR1.G05-B80“ * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Machine stops | x |
|  | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 26: CONTROL CABINET: FAULT SAFETY PLC

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Disconnect input ".K00-KIS01:7“ (One plug of emergency stop) |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 30: MACHINE: WAS RACED BACKWARDS

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Turn handwheel backwards |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 35: CONTROL CABINET: MONITORING MAIN SWITCH

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Switch off main switch and switch on immediately |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 41: CONTROL CABINET LEFT: OVERTEMPERATURE

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Adjust value of temperature controller (Control cabinet left) “=CAR1.W00-B11" less than the actual temperature in the control cabinet |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Set temperature controller “=CAR1.W00-B11" back to previous value of 45 °C * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 42: CONTROL CABINET RIGHT: OVERTEMPERATURE

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Adjust value of temperature controller (Control cabinet right) “=CAR1.W00-B13" less than the actual temperature in the control cabinet |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Set temperature controller “=CAR1.W00-B13" back to previous value of 45 °C * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 43: CONTROL CABINET: VOLTAGE MONITORING

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Switch off fuse “=CAR1.W00-F3053” |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Switch on fuse “=CAR1.W00-F3053” * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 78: EMERGENCY STOP: SAFETY RELAY NOT ACTIVE

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Disconnect input “91K20“ Pin A1 |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Reconnect input “91K20“ Pin A1 * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 79: LINE EMERGENCY STOP ACTUATED

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Line is running at reduced speed |
| Required operations | * Press “EMERGENCY STOP” strike button of rontech turret magazine |
| Consequence | * Line stops * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Unlock “EMERGENCY STOP” strike button of rontech turret magazine * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Line stops | x |
|  | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 81: EMERGENCY STOP ACTUATED: OPERATING PANEL

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is running with reduced speed |
| Required operations | * Press “EMERGENCY STOP” strike button |
| Consequence | * Machine stops * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Unlock “EMERGENCY STOP” strike button * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Machine stops | x |
|  | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 83: GUARD BASIC MACHINE: SAFETY RELAY NOT ACTIVE

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Disconnect input “=CAR1.F91-K01“ Pin ”A1“ |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Reconnect input “=CAR1.F91-K01“ Pin ”A1“ * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 86: GUARD OPEN: BOTTOM

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Open guard door bottom |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Close guard door bottom |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 86: GUARD 8 OPEN

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Open guard door 8 |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Close guard door 8 |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 87: GUARD OPEN: CARTON BELT

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Open guard door front carton belt |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * Test can only be performed at standstill, because guard is locked while running |
| Acknowledgement | * Close guard door front carton belt * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 87: GUARD 7 OPEN

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Open guard door 7 |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * Test can only be performed at standstill, because guard is locked while running |
| Acknowledgement | * Close guard door 7 * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 88: GUARD OPEN: INSERTION REAR

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Open guard door insertion rear |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Close guard door insertion rear * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 89: GUARD OPEN: DISCHARGE FRONT

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Open guard door discharge front |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * Test can only be performed at standstill, because guard is locked while running |
| Acknowledgement | * Close guard door discharge front * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 90: GUARD OPEN: CONTROL CABINET SWIVELED OFF LEFT

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Open guard door control cabinet rear left |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * Test can only be performed at standstill, because guard door is locked while running |
| Acknowledgement | * Close guard door control cabinet rear left * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 91: GUARD OPEN: CONTROL CABINET SWIVELED OFF RIGHT

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Open guard door control cabinet rear right |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * Test can only be performed at standstill, because guard door is locked while running |
| Acknowledgement | * Close guard door control cabinet rear right * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 96: GUARD OPEN: HANDWHEEL

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Open guard door handwheel |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * Test can only be performed at standstill, because guard is locked while running |
| Acknowledgement | * Close guard door handwheel * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 100: GUARD OPEN: PRODUCT CHAIN 1

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Open guard door product chain 1 |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * Test can only be performed at standstill, because guard is locked while running |
| Acknowledgement | * Close guard door product chain 1 * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 100: GUARD 3 OPEN

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Open guard door 3 |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * Test can only be performed at standstill, because guard is locked while running |
| Acknowledgement | * Close guard door 3 * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 104: GUARD OPEN: INFEED

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Open guard door infeed front |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * Test can only be performed at standstill, because guard is locked while running |
| Acknowledgement | * Close guard door infeed front * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 110: PRODUCT SENSING: CONSECUTIVE FAULT EXCESS HEIGHT

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode * Prepare three products which are too high * Product is available |
| Required operations | * Counter 131 “Product: consecutive fault sensing excess height“ is set to 3 * Press “Start” and call product * Press “Stop” in front of sensor “=CAR1.B10-B02” * Open guard door * Put the three products successively in front of “=CAR1.B10-B02” * Close guard door * Press “Reset” * Press “Start” |
| Consequence | * Machine stops * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Remove the manipulated products * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Machine stops | x |
|  | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 111: PRODUCT SENSING: CONSECUTIVE FAULT

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode * Product is available |
| Required operations | * Counter 112 “Product: consecutive fault sensing“ is set to 3 * Press “Start” and call up product * Press “Stop” in front of sensor “10B1” * Open guard door * Remove 3x product from product chain successively in front of “10B1” * Close guard door * Press “Reset” * Press “Start” |
| Consequence | * Machine stops * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Machine stops | x |
|  | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 112: PRODUCT SENSING: SENSOR MONITORING

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Cover sensor ”=CAR1.B10-B01“ permanently * Press “Start” |
| Consequence | * Machine stops * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Uncover sensor ”=CAR1.B10-B01“ * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Machine stops | x |
|  | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 113: PRODUCT SENSING: SENSOR MONITORING EXCESS HEIGHT

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Disconnect input “=.K00-KI08:14” and “=.K00-KI08:2” |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * Sensor ”=CAR1.B10-B02“ (Monitoring excess height) cannot be disconnected due to fix mechanical installation. Disconnection of the input simulates the wire break. |
| Acknowledgement | * Reconnect inputs * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 120: INSERTION: SAFETY SENSOR

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Disconnect sensor “=CAR1.B36-B01” * Press “Start” with product |
| Consequence | * Machine stops * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Reconnect sensor “=CAR1.B36-B01” * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Machine stops | x |
|  | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 121: INSERTION: DEFECTIVE PRODUCT STOPPED PLEASE REMOVE

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Prepare faulty product (e.g. wrong code leaflet, wrong code carton) * Place the wrong product in the leaflet stack or carton stack * Activate SWS 102 “Product: defective product stop at insertion” * Run machine with faulty product (e.g. wrong code carton) * Press “Start” with product |
| Consequence | * Machine stops * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Deactivate SWS 102 “Product: defective product stop at insertion” * Remove faulty product * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Machine stops | x |
|  | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 123: INSERTION: OVERLOAD

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Open guard door at insertion * Simulate overload at sensor “=CAR1.W40-B01“ (pull guide) |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 124: GUARD OPEN: SLIDE IN

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Open guard door slide in |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * Test can only be performed at standstill, because guard is locked while running |
| Acknowledgement | * Close guard door slide in * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 126: INSERTION: OVERLOAD PREINSERTION

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode * Good product is being produced |
| Required operations | * Press “Stop” * Move one preinserter to the back position * Press “Start” |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Move the preinserter back to its original position * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 173: INSERTION: SLIDE IN 1 NOT IN POSITION

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Disconnect sensor “40B1“ |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Reconnect sensor “40B1“ * Activate SWS 6 “Release stop brake” * Activate SWS 2 “Insertion” * Move shaft forwards and backwards to activate sensor * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 174: INSERTION: SLIDE IN 2 NOT IN POSITION

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Disconnect sensor “40B2“ |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Reconnect sensor “40B2“ * Activate SWS 6 “Release stop brake” * Activate SWS 2 “Insertion” * Move shaft forwards and backwards to activate sensor * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 175: INSERTION: SLIDE IN 3 NOT IN POSITION

