STOPS MANAGEMENT AND TROUBLE SHOOTING MANUAL

GOAL machines
Models equipped with 2007 PCB

English

Version 1.0 - May 2011

DESCRIPTION OF THE OPERATIONS TO RUN IN THE EVENT OF MACHINE FAILURE

WARNINGS - ERRORS - ALARMS

GOAL machines

Models equipped with 2007 PCB

Version 1.0 - May 2011

Lonati Spa - Via F. Lonati, 3 - 25123 BRESCIA - Phone 03023901 - Fax: 0302310024

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Classification of messages

WARNINGS - ERRORS - ALARMS

In the paragraphs on this chapter are listed all the messages of warning, error, alarm that may appear to the user on the machine Display.

For each message the meaning and the mode of behavior is described, the the user has to keep for the solution of the eventual damage at the origin of the appearance of the message of error or alarm.
With these explanations the user, in most cases, can identify the problem and implement solutions to resolve it.

CATEGORY: Characteristics

For each of the 3 big categories in which are divided the messages that can appear on the Display are now described the characteristics and the mode oh behavior for their elimination.

The messages that may appear on the Display are divided in 3 big groups.
For each of the 3 categories are now described the characteristics and the mode oh behavior.

-WARNINGS

The warnings (warnings) appear in the low part of the machine Display (the last 2 lines below) and inform the user regarding the machine status.
The most common type of warning are:

- Warnings relating to an operation (start, in progress, end) or to its failure.
- Warnings relating to a manual operation of the user.
- Warnings relating to an automatic operation of the machine.
- Warnings relating to a defected status of the machine.

The characteristics of the Warning is that it doesn't obstruct the machine movement with the various start Button.
It's an alert for the user regarding the machine or operation status, that even if defected does not obstruct the functioning.
The Warning is erasable with the key:
[F8]
If the Warning does not cancelled or it reappears means that the defected status is still present.
There are however conditions for wich the appearance of a Warning blocks for example the possibility of the use of the Start Button.
This is a characteristic of the single Warning, see the explanations concerning the specific Warning.

-ERRORS

The Errors appear in a special window to all the video on the machine Display, and inform the user of the presence of a defect.
This machine status is such that machine operation with the Start button is inhibited for safety reasons.
The use of the [Handle 1 and 2] buttons is allowed only for some particular Errors.
In order for the machine regain its correct functioning the cause of the Error has to be eliminated, which is possible to cancel the error by pressing the key:
[F8]
If the Error does not cancelled or it reappears means that the defected status is still present.
In general, with the Error window active is not possible to access the various machine menus or use the direct keys.
Some direct keys are however enabled because their function is necessary for the resolution of the damage.
An example, but only with the key in Programming position, are the keys for the "Reset and Self-configuration" of the "Serial Outputs".

Reference

The list of the Keys and Menu active in this window, and its meaning, is available in:
GUIDE OF USER INTERFACE
1. Error window

-ALARMS

The Alarms appear in a special window to all the video on the machine Display, and inform the user of the presence of a serious defect.
This machine status means that machine operation with any run button is inhibited for safety reasons.
The Alarm is symptom of a defect so serious that the following machine functioning is prohibited.
In fact the alarm may not be deleted by any key.
The machine has to be turned off, when turned on it automatically goes to the “end of cycle” step.
Before turning off the machine eventually check the cause of the alarm, the relative explanations are found in in the description of the specific Alarm.
In general, with the Alarm window active, it is not possible to access the various machine menus or use direct keys.
Some direct keys are however enabled because their function is necessary for the resolution of the damage.
An example, but only with the key in Programming position, are the keys for the “Reset and Self-configuration” of the “Serial Outputs”.
In the Alarm window is available an “Alarm menù”, where are present menu and functions, the use of which is necessary for the solution of the problem.

Reference

The list of the Keys and Menu active in this window, and its meaning, is available in:
GUIDE OF USER INTERFACE
1. Alarm window
2. -ALARM MENU

Principle of listing

The various Warnings, Errors, Alarms are listed in a sequence that responds to these principles:
1. A first division by category (in the order “Warnings”, “Errors”, “Alarms”).
2. Inside of each category the messages are divide by “Task” of belonging.A “Task” is a part of the software dedicated to a specific groups of functions.For example the “Task MOTO” manages the Main Motor movement.
3. Inside of each “Task” the messages are listed by a numeric order specific of the Software.In fact in the messages there is an initial part indicating “Task” of belonging and ordinal number.This is useful to find the specific message in all the languages.

For some particular Error or Alarm messages, the explanation is sent to specific section.
In this section the message is explained contemporaneously with the description of a particular machine functioning.
A typical example regards the Errors of “Load not connected” or “Short-Circuit”, defects in the I/O Serial Line, etcetera.

Warning

CHAIN

Ch1: MACHINE SET-OVER ACCEPTED Even using start button.
Ch2: MACHINE SET-OVER ACCEPTED Even using start button..
CHuW04: MACHINE SET-OVER ACCEPTED Use only handle-keys.
CHuW05: MACHINE SET-OVER Even using start button
CHuW06: Machine stops because F4 act. Press F8 key to clean this message
CHuW07: Internal battery holding programs out of order
CHuW28: Emergency button pressed
CHuW30: IMPORTANT !!! HW watchdog deactivated!!

ChuW39: Saving of sewing machine parameters in setup finished
ChuW40: Saving of sewing machine parameters in setup failed
ChuW41: Cylinder position acquired
ChuW42: Cylinder position not acquired. Outside the allowed limits

Ch3: RUNNING BLACKOUT PROCEDURE
Ch4: RUNNING SOCK RECOVERY PROCEDURE - correct reboot after a blackout -
Ch5: START MACHINE DISABLE by software
Ch6: START MACHINE DISABLE: manual command is active
Ch7: MACHINE STOPS BY SAW BLADE DEVICE
Ch8: MACHINE STOPS BY SAW BLADE DEVICE
Ch9: Motor running stop. Restore with two handle revolutions
Ch10: Handle-key 1 disabled by software
Ch11: Handle-key 2 disabled by software
Ch12: GEAR DISABLED for dial tall it is key in manual
CHuW01: Self-configuration of serial outputs in execution
CHuW02: Reset EEPROM board of serial outputs in execution
CHuW03: Serial outputs not configurated
CHuW08: Air valve activated. Release air valve to start machine
CHuW09: Pull out fingers activated. Release fingers to start machine
CHuW10: Knife Nr. 2 activated. Release knife Nr. 2 to start machine
CHuW33: Knife 1 special manual raising in progress
CHuW34: Knife 2 special manual raising in progress
CHuW35: Manual knife position reset completed
CHuW38: Yarn-finger doffing control terminated
CHuW29: Manual cutter hooking disabled in toe zone
CHuW31: Start of sol. valve shake
CHuW32: End of sol. valve shake
CHuW18: SHORT CIRCUIT End of cycle for DACSY/MDS
CHuW19: SHORT CIRCUIT Stop yarn sliding for DACSY/MDS
CHuW24: SHORT CIRCUIT needle extraction light
CHuW26: SHORT CIRCUIT Emergency light
CHuW36: SHORT-CIRCUIT Output for external lighting
CHuW13: End of cycle for DACSY/MDS NOT CONNECTED
CHuW14: Stop yarn sliding for DACSY/MDS NOT CONNECTED
CHuW25: needle extraction light NOT CONNECTED
CHuW27: Emergency light NOT CONNECTED
CHuW37: Output for external lighting NOT CONNECTED
CHuW44: Stitching machine insp.lamp DISCONNECTED
CHuW43: SHORT-CIRCUIT Stitching machine insp.lamp

Messages on the Zeroing

Ch1: MACHINE SET-OVER ACCEPTED Even using start button.

This message alerts the user that the Zeroing of the machine after pressing the [F0] key has been accepted.
Press any Run key to continue.

Ch2: MACHINE SET-OVER ACCEPTED Even using start button..

This message alerts the user that is active the initial Mechanical Reset procedure.
Press any Run key to continue.

CHuW04: MACHINE SET-OVER ACCEPTED Use only handle-keys.

This message alerts the user that the Zeroing of the machine after pressing the [F0] key has been accepted.
Press the [Handle] keys to continue.

CHuW05: MACHINE SET-OVER Even using start button

This message alerts the user that the Zeroing of the machine after pressing the [F0] key has been accepted.
The initial phase of the Zeroiong procedure that used the only [Handle 1 and 2] keys is finished.
Press any Run key to continue.

Messages on various Management and Operations

CHuW06: Machine stops because F4 act. Press F8 key to clean this message

This message warns that the machine is stopped at the End-of-block position because is active the key [F4].

CHuW07: Internal battery holding programs out of order

An introduction before explaning this message.
On the Pcb_2007 board is welded a buffer battery BT1 with the task of maintaining the data contained in RAM memory (for example the machine programs).
A test carried out automatically by the software check the integrity of this battery BT1 (residual charge).
In case the battery charge had been exhausted or otherwise not conforming to the operation data, this message warns the user, which will then replace the battery BT1.
The battery duration in normal conditions of use is, however of many years.

Notice

Attention

When appears this message, to each turn off the machine is easy that are lost the programs stored in RAM memory of Pcb_2007 (depends on the remaining capacity on the battery and the time for which the machine is kept off).

CHuW28: Emergency button pressed

This message alerts the user that is pressed, voluntarily or involuntarily, the [Emergency] button, and this is the reason for the stop of the machine.

CHuW30: IMPORTANT !!! HW watchdog deactivated!!

This message is used by Dinema technicians, in the event of machine operating with a “Test” software.
It alerts the Dinema technicians that the “Watch-dog” was OFF, and that the at the end of the tests must be reactivated.

Messages on operations in FLASH

ChuW39: Saving of sewing machine parameters in setup finished

This message alerts the user that the opeartion in FLASH memory has been finished.

This message acknowledges that the acquired data have been properly saved.

The message is specific for the following models:
Stitch-by-stitch models.
For further information, refer to the brochure:
Software parameter re-acquisition
In particular:
► Vertical pickup arm correction
► Posit. 2 adjustment turning motor down

ChuW40: Saving of sewing machine parameters in setup failed

This message informs the user of the failed saving of the Setup configuration to the FLASH memory of board Pcb_2007.
The most common causes that determine this problem are:
- An hardware malfunction of the board Pcb_2007.
  Replace the board Pcb_2007.
- A wrong size in the Software of the space available for data saving, or however in general a problem in the machine software.

Notice

Attention

Before replacing the boards or intervening in any way:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

The message is specific for the following models:
Stitch-by-stitch models.
For further information, refer to the brochure:
Software parameter re-acquisition
In particular:
► Vertical pickup arm correction
► Posit. 2 adjustment turning motor down

Adjustment request messages

ChuW41: Cylinder position acquired

The message is specific for the following models:
Stitch-by-stitch models.
The message refers to the calibration procedure called:
Cylinder angle position calibration
On the acquisition procedure, the message indicates that the parameter is valid and has been recorded.
When you exit from the menu, you are prompted to save the newly acquired data.
Confirm with [Y].

ChuW42: Cylinder position not acquired. Outside the allowed limits

The message is specific for the following models:
Stitch-by-stitch models.
The message refers to the calibration procedure called:
Cylinder angle position calibration
The above procedure can be used to record the cylinder positions for the possible types of work.
The positions are:
- Normal toe position
- Reversed toe position

The software checks that the desired position in within a set range.
During the acquisition procedure the message indicates that the parameter is NOT valid.
The most common causes that determine this problem are:
- The value accepted by the software exceeds +/- 10°
  Repeat the procedure.

- The opposite position recording button has been pressed by mistake.
  Repeat the procedure.
- Incorrect performance of the following operation:
  Mechanical zero acquisition

Reference

For further information, refer to the brochure:
- Software parameter re-acquisition
- Timing for machines equipped with PCB 2007 and RUNNER
- Timing for machines equipped with PCB 2007 and ECODD

Messages on the Blackout

Ch3: RUNNING BLACKOUT PROCEDURE

This message alerts the user that is activated the Blackout procedure (Saving and Recovery data) following the Line Phases missing.

Ch4: RUNNING SOCK RECOVERY PROCEDURE - correct reboot after a blackout -

This message alerts the user that has been carried out the Sock recovery, after the correct turning on of the machine, after a previous blackout.

Messages on the disabling of the various Start button

Ch5: START MACHINE DISABLE by software

This message informs the user that the machine cannot be Run.
This movement is not possible as it is disabled from the active Software management at the time.

Ch6: START MACHINE DISABLE: manual command is active

This message informs the user that the machine cannot be Run.
This movement is not possible as it is disabled from the software control associated with a Manual Command.

Ch7: MACHINE STOPS BY SAW BLADE DEVICE

This message informs the user that the machine cannot be Run.
This movement is not possible as it is disabled from the software control associated with the “Saw” device.

Ch8: MACHINE STOPS BY SAW BLADE DEVICE

This message informs the user that the machine cannot be Run.
This movement is not possible as it is disabled from the software control associated with the “Saw” device.

Ch9: Motor running stop. Restore with two handle revolutions

This message informs the user that the machine cannot be Run.
The user must perform at least 2 rounds, with the [Handle] key before proceeding further.
This message normally appears when the user raises the “Dial” device.
For a mechanic-textiles reason (Clearing of the Knit with Saw in motion), must be at least for 2 laps cylinder speed low.
At the end of 2 laps the “Saw” is steady and therefore the user may proceed with the the normal speed.

Ch10: Handle-key 1 disabled by software

This message informs the user that the machine cannot be Run by pressing this key:
[Handle 1]
This movement is not possible as it is disabled from the active Software management at the time.

Ch11: Handle-key 2 disabled by software

This message informs the user that the machine cannot be Run by pressing this key:
[Handle 2]
This movement is not possible as it is disabled from the active Software management at the time.

Ch12: GEAR DISABLED for dial tall it is key in manual

This message informs the user that the machine cannot be Run.
This movement is not possible as it is disabled from the software control associated with “Dial” in the up position.

Messages on the Serial outputs configuration

CHuW01: Self-configuration of serial outputs in execution

This message informs the user that the “Serial I/O acquisition” procedure has started, following a specific request.
The procedure terminates when the “End of Configuration” alarm message is displayed and you are prompted to switch off the machine.
When turning on the machine the “serial outputs” will result configured.

Reference

Furthers informations are available in the section:
I/O Serial line

Furthers informations are available in :
GUIDE OF USER INTERFACE
1. Customer configuration
2. Outputs self-configuration
3. -ERRORS

CHuW02: Reset EEPROM board of serial outputs in execution

This message informs the user that the “Serial I/O Reset” procedure has started, following a specific request.
The user may require this procedure by pressing the [CTRL] + [R] keys into the Error/Alarm window.
The procedure terminates when the “End of Reset” alarm message is displayed and you are prompted to switch off the machine.
When turning on the machine the “serial outputs” will result not configured.

Reference

Furthers informations are available in the section:
I/O Serial line

Furthers informations are available in :
GUIDE OF USER INTERFACE
1. -ERRORS
2. -ALARMS

CHuW03: Serial outputs not configurated

This message appears in entering working, when the “I/O serial outputs” are not configurated.
This may happens: after the first turning on the machine, after the cancellation of the machine Setup or the replacement of the Pcb_2007 board, after the “I/O serial otputs” Reset.
For the operation of the machine is necessary learning the quantity and the position of outputs with a load connected, operation that is carried out by the “Acquisition I/O serial otputs” procedure.

- The solution of the problem is to perform a new acquisition of the “I/O serial ouputs”.

Notice

Attention

The quantity and position of the “bars” (serial outpus boards) is set in the appropriate Setup heading.
This data must correspond to the actual layout (assembly) available on the machine.
Normally this “bars” setting is already right as the default provided in the software (“eprom custom”) is set the value as used for the machine.

Reference

Furthers informations are available in :
GUIDE OF USER INTERFACE

1. Customer configuration
2. Bars configuration
3. Outputs self-configuration
4. -ERRORS
5. -ALARMS

Messages on the manual commands

CHuW08: Air valve activated. Release air valve to start machine

This message informs the user that is active the manual command manual relative the function:
Suction 1
It was requested by the operator by pressing the key for the specific command.
The use of this manual command by the operator may be useful in various situations.
Typically to facilitate the yarn-thread procedure.
To be able to proceed with the running the operator must then restore the previous situation the activation of the manual command.
Use the key relative the same manual command.

CHuW09: Pull out fingers activated. Release fingers to start machine

This message informs the user that is active the manual command manual relative the function:
Rising fingers
The use of this manual command by the operator may be useful in various situations.
Typically to facilitate the yarn-thread procedure.
To be able to proceed with the running the operator must then restore the previous situation the activation of the manual command.
Use the key relative the same manual command.

CHuW10: Knife Nr. 2 activated. Release knife Nr. 2 to start machine

This message informs the user that is active the manual command manual relative the function:
Rising knife 2
It was requested by the operator by pressing the key for the specific command.
The use of this manual command by the operator may be useful in various situations.
Typically to facilitate the yarn-thread procedure.
To be able to proceed with the running the operator must then restore the previous situation the activation of the manual command.
Use the key relative the same manual command.

CHuW33: Knife 1 special manual raising in progress

This message informs the user that is active the manual command manual relative the function:
Rising knife 1
It was requested by the operator by pressing the key for the specific command.
For this manual command the activation key are:
[Fn] + [1]
The release (restoration of the previous situation) is carried out with the keys:
[Fn] + [Small Arrow Down].
The use of this manual command by the operator may be useful in various situations.
Typically to facilitate the procedure for cleaning of the “Knife” by residues of yarn that prevent an effective yarn cutting.
To be able to proceed with the running the operator must then restore the previous situation the activation of the manual command.
Use the appropriate key for the release of this manual command.

CHuW34: Knife 2 special manual raising in progress

This message informs the user that is active the manual command manual relative the function:
Rising knife 2
It was requested by the operator by pressing the key for the specific command.
For this manual command the activation key are:
[Fn] + [2]
The release (restoration of the previous situation) is carried out with the keys:
[Fn] + [Small Arrow Down].
The use of this manual command by the operator may be useful in various situations.
Typically to facilitate the procedure for cleaning of the “Knife” by residues of yarn that prevent an effective yarn cutting.
To be able to proceed with the running the operator must then restore the previous situation the activation of the manual command.
Use the appropriate key for the release of this manual command.

CHuW35: Manual knife position reset completed

This message informs the user that has been restored the command relative the function:
Rising knife 1
Rising knife 2
The previous situation the activation of the manual command has been restored, through the use of the appropriate key.
The release (restoration of the previous situation) is carried out with the keys:
[Fn] + [Small Arrow Down].
The user can then proceed with the machine running.

