**Alarm and Function Testing Execution**

**KWE 4000  
CUK/CUT/CUC  
CPS**

**Cartoning machine   
Carton Print System**

**74xxxx**

**Customer**

**Country**

* **Alarm Testing**
* **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 |

|  |  |
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| **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% |

* **Test protocols - Faults (FLT)**
* **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 |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Fault message is displayed on control panel |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Fault message is displayed on control panel |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Fault message is displayed on control panel |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Fault message is displayed on control panel |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Fault message is displayed on control panel |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Fault message is displayed on control panel |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Fault message is displayed on control panel |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Fault message is displayed on control panel |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Fault message is displayed on control panel |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Fault message is displayed on control panel |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Fault message is displayed on control panel |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Fault message is displayed on control panel |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Fault message is displayed on control panel |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Fault message is displayed on control panel |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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“ |  |
|  | * 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 |  | |

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

* **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“ |  |
|  | * 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 |  | |

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

* **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“ |  |
|  | * 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 |  | |

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

* **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“ |  |
|  | * 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 |  | |

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

* **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“ |  |
|  | * 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 |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Fault message is displayed on control panel |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Fault message is displayed on control panel |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Fault message is displayed on control panel |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Fault message is displayed on control panel |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Fault message is displayed on control panel |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Fault message is displayed on control panel |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Fault message is displayed on control panel |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
| Comments |  | |

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

* **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 |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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“ |  |
|  | * 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 |  | |

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

* **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 |  |
|  | * Fault message is displayed on control panel |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Fault message is displayed on control panel |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Fault message is displayed on control panel |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Fault message is displayed on control panel |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Fault message is displayed on control panel |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Fault message is displayed on control panel |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Fault message is displayed on control panel |  |
| Comments |  | |

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

* **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 |  |
|  | * Fault message is displayed on control panel |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * After 3 defective leaflets machine stops |  |
|  | * Fault message is displayed on control panel |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * After 3 defective leaflets machine stops |  |
|  | * Fault message is displayed on control panel |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * After 3 missing leaflets machine stops |  |
|  | * Fault message is displayed on control panel |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Fault message is displayed on control panel |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Fault message is displayed on control panel |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Fault message is displayed on control panel |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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“ |  |
|  | * 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 |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Fault message is displayed on control panel |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Fault message is displayed on control panel |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Fault message is displayed on control panel |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Fault message is displayed on control panel |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Fault message is displayed on control panel |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Fault message is displayed on control panel |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Fault message is displayed on control panel |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Fault message is displayed on control panel |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Fault message is displayed on control panel |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Fault message is displayed on control panel |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Fault message is displayed on control panel |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Fault message is displayed on control panel |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Fault message is displayed on control panel |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Fault message is displayed on control panel |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **FLT 654: 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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Fault message is displayed on control panel |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Fault message is displayed on control panel |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Fault message is displayed on control panel |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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“ |  |
|  | * 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 |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Fault message is displayed on control panel |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Fault message is displayed on control panel |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Fault message is displayed on control panel |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Fault message is displayed on control panel |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Fault message is displayed on control panel |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Fault message is displayed on control panel |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Fault message is displayed on control panel |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Fault message is displayed on control panel |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Fault message 2030 is displayed on control panel |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Fault message 2031 is displayed on control panel |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Fault message 2032 is displayed on control panel |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Fault message 2033 is displayed on control panel |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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)“ |  |
|  | * Fault message is displayed on control panel “Home position infeed 2 (67M22)“ |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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)“ |  |
|  | * Fault message is displayed on control panel “Home position infeed 2 (67M23)“ |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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)“ |  |
|  | * Fault message is displayed on control panel “Home position infeed 2 (67M24)“ |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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)“ |  |
|  | * Fault message is displayed on control panel “Home position infeed 2 (67M25)“ |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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 |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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)“ |  |
|  | * Fault message is displayed on control panel “Home position infeed 3 (67M32)“ |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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)“ |  |
|  | * Fault message is displayed on control panel “Home position infeed 3 (67M33)“ |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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)“ |  |
|  | * Fault message is displayed on control panel “Home position infeed 3 (67M34)“ |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **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)“ |  |
|  | * Fault message is displayed on control panel “Home position infeed 3 (67M35)“ |  |
|  | * Machine cannot be started as long as fault is active |  |
| Comments |  | |

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

* **Notes**

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