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Disconnect sensor “40B3“ |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Reconnect sensor “40B3“ * Activate SWS 6 “Release stop brake” * Activate SWS 2 “Insertion” * Move shaft forwards and backwards to activate sensor * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 176: INSERTION: SLIDE IN 4 NOT IN POSTION

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Disconnect sensor “40B4“ |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Reconnect sensor “40B4“ * Activate SWS 6 “Release stop brake” * Activate SWS 2 “Insertion” * Move shaft forwards and backwards to activate sensor * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 177: INSERTION: SLIDE IN 5 NOT IN POSTION

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Disconnect sensor “40B5“ |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Reconnect sensor “40B5“ * Activate SWS 6 “Release stop brake” * Activate SWS 2 “Insertion” * Move shaft forwards and backwards to activate sensor * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 178: MOTION DRIVE SLIDE IN TABLE: FAULT   
       FLT 179: MOTION DRIVE SLIDE IN TABLE + VARIABLE

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Disconnect pin 5 from plug X1 at motor control unit “40A1“ |
| Consequence | * Fault message is displayed on control panel “Motion drive slide in table: fault“ * Fault message is displayed on control panel “Motion drive slide in table: 127: excess temperature motor warning“ * Machine cannot be started as long as fault is active |
| Comments | * The variable contains further information about motion drive. * In combination with this fault the variable “127: excess temperature motor warning“ is displayed on control panel. In combination with other faults the variable can be different. |
| Acknowledgement | * Reconnect temperature sensor * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel “Motion drive slide in table: fault“ | x |
|  | * Fault message is displayed on control panel “Motion drive slide in table: 127: excess temperature motor warning“ | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 186: MOTION DRIVE HORIZONTAL PRESINSERTION: FAULT  
       FLT 192: MOTION DRIVE HORIZONTAL PRESINSERTION + VARIABLE

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Disconnect pin 5 from plug X1 at motor control unit “40A3“ |
| Consequence | * Fault message is displayed on control panel “Motion drive horizontal preinsertion: fault“ * Fault message is displayed on control panel “Motion drive horizontal preinsertion: 127: excess temperature motor warning“ * Machine cannot be started as long as fault is active |
| Comments | * The variable contains further information about motion drive. * In combination with this fault the variable “127: excess temperature motor warning“ is displayed on control panel. In combination with other faults the variable can be different. |
| Acknowledgement | * Reconnect temperature sensor * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel “Motion drive horizontal preinsertion: fault“ | x |
|  | * Fault message is displayed on control panel “Motion drive horizontal preinsertion: 127: excess temperature motor warning“ | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 187: MOTION DRIVE VERTICAL PREINSERTION: FAULT  
       FLT 193: MOTION DRIVE VERTICAL PREINSERTION + VARIABLE

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Disconnect pin 5 from plug X1 at motor control unit “40A4“ |
| Consequence | * Fault message is displayed on control panel “Motion drive vertical preinsertion: fault“ * Fault message is displayed on control panel “Motion drive vertical preinsertion: 127: excess temperature motor warning“ * Machine cannot be started as long as fault is active |
| Comments | * The variable contains further information about motion drive. * In combination with this fault the variable “127: excess temperature motor warning“ is displayed on control panel. In combination with other faults the variable can be different. |
| Acknowledgement | * Reconnect temperature sensor * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel “Motion drive vertical preinsertion: fault“ | x |
|  | * Fault message is displayed on control panel “Motion drive vertical preinsertion: 127: excess temperature motor warning“ | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 188: MOTION DRIVE INSERTION: FAULT  
       FLT 191: MOTION DRIVE INSERTION + VARIABLE

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Disconnect pin 5 from plug X1 at motor control unit “40A2“ |
| Consequence | * Fault message is displayed on control panel “Motion drive insertion: fault“ * Fault message is displayed on control panel “Motion drive insertion: 127: excess temperature motor warning“ * Machine cannot be started as long as fault is active |
| Comments | * The variable contains further information about motion drive. * In combination with this fault the variable “127: excess temperature motor warning“ is displayed on control panel. In combination with other faults the variable can be different. |
| Acknowledgement | * Reconnect temperature sensor * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel “Motion drive insertion: fault“ | x |
|  | * Fault message is displayed on control panel “Motion drive insertion: 127: excess temperature motor warning“ | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 196: MOTION DRIVE MAIN DRIVE: FAULT  
       FLT 198: MOTION DRIVE MAIN DRIVE + VARIABLE

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Disconnect pin 5 from plug X1 at motor control unit “1A1“ |
| Consequence | * Fault message is displayed on control panel “Motion drive main drive: fault“ * Fault message is displayed on control panel “Motion drive main drive: 127: excess temperature motor warning“ * Machine cannot be started as long as fault is active |
| Comments | * The variable contains further information about motion drive. * In combination with this fault the variable “127: excess temperature motor warning“ is displayed on control panel. In combination with other faults the variable can be different. |
| Acknowledgement | * Reconnect temperature sensor * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel “Motion drive main drive: fault“ | x |
|  | * Fault message is displayed on control panel “Motion drive main drive: 127: excess temperature motor warning“ | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 200: MACHINE: JAM AT DISCHARGE

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Cover sensor ”=CAR1.X85-B01“ |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Uncover sensor ”=CAR1.X85-B01“ * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 201: DOWNSTREAM: STOP FROM MACHINE 1

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Activate SWS 60 “Line mode downstream equipment” * Press “Start” * Press “Stop” at dowstream machine |
| Consequence | * Machine stops (downstream machine and cartoning line) * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * Disconnect input “=.K00-KI08:10“ to simulate the fault message if no downstream equipment is available * If required remove jumper |
| Acknowledgement | * Start dowstream machine * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Machine stops | x |
|  | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 203: DOWNSTREAM: STOP FROM MACHINE 2

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Activate SWS 60 “Line mode downstream equipment” * Press “Start” * Press “Stop” at dowstream machine 2 |
| Consequence | * Machine stops * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * Disconnect input “=.K00-KI08:11“ to simulate the fault message if no downstream equipment 2 is available * If required remove jumper |
| Acknowledgement | * Press “Start” at downstream machine 2 * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Machine stops | x |
|  | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 210: GUARD OPEN: CARTON MAGAZINE

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Open guard door carton magazine |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * Test can only be performed at standstill, because guard is locked while running |
| Acknowledgement | * Close guard door carton magazine * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 210: GUARD 6 OPEN

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Open guard door 6 |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * Test can only be performed at standstill, because guard is locked while running |
| Acknowledgement | * Close guard door 6 * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 212: GUARD OPEN: DISCHARGE TOP

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Open guard door discharge top |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * Test can only be performed at standstill, because guard is locked while running |
| Acknowledgement | * Close guard door discharge top * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 212: GUARD 9 OPEN

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Open guard door 9 |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * Test can only be performed at standstill, because guard is locked while running |
| Acknowledgement | * Close guard door 9 * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 213: CARTON: OVERLOAD SIDE FLAP FOLDER

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Open guard door of cartoner * Simulate overload at sensor “=CAR1.B37-B01“ (pull guide) |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 219: CARTON BELT: LOWER POSITION NOT REACHED

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Open guard door carton magazine top * Open guard door carton belt * Lift carton belt up (“=CAR1.W31-B53” is not activated) |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Lower carton belt * Close guard door carton magazine top * Close guard door carton belt * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 220: CARTON: STOCK AT THE END

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Empty carton magazine nearly to sensor "=CAR1.A30-B02“ * Press “Start” |
| Consequence | * Machine stops * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Fill up carton magazine * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Machine stops | x |
|  | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 221: MACHINE: COVER RAIL OPEN

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode * Guard doors are closed |
| Required operations | * Activate SWS 50 “Machine: cover rail” and lift up the cover rail |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Lower cover rail * Deactivate SWS “Machine: cover rail” * Press "Reset“ |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 222: CARTON: CONSECUTIVE FAULT CROSSCHECK