CHuW38: Yarn-finger doffing control terminated

This message informs the user that has been restored the command relative the function:
Rising fingers
The previous situation the activation of the manual command has been restored, through the use of the appropriate key.
The user can then proceed with the machine running.

Messages on the Saw management

CHuW29: Manual cutter hooking disabled in toe zone

This message informs the user that the manual operation of “Saw Blade hook” is not allowed in the “Heel” and “Toe” zone, because the mechanical condition could not allow the proper “Hook”.
This operation will be permitted outside the mentioned Zone.

Messages on Solenoid Valves "shake"

CHuW31: Start of sol. valve shake

If the machine remains off for more than 24 hours (DEFAULT), when it is restarted this launches a procedure to move all the Solenoid valves to prevent wrong initial movements determined by the Sock Cycle.
In practice during the entry in Working status for some seconds is performed this "Shake" procedure.
The sequence of commands to Solenoid Valves is determined by the user through a special programming.

This message informs the user that the machine is in the Solenoid valves movement stage.
After a few seconds, completed the "Shake" procedure, the machine can now start the Sock Cycle.

CHuW32: End of sol. valve shake

If the machine remains off for more than 24 hours (DEFAULT), when it is restarted this launches a procedure to move all the Solenoid valves to prevent wrong initial movements determined by the Sock Cycle.
In practice during the entry in Working status for some seconds is performed this "Shake" procedure.
The sequence of commands to Solenoid Valves is determined by the user through a special programming.

This message informs the user that the machine has completed the "Shake" procedure and can start the Sock Cycle.

Messages on Short-Circuit and Load not connected

CHuW18: SHORT CIRCUIT End of cycle for DACSY/MDS

CHuW19: SHORT CIRCUIT Stop yarn sliding for DACSY/MDS

CHuW24: SHORT CIRCUIT needle extraction light

CHuW26: SHORT CIRCUIT Emergency light

CHuW36: SHORT-CIRCUIT Output for external lighting

These messages inform the user that Load connected to the output indicated in the message may be faulty.
The message indicates that the Load connected to this output could be in Short-circuit.

- Check the Load connected to this ouput, if imperfect must replace him.
- There could be a wiring problem relatively the wires in arrival to the Load connected to this output, working to solve the problem.

In case of malfunctioning of the I/O serial line might appear this message, together with others of the type "Load not connected" and "Short-circuit".

- Solve the problem on the serial Line.

This output is commanded by the Pcb_2008 board (see the wirings plan related this board).

- Eventually make the replacement of the board Pcb_2008.

Reference

Furthers informations are available in the section:
I/O Serial line

CHuW13: End of cycle for DACSY/MDS NOT CONNECTED

CHuW14: Stop yarn sliding for DACSY/MDS NOT CONNECTED

CHuW25: needle extraction light NOT CONNECTED

CHuW27: Emergency light NOT CONNECTED

CHuW37: Output for external lighting NOT CONNECTED

These messages inform the user that Load connected to the output indicated in the message may be faulty.
The message indicates that the Load connected to this output could be interrupted or not connected.

- Check the Load connected to this ouput, if imperfect must replace him.
- There could be a wiring problem relatively the wires in arrival to the Load connected to this output, working to solve the problem.

In case of malfunctioning of the I/O serial line might appear this message, together with others of the type “Load not connected” and “Short-circuit”.

- Solve the problem on the serial Line.

This output is commanded by the Pcb_2008 board (see the wirings plan related this board).

- Eventually make the replacement of the board Pcb_2008.

Reference

Furthers informations are available in the section:
I/O Serial line

CHuW44: Stitching machine insp.lamp DISCONNECTED

Command output:

GL-__CTE: вO e8
This output is controlled by the board:

- Pcb_4812

These messages inform the user that Load connected to the output indicated in the message may be faulty.
The message indicates that the Load connected to this output could be interrupted or not connected.

- Check the Load connected to this ouput, if imperfect must replace him.
- There could be a wiring problem relatively the wires in arrival to the Load connected to this output, working to solve the problem.

In case of malfunctioning of the I/O serial line might appear this message, together with others of the type “Load not connected” and “Short-circuit”.

- Solve the problem on the serial Line.

Remember that the devices is linked to the board:

- Pcb_4812

This component is connected to the board:

- Pcb_3896
- Replace the board(s) if necessary.

Reference

For further information, refer to the brochure:

- Wiring diagrams (FOGLIO GUIDA DOCUMENTAZIONE APPARECCHIATURA).
- Serial line repair.

CHuW43: SHORT-CIRCUIT Stitching machine insp.lamp

Command output:

GL-__CTE: вO e8
This output is controlled by the board:

- Pcb_4812

These messages inform the user that Load connected to the output indicated in the message may be faulty.
The message indicates that the Load connected to this output could be in Short-circuit.

- Check the Load connected to this ouput, if imperfect must replace him.
- There could be a wiring problem relatively the wires in arrival to the Load connected to this output, working to solve the problem.

In case of malfunctioning of the I/O serial line might appear this message, together with others of the type “Load not

connected” and “Short-circuit”.

- Solve the problem on the serial Line.

Remember that the devices is linked to the board:

- Pcb_4812

This component is connected to the board:

- Pcb_3896
- Replace the board(s) if necessary.

Reference

For further information, refer to the brochure:

- Wiring diagrams (FOGLIO GUIDA DOCUMENTAZIONE APPARECCHIATURA).
- Serial line repair.

CONSOLE

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Co1: OPERATION POSSIBLE ONLY WITH KEY IN PROGRAMMING POSITION
Co5: OPERATION IMPOSSIBLE: program not active or programming not exist.
Co6: OPERATION POSSIBLE ONLY WITH MACHINE NOT RUNNING
Co17: Article change request -activated-
Co18: OPERATION IMPOSSIBLE: YARN sliding disabled by the software
Co19: OPERATION POSSIBLE ONLY WITH KEY WORKING POSITION
Co20: OPERATION IMPOSSIBLE: PROGRAM NOT ACTIVE
Co23: Operation impossible, sliding serial sensors not enabled
Co24: Operation possible only with key in working pos. and mach. Stopped
Co25: Operation disabled by the net
Co26: Operation disabled by the setup
Co27: File MOTOR.DT has been created
Co2: UNKNOWN OPERATION
Co4: RAM TASK KEYB insufficient
Co7: NET: program name not inserted
Co8: NET: address of source machine not inserted
Co9: NET: address of destination machine not inserted
Co10: NET: address of first destination machine not inserted
Co11: NET: address of last destination machine not inserted
Co13: Saving parameters for Heel Board IN PROGRESS ....
Co14: Saving parameters for Heel Board FINISHED CORRECTLY.
Co28: Reset Heel parameters IN PROGRESS
Co29: Reset Heel parameters FINISHED
Co21: Link programs creation
Co22: Operation on sock-counter disabled by the programs-link
Co30: New password approved
Co31: New password refused
Co32: Start temporary disabling of user password
Co33: Stop temporary disabling of user password
COuW01: WARNING !!! RTC MALFUNCTION
COuW02: Date setting not correct
COuW03: Start CAN modules numbering
COuW04: End CAN modules numbering
COuW05: CAN modules numbering interrupted
COuW06: Start YOYO numeration
COuW07: End YOYO numeration
COuW08: YOYO numeration interrupted
```

Messages on various Management and Operations

Co1: OPERATION POSSIBLE ONLY WITH KEY IN PROGRAMMING POSITION

This message informs the user that the attempted operation is only possible with the key selector in position of:
- PROGRAMMING -

- Perform the operation with the Key in the correct position.

Co5: OPERATION IMPOSSIBLE: program not active or programming not exist.

This message informs the user that the operation had a negative result as no machine program was active.

- Activate a Sock Program and repeat the operation.

Co6: OPERATION POSSIBLE ONLY WITH MACHINE NOT RUNNING

This message informs the user that the attempted operation is only possible with the machine switched off (stopped).

- Stop the machine and repeat the operation.

Co17: Article change request -activated-

This message informs the user that a new “Sock program” has been activated, otherwise that a new “Size” has been selected.

Co18: OPERATION IMPOSSIBLE: YARN sliding disabled by the software

This message informs the user that the last opeartion carried out, being on the “Yarn sliding”, was not accepted, because the “Yarn Sliding” system is disabled from Setup.
This operation is only possible with the “Yarn sliding” system installed.

Reference

Furthers informations are available in :
GUIDE OF USER INTERFACE
1. -SETUP TASK SCOR
2. Enable yarn sliding

Co19: OPERATION POSSIBLE ONLY WITH KEY WORKING POSITION

This message informs the user that the attempted operation is only possible with the key selector in position of:
- RUN -
- Perform the operation with the Key in the correct position.

Co20: OPERATION IMPOSSIBLE: PROGRAM NOT ACTIVE

This message informs the user that the operation had a negative result as no machine program was active.
- Activate a Sock Program and repeat the operation.

Co23: Operation impossible, sliding serial sensors not enabled

This message alerts the user that the Command required, being on the “Yarn sliding” has not been performed since the system of “Yarn sliding” control is disabled from Setup.
This operation is only possible with the “Yarn sliding” system installed.
Normally this message not appears because the control system must always be installed.
The system is normally uninstalled only to carry out Tests or if the user decides not to use the internal system of control of the “Yarn sliding”.

Reference

Furthers informations are available in :
GUIDE OF USER INTERFACE
1. -SETUP TASK SCOR
2. Enable yarn sliding

Co24: Operation possible only with key in working pos. and mach. Stopped

This message informs the user that the attempted operation is only possible with the machine switched off (stopped).
- Stop the machine and repeat the operation.

The operation is however possible only with the key in the Working position.

Co25: Operation disabled by the net

For “Net” means a Dinema device for the Production control.
This message informs the user that the function requested is disabled by the “Net” functioning.

Co26: Operation disabled by the setup

This message informs the user that the function requested is disabled by the actual Setup configuration.
This Setup configuration does not allow the use of the function request.

Co27: File MOTOR.DT has been created

This message informs the user that the file “Motor.dt” was created correctly.
The creation of this control file is determined by a setting of Setup.
With Setup value “zero”, the creation is disabled, a numeric value enables the creation and sets the amount of RAM memory reserved for the file (typically 20-30 Kbytes).
The file is then created on the occasion of each machine “Alarm”, always rewriting it (the file is always realtive to the last “alarm” appeared).
This file contains the value of a few internal contro variables at the time of its creation.
They may be useful to the Dinema technical staff for the resolution of specific problems (“debug”).
The user can force the creation of the file by pressing the keys [CTRL] + [M] with the machine stopped.

Reference

Furthers informations are available in :
GUIDE OF USER INTERFACE
1. Dimension file motor.dt

Messages on problems in the Software Management

Co2: UNKNOWN OPERATION

This message highlights a problem caused by an error in the Software management.
For this reason it should never appear to the customer.

Notice

Attention

Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Co4: RAM TASK KEYB insufficient

This message informs the user that the space of RAM memory reserved for the task “Console” is not enough.
The error is relative to user operation aboard the machine, or to the “Codified program” out of the limits imposed for that machine model (for ex. too many “Blocks”).
This reserved RAM memory is generally sufficient for the operations typically carried out on the specific machine model.
For this reason it should never appear to the customer.

Notice

Attention

Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Messages on the NET management

Co7: NET: program name not inserted

For “Net” means a Dinema device for the Production control.

This message informs the user that, whitin the option of Programs transfer from machine to machine managed by the “Net”:

- The program to be transferred was not selected.

Co8: NET: address of source machine not inserted

For “Net” means a Dinema device for the Production control.

This message informs the user that, whitin the option of Programs transfer from machine to machine managed by the “Net”:
- The address of the machine transmitting the program has not been selected.

Co9: NET: address of destination machine not inserted

For “Net” means a Dinema device for the Production control.

This message informs the user that, whitin the option of Programs transfer from machine to machine managed by the “Net”:
- The address of the machine to receive the program has not been selected.

Co10: NET: address of first destination machine not inserted

For “Net” means a Dinema device for the Production control.

This message informs the user that, whitin the option of Programs transfer from machine to machine managed by the “Net”:
- The address of the first machine to receive the program has not been selected.

Co11: NET: address of last destination machine not inserted

For “Net” means a Dinema device for the Production control.

This message informs the user that, whitin the option of Programs transfer from machine to machine managed by the “Net”:
- The address of the last machine to receive the program has not been selected.

Messages on the saving of the Heel parametrs

Co13: Saving parameters for Heel Board IN PROGRESS ….

This message concerns the saving of the main Brushless motor operating parameters (Heel parameters and accelerations) in the FLASH memory of board Pcb_2007.
It informs the user that the operation is in progress.
The saving operation can be required at the exit from the windows of modify of these values.

Reference

Furthers informations are available in :
GUIDE OF USER INTERFACE
1. Lonati configuration
2. Heel parameters
3. Speed increasing
4. Heel parameters configuration

Co14: Saving parameters for Heel Board FINISHED CORRECTLY.

This message concerns the saving of the main Brushless motor operating parameters (Heel parameters and accelera-

tions) in the FLASH memory of board Pcb_2007.
It informs the user that the operation is finished.
The saving operation can be required at the exit from the windows of modify of these values.

Reference

Furthers informations are available in :
GUIDE OF USER INTERFACE
1. Lonati configuration
2. Heel parameters
3. Speed increasing
4. Heel parameters configuration

Co28: Reset Heel parameters IN PROGRESS

This message concerns the Reset of the main Brushless motor operating parameters (Heel parameters and accelerations) in the FLASH memory of board Pcb_2007.
It informs the user that the operation is in progress.
This operation is performed by activating the associated onboard function.
At the end of the FLASH memory operation, the (standard) DEFAULT values available in the machine software will be displayed (CUSTOM EPROM).
These values have been recommended by Lonati.

Reference

Furthers informations are available in :
GUIDE OF USER INTERFACE
1. -SETUP TASK MOTO

Co29: Reset Heel parameters FINISHED

This message concerns the Reset of the main Brushless motor operating parameters (Heel parameters and accelerations) in the FLASH memory of board Pcb_2007.
It informs the user that the operation is finished.
This operation is performed by activating the associated onboard function.
At the end of the FLASH memory operation, the (standard) DEFAULT values available in the machine software will be displayed (CUSTOM EPROM).
These values have been recommended by Lonati.

Reference

Furthers informations are available in :
GUIDE OF USER INTERFACE
1. -SETUP TASK MOTO

Messages on the Programs Link management

Co21: Link programs creation

This message informs the user that there is a creation of a “Link programs” procedure in progress (“.cn”), operation carried out aboard the machine by the user.

Reference

Furthers informations are available in :
GUIDE OF USER INTERFACE
1. Sock-counter/link-programs menu
2. Link-programs modification

Co22: Operation on sock-counter disabled by the programs-link

This message informs the user that the operation request on the “Socks counter” is not executable.
It is disabled because is active the “Link programs” procedure.

Messages on User password management

Co30: New password approved

This message refers to the operation of User passwords.
It informs the user that the new password will be accepted and is therefore now active.

Co31: New password refused

This message refers to the operation of User passwords.
It informs the user that the new password was not accepted.

Co32: Start temporary disabling of user password

This message refers to the operation of User passwords.
It informs the user that the programming time (maximum 60 minutes) the password are disabled.
Therefore, for the programming time, the access to the protected windows is not more subordinated to the password of access.

Co33: Stop temporary disabling of user password

This message refers to the operation of User passwords.
It informs the user that are been restored the access password previously disabled, because the programming time is finished.
The access to the protected windows returns to be subordinated to the password of access.

Messages on the Hour and Data management

COuW01: WARNING !!! RTC MALFUNCTION

This message, that appears when the machine is turning on, informs the user that the “system clock” is not set correctly.
It indicates to press the key [C] to enter in the Clock window.
Then press the [C] key.
Therefore set “date” and “hour” of the clock, moving in the fields with the [Small Arrows] keys, and by varying values with the [Large Arrows] keys.
The system clock is blocked when the buffer battery of the RAM memory is disconnected, when the battery is discharged, when is replaced the Pcb_2007 board with a new one.
After the appearance of this message in any case, the Clock begins to operate, of course starting from the time 00:00.
Now is possible to delete the message and the machine is in correct condition of operation.
At each subsequent turning on of the machine, if the clock was not previously set, will appear always this message, and then as soon as possible to run the adjustment of the clock.

Reference

Furthers informations are available in :
GUIDE OF USER INTERFACE
1. -DATE / TIME

COuW02: Date setting not correct

This message appears each time that the date set and active is not a valid date, whatever the reason why this happened.

- Proceed to the setting for a valid date.

Messages on the CAN Numbering

COuW03: Start CAN modules numbering

The message refers to the procedure for numbering the CAN boards controlling the various stepping motors on the machine.
It appears at the start of the procedure.

Reference

Furthers informations are available in :
GUIDE OF USER INTERFACE
1. Motor Board Numbering

COuW04: End CAN modules numbering

The message refers to the procedure for numbering the CAN boards controlling the various stepping motors on the machine.
It appears at the end of the procedure.
Of course, the procedure must have been carried out properly, without interruptions or errors.

Reference

Furthers informations are available in :
GUIDE OF USER INTERFACE
1. Motor Board Numbering

COuW05: CAN modules numbering interrupted

The message refers to the procedure for numbering the CAN boards controlling the various stepping motors on the machine.
It appears in the case of traumatic end of the procedure.
For example if during the procedure an error is committed or you go out prematurely.

- Where appropriate repeat the procedure in the correct order.

Reference

Furthers informations are available in :
GUIDE OF USER INTERFACE
1. Motor Board Numbering

Messages on the YOYO Numbering

COuW06: Start YOYO numeration

The message refers to the procedure for numbering the YOYO motors on the machine.
It appears at the start of the procedure.

Reference

Furthers informations are available in :

GUIDE OF USER INTERFACE
1. YOYO motors numbering

COuW07: End YOYO numeration

The message refers to the procedure for numbering the YOYO motors on the machine.
It appears at the end of the procedure.
Of course, the procedure must have been carried out properly, without interruptions or errors.

Reference

Furthers informations are available in :
GUIDE OF USER INTERFACE
1. YOYO motors numbering

COuW08: YOYO numeration interrupted

The message refers to the procedure for numbering the YOYO motors on the machine.
It appears in the case of traumatic end of the procedure.
For example if during the procedure an error is committed or you go out prematurely.
- Where appropriate repeat the procedure in the correct order.

Reference

Furthers informations are available in :
GUIDE OF USER INTERFACE
1. YOYO motors numbering

DRUM

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Dr1: WARNING: machine in phase of pattern elaboration.
Dr2: Phase of pattern elaboration finished
DRuW01: Start of drums warming movement
DRuW02: End of drums warming movement
```

Messages on the: "Pattern processing"

Dr1: WARNING: machine in phase of pattern elaboration.

Some Sock Programs containing very complex pattern are managed by the software in different ways by the standard. At the step Zero the patterns contained in the Program shall be prepared and developed for the number of courses actually expected in the program.
The development of the Pattern is performed in a preliminary phase, unlike the normal working in which the Pattern is developed just before the Step or Economizer to perform.
For this reason, the production of a similar Sock does not provide the possibility to insert the "Stop Chain" function ([F1] key active) in the points where is active a Pattern.

This message informs the user that the phase of preparation and development of the Pattern is in progress.
For the duration of this operation may not start the Sock Cycle.

Dr2: Phase of pattern elaboration finished

Some Sock Programs containing very complex pattern are managed by the software in different ways by the standard. At the step Zero the patterns contained in the Program shall be prepared and developed for the number of courses actually expected in the program.
The development of the Pattern is performed in a preliminary phase, unlike the normal working in which the Pattern is developed just before the Step or Economizer to perform.
For this reason, the production of a similar Sock does not provide the possibility to insert the "Stop Chain" function ([F1] key active) in the points where is active a Pattern.

This message informs the user that the phase of preparation and development of the Pattern is finished.
The machine can now start the Sock Cycle.

Messages on the Pattern Drums warm up

DRuW01: Start of drums warming movement

If the machine remains off for more than 6 hours (DEFAULT), when it is in motion this launches a procedure to move all the Pattern Drums Levers to prevent wrong initial movements determined by the Sock Cycle.
In practice when the Start Button is pressed the machine starts to run at the same step Zero for several seconds in which is performed this "Shake" procedure.

This message informs the user that the machine is in the Pattern Drum Levers movement stage.
After a few seconds, completed the "Shake" procedure, the machine can now start the Sock Cycle.

DRuW02: End of drums warming movement

If the machine remains off for more than 6 hours (DEFAULT), when it is in motion this launches a procedure to move all the Pattern Drums Levers to prevent wrong initial movements determined by the Sock Cycle.
In practice when the Start Button is pressed the machine starts to run at the same step Zero for several seconds in which is performed this "Shake" procedure.

This message informs the user that the machine has completed the “Shake” procedure and can start the Sock Cycle.

GFILE

Gf1: Program loading in progress
Gf2: Program to erase is NOT existing
Gf3: Selected file is NOT existing
Gf4: Program loading finished correctly
Gf5: Program REJECTED
Gf6: Invalid program
Gf7: Operation on disk in progress
Gf8: Operation on serial line NOT accepted
Gf9: Operation on disk finished
Gf10: File reading in progress
Gf11: Disk formatting in progress
Gf12: File erasing in progress
Gf13: Wrong extension
Gf14: Illegal disk type
Gf15: CRC disk error
Gf16: Disk is write-protected
Gf17: Disk not ready
Gf18: Delete data mark found
Gf19: Invalid sector number
Gf20: Sector or track not found
Gf21: File truncated
Gf23: File too big
Gf24: File not existing on disk
Gf25: File protected from writing
Gf26: File protected from reading
Gf27: File not erasable
Gf28: Disk full
Gf29: Floppy disk doesn’t give response
Gf40: Memory for programs is full
Gf48: File correctly saved
Gf57: USB connection not present
Gf30: Program transmission in progress
Gf31: Program copy successfully completed
Gf32: Program copy failure
Gf33: - N E T - Net board not working
Gf34: - N E T - Net board not installed
Gf35: - N E T - Request in execution
Gf36: - N E T - Other request in execution
Gf43: Operation disabled by the net
Gf37: Codified program is INCOMPATIBILE with eprom custom
Gf47: Error incompatible software
Gf41: *** WAIT PLEASE *** Operation on FLASH in progress....
Gf42: Operation on FLASH memory: finished.
Gf44: Error in FLASH memory access.
Gf46: Error during the file compression phase.
Gf49: Events memory Nautilus almost exausted
Gf50: Events memory Nautilus exausted
Gf51: Nautilus not connected
Gf52: Commands automata buffer error
Gf53: Command for Nautilus not correct
Gf54: Nautilus connected
Gf55: Nautilus Heap not enought
Gf56: Overflow circular buffer Nautilus
Gf58: Nautilus basket command failed
Gf59: Nautilus basket command completed correctly
Gf60: NAUTILUS command completed correctly
GFuW04: Line Tx CAN disturbed
GFuW05: Line Rx CAN disturbed

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GFuW07: Press [CTRL]+[X] to restore the correct position
GFuW06: Acceleration limit Pin feed motor
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General messages on the files Management

Gf1: Program loading in progress

This message warns the user that an FDU or GRAPHITRON program is being loaded.

Gf2: Program to erase is NOT existing

This message alerts the user that the file chosen for the cancellation in RAM memory of the Pcb_2007 board does not exist (wrong choice or files damaged).
However it should never appear if not in case of damages of the files in RAM memory.

Gf3: Selected file is NOT existing

This message alerts the user that the selected file in RAM memory of the Pcb_2007 board does not exist (wrong choice or files damaged).
However it should never appear if not in case of damages of the files in RAM memory or in case of “Link program” composed of “Sock programs” no longer present in memory (for example, because deleted).

Gf4: Program loading finished correctly

This message alerts the user that the procedure of Program loading from FDU or GRAPHITRON has finished correctly.
The Program is now present in the RAM memory of the Pcb_2007 board.

Gf5: Program REJECTED

This message alerts the user that was attempted to load from the FDU or GRAPHITRON has been rejected.
The reason for this rejection can be:

- Interference on the transmission.
- Generic problems (softwrae and hardware) related the sending devices (FDU or GRAPHITRON).
- RAM memory available on the board Pcb_2007 not enought.
- Sock Program not compatible with the machine software.

Proceed as follows to solve the problem:

- Check the presence of interferences.
- Replace the transmission device (Floppy disk, USB device, FDU, GRAPHITRON).
- Delete a few Programs from the RAM memory of the Pcb_2007 board.
- Check the compatibility of the Program with the machine software.

Notice

Note

With the last versions of machine software, the presence of some of the problems listed above shall determine the appearance of a specific message, and not of this generic message.

Gf6: Invalid program

This message alerts the user that was attempted to load from the FDU or GRAPHITRON has been rejected.
This Program not corresponds to the machine model, it regards another machine model, for which is not valid.

Gf7: Operation on disk in progress

This generic message alerts the user that an operation on the external memory device (FDU or USB device).
Before requesting any other operation relative the external memory device, wait for the end of the previous one.

Gf8: Operation on serial line NOT accepted

This message alerts the user that the Serial line of transmission is already busy from previous operation.
Therefore the last command sent to through the Serial line (FDU or USB device) was rejected.

Gf9: Operation on disk finished

This message alerts the user that the operation made on the external memory device (FDU or USB device) has finished, and it has a positive outcome.
It is now possible to perform other operations.

Gf10: File reading in progress

This message alerts the user that the reading of a File from the external memory device (FDU or USB device) is in progress.
The following ooperation is the loading in the dedicated memory area:
(Gf1: . . .)

Gf11: Disk formatting in progress

This message alerts the user that the formatting of the external memory device (FDU or USB device) is in progress.
Wait until the end of the operation.

Gf12: File erasing in progress

This message alerts the user that the cancellation of a File (Program) on the external memory device (FDU or USB device) is in progress.

Gf13: Wrong extension

This message alerts the user that the external memory device on which was attempted to operate contains files damaged or it is damaged.
Check the functioning of the external memory device.

Gf14: Illegal disk type

This message alerts the user that the disc inserted in the FDU is illegal, incompatible for the device.
This can occur in case the formatting is not correct.
To resolve the problem, reformat the floppy disk or replace it.

Gf15: CRC disk error

This message alerts the user that the disc inserted in the FDU and that is trying to be used is damaged.
Replace the floppy disk.

Gf16: Disk is write-protected

This message informs the user that the operation tempted on the file on the FDU has failed since the file is write protected.
If it si wanted for the same disc to be used, eliminate the protection.

Gf17: Disk not ready

This message alerts the user that there is no disc inserted in the FDU, therefore the attempted operation has failed.
Insert a floppy disk in the FDU and repeat the operation.

Gf18: Delete data mark found

This message alerts the user that the disc inserted in the FDU and that is trying to be used is damaged.
Replace the floppy disk.

Gf19: Invalid sector number

This message alerts the user that the disc inserted in the FDU and that is trying to be used is damaged.
Replace the floppy disk.

Gf20: Sector or track not found

This message alerts the user that the disc inserted in the FDU and that is trying to be used is damaged.
Replace the floppy disk.

Gf21: File truncated

This message alerts the user that the disc inserted in the FDU and that has been attempted to be used is damaged.
Replace the floppy disk.

Gf23: File too big

This message alerts the user that the attempt to save the Program on external memory device has failed.
The file is too big for the available space on the external memory device.

Gf24: File not existing on disk

This message alerts the user that the file selected on the external memory device does not exist.
Was carried ou a wrong choice or the File is damaged.

Gf25: File protected from writing

This message informs the user that the operation tempted on the current file on the external memory drive has failed since the file is write protected.

Gf26: File protected from reading

This message informs the user that the operation tempted on the current file on the external memory drive has failed since the file is read protected.

Gf27: File not erasable

This message alerts the user that the operation of cancellation attempted on the File present on the external memory device has failed because the File is protected by cancellations.

Gf28: Disk full

This message alerts the user that the operation of writing on a File present on the external memory device has failed because has already reached the maximum number of Files allowed on it.

Gf29: Floppy disk doesn’t give response

This message alerts the user that the external memory device does not respond to the commands sent by machine.
The most common cause is the external memory device disconnected; other causes:

- Transmission Line from External device to Pcb_2007 board defected.

Check the cables from the front plug of engagement of the device to the Pcb_2007 board.
- External device defective
  Check its functioning on another machine.
- Board Pcb_2007 defective, replace it.

Gf40: Memory for programs is full

This message alerts the user that the RAM memory on the Pcb_2007 board is full, there is no more available memory for the memorizations requested by the user or by the Program.
The last operation of memorizations was not made for lack of free space.
This occurs: when a new Program is inserted, when the Program requires space for data, etcetera.
The solution is cancel a few Programs to free the space in RAM memory.

Gf48: File correctly saved

This message appears when the saving of the File on the external memory device has finished correctly.

Gf57: USB connection not present

This message alerts the user that the operation request on the USB Line was not done, because the USB Line is not present (Hardware absent or connection missing).
Typically are trying to run an operation in the USB menu without the machine is prepared with the USB Line (absent: connection on the keyboard, board and internal cable).
In case the machine has prepared for the USB:
- Check the cables connections between the USB connector on the keyboard and the appropriate board mounted on the Pcb_2007 board.
- Check whether the components of the main logic board are updated to a version compatible with th USB.
- Replace the USB board.
- Replace the board Pcb_2007.

Messages on trasmission between machines

Gf30: Program transmission in progress

This message alerts the user that that the transmission of a “file” from a machine to another through a proper cable is in progress.

Reference

Furthers informations are available in :
GUIDE OF USER INTERFACE
1. Transmit to other machine

Gf31: Program copy successfully completed

This message alerts the user that the transmission of a “file” from a machine to another through a proper cable has finished correctly.

Reference

Furthers informations are available in :
GUIDE OF USER INTERFACE
1. Transmit to other machine

Gf32: Program copy failure

This message alerts the user that the transmission of a “file” from a machine to another through a proper cable has

failed.
The cause of this failure can be a defect in the cable from the machine to the other, or the failure of one of the 2 Pcb_2007 boards in meeting between each other.

Reference

Furthers informations are available in :
GUIDE OF USER INTERFACE
1. Transmit to other machine

Messages on the NET management

Gf33: - N E T - Net board not working

This message informs the user that the “Net” board of the Dinema production control system is non-operational.

Notice

Attention

For information on how to solve the problem, refer to the Dinema handbook entitled “Production Control”, and contact a Dinema engineer if necessary.

Gf34: - N E T - Net board not installed

This message informs the user that the “Net” board of the Dinema production control system is non-installed.

Notice

Attention

For information on how to solve the problem, refer to the Dinema handbook entitled “Production Control”, and contact a Dinema engineer if necessary.

Gf35: - N E T - Request in execution

This message alerts the user that an operation requested by the “Net” (Dinema production control device) is in progress.

Gf36: - N E T - Other request in execution

This message alerts the user that an operation requested by the “Net” (Dinema production control device) was not sent in execution because another previous request (always by the “Net”) is still being carried out.

Gf43: Operation disabled by the net

This message alerts the user that the last operatione requested was not carried out because it was disabled by the function of the “Net” (Dinema production control device).

Messages on Software not compatible

Gf37: Codified program is INCOMPATIBILE with eprom custom

This message alerts the user that there is not software compatibility between the “Codified program” by GRAPHITRON and the machine software available on the machine.
There is an important difference between the the version of the machine software and the Programming software.

Notice

Attention

Contact Lonati technical staff for further information and for an eventual Software update.
This update, depending on the information provided, can be of the machine software, of the GRAPHITRON software, or both.

Gf47: Error incompatible software

An introduction, the machine software can to be loaded in the machine in 2 parts, the part defined “custom”, the part defined “system”.
In normal conditions this not happens, because the software machine is loaded in FLASH memory of the Pcb_2007 board in a single file.
This message appears when is tried to activate a file “.up” relative to the software “custom” and it is incompatible with the software “system” already present into tho machine (version control).
This “codes” of compatibility are written in the software “custom and system” and they define the possible matches between the specific software versions.
Proceed to the loading and activation of the machine softwaree in complete form or of the software “custom” in a compatible version.

Notice

Note

This compatibility analysis can be made only in case of activating the file “.up”.
The insertion of the software under file “mach.bin” prevents this control.

Reference

For the information concerning the procedures mentioned in previous explanations make reference to the section:
Operations on the Software machine

Messages on operations in FLASH

Gf41: *** WAIT PLEASE *** Operation on FLASH in progress....

This message alerts the user that is in progress an operation (Reading or Writing) on the FLASH memory of one of the board available on the machine.
During this phase (message active) any other operation on the machine is inhibit.
The more typical operation performed is the copy in FLASH memory of a new software version (Software Update).
All the Update operations conclude with a machine “Reset” and an alarm that tells the user that must turn off and then turn on the machine.

During the reading phase may not be problems.
During the writing phase (software or data Update) instead, in certain conditions could cause problems.
You must not turn off the machine or cause the lack of power in this phase, because the machine when turning on would not work and there would be the need to load again the machine software in the form of files “.bin”.
Writing left open has probably damaged the software present in the machine.

Reference

For the information concerning the software procedures in which it’s engaged the FLASH memory see the section:
Operations on the Software machine

Furthers informations are available in :
GUIDE OF USER INTERFACE
1. Software management

Gf42: Operation on FLASH memory: finished.

This message alerts the user that the opeartion in FLASH memory has been finished.
This message, for example, appears at the end of an operation of Reading in FLASH memory.
Instead, in case of Writing this message is not visible to the user, because the end of the operation determines a Machine “Reset” and the appearance of an alarm.

Reference

For the information concerning the software procedures in which it’s engaged the FLASH memory see the section:
Operations on the Software machine

Furthers informations are available in :
GUIDE OF USER INTERFACE
1. Software management

Gf44: Error in FLASH memory access.

This message alerts the user that the software, during the access to the FLASH memory of the Pcb_2007 board, have found an error.
The operation in FLASH memory is not made.
This message could be a symptom of a Hardware problem of the Pcb_2007 board or of a defect in the machine software.

Notice

Attention

Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Gf46: Error during the file compression phase.

This message alerts the user that during an internal operation of the Files management software an error occured in the compression of the File.
A typical case in which there is the possibility that appears this error is during the activation of a File “.up”.
If the File is too big and there is not enough free memory the decompression cannot happen.
Another situation of error can appear during the copy of the software from the FLASH memory to the RAM memory, the causes are the same previously exposed.

Notice

Attention

In case this error appears in another situations, could be caused by an inside problem to the software management.
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Messages on the NAUTILUS device

Gf49: Events memory Nautilus almost exausted

This message concerning the Dinema NAUTILUS device (system of events and production monitoring).
An introduction, the system reserve to itself (allocates) a certain amount of RAM memory of the Pcb_2007 board, to be used for its necessity.
One of the uses of this memory is the storage of significant machine events in the case of server system control Nautilus OFF.
Then, when the Server is turned on, these events will be communicated and stored by the system of control.
Keep in mind that is not recommended turn off the Server of control, precisely for the possibility of losing significant data relating to the production management.
This message appears when the software detects that the RAM memory allocated on the Pcb_2007 board and used by the system to store the significant events is:
”almost exausted”.

Notice

Attention

For information on how to solve the problem, refer to the Dinema handbook entitled “NAUTILUS”, and contact a Dinema engineer if necessary.

Gf50: Events memory Nautilus exausted

This message concerning the Dinema NAUTILUS device (system of events and production monitoring).
An introduction, the system reserve to itself (allocates) a certain amount of RAM memory of the Pcb_2007 board, to be used for its necessity.
One of the uses of this memory is the storage of significant machine events in the case of server system control Nautilus OFF.
Then, when the Server is turned on, these events will be communicated and stored by the system of control.
Keep in mind that is not recommended turn off the Server of control, precisely for the possibility of losing significant data relating to the production management.
This message appears when the software detects that the RAM memory allocated on the Pcb_2007 board and used by the system to store the significant events is:
”exausted”.
At this point the data are compromises, as all subsequent events may not be stored.
The user is however informed that these production data are not complete.

Notice

Attention

For information on how to solve the problem, refer to the Dinema handbook entitled “NAUTILUS”, and contact a Dinema engineer if necessary.

Gf51: Nautilus not connected

This message concerning the Dinema NAUTILUS device (system of events and production monitoring).
This message appears when the machine is unable to connect with the Server of control.

Notice

Attention

For information on how to solve the problem, refer to the Dinema handbook entitled “NAUTILUS”, and contact a Dinema engineer if necessary.

Gf52: Commands automata buffer error

This message concerning the Dinema NAUTILUS device (system of events and production monitoring).
This is an internal message, it appears when, in the initial phase of connection of the machine to the server, is found to have a communication problem.

Notice

Attention

For information on how to solve the problem, refer to the Dinema handbook entitled “NAUTILUS”, and contact a Dinema engineer if necessary.

Gf53: Command for Nautilus not correct

This message concerning the Dinema NAUTILUS device (system of events and production monitoring).
This message appears when a NAUTILUS command cannot be executed because one previous is still running.
The command will be executed at the end of the previous.

Notice

Attention

For information on how to solve the problem, refer to the Dinema handbook entitled “NAUTILUS”, and contact a Dinema engineer if necessary.