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode * Counter consecutive fault carton crosscheck is set to 3 |
| Required operations | * Counter 210 “Carton: consecutive fault cross check“ is set to 3 * Counter 240 “Carton: consecutive fault code reader“ is set to 5 * Cover sensor “=CAR1.B32-B01” * Cover sensor “=CAR1.A30-B02” * Remove ≥ 3x cartons from carton magazine in front of sensor “=CAR1.A30-B01” one after the other * Press “Start” with product |
| Consequence | * After 3 undetected cartons machine stops * Fault message is displayed on control panel |
| Comments | * None |
| Acknowledgement | * Uncover sensor “=CAR1.B32-B01” * Uncover sensor “=CAR1.A30-B02” * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * After 3 undetected cartons machine stops | x |
|  | * Fault message is displayed on control panel | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 223: CARTON: PICKUP CHECK

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in setup mode |
| Required operations | * Cover sensor “=CAR1.A30-B04” |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Uncover sensor “=CAR1.A30-B04” * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 224: CARTON BELT: OVERLOAD

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Switch off protective motor switch “31Q10” |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Switch on protective motor switch “31Q10” * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 225: CARTON: CONSECUTIVE FAULT CODE READER

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode with product * Counter 240 ”Carton: consecutive fault code reader” is set to 3 |
| Required operations | * Place 3 cartons without or with wrong code in the carton magazine * Press “Start” |
| Consequence | * Machine stops * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Machine stops | x |
|  | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 226: CARTON: FAULT CODE READER

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode * SWS 200 “Code reader carton” is activated |
| Required operations | * Disconnect input “=.K00-KI04:12” |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Reconnect input “=.K00-KI04:12” * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 227: CARTON: SENSOR MONITORING CROSSCHECK

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Cover sensor ”=CAR1-A30-B01“ * Run machine for more than one cycle |
| Consequence | * Machine stops * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Uncover sensor ”=CAR1-A30-B01“ * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Machine stops | x |
|  | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 230: GLUE UNIT: OPERATING TEMPERATURE NOT REACHED

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode * SWS 204 “Glueing” is activated |
| Required operations | * Change temperature setpoint at Nordson glueing unit |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Set tempature setpoint at Nordson glueing unit back to previous value * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 231: GLUE UNIT: DEVICE NOT READY

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode * SWS 204 “Glueing” is activated |
| Required operations | * Switch off glueing unit |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Switch on glueing unit * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 232: GLUE UNIT: GLUE LEVEL IS TOO LOW

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode * SWS 204 “Glueing” is activated |
| Required operations | * Simulate low glue in glueing device (run glue empty or disconnect input “=.K00-KI02:11” |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Reconnect input “=.K00-KI02:11” if necessary * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 235: GLUE STATION 1: SENSOR MONITORING CARTON SENSING

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode * SWS 204 “Glueing” is activated |
| Required operations | * Disconnect sensor “=CAR1.B86-B04” |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Reconnect sensor “=CAR1.B86-B04” * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 250: CARTON REJECT 1: BIN OVERFILL

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Cover sensor ”=CAR1.Q82-B03“ |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Uncover sensor ”=CAR1.Q82-B03“ * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 251: CARTON REJECT 1: CROSS CHECK

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Cover sensor “=CAR1.Q82-B01“ |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Uncover sensor “=CAR1.Q82-B01“ * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 254: CARTON REJECT 1: SENSOR MONITORING CROSS CHECK

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct warning message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Open guard door discharge top * Bridge guard door discharge top * Press “Start” * Cover sensor “=CAR1.Q82-B01“ permanently in case several cartons are coming |
| Consequence | * Machine stops * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Uncover sensor “=CAR1.Q82-B01“ * Remove bridge guard door discharge top * Close guard door discharge top * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Machine stops | x |
|  | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 256: PRODUCT CHAIN: OVERFILL REJECT

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Cover sensor ”80B1“ |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Uncover sensor ”80B1“ * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 270: CARTON: OPEN FLAP: SENSOR MONITORING COVER FLAP REAR

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode * All modules are activated in menu production switches |
| Required operations | * Disconnect sensor “=CAR1.B86-B01” * Press “Start” |
| Consequence | * After some cycles the Fault message is displayed on control panel |
| Comments | * None |
| Acknowledgement | * Reconnect sensor “=CAR1.B86-B01” * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 271: CARTON: OPEN FLAP: SENSOR MONITORING COVER FLAP FRONT

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode * All modules are activated in menu production switches |
| Required operations | * Disconnect sensor “=CAR1.B86-B02” * Press “Start” |
| Consequence | * After some cycles the Fault message is displayed on control panel |
| Comments | * None |
| Acknowledgement | * Reconnect sensor “=CAR1.B86-B02” * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 272: CARTON: OPEN FLAP: SENSOR MONITORING SIDE FLAP REAR

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct warning message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode * SWS 275 “Check carton open side flap” is activated |
| Required operations | * Cover sensor "=CAR1.B86-B03“ |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Uncover sensor "=CAR1.B86-B03“ * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 273: CARTON: OPEN FLAP: SENSOR MONITORING SIDE FLAP FRONT

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct warning message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode * SWS 257 “Check carton open side flap” is activated |
| Required operations | * Cover sensor "=CAR1.B86-B04“ |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Uncover sensor "=CAR1.B86-B04“ * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 277: OUTFEED BELT 1: OVERLOAD

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Switch off protective motor switch “87Q10” |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Switch on protective motor switch “87Q10” * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 285: MOTION DRIVE CARTON SETUP: FAULT  
       FLT 288: MOTION CARTON SETUP + VARIABLE

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Disconnect pin 5 from plug X1 at motor control unit “30A1“ |
| Consequence | * Fault message is displayed on control panel “Motion drive carton setup: fault“ * Fault message is displayed on control panel “Motion carton setup: 127: excess temperature motor warning“ * Machine cannot be started as long as fault is active |
| Comments | * The variable contains further information about motion drive. * In combination with this fault the variable “127: excess temperature motor warning“ is displayed on control panel. In combination with other faults the variable can be different. |
| Acknowledgement | * Reconnect temperature sensor * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel “Motion drive carton setup: fault“ | x |
|  | * Fault message is displayed on control panel “Motion carton setup: 127: excess temperature motor warning“ | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 289: CARTON: OPEN FLAP: CONSECUTIVE FAULT COVER FLAP

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Activate SWS 256 “Check carton open cover flap“ * Set counter “Consecutive fault: open cover flap“ to 3 * Insert 3 cartons with open cover flap before sensor “38B1“ * Press “Start” |
| Consequence | * Machine stops * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Machine stops | x |
|  | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 294: CARTON: OPEN FLAP: CONSECUTIVE FAULT SIDE FLAP

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct warning message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode * Counter 256 ”Carton: consecutive fault open flap” is set to 1 |
| Required operations | * Place one carton with open side flap into machine * Press “Start” |
| Consequence | * Machine stops * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Machine stops | x |
|  | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 300: LEAFLET: STOCK AT THE END

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Remove leaflet stack from leaflet device |
| Consequence | * Machine stops * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Insert leaflet stack back into leaflet device * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Machine stops | x |
|  | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 301: LEAFLET: CROSS CHECK IN PRODUCT CHAIN

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode * Product is available |
| Required operations | * Activate SWS 300 “Leaflet device” * Press “Start” with product until leaflet gripper chain is filled up * Press “Stop” * Open guard door leaflet device * Remove leaflet before sensor ”=CAR1.A20-B01“ and after sensor ”=CAR1.A20-B02“ * Close guard door leaflet device * Press “Reset” * Press “Start” |
| Consequence | * Machine stops * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Machine stops | x |
|  | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 302: LEAFLET: CROSS CHECK REJECT