Gf54: Nautilus connected

This message concerning the Dinema NAUTILUS device (system of events and production monitoring).
This message should not appear, is only a communication that the NAUTILUS system is connected correctly.

Notice

Attention

For information on how to solve the problem, refer to the Dinema handbook entitled “NAUTILUS”, and contact a Dinema engineer if necessary.

Gf55: Nautilus Heap not enought

This message concerning the Dinema NAUTILUS device (system of events and production monitoring).
An introduction, the system reserve to itself (allocates) a certain amount of RAM memory of the Pcb_2007 board, to be used for its necessity.
This message appears when the machine is turned on and the NAUTILUS system is unable to allocate the RAM memory provided, as it is not available on the Pcb_2007 board (probably already occupied by Sock programs or other Files).

Notice

Attention

For information on how to solve the problem, refer to the Dinema handbook entitled “NAUTILUS”, and contact a Dinema engineer if necessary.

Gf56: Overflow circular buffer Nautilus

This message concerning the Dinema NAUTILUS device (system of events and production monitoring).
This is an internal message, it appears when, in the communication with the Server, is found to have a misalignment of the data in communication protocol.

Notice

Attention

For information on how to solve the problem, refer to the Dinema handbook entitled “NAUTILUS”, and contact a Dinema engineer if necessary.

Gf58: Nautilus basket command failed

This message concerning the Dinema NAUTILUS device (system of events and production monitoring).
This message is displayed when this NAUTILUS command is not executed correctly.

Notice

Attention

For information on how to solve the problem, refer to the Dinema handbook entitled “NAUTILUS”, and contact a Dinema engineer if necessary.

Gf59: Nautilus basket command completed correctly

This message concerning the Dinema NAUTILUS device (system of events and production monitoring).
This message is displayed when this NAUTILUS command is executed correctly.

Notice

Attention

For information on how to solve the problem, refer to the Dinema handbook entitled “NAUTILUS”, and contact a Dinema engineer if necessary.

Gf60: NAUTILUS command completed correctly

This message concerning the Dinema NAUTILUS device (system of events and production monitoring).
This message is displayed when this NAUTILUS command is executed correctly.

Notice

Attention

For information on how to solve the problem, refer to the Dinema handbook entitled “NAUTILUS”, and contact a Dinema engineer if necessary.

Messages on the CAN line troubled

GFuW04: Line Tx CAN disturbed

GFuW05: Line Rx CAN disturbed

This message alerts the user that have been found problems on the transmission CAN Line between the Pcb_2008 board and a CAN module.
These CAN modules for example, to be:
- the control board for the stepping motors (board Pcb_3836).
- the control board for the main motor (ECODD15 Drive control).

Have to assess if these problems have undermined the machine functioning, in general, if this happens other errors and alarms on the CAN system are displayed.

- Check the connection cables between the Pcb_2007 board and the CAN modules, and between the modules themselves, eventually replace the cables and the boards concerned.

Notice

Attention

Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Messages on various Management and Operations

GFuW07: Press [CTRL]+[X] to restore the correct position

This message regards the machine equipped with a specific Encoder for the control of the position of:
Sinker cap position
If for any reason the real position of the “Sinker Cap” is different from that seen through the Encoder, an error alerts the user of this mismatch.
The User has the possibility, in this error window, to restore the correct position of the device, which is that in Sock program.

This message alerts the user that to restore the correct position of the “Sinker Cap” the user must press the keys indicated in the message.

GFuW06: Acceleration limit Pin feed motor

Pin holding unit

Rotation of the unit is driven by a motor.
This motor is called:
Pin frwd. Motor

Stage: toe seaming

Rotation of the unit is synchronised with the movement of the seaming machine needle.
When the needle is in a low position, the unit advances by one pin, so when the needle goes up, it encounters the following pin and seams another stitch (joining the two bushings).
From Graphitron you can adjust the sewing machine speed.
The distance between two pins is called step.
Since the pins are distributed on the same semi-circle for all models, the step increases as the number of needles decreases.
Therefore:
The motor must accelerate more on the models with a lower number of needles to ensure correct synchronism.

From Graphitron you can adjust the sewing machine speed.
This message indicates that the current motor might keep the pace if the Sewing Machine runs at a higher speed, or if Sock Programme is set to a model with fewer needles.

Reference

GFuE418

MAIN

Ma1: Press SPACE to see the MAIN MENU 'CTRL + HELP' to see HELPS
Ma2: Program not activated
Ma3: There is no subprogram
Ma4: Size not codified
Ma5: Testing program not enabled
Ma8: Sock counter: Planned number of socks has been reached
Ma13: Sock-counter baskets: set number of socks reached
Ma9: NEW ECONOMIZERS REJECTED
Ma15: Stop program forced by the net
Ma18: MACHINE STOPPED AT END OF CYCLE [F3 active]
Ma19: Stop machine programmed for end of yarn bobbin
Ma10: Machine is working again with programed speed
Ma11: Machine is working with speed reduction
Ma20: Working disabled because of FLASH updating
Ma28: Machine working disabled by the software
Ma27: Machine reset enabled by the article
MAuW06: Start Program of first pin position calibration test
MAuW07: Start Program of cylinder angle position calibration test
Ma16: Macchine not in synchronism
MAuW01: Mechanical zero setting stage
MAuW02: Mechanical zero ACQUIRED
MAuW03: Mechanical zero not yet acquired in the test program

Messages on various Management and Operations

Ma1: Press SPACE to see the MAIN MENU 'CTRL + HELP' to see HELPS

This message informs the user that pressing the [SPACE] key is possible to access the general menu.
This message is normally present when there aren't others messages.

Ma2: Program not activated

This message appears when the Key is placed in Working position and no Program is activated.
Through the general menu activate a Program and enter again in Working.

Ma3: There is no subprogram

This message informs the user that the Codified Program (by software GRAPHITRON) is not compatible with the machine Software.

Notice

Attention

Contact Lonati technical staff for further information and for an eventual Software update.

Ma4: Size not codified

This message informs the user that the size imposed in the active Program was not codified.
Impose a size present in the Codified Program, or through the GRAPHITRON code the missing size.

Ma5: Testing program not enabled

This message informs the user that the Test Program required is not enabled.
The Test Program may be disabled by software or Setup.

Notice

Attention

Contact Lonati technical staff for further information and for an eventual Software update.

Ma8: Sock counter: Planned number of socks has been reached

This message informs the user that is reached the “Target” of sock production previously imposed at level of:
Sock counter
The behavior of the machine is determined by the option imposed in the Sock Counter at the voice “Operation”:

- Operation “A” : On reaching the number of programmed socks (Target), production continues without any signal.
- Operation “B” : On reaching the number of programmed socks (Target), production continues, but this fact is signaled by the “Out Counter” light flashing.
- Operation “C” : On reaching the number of programmed socks (Target), the machine stops and this fact is signaled by the “Out Counter” light flashing.

Reference

Furthers informations are available in :
GUIDE OF USER INTERFACE
1. Sock-counter/link-programs menu

Ma13: Sock-counter baskets: set number of socks reached

This message informs the user that is reached the “Target” of sock production previously imposed at level of:
Baskets sock-counter

Ma9: NEW ECONOMIZERS REJECTED

This message informs the user that odd econimizers are present in the “Heel” and “Toe” zone.
In these zone are permitted only even Econimizers.
It is necessary to correct the Economizers number in the active program.

Ma15: Stop program forced by the net

This message informs the user that the Chain Stop [F1] has been inserted by the “Net” management (Dinema production control device).
Any failures are due to the “Net” management or to the “Net” boards.

Ma18: MACHINE STOPPED AT END OF CYCLE [F3 active]

This message warns that the machine is stopped at the End-of-cycle position because is active the key [F3].

Ma19: Stop machine programmed for end of yarn bobbin

This message warns that the machine is stopped at the End-of-cycle position because is active the key [F3].
This key has been activated from a previous user programming.
In the main window, by pressing the [SHIFT] + [F3] keys you access a window where is possible to program the number of Sock Cycles after which the machine will stop at the End of Cycle.
If the user sees that a yarn bobbin is exhausted, and assess the number of socks that it can still produce with the yarn remained, it can set this socks number in the window of: programmed stop for “End of Yarn bobbin”.
In this way the machine will stop at the End Cycle using the greatest amount of yarn; at this point the user will the replacement of the Yarn Bobbin, possibly after exhausting completely the yarn residue.
After the stop of the machine at End of Cycle, with consequent viewing this message, the value programmed will zero.

Reference

Furthers informations are available in :
GUIDE OF USER INTERFACE
1. -TARGET FOR YARN CONE END

Messages on the speed machine for the warm up options

Ma10: Machine is working again with programed speed

This message informs the user that the machine has completed the “Target” production imposed by the machine Warm-up option.
The machine is then returned automatically to the operation with normal speed.

Reference

Furthers informations are available in :
GUIDE OF USER INTERFACE
1. Warm up machine

Ma11: Machine is working with speed reduction

This message informs the user that is active the machine Warm-up option.
The machine will run at reduced speed until reaching the “Target” production set in the relative Setup window.

Reference

Furthers informations are available in :
GUIDE OF USER INTERFACE
1. Warm up machine

Messages on disabling of Working and Zeroing

Ma20: Working disabled because of FLASH updating

This message informs the user that work mode is not active since a Write/Read operation in the machine’s FLASH memory is in progress.

Ma28: Machine working disabled by the software

This message informs the user that work mode is not active as disabled by the software.

Ma27: Machine reset enabled by the article

This message informs the user that is not possible to perform the Zeroing procedure as the sock is located in a particular zone where is not expected this possibility.

Software parameter re-acquisition

MAuW06: Start Program of first pin position calibration test

The message informs that a specific test Programme has been activated to perform calibration.
The test program halts execution of the current chain program.
For further information, refer to the brochure:
Software parameter re-acquisition

In particular:
First pin position calibration

MAuW07: Start Program of cylinder angle position calibration test

The message informs that a specific test Programme has been activated to perform calibration.
The test program halts execution of the current chain program.
For further information, refer to the brochure:
Software parameter re-acquisition
In particular:
Cylinder angle position calibration

Messages on Zero cylinder management

Ma16: Macchine not in synchronism

When you run the mechanical zero acquisition (pressure of the key inside the specific program in the Setup), appears this message, if:

- the Zero is not acquired correctly.

The causes of failure to acquire may be:

- Insufficient machine rotation (at least 2 revolution) before acquiring.
- Resolver counting not correct.

Reference

However for any eventual counting problem (same causes of this malfunction), see the control procedure described about the error:
Ma4

For information on the “Mechanical zero acquisition” procedure see the section :
Procedure of “Mechanical zero acquisition” for:
Machines GOAL / PANTYHOSE

Furthers informations are available in :
GUIDE OF USER INTERFACE
1. Motor setup

MAuW01: Mechanical zero setting stage

During the mechanical zero acquiring procedure, this message tells the user to start the machine with [Handle 2] (at least 2 or 3 complete revolutions).
Then search for the mechanical zero (by using [Handle 1 and 2] keys, and the manual one, if necessary), and then acquire it.

Reference

For information on the “Mechanical zero acquisition” procedure see the section :
Procedure of “Mechanical zero acquisition” for:
Machines GOAL / PANTYHOSE

Furthers informations are available in :
GUIDE OF USER INTERFACE
1 Motor setup

MAuW02: Mechanical zero ACQUIRED

When you run the mechanical zero acquisition (pressure of the key inside the specific program in the Setup), appears this message, if:

- the Zero is acquired correctly.

The user is thus be informed that the operation of mechanical zero acquisition has had success.
With the exit from Setup and the data saving correctly finished, the machine will work with the new mechanical zero acquired.

In case of machine equipped Motor drive board of ECODD15 type, this message appears to pressure of the [FN] + [A] or [FN] + [Z] keys in the error window.
This when is asked to choose which zero considered valid (on board Pcb_2007 or on ECODD drive board).

Reference

Further information about the acquisition or choice of the zero valid are available in the procedure describeb about the error:
MAuE03

For information on the “Mechanical zero acquisition” procedure see the section :
Procedure of “Mechanical zero acquisition” for:
Machines GOAL / PANTYHOSE

Furthers informations are available in :
GUIDE OF USER INTERFACE
1. Motor setup

MAuW03: Mechanical zero not yet acquired in the test program

This message informs the user that the mechanical zero acquiring procedure is still active, and therefore the mechanical zero was not yet acquired, is necessary to complete the procedure.
Through the general menu activate a Program and enter again in Working.

Reference

For information on the “Mechanical zero acquisition” procedure see the section :
Procedure of “Mechanical zero acquisition” for:
Machines GOAL / PANTYHOSE

MOTO

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Mo4: NOT enough memory to create file MOTOR.DT
Mo5: Stroke too short for braking at heel
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Messages on various Management and Operations

Mo4: NOT enough memory to create file MOTOR.DT

This message informs the user that the creation of the file MOTOR.DT cannot be done with the quantity of memory set in the Setup, because the space in available memory is not enough for its creation.
Free RAM memory cancelling some Sock program or other file not used (files “.co”, “.cn”, “.up”), or decrease the space required for the creation of the file MOTOR.DT.

Reference

Furthers informations are available in :
GUIDE OF USER INTERFACE
1. Dimension file motor.dt

Mo5: Stroke too short for braking at heel

This message informs the user that given the Acceleration and Speed parameters set, there isn’t sufficient space for a correct braking and restart of the the cylinder in Alternate motion (Heel).
In practice you cannot run a correct Heel with the parameters set.

Notice

Attention

Contact Lonati technical staff for further information and for the information necessary for the problem solution.

MPP

MPuW01: Position table missing on GR5
MPuW02: Machine stops by dial head not in correct position
MPuW03: Manual rise dial not executable during dial-jacks movement
MPuW05: Dial movement not allowed in this block
MPuW07: Welt movement not possible: jacks out of dial
MPuW08: Welt movement not possible: in progress the 4 turns handle

Messages on the Dial management

MPuW01: Position table missing on GR5

This message informs the user that in the Sock Program created on GRAPHITRON is missing the table of positions regarding the “Dial” movement.
The operator must correct the programme by entering this “Table of positions”.

MPuW02: Machine stops by dial head not in correct position

This message informs the user that the machine cannot be Run.
This movement is not possible as it is disabled from the software control associated with a Manual Command.
In this case the origin of the problem is the manual command [Dial Raiser] which has not been completed.

MPuW03: Manual rise dial not executable during dial-jacks movement

This message informs the user that the Manual Command required cannot be done in this Sock Zone.
In particular, the manual command is not allowed in the “Entry/Exit of Dial Jacks” phase, or the cylinder position (degrees) does not allow it.

MPuW05: Dial movement not allowed in this block

This message informs the user that the Manual Command required cannot be done in this Sock Zone.
In particular. in the Sock Program (GRAPHITRON programming), in this Zone is not allowed the “Dial” movement, therefore is not possible to run the manual command requested.

MPuW07: Welt movement not possible: jacks out of dial

This message informs the user that the Manual Command required cannot be done in this Sock Zone.
In particular, the manual command is not allowed in the Zone where the “Dial Jacks” are positioned out of the “Dial”.

Notice

Note

This message may appear during the phase of release of the “Saw blade” in machines prepared with “Traditional Closed Toe”.

MPuW08: Welt movement not possible: in progress the 4 turns handle

This message informs the user that the Manual Command required cannot be done in this Sock Zone.
In particular, the manual command is not allowed during the excution of the 4 turns with the [Mechanical Handle].

Notice

Note

This message may appear during the phase of release of the “Saw blade” in machines prepared with “Traditional

Closed Toe”.

REST

```
Re3: Sizing modify is being executed *** DON'T SWITCH MACHINE OFF ***
Re4: At least one REST zone hasn't been kept.
REuW04: Modification not accepted Program-protected zone
Re1: Programmed measure impossible.
Re2: Input measure impossible.
Re5: Special manual command NOT existing.
```

Messages on modify of the Zone values

Re3: Sizing modify is being executed *** DON'T SWITCH MACHINE OFF ***

This message, appears during the passage for the step zero, and indicates that at that time were modified automatically the "stitch" values of the Sock program in execution.
For example, this happens when previously has been performed a "stitch" modification aboard the machine, or when a "stitch" correction is made automatically by magement of the Sock Lenght control (if enabled).
The machine for the time (very short) of the modification remains in movement at step Zero, completed the modification restarts the sock cycle.

Re4: At least one REST zone hasn't been kept.

This message informs the user that at least one zone on the task indicated was not maintained equal, by the program previously active in the activated now, and this for the conformation of the new program.
The task this message refers to is "REST" (knit, etc.).
If, in this task, are variations between the Codified program in RAM memory and that one to be inserted (activate), are rertained valid all the values present in the new program.
This message appears if after the activation of the Sock Program any value of on this task is not maintained equal to that already present in the machine.

REuW04: Modification not accepted Program-protected zone

This message informs the user that the modification cannot be carried out because the active Zone is protected.
The task this message refers to is "REST" (knit, etc.).
In the programming (by GRAPHITRON) for this particular Zone the change is not allowed.
The operator has full autonomy in the decision on which Zone protect by a possible change aboard the machine.

Messages on programmed and inserted Measures

Re1: Programmed measure impossible.

This message informs the user that the meausure (generic) set in the codified Sock Program receveid from GRAPHITRON is not permitted.
The task this message refers to is "REST" (knit, etc.).
Correct the Sock program.

Re2: Input measure impossible.

This message informs the user that the value placed aboard the machine in the active Sock Program is not permitted.
For example, it does not respect the limits ("Range") provided.
The task this message refers to is "REST" (knit, etc.).
Correct the inserted value.

Messages on various Management and Operations

Re5: Special manual command NOT existing.

This message informs the user that the operation request relative the manual command was not done, because in the software (EPROM) this functionality is not available.
It's typically a Software problem (eprom custom), or the machine model in use does not provide this management.

SCORE

```
Sc2: YARN SLIDING: Automatic out of phase
Sc4: Command not accepted Yarn sliding not working
Sc5: Program not active, Next learning refused.
Sc3: YARN SLIDING: Wrong input number of yarns
Sc7: Writing parameters in FLASH has been finished
Sc9: Memorizing NOT done, parameters NOT modified
Sc11: Serial sensors configuration in progress
Sc12: Serial sensors WRONG configuration
Sc13: Serial sensors CORRECT configuration
Sc15: Serial sensors has been, reset, learning failed
```

Messages on the functioning of the Yarn Sliding

Sc2: YARN SLIDING: Automatic out of phase

This message alerts the user that the “yarn sliding” control has detected too many consecutive anomalous errors and that the phase of “control” has been automatically suspended.
Probably the actual “Yarn sliding Learning” isn’t compatible with the actual Sock program, repeat the Learning procedure.
Also to assess the integrity of the “Sliding sensor” that before the appearance of this message had caused continue errors of “Broken yarn” or “Yarn not cut”.