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Place leaflet in one leaflet gripper between reject and sensor “20B4” * Press “Start” |
| Consequence | * Machine stops * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Remove leaflet * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Machine stops | x |
|  | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 304: LEAFLET: CONSECUTIVE FAULT CROSS CHECK IN UNIT

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Counter 310 “Leaflet: consecutive fault cross check in device“ is set to 3 * Activate SWS 300 “Leaflet device” * Deactivate SWS 302 “Leaflet: code reader rear” and/or SWS 301 “Leaflet: code reader front” * Take all leaflets out of the leaflet device (leaflet magazine) * Press “Start” with product |
| Consequence | * Machine stops * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Fill up leaflets into the leaflet magazine * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Machine stops | x |
|  | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 305: LEAFLET: STOP AFTER MEASURE RUN

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in setup mode * Leaflets are available in the leaflet device |
| Required operations | * Activate SWS 300 “Leaflet device“ * Activate SWS 320 ”Measure run leaflet“ * Press “Start” |
| Consequence | * Machine stops after a few seconds * Fault message is displayed on control panel * Message “Measuring run completed successfully” is displayed on control panel after measure run is completed |
| Required operations | * Confirm message by entering the "checkmark“ |
| Comments | * None |
| Acknowledgement | * None |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Machine stops after a few seconds | x |
|  | * Fault message is displayed on control panel | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 307: LEAFLET: SENSOR MONITORING STOCK AT THE END

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode * SWS 300 “leaflet device” is active |
| Required operations | * Disconnect sensor =CAR1.B28-B01 |
| Consequence | * Machine stops * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Reconnect sensor =CAR1.B28-B01 * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Machine stops | x |
|  | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 310: GUARD OPEN: LEAFLET UNIT FRONT

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Open guard door leaflet unit front |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * Test can only be performed at standstill, because guard is locked while running |
| Acknowledgement | * Close guard door leaflet unit front * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 311: GUARD OPEN: LEAFLET UNIT TOP

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Open guard door leaflet unit top |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * Test can only be performed at standstill, because guard is locked while running |
| Acknowledgement | * Close guard door leaflet unit top * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 312: GUARD OPEN: LEAFLET UNIT REAR

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Open guard door leaflet unit rear |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * Test can only be performed at standstill, because guard is locked while running |
| Acknowledgement | * Close guard door leaflet unit rear * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 315: GUARD OPEN: LEAFLET UNIT BOTTOM LEFT

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Open guard door leaflet unit bottom left |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Close guard door leaflet unit bottom left * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 315: GUARD 4 OPEN

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Open guard door 4 |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Close guard door 4 * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 316: GUARD OPEN: LEAFLET UNIT BOTTOM RIGHT

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Open guard door leaflet unit bottom right |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Close guard door leaflet unit bottom right * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 316: GUARD 5 OPEN

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Open guard door 5 |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Close guard door 5 * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 317: GUARD LEAFLET UNIT: SAFETY RELAY NOT ACTIVE

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Disconnect safety relay “20K18“ at connecting point “A1“ |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Reconnect safety relay * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 320: LEAFLET: CONSECUTIVE FAULT CODE READER FRONT

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode * Counter 330 “Leaflet: consecutive fault code reader front“ is set to 3 |
| Required operations | * Prepare 3 leaflets with no or wrong code * Activate SWS 300 “Leaflet device” * Deactivate SWS 100 “Insert defective product” * Activate SWS 301 “Leaflet: code reader front” * Insert 3 leaflets with no or wrong code in leaflet stack successively * Press “Start” with product |
| Consequence | * Leaflets with wrong / missing code are ejected * After 3 defective leaflets machine stops * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * To manipulate the code of the leaflet use a black felt-tip pen (e.g. Edding) |
| Acknowledgement | * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Leaflets with wrong / missing code are ejected | x |
|  | * After 3 defective leaflets machine stops | x |
|  | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 321: LEAFLET: CONSECUTIVE FAULT CODE READER REAR

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode * Counter 331 “Leaflet: consecutive fault code reader rear“ is set to 3 |
| Required operations | * Prepare 3 leaflets with no or wrong code * Activate SWS 300 “Leaflet device” * Deactivate SWS 100 “Insert defective product” * Activate SWS 302 “Leaflet: code reader rear” * Insert 3 leaflets with no or wrong code in leaflet stack successively * Press “Start” with product |
| Consequence | * Leaflets with wrong / missing code are ejected * After 3 defective leaflets machine stops * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * To manipulate the code of the leaflet use a black felt-tip pen (e.g. Edding) |
| Acknowledgement | * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Leaflets with wrong / missing code are ejected | x |
|  | * After 3 defective leaflets machine stops | x |
|  | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 322: LEAFLET: CONSECUTIVE FAULT CROSS CHECK IN CARTON

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode * Counter 303 “Leaflet: consecutive fault cross check in carton“ is set to 3 |
| Required operations | * Activate SWS 300 “Leaflet device” * Press “Start” with product * Press “Stop” before sensor “75B4” * Open guard door * Remove 3 leaflets before sensor ”75B4“ * Close guard door * Press “Reset” * Press “Start” with product |
| Consequence | * Cartons without leaflets are ejected * After 3 missing leaflets machine stops * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Cartons without leaflets are ejected | x |
|  | * After 3 missing leaflets machine stops | x |
|  | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 324: LEAFLET: FAULT CODE READER REAR

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode with product * SWS 302 “Code reader leaflet rear” is activated |
| Required operations | * Disconnect input “=.K00-KI04:15” |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Reconnect input “=.K00-KI04:15” * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 325: LEAFLET: SENSOR MONITORING CROSS CHECK IN CARTON

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Cover sensor “=CAR1.B75-B04“ * Press “Start” |
| Consequence | * Machine stops * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Uncover sensor “=CAR1.B75-B04“ * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Machine stops | x |
|  | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 326: LEAFLET: SENSOR MONITORING CROSS CHECK IN UNIT

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Cover sensor ”=CAR1.X161-B11“ * Press “Start” |
| Consequence | * Machine stops * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Uncover sensor ”=CAR1.X161-B11“ * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Machine stops | x |
|  | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 327: LEAFLET: SENSOR MONITORING CROSS CHECK IN PRODUCT CHAIN

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Cover sensor ”=CAR1.X161-B10“ * Press “Start” |
| Consequence | * Machine stops * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Uncover sensor ”=CAR1.X161-B10“ * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Machine stops | x |
|  | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 328: LEAFLET UNIT: END POSITION NOT REACHED BELOW

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Disconnect sensor ”20B53“ |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Reconnect sensor ”20B53“ * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 329: LEAFLET UNIT: ONE END POSITION DRIVE COUPLING NOT REACHED

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Disconnect sensor ”20B51“ |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Reconnect sensor ”20B51“ * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 330: LEAFLET UNIT: END POSITION NOT REACHED THE TOP

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Disconnect sensor ”20B52“ * Open the mechanical locking on the leaflet device * Press both buttons "Lift up leaflet unit“ until leaflet unit is at the top position for approximately 10s until the fault message is displayed |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Reconnect sensor ”20B52“ * Move down leaflet unit * Close the mechanical locking at the leaflet device * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 331: LEAFLET UNIT: NOT SWIVELED IN

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Disconnect sensor ”20B54“ |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Reconnect sensor ”20B54“ * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 347: LEAFLET: SENSOR MONITORING CODE READER REAR

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Activate SWS 302: "Code reader leaflet rear“ * Switch off machine (main switch) * Disconnect sensor “=CAR1.B75-B02“ * Switch on main switch |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Reconnect sensor “=CAR1.B75-B02“ * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 382: MOTION DRIVE LEAFLET UNIT: FAULT  
       FLT 380: MOTION DRIVE LEAFLET UNIT + VARIABLE

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Disconnect pin 5 from plug X1 at motor control unit “20A1“ |
| Consequence | * Fault message is displayed on control panel “Motion drive leaflet unit: fault“ * Fault message is displayed on control panel “Motion drive leaflet unit: 127: excess temperature motor warning“ * Machine cannot be started as long as fault is active |
| Comments | * The variable contains further information about motion drive. * In combination with this fault the variable “127: excess temperature motor warning“ is displayed on control panel. In combination with other faults the variable can be different. |
| Acknowledgement | * Reconnect temperature sensor * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel “Motion drive leaflet unit: fault“ | x |
|  | * Fault message is displayed on control panel “Motion drive leaflet unit: 127: excess temperature motor warning“ | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 390: LEAFLET UNIT: NOT READY

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode * SWS 300 “Leaflet device” is activated |
| Required operations | * Press “EMERGENCY STOP” strike button at leaflet device |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Unlock “EMERGENCY STOP” strike button at leaflet device * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 391: LEAFLET UNIT: OVERLOAD DRIVE EJECT

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Switch off protective motor switch “20Q11“ |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Switch on protective motor switch * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 410: ROBOT: GUARD OPEN: BELT 1

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Open guard door robot belt 1 |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * Test can only be performed at standstill, because guard is locked while running |
| Acknowledgement | * Close guard door robot belt 1 * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 412: ROBOT: EMERGENCY STOP ACTUATED

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode * SWS 63 “Line mode upstream equipment” is activated |
| Required operations | * Press “Emergency stop” at robot |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Enable “Emergency stop” at robot * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 412: TLT: EMERGENCY STOP ACTUATED

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode * SWS 63 “Line mode upstream equipment” is activated |
| Required operations | * Press “Emergency stop” at TLT |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Enable “Emergency stop” at TLT * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 413: VIAL INFEED: GUARD: SAFETY RELAY NOT ACTIVE

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode * All safety guards are closed |
| Required operations | * Disconnect input “54K181” Pin A1 |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Reconnect input “54K181” Pin A1 * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 413: TLT: GUARD: SAFETY RELAY NOT ACTIVE

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode * SWS 63 “Line mode upstream equipment” is activated * All safety guards are closed |
| Required operations | * Disconnect input “67K8” Pin A1 |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Reconnect input “67K8” Pin A1 * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 417: VIAL INFEED: GUARD OPEN

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Open guard door at vial infeed |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Close guard door at vial infeed * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 418: VIAL INFEED: GUARD OPEN: FRONT

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Open guard door vial infeed front |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Close guard door vial infeed front * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 421: ROBOT: GUARD OPEN: FRONT LEFT

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Open guard door robot front left |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * Test can only be performed at standstill, because guard is locked while running |
| Acknowledgement | * Close guard door robot front left * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 422: ROBOT: GUARD OPEN: FRONT RIGHT

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Open guard door robot front right |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * Test can only be performed at standstill, because guard is locked while running |
| Acknowledgement | * Close guard door robot front right * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 423: VIAL INFEED: EMERGENCY STOP: SAFETY RELAIS NOT ACTIVE

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Disconnect input “54K190” Pin “A1” |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Reconnect input “54K190” Pin “A1” * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 430: VIAL INFEED: BELT 1: OVERLOAD

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Switch off protective motor switch “54Q10” * Press “Start” |
| Consequence | * Machine stops * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Switch on protective motor switch “54Q10” * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Machine stops | x |
|  | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 431: BOTTLE INFEED: ROTARY TABLE: OVERLOAD

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Switch off protective motor switch “=CAR1.W154-Q90” * Press “Start” |
| Consequence | * Machine stops * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Switch on protective motor switch “=CAR1.W154-Q90” * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Machine stops | x |
|  | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 433: BOTTLE INFEED: INLET: OVERLOAD

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in setup mode |
| Required operations | * Press “Start” * Push inlet overload mechanism “=CAR1.W154-B06” |
| Consequence | * Fault message is displayed on control panel * Machine stops * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Bring inlet overload mechanism “=CAR1.W154-B06” to normal position * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Machine stops | x |
|  | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 439: BOTTLE INFEED: ROTARY TABLE: FAULT

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Disconnect input “=CAR1.W154-M90” Pin “6” at clamp “=CAR1.W154-KI00” * Press “Start” |
| Consequence | * Machine stops * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Reconnect input “=CAR1.W154-M90” Pin “6” at clamp “=CAR1.W154-KI00” * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Machine stops | x |
|  | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 441: VIAL INFEED: BELT 1: FAULT

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Disconnect input “54M10” Pin “1” at clamp “54A1E12” * Press “Start” |
| Consequence | * Machine stops * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Reconnect input “54M10” Pin “1” at clamp “54A1E12” * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Machine stops | x |
|  | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 443: VIAL INFEED: PRODUCT TIPPED OVER

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode * Vials are available |
| Required operations | * Relocate a vial so that the sensor “54B10” is activated and sensor “54B12” is not activated |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Rearrange the vials * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 443: BOTTLE INFEED: PRODUCT TIPPED OVER

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode * Bottles are available |
| Required operations | * Tipp over a bottle to activate the sensor “=CAR1.W154-B60”  Sensor “CAR1.W154-B61” is not activated |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Rearrange the bottles * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 444: VIAL INFEED: PRODUCT SENSING: CONSECUTIVE FAULT

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode * Vials are available |
| Required operations | * Counter 430 “Vial infeed: consecutive fault product sensing” is set to 3 * Press “Start” with product * Press “Stop” before sensor “54B13” * Open guard door vial infeed * Remove 3 vials in front of sensor “54B13” * Close guard door vial infeed * Press “Reset” * Press “Start” |
| Consequence | * Machine stops * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Machine stops | x |
|  | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 446: VIAL INFEED: PRODUCT NOT TIPPED OVER

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode * Vials are available |
| Required operations | * Press “Start” with product and erect one vial in front of sensor “54B14” |
| Consequence | * Machine stops * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Open guard door vial infeed and tip over the vial * Close guard door vial infeed * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Machine stops | x |
|  | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 456: ROBOT: PRODUCT NOT PICKED UP

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode with product |
| Required operations | * Disconnect one pneumatic piping of vacuum picker and fix it savely at the picker (e.g. by using cable tie) * Press “Start” |
| Consequence | * Machine stops * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Reconnect the pneumatic piping * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Machine stops | x |
|  | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 457: ROBOT: VACUUM: FAULT

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode * Flowpack is selected as product |
| Required operations | * Bridge guard door * Press “Start” * Disconnect input “=.W150-KI00:14” |
| Consequence | * Machine stops * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Remove bridge of guard door * Reconnect input “=.W150-KI00:14” * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Machine stops | x |
|  | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 460: TLT: NOT READY

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode * SWS 63 “Line mode upstream equipment” is activated |
| Required operations | * Switch off TLT |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Press “Reset” * Switch on TLT |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 461: TLT: GUARD OPEN: TRANSFER/TLT FAULT RESET

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode * SWS 63 “Line mode upstream equipment” is activated |
| Required operations | * Open guard at transfer unit TLT |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 463: TLT: WRONG OPERATION MODE

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode * SWS 63 “Line mode upstream equipment” is activated |
| Required operations | * Activate SWS 2 “Setup“ at TLT |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 464: TLT: FAULT SPEED TOO HIGH

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode * SWS 63 “Line mode upstream equipment” is activated |
| Required operations | * Reduce machine speed to 50% of current value * Press “Start” |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 472: VIAL INFEED: TRANSFER WHEEL: OVERLOAD

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Disconnect sensor ”54B15” |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Reconnect sensor ”54B15” * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 473: ROBOT: NO PRODUCT

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode * Flowpack is selected as product |
| Required operations | * Bridge guard door * Press “Start” * Disconnect input “=.W150-KI00:14” |
| Consequence | * Machine stops * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Remove bridge of guard door * Reconnect input “=.W150-KI00:14” * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Machine stops | x |
|  | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 474: BOTTLE INFEED: SENSOR MONITORING PRODUCT TIPPED OVER