Notice

Note

This message is not managed with active the “Special Management” of the “Yarn sliding”.

Sc4: Command not accepted Yarn sliding not working

This message alerts the user that the Command required, being on the “Yarn sliding” has not been performed since the system of “Yarn sliding” control is disabled from Setup.
This operation is only possible with the “Yarn sliding” system installed.
Normally this message not appears because the control system must always be installed.
The system is normally uninstalled only to carry out Tests or if the user decides not to use the internal system of control of the “Yarn sliding”.

Reference

Furthers informations are available in :
GUIDE OF USER INTERFACE
1. -SETUP TASK SCOR
2. Enable yarn sliding

Sc5: Program not active, Next learning refused.

This message alerts the user that the “Yarn sliding Learning” procedure has been attempted without any active Sock program.
- Activate a Sock Program and repeat the operation.

Messages on software problems in the Yarn Sliding

Sc3: YARN SLIDING: Wrong input number of yarns

This message alerts the user that the number of Yarn sensors set is greater than the maximum allowed by the software (128).
The number foreseen by the software is tall however, such to allow a correct machine functioning.

Notice

Attention

Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Messages on the configuration/learning of the Yarns sliding

Sc7: Writing parameters in FLASH has been finished

This message informs the user that “Yarn Sliding” sensors Setup and Configuration data saving in the FLASH memory of board Pcb_2007 is correctly finished.
This message appears in response:

- of the saving of the Sensors Identification data (Setup).
- of the saving of the Sensors Configuration data (Sensors parameters and Sensors filters).

Sc9: Memorizing NOT done, parameters NOT modified

This message alerts the user that the saving of the “Yarn sliding” control Setup data in the FLASH memory of the Pcb_2007 board has failed.
The changes made to the parameters have not been saved and thus are not active.

Notice

Note

This message is not managed with active the “Special Management” of the “Yarn sliding”.

Sc11: Serial sensors configuration in progress

This message informs the user that “Yarn Sliding” sensors Setup and Configuration data is being saved to the FLASH memory of board Pcb_2007.
This message appears in response:

- of the saving of the Sensors Identification data (Setup).
- of the saving of the Sensors Configuration data (Sensors parameters and Sensors filters).

Sc12: Serial sensors WRONG configuration

This message informs the user that “Yarn Sliding” sensors Setup and Configuration data saving in the FLASH memory of board Pcb_2007 is failed.
Any condition has prevented this saving.
Repeat the procedure.
If the problem persists:

- Check the integrity of the cables and of the connection concerning the Yarn sensors, and between them and the Pcb_2008 board.
- Replace the sensors.
- Replace the board Pcb_2008.

Notice

Attention

Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Sc13: Serial sensors CORRECT configuration

This message informs the user that “Yarn Sliding” sensors Setup and Configuration data saving in the FLASH memory of board Pcb_2007 is correctly finished.
This message appears in response:

- of the saving of the Sensors Identification data (Setup).
- of the saving of the Sensors Configuration data (Sensors parameters and Sensors filters).

Normally this message is not seen because covered by the priority message:
Sc7
which indicates the writing of the configuration parameters in FLASH memory of the Pcb_2007 board.

Sc15: Serial sensors has been, reset, learning failed

This message alerts the user that during the “Yarn sliding Learning” procedure something has determined the Sensors Reset, and therefore the operation has failed.
In general this is caused by:

- Defective connection of the sensors to the board (for exmple cable disconnected).
- Interferences thata have logically disconnected the sensors from the board.
- Software problems in the Sensors communication.

Help to understand the case may be the condition of the Leds on sensors; with the yarn stationary must be ON only the “Red Led”, with the Yarn in movement must be ON only the “Green Led”.

- Sometimes is sufficient Turn off and Turn on the machine.
- Remove the cause of error and repeat the Learning procedure.

Notice

Attention

Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

YARN

```
Ya1: Changing in cycle executed, machine restarting is possible
Ya2: At least one YARN zone hasn't been kept.
YAuW07: Modification not accepted Program-protected zone
Ya3: Input measure impossible.
```

Messages on modify of the Zone values

Ya1: Changing in cycle executed, machine restarting is possible

This message informs the user that the modification just made is finished and so is possible tom restart the machine.
The task this message refers to is “YARN” (Elastic, PYF, etc.).
Obviously the modification required as a condition the machine running out.

Ya2: At least one YARN zone hasn’t been kept.

This message informs the user that at least one zone on the task indicated was not maintained equal, by the program previously active in the activated now, and this for the conformation of the new program.
The task this message refers to is “YARN” (Elastic, PYF, etc.).
If, in this task, are variations between the Codified program in RAM memory and that one to be inserted (activate), are rertained valid all the values present in the new program.
This message appears if after the activation of the Sock Program any value of on this task is not maintained equal to that already present in the machine.

YAuW07: Modification not accepted Program-protected zone

This message informs the user that the modification cannot be carried out because the active Zone is protected.
The task this message refers to is “YARN” (Elastic, PYF, etc.).
In the programming (by GRAPHITRON) for this particular Zone the change is not allowed.
The operator has full autonomy in the decision on which Zone protect by a possible change aboard the machine.

Messages on programmed and inserted Measures

Ya3: Input measure impossible.

This message informs the user that the value placed aboard the in the active Sock Program is not permitted.
For example, it does not respect the limits (“Range”) provided.
The task this message refers to is “YARN” (Elastic, PYF, etc.).
Correct the inserted value.

Error

CHAIN

Ch1: RILINK FUNCTION 30
Ch6: Full Tab limit speed not accepted
Ch7: Config. dial wrong or nonexistent
Ch3: Dial out Position
Ch4: Clear dial jacks
CHuE01: Sock not ejected
CHuE07: Stop open bell
CHuE02: Lack of power phase
CHuE03: Alarm driver motor board
CHuE04: Battery B1 and B2 out of order
CHuE11: Lack of power 15 VDC positive
CHuE12: Lack of power 15 VDC negative
CHuE93: Lack of tension drums logic
CHuE94: Lack of tension drums power
CHuE190: Contactor not in position
CHuE14: Suction fan main switch
CHuE27: Stop turning device fan thermic
CHuE05: Lack of air pressure
CHuE06: Stop handle
CHuE09: CAUTION: CYLINDER CARTERS OPEN
CHuE154: Emergency button pressed
CHuE24: Stop lack of oil
CHuE191: Oil filter clogs
CHuE25: OIL PRESSURE
CHuE26: Stop oil depressurization
CHuE182: Lack of pressure in oil pump
CHuE19: Stop clean knife 1
CHuE96: Stop clean knife 2
CHuE68: Disable obstructed dial
CHuE20: Stop needles during heel
CHuE38: Needles butt
CHuE51: Broken selectors stop motion
CHuE70: Brocken selectors Press [F0]
CHuE35: Latch needles 3
CHuE36: Latch needles 2
CHuE37: Latch needles 1
CHuE21: Stop elastic 1
CHuE22: Stop elastic 2
CHuE23: Stop heel and toe take up
CHuE32: Winders
CHuE33: Stop yarn antibreak control 1
CHuE71: End rack
CHuE82: End bobbin scaffolding
CHuE08: Stop yarn creel
CHuE84: Pattern drum 4 not connected board 1
CHuE85: Pattern drum 3 not connected board 1
CHuE86: Pattern drum 2 not connected board 1
CHuE87: Pattern drum 1 not connected board 1
CHuE89: Drum 8 not connected board 2
CHuE90: Drum 7 not connected board 2
CHuE91: Drum 6 not connected board 2
CHuE92: Drum 5 not connected board 2
CHuE136: Drum 12 not connected board 3
CHuE137: Drum 11 not connected board 3
CHuE138: Drum 10 not connected board 3
CHuE139: Drum 9 not connected board 3
CHuE140: Drum 5 not connected board 1
CHuE141: Drum 6 not connected board 1

CHuE15:
CHuE16: Saw blade control stop motion -B-
CHuE17: Saw blade control stop motion -C-
CHuE18: Saw blade control stop motion -D-
CHuE52: Stop dropper on the left
CHuE55: Stop dropper on the right
CHuE53: Dropper error on the left Needle not drop.
CHuE56: Dropper err. on the right Needle not drop.
CHuE54: Dropper error on the left Halted.
CHuE57: Dropper err. on the right Halted.
CHuE58: Dial not in position Lower proxim. A
CHuE59: Dial not in position Lower proxim. B
CHuE60: Dial not in position Lower proxim. C
CHuE61: Dial not in position Lower proxim. D
CHuE62: Dial not in position Lower proxim. E
CHuE63: Dial not in position Upper proxim. A
CHuE64: Dial not in position Upper proxim. B
CHuE65: Dial not in position Upper proxim. C
CHuE66: Dial not in position Upper proxim. D
CHuE67: Dial not in position Upper proxim. E
CHuE124: Dial not in position. Lower proximity
CHuE125: Dial not in position. Upper proximity
CHuE120: Dial phase contr. stop motio. 0 position
CHuE131: Dial phase control stop motion
CHuE128: Saw blade engage in wrong position
CHuE129: Saw blade release in wrong position
CHuE132: Saw blade release failure!! Press [F0]
CHuE121: Upper elastic feed 1 stop motion
CHuE122: Lower elastic feed 1 stop motion
CHuE123: Elastic feed 1 broken
CHuE130: Elastic motor feed 1 not at zero
CHuE126: Capsize position not corrected
CHuE133: Capsize position not corrected
CHuE127: Normal position not corrected
CHuE134: Normal position not corrected
CHuE167: Stop yarnfinger plate position
CHuE168: Stop yarnfinger plate lock
CHuE171: Problems dial on detachment
CHuE169: Stop Solis reverser pressure
CHuE170: Stop Solis reverser inspection
CHuE34: Throat plate
CHuE39: Raising needles heel return
CHuE40: Lowering needles elastic
CHuE42: Lowering needles cam out heel and toe
CHuE43: Raiser needles enter heel and toe
CHuE69: Lowering needles transfer cam
CHuE73: Latch opener transfer cam
CHuE110: Lowering needles clearing cam
CHuE118: Raise fabric closed toe
CHuE119: Raiser needles transfer
CHuE178: Needle down welt discharge
CHuE192: Lowering needles elastic position A
CHuE193: Lowering needles elastic position B
CHuE196: Stop lowering needles ladderproof closing
CHuE197: Stop needle-levelling enter heel
CHuE117: Central cam stop
CHuE41: Clearing cam feed 1
CHuE97: Clearing cam feed 2
CHuE44: Tucking cam feed 1
CHuE45: Tucking cam feed 2
CHuE100: Tucking cam feed 3
CHuE114: Tucking cam feed 4
CHuE172: Feed 1 tuck posn.A

CHuE173: Feed 2 tuck posn.A
CHuE46: Heel and toe stitch cam pos. B
CHuE47: Heel and toe stitch cam pos. A
CHuE48: Stitch cam feed 1
CHuE98: Stitch cam feed 2 pos. A
CHuE99: Stitch cam feed 2 pos. B
CHuE101: Stitch cam feed 1 pos. A
CHuE102: Stitch cam feed 1 pos. B
CHuE103: Stitch cam feed 3 pos. B
CHuE111: Stitch cam feed 4 pos. A
CHuE113: Stitch cam feed 4 pos. B
CHuE115: Stitch cam feed 3 pos. A
CHuE49: Elastic selectors exclusion
CHuE50: Selectors exclusion feed 1
CHuE179: Cancel selectors feed 2
CHuE74: Jacks extraction drum 1
CHuE75: Jacks extraction drum 2
CHuE76: Jacks extraction drum 3
CHuE77: Jacks extraction drum 4
CHuE78: Jacks extraction drum 5
CHuE79: Jacks extraction drum 6
CHuE142: Jacks extraction feed 1
CHuE143: Jacks extraction feed 2
CHuE144: Jacks extraction feed 3
CHuE145: Jacks extraction feed 4
CHuE80: Raise medium jacks heel and toe forward
CHuE81: Raising needles col. 4
CHuE106: Raise medium jacks colour 1
CHuE107: Raise medium jacks colour 2
CHuE151: Rise footlet medium jacks 1
CHuE152: Rise footlet medium jacks 2
CHuE153: Rise footlet medium jacks 3
CHuE177: Selector up colour 6
CHuE195: Stop raise medium jacks ladderproof closing
CHuE104: Lowering needles colour 1
CHuE105: Lowering needles colour 3
CHuE112: Lowering needles colour 2
CHuE149: Lowering needles colour 4
CHuE180: Stop needle down colour 5
CHuE181: Stop needle down colour 6
CHuE116: Sole splicing cam feed 1
CHuE146: Sole splicing cam feed 2
CHuE147: Sole splicing cam feed 3
CHuE148: Sole splicing cam feed 4
CHuE150: Sole splicing cam
CHuE174: Feed 2 sole reinf posn.A
CHuE175: Feed 3 sole reinf posn.A
CHuE176: Feed 4 sole reinf posn.A
CHuE157: Stop open palette
CHuE194: Latch closer stop
CHuE183: Stop Dial jacks enter 1
CHuE184: Stop Dial jacks enter 2
CHuE185: Stop Dial jacks partial enter 1
CHuE186: Stop Dial jacks partial enter 2
CHuE187: Stop Dial jacks exit 1
CHuE188: Stop Dial jacks exit 2
CHuE189: Stop Dial jacks enter for pattern 2
CHuE300: Cylinder locking piston
CHuE303: Cylinder knit pusher DOWN
CHuE304: Cylinder knit pusher UP
CHuE305: Pickup piston in
CHuE306: Pickup piston out
CHuE307: Pin holder knit pusher

CHuE308: Sewing device roller forward
CHuE309: Sewing device roller backward
CHuE310: Sewing device yarn
CHuE311: Pin holder unit rotation lever
CHuE312: Pin holder unit rotation prox. switch
CHuE313: Pin holder
CHuE314: Turning device locking piston down
CHuE315: Turning motor HIGH lim. switch not reached
CHuE316: Knit transfer piston down
CHuE317: Knit transfer piston up
CHuE318: Top turn. roller tube locking cam blocked
CHuE319: Top turn. roller tube locking cam released
CHuE320: Internal knit raising tube
CHuE321: Sock present photocell
CHuE322: Sock present control rod at zero
CHuE331: Sock present control rod working
CHuE327: Sewing device cutter
CHuE333: Pickup arm motors not resettable automatically
CHuE328: Mov. of angle pickup arm obstructed
CHuE329: TOP turning device piston blocked UP
CHuE330: TOP turning device piston blocked DOWN
CHuE332: Top turning device guards open
CHuE334: Sock stretching sector position 0
CHuE335: Sock stretching sector position 1
CHuE340: Vertical pickup arm motor position
CHuE325: Sew. Dev. stop button pressed or sew.dev.error
CHuE342: Barrier obstructed
CHuE341: Pin feed motor: prox.zero out of tol. [Fn+T]
CHuE323: Max number of turning movements exceeded
CHuE336: Sock sewing procedure time too long
CHuE343: Timeout of error reception from stepping motor
CHuE326: Sewing device setup data not complete
CHuE302: Pin holder unit rotation position calibration
CHuE301: First pin posn. calibration
CHuE339: Calibrate lever out posn. of pin holder unit rotation
CHuE337: Calibrate angle pickup arm Onboard mach.pos.
CHuE338: Cylinder angle position calibration
05: Cylinder locking piston not in position Not engaged
06: Cylinder locking piston not in position Not disengaged
07: Cylinder knit pusher not in position. Not down
08: Cylinder knit pusher not in position. Not up
09: Pickup piston not in position. Not out
10: Pickup piston not in position. Not in
11: Internal knit raising tube not in position. Not up
12: Internal knit raising tube not in position. Not down
13: Knit transfer piston not in position Not up
14: Knit transfer piston not in position Not down
15: Pin hold knit pusher not in position Not down
16: Pin hold knit pusher not in position Not up
17: Pin holder unit rot. lever not in position Not forward
18: Pin holder unit rot. lever not in position Not reversed
19: Sewing device roller not in position Not forward
20: Sewing device roller not in position Not reversed
21: Sewing device cutter not in position Not closed
22: Sewing device cutter not in position Not open
23: Up turning dev.piston not in position Not down
24: Up turning dev.piston not in position Not up
25: Up turning device tube locking cam not in position.Does NotRelease
26: Up turning device tube locking cam not in position. Does not block
27: Down turning device locking piston not in position. Does not block
28: Down turning device locking piston not in position. Does not block
29: Sock stretching sect. not in position. Not closed
30: Sock stretching sect. not in position. Not open