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode * Bottles are available |
| Required operations | * Disconnect sensor “=CAR1.W154-B61” * Press “Start” |
| Consequence | * Machine stops * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Reconnect sensor “=CAR1.W154-B61” * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Machine stops | x |
|  | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 476: TLT: PRODUCT CHAIN NOT EMPTY

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode * SWS 63 “Line mode upstream equipment” is activated |
| Required operations | * Disconnect sensor “60B10” or press down lever at product chain TLT |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 512: INFEED: EMERGENCY STOP ACTUATED

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Press “Emergency stop” at infeed |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Enable “Emergency stop” at infeed * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 514: INFEED: GUARD OPEN: PRODUCT CHAIN 1

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Open guard door (cover cycle belt) |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * Test can only be performed at standstill, because guard is locked while running |
| Acknowledgement | * Close guard door (cover cycle belt) * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 517: INFEED: GUARD OPEN

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Open guard door (cover overhead conveyor) |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * Test can only be performed at standstill, because guard is locked while running |
| Acknowledgement | * Close guard door (cover overhead conveyor) * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 530: INFEED: BELT 1: OVERLOAD

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Switch off protective motor switch “W257-Q50“ |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Switch on protective motor switch “W257-Q50“ * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 532: INFEED: BELT 2: OVERLOAD

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Switch off protective motor switch “W257-Q60“ |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Switch on protective motor switch “W257-Q60“ * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 541: INFEED: BELT 1: FAULT

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode * SWS 500 “Infeed” is activated * Inhaler is selected as product |
| Required operations | * Press “Start” * Switch off protective motor switch “W257-Q50“ |
| Consequence | * Machine stops * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Switch on protective motor switch “W257-Q50“ * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Machine stops | x |
|  | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 542: INFEED: BELT 2: FAULT

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode * SWS 500 “Infeed” is activated * Corresponding product is selected as product |
| Required operations | * Press “Start” * Switch off protective motor switch “W257-Q60“ |
| Consequence | * Machine stops * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Switch on protective motor switch “W257-Q60“ * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Machine stops | x |
|  | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 551: INFEED: BELT 1: PRODUCT JAM (INHALER)

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode * SWS 500 “Infeed” is activated * Inhaler is selected as product |
| Required operations | * Cover sensor “W257-B60” (e.g. with a tape) * Press “Start” |
| Consequence | * Machine stops * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Uncover sensor “W257-B60” * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Machine stops | x |
|  | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 554: INFEED 2: WRONG POSITION PRODUCT

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Activate SWS 500 “Infeed 2“ * Disconnect sensor “67B20“ |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * Fault message is displayed on control panel after delay time |
| Acknowledgement | * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT654: INFEED 3: WRONG POSITION PRODUCT

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Activate SWS 600 “Infeed 3“ * Disconnect sensor “67B30“ |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * Fault message is displayed on control panel after delay time |
| Acknowledgement | * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 902: INSERTER: CONSECUTIVE FAULT CODE READER

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode with product * Counter 901 ”Inserter: consecutive fault code reader” is set to 3 |
| Required operations | * Place 3 brochures without or with wrong code in the inserter * Press “Start” |
| Consequence | * Machine stops * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Machine stops | x |
|  | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 903: INSERTER: CONSECUTIVE FAULT CROSS CHECK

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode with product * SWS 901 “Inserter: Code reader” is activated |
| Required operations | * Set counter 920 “Inserter: Consecutive fault cross check” to 3 * Disconnect sensor “12B7” of inserter * Press “Start” |
| Consequence | * Machine stops * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Reconnect sensor “12B7” * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Machine stops | x |
|  | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 904: INSERTER: GUARD OPEN: HANDOVER

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Open guard door at transfer section of inserter |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * Test can only be performed at standstill, because guard is locked while running |
| Acknowledgement | * Close guard door at transfer section of inserter * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 907: INSERTER: NOT OPERATIONAL

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode * SWS 900 “Inserter” is activated |
| Required operations | * Disconnect input “=.X261-KI00:3” |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Reconnect input “=.X261-KI00:3” * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 922: INSERTER: EMERGENCY STOP ACTUATED

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is running with reduced speed |
| Required operations | * Press “EMERGENCY STOP” strike button at inserter |
| Consequence | * Machine stops * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Unlock “EMERGENCY STOP” strike button at inserter * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Machine stops | x |
|  | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 943: INSERTER: CABINET: VOLTAGE MONITORING

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is running with reduced speed |
| Required operations | * Switch off fuse “=CAR1.X261-F15” |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Switch on fuse “=CAR1.X261-F15” * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 947: INSERTER: SENSOR MONITORING CODE READER

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Activate SWS 901: "Code reader“ * Switch off machine (main switch) * Disconnect sensor “=CAR1.B75-B05“ * Switch on main switch |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Reconnect sensor “=CAR1.B75-B05“ * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 1242: MOTION DRIVE CARTON ALIGNMENT: FAULT  
       FLT 1243: MOTION DRIVE CARTON ALIGNMENT + VARIABLE

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Disconnect pin 5 from plug X1 at motor control unit “30A2“ |
| Consequence | * Fault message is displayed on control panel “Motion drive carton alignment: fault“ * Fault message is displayed on control panel “Motion drive carton alignment: 127: excess temperature motor warning“ * Machine cannot be started as long as fault is active |
| Comments | * The variable contains further information about motion drive. * In combination with this fault the variable “127: excess temperature motor warning“ is displayed on control panel. In combination with other faults the variable can be different. |
| Acknowledgement | * Reconnect temperature sensor * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel “Motion drive carton alignment: fault“ | x |
|  | * Fault message is displayed on control panel “Motion drive carton alignment: 127: excess temperature motor warning“ | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 1246: CARTON: SENSOR MONITORING CHECK CODE

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Activate SWS 200: ”Code reader carton“ * Connect +24 V to camera |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Disconnect +24 V * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 1247: INSERTION: SENSOR MONITORING SAFETY SENSOR

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Disconnect sensor “=CAR1.B36-B01” |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Reconnect sensor “=CAR1.B36-B01” * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 1250: DISCHARGE BELT SLIDE IN: FAULT

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Disconnect input “I81M11“ connecting point “.3“ from plug “0A1E02“ |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Reconnect input * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 1251: DISCHARGE BELT OPPOSITE SLIDE IN: FAULT

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Disconnect input “I81M10“ connecting point “.2“ from plug “0A1E02“ |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Reconnect input * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 1443: ROBOT: CABINET: VOLTAGE MONITORING

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Switch off fuse “=CAR1.W150-F10” |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Switch on fuse “=CAR1.W150-F10” * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 1515: INFEED: BELT 2: PRODUCT JAM (FLOWPACK)

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode * SWS 500 “Infeed” is activated * Flowpack is selected as product |
| Required operations | * Cover sensor “W257-B65” (e.g. with a tape) * Press “Start” |
| Consequence | * Machine stops * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Uncover sensor “W257-B65” * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Machine stops | x |
|  | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 1516: INFEED: BELT 1: PRODUCT REJECT (INHALER): BIN OVERFILL

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode * SWS 500 “Infeed” is activated * Inhaler is selected as product |
| Required operations | * Cover sensor “W257-B62” (e.g. with a tape) * Press “Start” |
| Consequence | * Machine stops * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Uncover sensor “W257-B62” * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Machine stops | x |
|  | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 1517: INFEED: BELT 2: PRODUCT REJECT (FLOWPACK): BIN OVERFILL

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode * SWS 500 “Infeed” is activated * Flowpack is selected as product |
| Required operations | * Cover sensor “W257-B67” (e.g. with a tape) * Press “Start” |
| Consequence | * Machine stops * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Uncover sensor “W257-B67” * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Machine stops | x |
|  | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 1518: INFEED: BELT 1: PRODUCT REJECT (INHALER): CROSS CHECK