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44: Sock present control rod onboard machine
45: Sock present control rod onboard machine not at zero
32: Mobile pin unit not in position. Not closed
33: Mobile pin unit not in position. Not open
56: Vertical pickup arm position
35: Up turning dev.motor not in end-of-stoke position
38: Pin holder unit rotation motor has not rotated correctly
36: Up turning dev.motor not reached proximity zero
39: Pin holder unit rotation motor not in zero position
40: Shutter valve motor not in zero position
41: External CT shutter valve motor not to zero
47: Down turning device inclin. motor not to zero
37: Down turning device inclination motor movement not executed
31: Angle pickup arm motor has lost steps. Encoder offset [Fn+G]
57: angle pick-up device arm position [Fn+F0]
42: Down turning device motor has lost steps. Encoder offset [Fn+B]
42a: Turning device motor down has lost steps. [Fn+R]Repeat[Fn+B]Rest.
49: Vertical pickup arm motor has lost steps. Encoder offset [Fn+V]
34: Up turning dev.motor has exceeded number of stretching movements
54: Sock seaming phase time too long
02: SEWING DEVICE RESET ACTIVATED
03: Manually lower the yarn finger plate
04: Machine ready Take away phase stop Run de machine
60: Press the machine run button to continue
61: Press the sewing start button to continue
62: Seaming device STOP button pressed
52: Manually remove sock from pickup units
53: Manually cut seaming fabric
55: Sock presence photocell. Manually adjusts sock
58: Reverser tube not in correct position Unhook it manually
63: Angle pickup arm motorvv movement obstructed
65: Up turning device guards open
66: Barrier obstructed
64: Sewing yarn broken
48: Yarn finger plate not in position
50: Generic error on motors
51: Sock ejection failed
59: No phase
```

Messages on problems in the Software Management

Ch1: RILINK FUNCTION 30

This error appears when there iss a problem on the “LINK” of a function of type 30.
This problem is probably due to a software failure, and it is supposed it will never be displayed to the user.

Notice

Attention

Contact Lonati technical staff for further information and for an eventual Software update.

Ch6: Full Tab limit speed not accepted

This alarm appear when in the Codified Program are present too many speed limits, such as to fill the proper table.
This alarm indicates incompatibility between the programming software (GRAPHITRON) and the machine software (Eproms).

- The solution, depending on the case, is to update the machine software (Eproms) or the GRAPHITRON software.

Other causes for this problem may be the machine software or programming software not valid because damaged or containing a mistake.

- Also in this case, the solution is to run the software update with a valid and compatible version.

Notice

Attention

Contact Lonati technical staff for further information and for an eventual Software update.

Ch7: Config. dial wrong or nonexistent

This alarm appear when in the Codified Program is set a number of needles different from the “Cut” (Number of Dial Jacks) provided for the Dial set in the machine software.
The cause of this problem may be a machine software (Eproms) not updated.

- The solution, depending on the case, is to update the machine software (Eproms) or the GRAPHITRON software.

Other causes for this problem may be the machine software or programming software not valid because damaged or containing a mistake.

- Also in this case, the solution is to run the software update with a valid and compatible version.

Notice

Attention

Contact Lonati technical staff for further information and for an eventual Software update.

Messages on the Dial and Dial jacks management

Ch3: Dial out Position

Sensor input:
Pcb_3759 J14 p03
Command output:
G44J: B16 e1 — G54JOT: B1 e3 — G615: B2 e7 — G615D: B2 e7 — G616: B16 e7 — G616D: B16 e7 — G61Q: B1 e5 — G624: B1 e7 — G626: B1 e3 — GL-544: B1 e7

The input board for this signal is Pcb_3759.

These errors are related to the movement of the not motorized Raiser/Lower Dial device, determined by the command that arrives to the relative Solenoid valve.
For this device is present a control input.
A sensor properly positioned check the condition of Dial Down.
To each movement downwards or upwards of the Dial, after a certain time (timeout) the software check that the sensor is in the proper reading status.

When the Dial is Down (Solenoid valve de-energized) the control sensor is in a reading status.
In this condition the control contact is closed on the Ground.
The inputs Autotest therefore displays the value “1”.

When the Dial is Up (Solenoid valve energized) the control sensor is not in a reading status.
In this condition the control contact is open on the Ground.
The inputs Autotest therefore displays the value “0”.

Error control

It is always advisable try to cancel the error visualized on the Display by pressing the [F8] key, so testing if it’s still active.
At this point we will have two possibilities:

1. The error is cancelled and the machine resumes its functioning.
2. The error is not cancelled, and the machine is blocked with the error displayed.

1st case: the error is cancelled with the [F8] key

This type of error not persistent must not be understimated, as it indicates an anomalous movement of the mechanical device (too delayed).
The error is displayed because the mechanical device, altough it's in the right position, carried out the movement in too much time.
Proceed as follows to solve the problem:

- Check that the movement of the device is not slowed down or blocked by mechanical obstacoles.
- Check that the internal compressed air ducts of the mechanical device are not blocked and/or clogged.
- Check that the external compressed air ducts (tubes) are not blocked and/or clogged.
- Check that the pneumatic part of the Solenoid valves is no blocked and/or clogged, or mechanically damaged.

2nd case: the error is not cancelled with the [F8] key

Should the error not be cancelled, means that the mechanical part concerned shall not be in the right position, or the sensor or the electronic boards has not detected correctly the new position of mechanical part.
Proceed as follows to solve the problem:
Visually check the position taken by the mechanical part concerned the movement.

A If the mechanical part is not in the right position proceed with the point:

Mechanical device out of position

Should the mechanical device actually be out of position, there are two possible types of problems:

1. *Mechanical problem*

   The mechanical device's movement is blocked, or the Solenoid valve, even though it's properly activated, does not allow the passage of the compressed air toward the exit.

   - *Check that the movement of the mechanical part can be carried out without problems.*
     Therefore, if necessary, replace the Solenoid valve concerned.

2. *Electric or electronic problem*

   The failed movement is due to lack of compressed air from the Solenoid valve.

   - *Replace the Solenoid valve concerned.*
   - *Replace the Output board corresponding to the command.*

B If the mechanical part is in the right position proceed with the point:

Mechanical device in right position

If the mechanical part concerned is in the right position, the control sequence was carried out correctly.
Therefore, also the corresponding Solenoid valve functions properly.
The problem may be caused by position sensor that has not found the new position.

- *Check the correct adjustment of the position sensor, and possibly replace it.*
- *Check the connecting cables between the sensor and the inputs board.*
- *Replace the Input board.*

Ch4: Clear dial jacks

This error is caused by a specific action carried out by the operator, which may endanger the mechanical integrity of the machine.
He has raised the Dial unit and put on rotation the cylinder with the Sock Cycle in condition of "Welt".
This operation is not correct, to avoid mechanical damage must be carried out a particular manual zeroing.
This error indicates the user for the procedure to be run out of this situation.

- The operator must manually disengage the not completed Sock from the Dial, evetually using an adequate caliper.
- Then end the operation of release using the [Mechanical Handle].

Messages on the Sock exit

CHuE01: Sock not ejected

Sensor input:	Pcb_2008 J26	
Signalling Led	Pcb_2008 Ds31	

This error informs the user that, in the Sock Cycle segment between the command (code) “Sock passage enabling” and the command (code) “Sock passage control” the software has not received the produced Sock ejecton signal through the relevant device placed on the “Sock output Tube”.
This signal, entering in the Pcb_2008 board, is visualized through the lighting for a time of about 1 or 2 seconds of the relevant Led.
The control device on the tube is comprised of an infrared ray emitter photodiode (lamp simulation) with a light-sensitive phototransistor in front of it.
The sensor (Phototransistor) is placed opposite the light, when passes the Sock it is momentarily darkened and then sends the signal of Sock Passage to the input board.

In case of error check if the “Sock passage” signal arrives correctly to the input board.

If this happens:

- *Check that the Sock passage takes place during the part of the Sock Cycle between the programming of the 2 codes (Enable and Control).*
  A programming error or a faulty release of the sock can cause this error.
- *Replace the board Pcb_2008.*

Otherwise:

- *Check the integrity and the connection of the cable between the Sock passage control device and the input board.*
- *Replace the Sock Passage control device.*

CHuE07: Stop open bell

Sensor input:
Pcb_3759 J11 p14

The input board for this signal is Pcb_3759.

This error mainly indicates the lack of sufficient suction in the Sock construction Tube.
In the condition of “Vacuum Valve” in suction the closure of the Sock ejecton device (“Sock ejection hood”) is maintained by this suction.
A contact on the device performs this control.
Through a cable is trasmitted this stop signal to the machine.
This cable also includes a wire that bring properly the Ground (0 Vdc) to the device.

The correct condition (stop not active) is:
”contact open”
With stop not active, the inputs Autotest displays the value “0”.
With stop active, the inputs Autotest displays the value “1”.

In certain conditions the “Vacuum Valve” is programmed to close the suction (for example during the “Welt” construction and during the Sock expulsion).
The user should disable the control of this error in the chain steps in which the “Vacuum Valve” does not suck.
Otherwise the software, noting the “contact closed”, would stop the machine with this error.
A typical situation in which may appear this error is in response to a sequence of non expulsions of the produced sock.
These socks fill the Tube of expulsion, up to prevent the proper closing of the device, with consequent displaying of this error.

In case of error first check if has been intervened the control device (real error).

- Solve the real problem that has caused the error.

If the control device has not intervened, check the regulation and setting and then proceed as follows.

With error active (non-erasable with [F8] key), access to Inputs Autotest.
Press the [CTRL] + [B] keys in the error window.

If the Inpurs Autoest displays the value “0”:

- *Replace the Input board.*

If the Inpurs Autoest displays the value “1”:

If air suction is not present on the device:

Given these conditions:

- *Check the correct programming of the enabling codes for this control, assuming in this case the correct position of the "Vacuum Valve".*
- *Check the correct position of the "Vacuum Valve", assuming in this case that it should be in position to determine the suction from the device.*

If air suction is present on the device:

Given these conditions:

- *Check that no cause prevent the correct closure of the device.*
- *Check the wiring between the control device and the input board.*
- *Replace the Input board.*

Notice

Attention

If the wire that connects the inputs board to the control device was rough or however interrupted, the error would never appear, then the machine would work without this control.

Messages on electronic/electric devices

CHuE02: Lack of power phase

Signal generation:	Pcb_3787B/1	
Signal path:	Pcb_3787B/1 J03 p01	Pcb_3812 J06 p06
Signal path:	Pcb_3812 J06 p01	Pcb_2008 J16 p02
Signal input:	Pcb_2008 J16 p02	
Signalling Led	Pcb_2008 Ds2	

This error appears when is detected the lack of at least one of the 3 phases of the three-phase line (Vac) for the power of the machine.
The three-phase 220 Vac voltage outgoing by the power autotransformer comes in, among other, on the Pcb_3787B/1 board, which detects a possible lowering of this three-phase tension.
This signal then, through the Pcb_3812 board arrives finally to the Pcb_2008 board.
In normal conditions, the proper signalling Led is ON.
When a signal of "Phase missing" arrives, for example in the case of "Line voltage" not correct, the Led becomes OFF.

Proceed as follows to solve the problem:

- Check the presence of the "Line Phases" in entry to the Electronic Equipment ("Main switch").
  If missing, intervene on the external three-phase line for the power of the machine.
- Check the "line phases" connecting cables between:
  Main switch - Power Autotransformer - Interface board D4840496 - Board Pcb_3787B/1.
- Check this signal connecting cables between:
  Board Pcb_3787B/1 - Board Pcb_3812.
  Board Pcb_3812 - Board Pcb_2008.
- Check the status of the fuses placed on the power Interface board D4840496.
- Replace the board Pcb_3787B/1.
- Replace the board Pcb_3812.
- Replace the board Pcb_2008.

Interaction between "Missing Phase" management and Black-out procedure

Blackout Signal		
Signal generation:	Pcb_3812	
Signal path:	Pcb_3812 J06 p03	Pcb_2008 J16 p03
Signal input:	Pcb_2008 J16 p03	
Signalling Led	Pcb_2008 Ds3	

The “Missing line phase” signal quickly detected, should the machine be functioning (a Sock cycle is underway), is necessary to activates the “Black-out procedure”.
After 4 seconds with a “Missing Phase” the Pcb_3812 board sends the Pcb_2008 board a “Black-out” signal displayed by the lighting of the relevant Led.
This signal causes the real start of the “Black-out procedure”.
This procedure allows the saving of the Sock Program data of its position before the Turning off determined by the tension absence.
Of course, this procedure is carried out correctly only if are present and operating the “Black-out batteries” B1 B2 (2 batteries 12vdc – 1, 1 ah) that will maintain stable for about 8 seconds, the tension 24 Vdc, and consequently, the other logic tensions (5 Vdc and +/-15 Vdc), in order to allow the software the data recovery.
When the Vac line tension will be restored (practically a Turning on) the machine will have maintened the data relating the active Program.
By Restart the machine it will continue the production of the current Sock.

In the case of Black-out procedure not ended successfully, for example because the batteries were defective, to the Line Tension restoration the machine will have lost the working data for the active Program.
Thus, the Sock Program will zeroed (electronic chain at the End of Cycle step).
This could cause problems in the restoration of the mechanical operation conditions.

Problem: machine blocked for “Black-out” always active

In case of “Black-out” procedure active with Power Three-phase Line correct, the software runs the data saving and then stays waiting for the machine Turning off.
But since the Three-phase tension is correct, Turning off doesn’t happen.
In this particular condition, the machine stays waiting, not allowing the user none aboard the machine.
The user must Turn off and then Turn on the machine.

If the problem remains (Black-out signal active with Line Vac voltage correct) the machine stays indefinitely in this condition.
A problem of this type may be caused by defective boards and the wiring between the 2 boards (limited the signals of “Missing Phase” and “Black-out”.

- Check this signal connecting cables between:
  Board Pcb_3787B/1 - Board Pcb_3812.
  Board Pcb_3812 - Board Pcb_2008.
- Replace the board Pcb_3787B/1.
- Replace the board Pcb_3812.
- Replace the board Pcb_2008.

In case of lack of a single Line Phase, the power supply board Pcb_3787B/1 is able to keep the correct logic tensions (24 VDC and tensions derived), but actives in any case the Black-out procedure.
The machine therefore remains blocked awaiting for the machine Turning off.

- The user First must therefore solve the problem of “Missing Phase”.
  Check back the presence of the Line Phases as already explained above.

Reference

For information on the “Black-out” procedure see the section:
Blackout Procedure

CHuE03: Alarm driver motor board

Signal generation:	Motor Drive board	
Signal input:	Pcb_2008 J46 p06	

This error informs the user that the Motor Drive board has dtected a malfunctioning and sent a warning signal to the Pcb_2008 board.
With stop not active, the inputs Autotest displays the value “1”.
With stop active, the inputs Autotest displays the value “0”.

This error determines different behaviour depending on the type of Motor Drive board mounted by the machine.
The Motor Drive boards mounted can be of 2 types, RUNNER and ECODD15.
The following explanation are divided into more chapters, each on a type of Motor Drive board.

Machine equipped with the “Motor drive control” board of the type RUNNER

The operating status of the RUNNER Drive motor board is shown on the Display (7 segments) present on the board.
In normal conditions of functioning is shown in sequnce the writing “r-XX”, were “XX” indicates the version of the sof-twrae installed on the Drive motor board.
In conditions of defected functioning is shown in sequnce the writing “Er-YY”, were “YY” indicates the type of defected event occurred.
The disabling of the motor, in case of alarm from the Drive motor board, has been demanded to the machine software, at the time it receives the alarm signal.
The management of the alarms of the Drive motor board is such that it is always viewed (on the 7 sements Display) the first alarm occurred.
When the machine is turned off the alarm is memorized to then be shown to the next turning on.
In this case, when the machine is turning on is shown the writing “r-XX” for a single time, which will follow the writing “”LE” (Acronym of Last Error) followed by the memorized alarm (“LE-YY”).
This allows the user to be able to verify the type of alarm found by the Drive motor board, also after turn off the machine.
In fact, in normal conditions of functioning, in order to access visually to Drive motor board it is necessary turn off the machine to eliminate momentarily the protective casing.

Attention

This operation must be carried out by staff technically entitled to electric maintenance, as, eliminated the protections, become accessible electrical parts in tension.

In case the alarm is not present, once the march is enabled the writing “r-XX” reappears, that indicates the return to normal operation.

The alarms have a management called “latched”, as soon a defected event occurs the Drive motor board displays the associated errors and keeps active until the reset of the board (turning offand turning on of the machine).
It’s an exception the alarm “Internal tension Er-06”; in this case the Drive motor board manages the alarm only until the defected event disappears.
If this alarm is no longer found is sufficient press [F8] to eliminate the error, the machine back in in normal conditions of operation.
In this case a momentaniously decline of the Line Tension doesn’t compromise the machine functioning (the user is not obliged to turn off the machine).

Below are listed the alarms foreseen and is given a short description on their meaning and on their management by the board:

Er-01	Brake fuse interrupted. The alarm is not latched and doesn’t disable the motor.
Er-02	Overheating of the Drive motor board above the limit allowed. The alarm is not latched and doesn’t disable the motor.
Er-03	Overheating of the Motor above the limit allowed. The alarm is not latched and doesn’t disable the motor.
Er-04	Defect in the converter that manages the Resolver. The alarm is not latched and doesn’t disable the motor.
Er-05	Short-circuit on the motor phases, between them, or to potential. The alarm is not latched and doesn’t disable the motor.
Er-06	Defect in the value of the input 3-phase tension or in the value of the internal tension of the supply. The alarm is not latched and doesn’t disable the motor.
Er-07	Defect in the cable of Resolver or of the same. The alarm is not latched and doesn’t disable the motor.
Er-08	Overreached the maximum speed value imposed in the Drive motor board. The alarm is not latched and doesn’t disable the motor. The software stops the motor placing the speed reference to zero until the machine Reset.

Er-09 Enablement of the Drive motor board not allowed during the phasing of the Resolver.
The alarm is not latched and doesn't disable the motor.
Er-10 Rotation contrary to the one imposed.
The alarm is not latched and doesn't disable the motor.
The software stops the motor placing the speed reference to zero until the machine Reset.
Er-12 Intervention of the I2t protection.
The alarm is not latched and doesn't disable the motor.
Er-13 Motion obstructed (the output of the speed PID went in saturation for more than 3 sec.).
The alarm is not latched and doesn't disable the motor.
The software stops the motor placing the speed reference to zero until the machine Reset.
Er-14 Procedure of automatic phasing of the Resolver not correct.
Er-15 E2prom parameters of personalization missing.
Er-16 E2prom parameters of personalization not functioning.
E Microprocessor blocked.
The alarm is latched and the Hardware of the board disables the motor.

In presence of this Drive motor board Stop, if it's not cancelled by pressing [F8], read the code wiewed on the Dispay (7 segments) of the RUNNER Drive motor board.
According to the value read, identify in the table the problem that has caused the error.

- However a regular procedure in case of presence of a Drive motor board Stop is the replacement of the Motor Drive board, because it can always be the cause of the problem.

We now present a few possible situations and so the probably problem at its origin.

Display (7 segments) of the Drive motor board OFF.

- *Check the +/- 15 vDC supply in entry to the conn. J1 of the Drive motor board from the conn. J47 of the board Pcb 2008.*
- *Replace the Motor Drive board.*

Er-06 Shown on the Display (7 segments) of the Drive motor board.

- *Check the 220 Vac supply in entry of the Drive motor board, and however the the 3-phases Line tension in its run.*
- *Replace the Motor Drive board.*

Er-07 Shown on the Display (7 segments) of the Drive motor board.

- *Check the cble from the Resolver (between the Resolver or Motor and the Drive motor board).*
- *Replace the resolver.*
  In case it is contained in the motor, replace the motor.
- *Replace the Motor Drive board.*

Er-12 Shown on the Display (7 segments) of the Drive motor board.

- *Check the mechanical condition of the machine, an excessive resistence to the rotation increases the current provided by the board, going over the limit imposed by the software.*
- *Check the Resolver phase.*
- *Replace the resolver.*
- *Replace the motor.*
- *Replace the Motor Drive board.*

Er-13 Shown on the Display (7 segments) of the Drive motor board.

- *Check an eventual enablement to the movement.*
- *Check the cable relating the Start circuit.*
  In particular the logical signals (reference and enable) between the Pcb 2008 and Drive motor board.
  In particular the power Phases for the command of the Motor: Drive motor board - Motor Contactor - Motor.
- *Check the Resolver phase.*
- *Replace the resolver.*
- *Replace the motor.*
- *Replace the Motor Drive board.*

Display (7 segments) of the Drive motor board in correct condition (no alarm).

- *Check the cable relating the Start circuit.*
  In particular the signal of "Drive motor board Alarm" between the Pcb 2008 and the Drive motor board.
- *Replace the Motor Drive board.*
- *Replace the board Pcb_2008.*

Machine equipped with the "Motor drive control" board of the type ECODD15

CAN line Connection:	Pcb_2008 J23	Ecodd J02

In a time following on the machines is mounted a Motor Drive board of the type ECODD15.
The ECODD15 Motor Drive board is connected through a CAN line with the Pcb_2008 board, and dialogues with it in digital form.
The communication (always present) between these 2 boards, and an appropriate control software has almost eliminated the possibility of the occurrence of this error.
In fact now, any anomaly found by the Motor Drive board is communicated with a code to the machine software which stops the machine with a specific error/alarm on the machine Display.
In these cases (error sent via CAN), this generic error of “Motor Drive alarm” is disabled, otherwise would override the specific error on the machine Display.
The generic alarm Relay present on the Motor Drive board still intervenes and the error signal arrives to the Pcb_2008 board.
The only case in which this generic error may appear is when the CAN line between the Motor Drive board and the Pcb_2008 board is open, discontinued or disturbed.
The 2 boards not communicate, and therefore the ECODD Motro Drive board shall enter into Alarm status activating this line of error, which in this case is not disabled and therefore appears on the machine Display.

In case of the occurrence of this error, proceed as follows:
- Check the correct connections of the CAN cable between the Pcb_2008 board and the Motor Drive board, eventually replacing the cable.
- Replace the Motor Drive board.
- Replace the board Pcb_2008.

Notice

Attention

Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

CHuE04: Battery B1 and B2 out of order

Do not currently managed.

CHuE11: Lack of power 15 VDC positive

CHuE12: Lack of power 15 VDC negative

Signalling Led	Pcb_2008 Ds39	Pcb_2008 Ds36

Voltage +/-15 Vdc is directly created on board Pcb_2008.
The board itself check the presence of these tensions, and in the event of their lack signalizes the error.
The correct presence of these tensions is also reported by the specific Leds present on the Pcb_2008 board.
Leds ON = tension OK

In case of error, the only solution is:
- Replace the board Pcb_2008.

Notice

Attention

The real lack of this tension may be caused by an external situation to the board.
In fact these tensions may also be used by other boards.
Typically the Motor Drive board type RUNNER.
A problem on the external board or on the cable relative (for example a short circuit on the input of this tension) may also create a malfunctioning of the Pcb_2008 board, with appearance of this error.

CHuE93: Lack of tension drums logic

Equipment with Pcb 3868 (1st version).

The control signal is interfaced by the Pcb 3868 board.

Signal generation:	Pcb_3820	
Signal path:	Pcb_3820 conn. J5 pin 01-02	Pcb_3868 conn. J2 pin 01-02
Signal path:	Pcb_3868 conn. J4 pin 06	Pcb_2008 conn. J1 pin 02
Signal input:	Pcb_2008 J01 p02	

Equipment without Pcb 3868 (2nd version).

The control signal reaches directly the Pcb_2008 board.

Signal generation:	Pcb_3820	
Signal path:	Pcb_3820 J06 p01	Pcb_2008 J01 p02
Signal input:	Pcb_2008 J01 p02	

Voltage 5 Viso (pattern drum logic) is created on board Pcb_3820 (pattern drum logic interface board), it is therefore read by the 24VDC supply on the board.
This 5 Viso voltage is then used by the board itself for its operation.
This board is linked to the “Logic Bus” of the Pcb_2007 board (Flat cable), and manages the logic that determines the movement of the Pattern Drums levers (Pattern Drums logic).
The information on the integrity of this tension (control signal) comes out of this board and arrives to the Pcb_2008 board.
The path of this signal is different depending on the Electronic Equipment version and therefore by its equipment (Hardware mounted).

This error is managed whatever the type of Pattern Drum that available on the the machine.

In the event of an error, check that the output voltage of board Pcb_3820 is +5 Viso.

If there isn’t this voltage:

- *Replace the board Pcb_3820.*

If the voltage is correct:

- *Check the wiring of these control signals between the boards previously indicated in the path.*
- *Replace the board Pcb 3868, if present.*
- *Replace the board Pcb_2008.*

CHuE94: Lack of tension drums power

Equipment with Pcb 3868 (1st version).

The control signal is interfaced by the Pcb 3868 board.

Signal generation:	Pcb_3824A/1 / Pcb_3824A/2	
Signal path:	Pcb_3824 conn. J1 pin 01-04	Pcb_3868 conn. J1 pin 01-02
Signal path:	Pcb_3868 conn. J4 pin 04	Pcb_2008 conn. J8 pin 02
Signal input:	Pcb_2008 J08 p02	

Equipment without Pcb 3868 (2nd version).

The control signal reaches directly the Pcb_2008 board.

Signal generation:	Pcb_3824A/1 / Pcb_3824A/2	

Signal path:	Pcb_3824 J03 p02	Pcb_2008 J08 p02
Signal input:	Pcb_2008 J08 p02	

This error is common for both machines equipped with Pattern Drums type “WAC” that equipped with Pattern Drums type “MATRIX”.
The type of boards and checks to be made are however different depending on the type of Pattern Drums.
In the following sections will be exhibited the explanations relating to the various types of Equipment.

The errors refers to machines equipped with Pattern Drums type “WAC”.

Voltage +/-48 Vdc (pattern drum power) is created on supply board Pcb_3824A/2, it is therefore read by the 220 Vac supply on the board.
This tension is used for the functioning of Pattern Drums of the type indicated.
This voltage, properly sent to the heads of the Ceramic, determines the movement of the Lever associated.
The information on the integrity of this tension (control signal) comes out of this board and arrives to the Pcb_2008 board.
The path of this signal is different depending on the Electronic Equipment version and therefore by its equipment (Hardware mounted).

This error is managed whatever the type of Pattern Drum that available on the the machine.

In the event of an error, check that the output voltage of board Pcb_3824A/2 is +/- 48VDC.
If there isn’t this voltage:
- *Replace the board Pcb_3824A/2.*

If the voltage is correct:
- *Check the wiring of these control signals between the boards previously indicated in the path.*
- *Replace the board Pcb 3868, if present.*
- *Replace the board Pcb_2008.*

The errors refers to machines equipped with Pattern Drums type “MATRIX”.

Voltage +/-100 Vdc (pattern drum power) is created on supply board Pcb_3824A/1, it is therefore read by the 220 Vac supply on the board.
This tension is used for the functioning of Pattern Drums of the type indicated.
This voltage, properly sent to the heads of the Ceramic, determines the movement of the Lever associated.
The information on the integrity of this tension (control signal) comes out of this board and arrives to the Pcb_2008 board.
The path of this signal is different depending on the Electronic Equipment version and therefore by its equipment (Hardware mounted).

This error is managed whatever the type of Pattern Drum that available on the the machine.

In the event of an error, check that the output voltage of board Pcb_3824A/1 is +/- 100VDC.
If there isn’t this voltage:
- *Replace the board Pcb_3824A/1.*

If the voltage is correct:
- *Check the wiring of these control signals between the boards previously indicated in the path.*
- *Replace the board Pcb 3868, if present.*
- *Replace the board Pcb_2008.*

CHuE190: Contactor not in position

The machine software always checks the status of the Motor Contactor TL1, in order to intervene with errors and alerts in case of anomalies.
The coherence control is executed verifying always the status of the auxiliary contact of the Motor Contactor TL1, and comparing it with the status expected by the software.
If the comparison gives as result in an incoherence data, the machine displays this error.

Practically, with the appropriate times and adjustments, the control software is:
A. With machine in running the auxiliary contact of the Contactor must be closed.

B. With machine stopped the auxiliary contact of the Contactor must be open.
In case this does not happen, is get this position error.

Proceed as follows to solve the problem:
- Replace the motor Contactor TL1.
- Replace the board Pcb_2008.

CHuE14: Suction fan main switch

Signal input:
Pcb_2008 J27 p06
Command output:
Pcb_2008 J27 p09

The input board for this signal is Pcb_2008.

In the case of machine prepared with the Suction Fan, on the external Vac Line (Power) for the Suction Fan is mounted a device which is a Contactor and a Thermal Relay.
Also in the machine Setup must be enabled the functioning of the external Suction Fan.
The line Three-phase tension used for the Fan power, after the passage in the D4840496 board (Power interface) arrives to this device.
When the Fan is enabled a 24 Vdc command arrives to the Contactor coil, allowing the closure of the contacts and the passage of the tension.
The Thermal Relay is a protection for maximum current, must be adjusted to the maximum current consumption allowed in the Fan compared with the supply voltage (Three-phase line).
When occurs the current protection (Thermal relay), the Contactor is disengaged and the Fan remain without power.
At the same time a contact of the Fan Contactor inhibits to the control signal of this error the arrival to the inputs board (input stop), causing the appearance of the error.

With Fan enabled by Setup, the values in the Inputs Autotest must be:
With stop not active, the inputs Autotest displays the value “1”.
With stop active, the inputs Autotest displays the value “0”.

With Fan disabled by Setup, the value shown in the Inputs Autotest is meaningless (however is “0”), since even the management of this stop is disabled.

When the Fan is disabled by Setup, this error should not appear.
If it should appear:
- Check the Setup configuration.
  Eventually performing the Reset of the Setup and proceed with a new configuration.
- Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Instead, when the machine is prepared with Fan the functioning is enabled by Setup.
If the Inpurs Autoest displays the value “1”:
- *Replace the Input board.*

If the Inpurs Autoest displays the value “0”:
If is intervened the Thermal Relay.
Proceed as follows:
- *Check if the adjustment of the relay is in accordance with the absorption indicated for the Three-phase tension.*
- *Check the real absorption of the Fan, it must not exceed the permitted in conditions of correct working.*
  This greater absorption for example, may be due: to rotating blocked, to the presence of dirt inside the air tubes, to the electric coils damaged by the high temperature, to the suction blocked with a consequent increase in temperature, etcetera.
- *Make sure the functionality of the Fan, removing any causes of damage.*
- *Replace the thermal relay, may be faulty.*

In all these cases, removed the cause of the problem:
- *Restore the Thermal Relay by pressing the proper button on the Relay itself.*
  The device should return in a correct condition.

If is not intervened the Thermal Relay.

Check the presence of the 24 Vdc command in arrival to the Contactor coil.

In positive case.

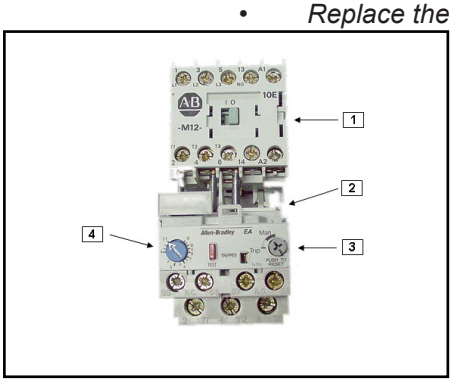
The condition is correct, therefore:

- *Replace the device: Contactor + Thermal relay.*
- *Check the wiring between the Contactor and the control board.*
- *Replace the Input board.*

In negative case.

The condition is wrong, therefore:

- *Check if the Contactor coil has been successfully configured during the last operation of "Serial outputs acquisition".*
  Otherwise press the restoration (Reset) button of the Relay and repeat a new operation of "Serial outputs acquisition".
- *Check the wiring between the Contactor and the control board.*
- *Replace the Input board.*



Legend

- [1]: Contactor
- [2]: Thermal Relay
- [3]: Release Current adjustment
- [4]: Reset button

Notice

Note

An error of this type could also appear in the event of problems relating to the "I/O Serial Line", of course the machine must be prepared for the Fan.
The user can see this particular situation, when, in addition to this error is displayed in contemporary an error on "Load not connected or Short-circuit".
In this case refer to chapters on the resolution of problems relating the "I/O Serial Line".

Reference

Furthers informations are available in :
GUIDE OF USER INTERFACE
1 External fan

CHuE27: Stop turning device fan thermic

Signal input:
Pcb_2008 J27 p06
Command output:
Pcb_2008 J27 p09

The input board for this signal is Pcb_2008.

In the case of machine prepared with the Suction Fan, on the external Vac Line (Power) for the Suction Fan is mounted a device which is a Contactor and a Thermal Relay.
Also in the machine Setup must be enabled the Turning device management.
The line Three-phase tension used for the Fan power, after the passage in the D4840496 board (Power interface) arrives to this device.
When the Fan is enabled a 24 Vdc command arrives to the Contactor coil, allowing the closure of the contacts and the passage of the tension.
The Thermal Relay is a protection for maximum current, must be adjusted to the maximum current consumption allowed in the Fan compared with the supply voltage (Three-phase line).
When occurs the current protection (Thermal relay), the Contactor is disengaged and the Fan remain without power.

At the same time a contact of the Fan Contactor inhibits to the control signal of this error the arrival to the inputs board (input stop), causing the appearance of the error.

With Turning device management enabled by Setup, the values in the Inputs Autotest must be:
With stop not active, the inputs Autotest displays the value “1”.
With stop active, the inputs Autotest displays the value “0”.

With Turning device management disabled by Setup, the value shown in the Inputs Autotest is meaningless (however is “0”), since even the management of this stop is disabled.

When the Fan is disabled by Setup, this error should not appear.
If it should appear:

- Check the Setup configuration.
  Eventually performing the Reset of the Setup and proceed with a new configuration.
- Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Instead, when the machine is prepared with Fan the functioning is enabled by Setup.

If the Inpurs Autoest displays the value “1”:

- *Replace the Input board.*

If the Inpurs Autoest displays the value “0”:

If is intervened the Thermal Relay.

Proceed as follows:

- *Check if the adjustment of the relay is in accordance with the absorption indicated for the Three-phase tension.*
- *Check the real absorption of the Fan, it must not exceed the permitted in conditions of correct working.*
  This greater absorption for example, may be due: to rotating blocked, to the presence of dirt inside the air tubes, to the electric coils damaged by the high temperature, to the suction blocked with a consequent increase in temperature, etcetera.
- *Make sure the functionality of the Fan, removing any causes of damage.*
- *Replace the thermal relay, may be faulty.*

In all these cases, removed the cause of the problem:

- *Restore the Thermal Relay by pressing the proper button on the Relay itself.*
  The device should return in a correct condition.

If is not intervened the Thermal Relay.

Check the presence of the 24 Vdc command in arrival to the Contactor coil.

In positive case.

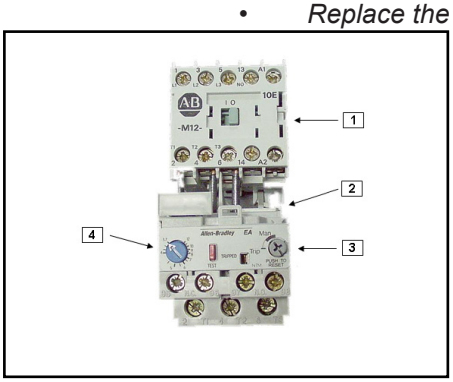
The condition is correct, therefore:

- *Replace the device: Contactor + Thermal relay.*
- *Check the wiring between the Contactor and the control board.*
- *Replace the Input board.*

In negative case.

The condition is wrong, therefore:

- *Check if the Contactor coil has been successfully configured during the last operation of “Serial outputs acquisition”.*
  Otherwise press the restoration (Reset) button of the Relay and repeat a new operation of “Serial outputs acquisition”.
- *Check the wiring between the Contactor and the control board.*
- *Replace the Input board.*



Legend

- [1]: Contactor
- [2]: Thermal Relay
- [3]: Release Current adjustment
- [4]: Reset button

Notice

Note

An error of this type could also appear in the event of problems relating to the “I/O Serial Line”, of course the machine must be prepared for the Fan.
The user can see this particular situation, when, in addition to this error is displayed in contemporary an error on “Load not connected or Short-circuit”.
In this case refer to chapters on the resolution of problems relating the “I/O Serial Line”.

Reference

Furthers informations are available in :
GUIDE OF USER INTERFACE
1 Turning device

Messages on various errors

CHuE05: Lack of air pressure

Sensor input:
Pcb_3759 J11 p12

The input board for this signal is Pcb_3759.

This error is caused by the insufficient compressed air pressure in the pneumatic circuit.
On the pressure gauge place at the entry of compressed air is connected a wire on the mechanical “End Run” of pointer to measuring the pressure.
When the pressure is lowered until the pointer touches the “End Run”.
Through a cable is trasmitted this stop signal to the machine.
The correct condition (stop not active) is:
”contact open”
With stop not active, the inputs Autotest displays the value “0”.
With stop active, the inputs Autotest displays the value “1”.

In case of error first check if has been intervened the control device (real error).
- Solve the real problem that has caused the error.

If the control device has not intervened, check the regulation and setting and then proceed as follows.

With error active (non-erasable with [F8] key), access to Inputs Autotest.
Press the [CTRL] + [B] keys in the error window.
If the Inpurs Autoest displays the value “0”:
- *Replace the Input board.*

If the Inpurs Autoest displays the value “1”:
- *Check the air pressure level and eventually restore it.*
- *To facilitate the failure search, disconnect the control wire from the device.*

If the error is cancelled by pressing the [F8] key the device is defective.
- *Proceed to the repair or replacement of the device.*
  Eventually replace the Group of the Air pressure gauge.

If the error remains.
- *Check that the wire in its path between the device and the inputs board is not to ground.*
  In the case, operate the repair or replacement of the wire.