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode * SWS 500 “Infeed” is activated * Inhaler is selected as product |
| Required operations | * Prepare inhaler with overlength * Adjust min machine speed * Put prepared inhaler with overlength into infeed * Press “Start” |
| Consequence | * Machine starts and ejects inhaler |
| Required operations | * Press “Stop” immediately after inhaler was ejected * Take ejected inhaler out of collection bin and reinsert inhaler at previous position after inhaler before * Press “Start” |
| Consequence | * Machine stops * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Remove manipulated inhaler * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Machine stops | x |
|  | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 1519: INFEED: BELT 2: PRODUCT REJECT (FLOWPACK): CROSS CHECK

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode * SWS 500 “Infeed” is activated * Flowpack is selected as product |
| Required operations | * Adjust min machine speed * Put two flowpacks in a row with short distance * Press “Start” |
| Consequence | * Machine starts and ejects flowpacks |
| Required operations | * Press “Stop” immediately after flowpack was ejected * Take ejected flowpack out of collection bin and reinsert flowpack at previous position with low distance * Press “Start” |
| Consequence | * Machine stops * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Take away flowpack with low distance * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Machine stops | x |
|  | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 1543: INFEED: CABINET VOLTAGE MONITORING

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Switch off fuse “=CAR1.W257-F3052” |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Switch on fuse “=CAR1.W257-F3052” * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 2001: GUARD OPEN: BIN OVERFILL

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Open guard door of ejection bin inhaler infeed |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * Test can only be performed at standstill, because guard is locked while running |
| Acknowledgement | * Close guard door of ejection bin inhaler infeed * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 2001: GUARD OPEN: SLIDE IN TOP

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Open guard door at slide in top |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * Test can only be performed at standstill, because guard is locked while running |
| Acknowledgement | * Close guard door at slide in top * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 2002: PRODUCT CHAIN GUARD: SAFETY RELAY NOT ACTIVE

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Disconnect input “I91S83.4“ at clamp 0A1E05 |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Reconnect input “I91S83.4“ at clamp 0A1E05 * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 2002: INFEED: CHECK LABEL INHALER: CONSECUTIVE FAULT

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode * Product is available * Counter 2001 “Infeed: consecutive check label inhaler“ is set to 3 |
| Required operations | * Prepare three inhalers without label * Put inhaler without label on infeed belt * Press “Start” |
| Consequence | * Machine stops * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Machine stops | x |
|  | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 2003: GUARD OPEN: SLIDE IN BOTTOM

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Open guard door at slide in bottom |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Close guard door at slide in bottom * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 2004: INFEED: OVERHEAD CONVEYOR NOT IN LOWER POSITION

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode * Inhaler is selected as product * SWS 500 “Infeed“ is activated |
| Required operations | * Disconnect input “=.W257-KI02:5” |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Reconnect input “=.W257-KI02:5” * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 2005: CARTON REJECT 1: CROSS CHECK CARTON REJECTED

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode * Prepare carton ejection so that sensor will not detect ejected carton (e.g. put a metal sheet above sensor that carton will fall beside the sensor) |
| Required operations | * Simulate a manipulated carton (e.g. Carton with wrong code) * Press “Start” |
| Consequence | * Carton is ejected but sensor “=CAR1.B82-B10” does not see ejected carton * Machine stops * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Machine stops | x |
|  | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 2006: CARTON REJECT 1: SENSOR MONITORING CROSS CHECK CARTON REJECTED

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Disconnect sensor “=CAR1.B82-B10” |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Reconnect sensor “=CAR1.B82-B10” * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 2007: INFEED: CONSECUTIVE FAULT CHECK POSITION INHALER

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Check if counter 2003 “Infeed: Consecutive fault check position inhaler“ is set to 1 * Turn one inhaler in a wrong position before infeed * Press “Start” |
| Consequence | * Machine stops * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Machine stops | x |
|  | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 2008: INFEED: CHECK POSITION INHALER: DEVICE NOT READY

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Activate SWS 2005 “Infeed: Check position inhaler“ * Disconnect camera “position check inhaler“ |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Reconnect camera ”position check inhaler“ * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 2009: INFEED: CHECK POSITION INHALER: SENSOR MONITORING

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Activate SWS 2005 “Infeed: Check position inhaler“ * Switch off machine (main switch) * Disconnect sensor “=CAR1.B75-A10“ * Switch on machine (main switch) |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Reconnect sensor “=CAR1.B75-A10“ * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 2010: INFEED: CHECK CAP INHALER: DEVICE NOT READY

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode * Inhaler is selected as product |
| Required operations | * Disconnect sensor “=CAR1.B75-B07” |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Reconnect sensor “=CAR1.B75-B07” * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 2011: INFEED: CHECK CAP INHALER: TEACH PROCEDURE NOT SUCCESSFUL

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Put cap of current product half below color sensor “B75-B07” (sensor needs to see half cap color and half belt) * Activate SWS 2003 “Infeed: Check cap inhaler - Teach” |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Press “Reset” * Perform correct teaching of sensor |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 2012: INFEED: CHECK CAP INHALER: CALIBRATION PROCEDURE NOT SUCCESSFUL

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Put a reference white half below color sensor “B75-B07” (sensor needs to see half of reference white) * Activate SWS 2004 “Infeed: Check cap inhaler - Calibration” |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Press “Reset” * Perform correct calibration of sensor |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 2013: INFEED: CHECK CAP INHALER: SENSOR MONITORING

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode * Inhaler is selected as product |
| Required operations | * Activate SWS 2002: “Infeed: Check cap inhaler” * Disconnect sensor “=CAR1.B75-B07” |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Reconnect sensor “=CAR1.B75-B07” * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 2016: INFEED: CROSS CHECK EJECT BELT 1 (INHALER): SENSOR MONITORING

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode * Inhaler is selected as product |
| Required operations | * Disconnect sensor “=CAR1.W257-B01” |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Reconnect sensor “=CAR1.W257-B01” * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 2017: INFEED: CROSS CHECK EJECT BELT 2 (FLOWPACK): SENSOR MONITORING

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode * Flowpack is selected as product |
| Required operations | * Disconnect sensor “=CAR1.W257-B69” |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Reconnect sensor “=CAR1.W257-B69” * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 2025: GRASP-IN PROTECTION INFEED 1 (67B16)

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Activate SWS 400 ”Infeed 1“ * Remove product from infeed 1 so that sensor “67B16“ is not covered |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * Fault message is displayed on control panel after delay time |
| Acknowledgement | * Refill infeed 1 with product until sensor “67B16“ is covered * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 2026: STEP NUMBER NOT REACHED INF. 1 (67M12)  
       FLT 2030: HOME POSITION INFEED 1 (67M12)

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Activate SWS 400 “Infeed 1“ * Disconnect input “12“ at control unit “67A12“ |
| Consequence | * Fault message is displayed on control panel FLT 2026 * Fault message is displayed on control panel FLT 2030 * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Reconnect input * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message 2026 is displayed on control panel | x |
|  | * Fault message 2030 is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 2027: STEP NUMBER NOT REACHED INF. 1 (67M13)  
       FLT 2031: HOME POSITION INFEED 1 (67M13)

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Activate SWS 400 “Infeed 1“ * Disconnect input “12“ at control unit “67A13“ |
| Consequence | * Fault message is displayed on control panel FLT 2027 * Fault message is displayed on control panel FLT 2031 * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Reconnect input * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message 2027 is displayed on control panel | x |
|  | * Fault message 2031 is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 2028: STEP NUMBER NOT REACHED INF. 1 (67M14)  
       FLT 2032: HOME POSITION INFEED 1 (67M14)

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Activate SWS 400 “Infeed 1“ * Disconnect input “12“ at control unit “67A14“ |
| Consequence | * Fault message is displayed on control panel FLT 2028 * Fault message is displayed on control panel FLT 2032 * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Reconnect input * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message 2028 is displayed on control panel | x |
|  | * Fault message 2032 is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 2029: STEP NUMBER NOT REACHED INF. 1 (67M15)  
       FLT 2033: HOME POSITION INFEED 1 (67M15)

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Activate SWS 400 “Infeed 1“ * Disconnect input “12“ at control unit “67A15“ |
| Consequence | * Fault message is displayed on control panel FLT 2029 * Fault message is displayed on control panel FLT 2033 * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Reconnect input * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message 2029 is displayed on control panel | x |
|  | * Fault message 2033 is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 2034: GUARD DOOR INFEED - RUNNING IN TOP - OPEN

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Open guard door infeed - running in top |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Close guard door * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 2035: GUARD DOOR INFEED - RUNNING IN BOTTOM - OPEN

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Open guard door infeed - running in bottom |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Close guard door * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 2036: GUARD DOOR INFEED - FRONT LEFT - OPEN (67S202)

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Open guard door infeed - front left (67S202) |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Close guard door * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 2037: GUARD DOOR INFEED - FRONT CENTER - OPEN (67S203)

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Open guard door infeed - front center (67S203) |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Close guard door * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 2038: GUARD DOOR INFEED - FRONT RIGHT - OPEN (67S204)

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Open guard door infeed - front right (67S204) |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Close guard door * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 2039: GUARD DOOR INFEED - REAR RIGHT - OPEN (67S206)

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Open guard door infeed - rear right (67S206) |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Close guard door * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 2040: GUARD DOOR INFEED - REAR LEFT - OPEN (67S205)

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Open guard door infeed - rear left (67S205) |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Close guard door * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 2044: PRODUCT BACKUP AT INFEED FEED 2

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Disconnect sensor “67B20“ |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Reconnect sensor * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 2045: ACCELERATION BELT 2 NOT LOCKED (67B290)

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Disconnect sensor “67B290“ |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Reconnect sensor * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 2046: STEP NUMBER NOT REACHED INF. 2 (67M22)  
       FLT 2050: HOME POSITION INFEED 2 (67M22)

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Activate SWS 500 “Infeed 2“ * Disconnect input “12“ at control unit “67A22“ |
| Consequence | * Fault message is displayed on control panel “Step number not reached inf. 2 (67M22)“ * Fault message is displayed on control panel “Home position infeed 2 (67M22)“ * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Reconnect input * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel “Step number not reached inf. 2 (67M22)“ | x |
|  | * Fault message is displayed on control panel “Home position infeed 2 (67M22)“ | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 2047: STEP NUMBER NOT REACHED INF. 2 (67M23)  
       FLT 2051: HOME POSITION INFEED 2 (67M23)

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Activate SWS 500 “Infeed 2“ * Disconnect input “12“ at control unit “67A23“ |
| Consequence | * Fault message is displayed on control panel “Step number nocht reached inf. 2 (67M23)“ * Fault message is displayed on control panel “Home position infeed 2 (67M23)“ * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Reconnect input * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel “Step number nocht reached inf. 2 (67M23)“ | x |
|  | * Fault message is displayed on control panel “Home position infeed 2 (67M23)“ | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 2048: STEP NUMBER NOT REACHED INF. 2 (67M24)  
       FLT 2052: HOME POSITION INFEED 2 (67M24)

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Activate SWS 500 “Infeed 2“ * Disconnect input “12“ at control unit “67A24“ |
| Consequence | * Fault message is displayed on control panel “Step number not reached inf. 2 (67M24)“ * Fault message is displayed on control panel “Home position infeed 2 (67M24)“ * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Reconnect input * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel “Step number not reached inf. 2 (67M24)“ | x |
|  | * Fault message is displayed on control panel “Home position infeed 2 (67M24)“ | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 2049: STEP NUMBER NOT REACHED INF. 2 (67M25)  
       FLT 2053: HOME POSITION INFEED 2 (67M25)

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Activate SWS 500 “Infeed 2“ * Disconnect input “12“ at control unit “67A25“ |
| Consequence | * Fault message is displayed on control panel “Step number not reached inf. 2 (67M26)“ * Fault message is displayed on control panel “Home position infeed 2 (67M25)“ * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Reconnect input * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel “Step number not reached inf. 2 (67M26)“ | x |
|  | * Fault message is displayed on control panel “Home position infeed 2 (67M25)“ | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 2055: PRODUCT BACKUP AT INFEED FEED 3

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Activate SWS 600 “Infeed 3“ * Disconnect sensor “67B30“ |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Reconnect sensor * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 2056: ACCELERATION BELT 3 NOT LOCKED (67B390)

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Activate SWS 600 “Infeed 3“ * Disconnect sensor “67B390“ |
| Consequence | * Fault message is displayed on control panel * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Reconnect sensor * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 2057: STEP NUMBER NOT REACHED INF. 3 (67M32)  
       FLT 2061: HOME POSITION INFEED 3 (67M32)

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Activate SWS 600 “Infeed 3“ * Disconnect input “12“ at control unit “67A32“ |
| Consequence | * Fault message is displayed on control panel “Step number not reached inf. 3 (67M32)“ * Fault message is displayed on control panel “Home position infeed 3 (67M32)“ * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Reconnect input * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel “Step number not reached inf. 3 (67M32)“ | x |
|  | * Fault message is displayed on control panel “Home position infeed 3 (67M32)“ | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 2058: STEP NUMBER NOT REACHED INF. 3 (67M33)  
       FLT 2062: HOME POSITION INFEED 3 (67M33)

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Activate SWS 600 “Infeed 3“ * Disconnect input “12“ at control unit “67A33“ |
| Consequence | * Fault message is displayed on control panel “Step number not reached inf. 3 (67M33)“ * Fault message is displayed on control panel “Home position infeed 3 (67M33)“ * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Reconnect input * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel “Step number not reached inf. 3 (67M33)“ | x |
|  | * Fault message is displayed on control panel “Home position infeed 3 (67M33)“ | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 2059: STEP NUMBER NOT REACHED INF. 3 (67M34)  
       FLT 2063: HOME POSITION INFEED 3 (67M34)

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Activate SWS 600 “Infeed 3“ * Disconnect input “12“ at control unit “67A34“ |
| Consequence | * Fault message is displayed on control panel “Step number not reached inf. 3 (67M34)“ * Fault message is displayed on control panel “Home position infeed 3 (67M34)“ * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Reconnect input * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel “Step number not reached inf. 3 (67M34)“ | x |
|  | * Fault message is displayed on control panel “Home position infeed 3 (67M34)“ | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

* + 1. FLT 2060: STEP NUMBER NOT REACHED INF. 3 (67M35)  
       FLT 2064: HOME POSITION INFEED 3 (67M35)

|  |  |
| --- | --- |
| **Test objective** | * Test whether correct fault message is displayed on control panel |
|  |  |
| **Test procedure** |  |
| Test prerequisites | * Machine is ready in automatic mode |
| Required operations | * Activate SWS 600 “Infeed 3“ * Disconnect input “12“ at control unit “67A35“ |
| Consequence | * Fault message is displayed on control panel “Step number not reached inf. 3 (67M35)“ * Fault message is displayed on control panel “Home position infeed 3 (67M35)“ * Machine cannot be started as long as fault is active |
| Comments | * None |
| Acknowledgement | * Reconnect input * Press “Reset” |

|  |  |  |
| --- | --- | --- |
| **Test result** |  | **yes/no** |
| Acceptance Criteria | * Fault message is displayed on control panel “Step number not reached inf. 3 (67M35)“ | x |
|  | * Fault message is displayed on control panel “Home position infeed 3 (67M35)“ | x |
|  | * Machine cannot be started as long as fault is active | x |
| Comments | x | |

|  |  |  |
| --- | --- | --- |
| **Results comply** | yes/no  x | Date/Initials  x |
| **Results approved** | Date/Initials  x | |

1. Notes

Here is the "textmark" for the page numbering => do not delete this line! This text will not be printed.