- *Replace the Input board.*

Notice

Attention

If the wire that connects the inputs board to the control device was rough or however interrupted, the error would ne-

ver appear, then the machine would work without this control.

CHuE06: Stop handle

Sensor input:
Pcb_2008 J29 p01
Command output:
G44J: в6 e6 — G54JCT: в9 e4 — G54JOT: в10 e4 — G615: в8 e5 — G615D: в8 e5 — G616: в8 e7 — G616D: в8 e7 — G61Q: в7 e6 — G624: в12 e8 — G626: в6 e6 — GL-544: в6 e1 — GL-544CT: в9 e2 — GL-615: в8 e7 — GL-616: в8 e7 — GL-616D: в8 e5 — GL-61QCT: в11 e7 — GL-615CTE: в11 e3 — GL-616DCTE: в13 e7

The input board for this signal is Pcb_2008.

An introduction, in the machines is available a “Mechanical Handle” which allows the rotation of the Cylinder.
It may be inserted (enabled) only with machine stopped.
When the machine running the Mechanical Handle must be desengaged by rotation gears.
A Solenoid valve commands a device that engage (enable) this “Mechanical Handle”.
The software, automatically, with a proper command to the Solenoid valve, prevent the engage of the Mechanical Handle when the machine is in motion.
When the Solenoid valve is de-energized the Mechanical Handle is not inserted (not engaged).
With Mechanical Handle enabled, any command of running as a priority performs the disabling of the Mechanical Handle, only after the machine can begin the movement.
With machine stopped, automatically the Solenoid valve is energezid for the engage command of the Mechanical Handle.
This automatic enabling of the Mechanical Handle does not take place in the blocks (Zone) of “Heel” and “Toe” (i.e. in alternate motion).
To the contact placed on the Piston engaging the Mechanical Handle is connected a wire that brings the signal on the Handle status to the inputs board.

The Input Autotest, depending on the condition must display these values:
Mechanical Handle engaged (only with machine stopped): Autotest = “0”.
Mechanical Handle not engaged (always with machine in movement): Autotest = “1”.
The control of the Mechanical Handle is performed in all the conditions of the machine (stopped and in motion).
With machine stopped, the Mechanical Handle must always be engaged (autotest = “0”).
Otherwise appears this error.
With machine in motion, the Mechanical Handle must always be desengaged (autotest = “1”).
Otherwise appears this error.

The identification of the problem cause therefore depends by the machine status (Motion condition and status of Handle enabling).

Error presence with machine stopped and Mechanical Handle enabled (manual command active).

If the Inpurs Autoest displays the value “0”:
- *Replace the Input board.*

If the Inpurs Autoest displays the value “1”:
Check if the tube (pipe) arriving to the command Piston of the Mechanical Handle has compressed air.
In positive case.
The condition is correct, therefore:
- *Check the functionality of the mechanical device and the status of the error contact. It should not be to Ground.*

In negative case.
The condition is wrong, therefore:
- *Check if the tube is obstructed.*
- *Replace the Solenoid valve concerned.*
- *Replace the Output board corresponding to the command. It is placed under the solenoid valve.*

Presence of the error with machine stopped and Mechanical Handle disabled or with machine in motion.

If the Inpurs Autoest displays the value “1”:
- *Replace the Input board.*

If the Inpurs Autoest displays the value “0”:

Check if the tube (pipe) arriving to the command Piston of the Mechanical Handle has compressed air.

In negative case.

The condition is correct, therefore:
- *Check the functionality of the mechanical device and the status of the error contact. It should not be to Ground.*
- *Check the wiring between the control device and the input board.*
- *Replace the Input board.*

In positive case.

The condition is wrong, therefore:
- *Replace the Solenoid valve concerned.*
- *Replace the Output board corresponding to the command. It is placed under the solenoid valve.*

Notice

Attention

With machine in motion or stopped without Mechanical Handle enabled through manual command, in case of control wiring disconnected, this error is always active.

CHuE09: CAUTION: CYLINDER CARTERS OPEN

Machines equipped with board Pcb_2008 first version

Sensor input:	Pcb_2008 J11 p01	
Signalling Led	Pcb_2008 Ds19	

Machines equipped with board Pcb_2008 version A and subsequent

Sensor input:	Pcb_2008 J55 p01	
Signalling Led	Pcb_2008 Ds19	

This message appears when at least one of the control contacts of the “Doors” for the rotation cylinder area protection is open.
With this message active is only possible the use of [Mechanical Handle].
This in order to safeguard the operator in the event of cylinder rotation without protections.
The “doors” cylinder when are inserted in own position clese the serie of contacts, in this way that also only one contact not closed causes the circuit interruption, and therefore the stop of the machine.
The signal (0 Vdc = “doors” closed) through the interface connector reachs the Pcb_2008 board.
The correct condition (stop not active) is:

”contact closed”

With stop not active the appropriate signalling Led must be ON.
With stop not active, the inputs Autotest displays the value “0”.
With stop active, the inputs Autotest displays the value “1”.

When appears this message:
- Check the closing of the contacts where is inserted the the cylinder “doors”.
- Check the connection of the cable to the Interface connector (Modu2 4x2).
- Check the wiring from the interface connector to the board Pcb_2008.
- Replace the board Pcb_2008.

Notice

Attention

Before perform boards replacing, contact the Lonati technical staff for further information.

CHuE154: Emergency button pressed

Emergency Stop Button		
1st Contact N.C. (poles 1 and 2)	Signal input:	Pcb_2008 J05 p29 p30
2nd Contact N.C. (poles 3 and 4)	Signal input:	Pcb_2008 J11 p05 p07

This error appears when during the machine operation is pressed the “Emergency Button” of the machine, that prevents any movement of the main motor.
The signalling “Red Lamp” lights up and this error appears on the machine Display warning the user that is pressed the “Emergency Button”.
Practically the error is a redundant alert (already is ON the “Red Lamp”) which indicates to the user the reason for the stop of the machine.

The appearance of this error can be caused only by the pressure of the “Emergency Button”.
In case this was not happened, proceed as follows:

- Check and eventually replace the “Emergency Button”.
- Check the wiring that connect this device to its input board.
- Replace the board Pcb_2008.

Notice

Note

The pressure of the “Emergency Button” cause an immediate stop of the machine, through inhibition the motion at both hardware and software level.
The “Emergency Button” acts on 2 “N.C.” contacts where is connected the wiring that transmits the signals to the relative inputs board.
The opening of 1st contact of the “Emergency Button” inhibits at hardware level the functioning of any running button (Hardware safety).
The opening of 2nd contact of the “Emergency Button” inhibits at Software level any Cylinder movement (interruption of the logical consensus for the motion).

Messages on the Oil management

CHuE24: Stop lack of oil

Sensor input:
Pcb_2008 J29 p02

The input board for this signal is Pcb_2008.

This error is caused by the lowering of the tank oil level.
A level contact performs this verification.
Through a cable is trasmitted this stop signal to the machine.
This cable also includes a wire that bring properly the Ground (0 Vdc) to the device.
The correct condition (stop not active) is:
”contact open”
With stop not active, the inputs Autotest displays the value “0”.
With stop active, the inputs Autotest displays the value “1”.

In case of error first check if has been intervened the control device (real error).

- Solve the real problem that has caused the error.

If the control device has not intervened, check the regulation and setting and then proceed as follows.

With error active (non-erasable with [F8] key), access to Inputs Autotest.
Press the [CTRL] + [B] keys in the error window.

If the Inpurs Autoest displays the value “0”:

- *Replace the Input board.*

If the Inpurs Autoest displays the value “1”:

- *Check the oil level and eventually restore it.*
- *To facilitate the failure search, disconnect the control wire from the device.*

If the error is cancelled by pressing the [F8] key the device is defective.

- *Proceed to the repair or replacement of the device.*
  Eventually replace the contact or the complete contact device.

If the error remains.

- *Check that the wire in its path between the device and the inputs board is not to ground.*
  In the case, operate the repair or replacement of the wire.
- *Replace the Input board.*

Notice

Attention

If the wire that connects the inputs board to the control device was rough or however interrupted, the error would never appear, then the machine would work without this control.

CHuE191: Oil filter clogs

Sensor input:
Pcb_2008 J28 p06

The input board for this signal is Pcb_2008.

This error is caused by the accumulation of the oil in the oil Filter.
A level contact performs this verification.
Through a cable is trasmitted this stop signal to the machine.
This cable also includes a wire that bring properly the Ground (0 Vdc) to the device.
The correct condition (stop not active) is:
”contact closed”
With stop not active, the inputs Autotest displays the value “1”.
With stop active, the inputs Autotest displays the value “0”.

In case of error first check if has been intervened the control device (real error).

- Solve the real problem that has caused the error.

If the control device has not intervened, check the regulation and setting and then proceed as follows.

With error active (non-erasable with [F8] key), access to Inputs Autotest.
Press the [CTRL] + [B] keys in the error window.

If the Inpurs Autoest displays the value “1”:

- *Replace the Input board.*

If the Inpurs Autoest displays the value “0”:

- *Check the quantity of oil in the Filter and eventually free by the oil the Filter itself.*
- *Check the functionality of the control contact (float).*
  Eventually replace the Contact or the Filter.
- *Check the wiring between the control device and the input board.*
- *Replace the Input board.*

CHuE25: OIL PRESSURE

Sensor input:

Pcb_2008 J29 p03

Command output:

G44J: в6 e7 — G54JCT: в9 e3 — G54JOT: в10 e3 — G615: в8 e6 — G615D: в8 e6 — G616: в7 e8 — G616D: в7 e8 — G61Q: в7 e7 — G624: в12 e7 — G626: в6 e7 — GL-544: в5 e8 — GL-544CT: в9 e3 — GL-615: в7 e8 — GL-616: в7 e8 — GL-616D: в7 e2 — GL-61QCT: в11 e8 — GL-615CTE: в11 e2 — GL-616DCTE: в13 e6

The input board for this signal is Pcb_2008.

In these models, the system of oil pumping is performed through pumped of constant duration, determined by the Sock Program active (GRAPHITRON).

Taking account of the appropriate reaction times can be said that:

A. For all the duration of pumped (Solenoid valve energized), the return signal from the Pressure control device to control must be “0 Vdc”.
The inputs Autotest therefore displays the value “1”.

B. In a rest situation (Solenoid valve de-energized) the return signal from the pressure control device must be absent.
The inputs Autotest therefore displays the value “0”.

The Pressure control device is placed on oil container (Tank).

This error informs the user that the signal of “oil pumped active” was not detected by the software within the expected time, compared to the moment of the pumped activation.

Proceed as follows to solve the problem:

- *Check if there are losses in the oil circuit that does a decrease of pressure.*
- *Check if the Solenoid valve is correctly commanded, and that the air command reaches the oil container (Tank).*
  Otherwise:
  - *Check if the tube is obstructed.*
  - *Replace the Solenoid valve concerned.*
  - *Replace the Output board corresponding to the command.*
    It is placed under the solenoid valve.
- *Check the wiring between the control device and the input board.*
- *Replace the Oil Container (upper part).*
- *Replace the Input board.*

In a rest situation (no pumped active), the software also check that the return signal from the Pressure control device is in the correct status.

Otherwise is displayed the error:

CHuE26

CHuE26: Stop oil depressurization

Sensor input:

Pcb_2008 J29 p03

Command output:

G44J: в6 e7 — G54JCT: в9 e3 — G54JOT: в10 e3 — G615: в8 e6 — G615D: в8 e6 — G616: в7 e8 — G616D: в7 e8 — G61Q: в7 e7 — G624: в12 e7 — G626: в6 e7 — GL-544: в5 e8 — GL-544CT: в9 e3 — GL-615: в7 e8 — GL-616: в7 e8 — GL-616D: в7 e2 — GL-61QCT: в11 e8 — GL-615CTE: в11 e2 — GL-616DCTE: в13 e6

The input board for this signal is Pcb_2008.

In these models, the system of oil pumping is performed through pumped of constant duration, determined by the Sock Program active (GRAPHITRON).

Taking account of the appropriate reaction times can be said that:

A. For all the duration of pumped (Solenoid valve energized), the return signal from the Pressure control device to control must be “0 Vdc”.
The inputs Autotest therefore displays the value “1”.

B. In a rest situation (Solenoid valve de-energized) the return signal from the pressure control device must be absent.
The inputs Autotest therefore displays the value “0”.

The Pressure control device is placed on oil container (Tank).

This error informs the user that at the end of the Oil pumped procedure, or however in a rest situation for the Oil Pump, the return signal from the Pressure control device is not in the correct status.

Proceed as follows to solve the problem:

- *Check if there are situations that determine a failure depressurization of the circuit.*
- *Replace the Oil Container (upper part).*
- *Check the wiring between the control device and the input board.*
- *Replace the Input board.*

In a working situation (pumped active), the software also check that the return signal from Pressure control device is in the correct status.
Otherwise is displayed the error:
CHuE25
CHuE182

CHuE182: Lack of pressure in oil pump

Sensor input:
Pcb_2008 J29 p03
Command output:
G44J: в6 e7 — G54JCT: в9 e3 — G54JOT: в10 e3 — G615: в8 e6 — G615D: в8 e6 — G616: в7 e8 — G616D: в7 e8 — G61Q: в7 e7 — G624: в12 e7 — G626: в6 e7 — GL-544: в5 e8 — GL-544CT: в9 e3 — GL-615: в7 e8 — GL-616: в7 e8 — GL-616D: в7 e2 — GL-61QCT: в11 e8 — GL-615CTE: в11 e2 — GL-616DCTE: в13 e6

The input board for this signal is Pcb_2008.

In these models, the system of oil pumping is performed through pumped of constant duration, determined by the Sock Program active (GRAPHITRON).
Taking account of the appropriate reaction times can be said that:

A. For all the duration of pumped (Solenoid valve energized), the return signal from the Pressure control device to control must be “0 Vdc”.
The inputs Autotest therefore displays the value “1”.
B. In a rest situation (Solenoid valve de-energized) the return signal from the pressure control device must be absent.
The inputs Autotest therefore displays the value “0”.

The Pressure control device is placed on oil container (Tank).

This error informs the user that the signal of “Oil pumped active” was not maintained the sufficient time for the effective lubrication.
The correct signal of “Oil pumped active” was initially detected by software, but it was not maintained for all the time in which the pumped command is remained active.

Proceed as follows to solve the problem:

- *Check if there are losses in the oil circuit that does a decrease of pressure.*
- *Check if the Solenoid valve is correctly commanded, and that the air command reaches the oil container (Tank).*
  Otherwise:
  - *Check if the tube is obstructed.*
  - *Replace the Solenoid valve concerned.*
  - *Replace the Output board corresponding to the command.*
    It is placed under the solenoid valve.
- *Check the wiring between the control device and the input board.*
- *Replace the Oil Container (upper part).*
- *Replace the Input board.*

In a rest situation (no pumped active), the software also check that the return signal from the Pressure control device is in the correct status.
Otherwise is displayed the error:
CHuE26

Messages on yarn accumulation

CHuE19: Stop clean knife 1

Sensor input:
Pcb_3759 J11 p09
Command output:
Rising knife 1 position 2
G44J: в16 e6 — G54JCT: в9 e7 — G54JOT: в8 e7 — G61Q: в1 e6 — G624: в16 e8 — G626: в6 e2 — GL-544: в16 e6 — GL-544CT: в15 e6 — GL-61QCT: в15 e7
Rising knife 1
G44J: в16 e7 — G54JCT: в15 e4 — G54JOT: в16 e4 — G61Q: в2 e1 — G624: в16 e3 — G626: в16 e5 — GL-544: в16 e7 — GL-544CT: в15 e7 — GL-61QCT: в15 e8

The input board for this signal is Pcb_3759.

CHuE96: Stop clean knife 2

Sensor input:
G44J: Pcb_3759 J11 p10 — G54JCT: Pcb_3759 J11 p10 — G54JOT: Pcb_3759 J11 p10 — GL-544: Pcb_3759 J11 p05 — GL-544CT: Pcb_3759 J11 p05
Command output:
Rising knife 2 position 2
G44J: в16 e3 — G54JCT: в9 e8 — G54JOT: в8 e6 — GL-544: в16 e3 — GL-544CT: в15 e3 — GL-616CTE: в8 e3
Rising knife 2
G44J: в16 e4 — G54JCT: в15 e3 — G54JOT: в16 e3 — GL-544: в16 e4 — GL-544CT: в15 e4

The input board for this signal is Pcb_3759.

This error is due to the intervention of the control mechanism for the “knife cleaning” (device for the yarn cutting), determined by the yarn accumulation around to it.
This happens when the yarn is not cut or is not suctioned by the “Air shoe”.
This accumulation causes the failure lowering of the cutting device.
For this reason, the sensor linked to it not reaches its control position, the signal sent to the software does not change status and therefore is get this error.
The device is approaching and away from the control position through commands provided to the relevant Solenoid valves by the Sock Program.
This check (error) is enabled only when is active the cutting device (Knife).
At End of Cycle and in normal working conditions the Knife is low in the cut position.

Through a cable is trasmitted this stop signal to the machine.

Initially the Control Sensor was of the type “Normally Open”.
Subsequently the Control Sensor has become of the type “Normally Closed”.
In the machine Setup therefore is set the type of control sensor.

In case of sensor of control of the type “Normally Closed” (1st type):

The correct condition (stop not active) is:
”contact open”

With stop not active, the inputs Autotest displays the value “0”.
With stop active, the inputs Autotest displays the value “1”.

In case of sensor of control of the type “Normally Open” (2nd type):

The correct condition (stop not active) is:
”contact closed”
With stop not active, the inputs Autotest displays the value “1”.
With stop active, the inputs Autotest displays the value “0”.

In case of error first check if has been intervened the control device (real error).
- Solve the real problem that has caused the error.

If the control device has not intervened, check the regulation and setting and then proceed as follows.

With error active (non-erasable with [F8] key), access to Inputs Autotest.
Press the [CTRL] + [B] keys in the error window.

In case of sensor of control of the type “Normally Closed” (1st type):

If the Inpurs Autoest displays the value “0”:
- *Replace the Input board.*

If the Inpurs Autoest displays the value “1”:
- *To facilitate the failure search, disconnect the control wire from the device.*

If the error is cancelled by pressing the [F8] key the device is defective.
- *Replace the sensor.*

If the error remains.
- *Check that the wire in its path between the device and the inputs board is not to ground. In the case, operate the repair or replacement of the wire.*
- *Replace the Input board.*

In case of sensor of control of the type “Normally Open” (2nd type):

If the Inpurs Autoest displays the value “1”:
- *Replace the Input board.*

If the Inpurs Autoest displays the value “0”:
- *Replace the sensor.*
- *Check that the wire in its path between the device and the inputs board is not interrupted. In the case, operate the repair or replacement of the wire.*
- *Replace the Input board.*

CHuE68: Disable obstructed dial

Sensor input:
Pcb_3759 J11 p16

The input board for this signal is Pcb_3759.

This error is due to the intervention of the control mechanism for the yarn accumulation around the “Dial”.
This happens when the yarn is not cut or is not suctioned by the “Air shoe”.
This accumulation causes the flexing of a “Pin” towards mass (Ground) and therefore the intervention of the error.

Through a cable is trasmitted this stop signal to the machine.
The correct condition (stop not active) is:
”contact open”
With stop not active, the inputs Autotest displays the value “0”.

With stop active, the inputs Autotest displays the value “1”.

In case of error first check if has been intervened the control device (real error).
- Solve the real problem that has caused the error.

If the control device has not intervened, check the regulation and setting and then proceed as follows.

With error active (non-erasable with [F8] key), access to Inputs Autotest.
Press the [CTRL] + [B] keys in the error window.

If the Inpurs Autoest displays the value “0”:
- *Replace the Input board.*

If the Inpurs Autoest displays the value “1”:
- *To facilitate the failure search, disconnect the control wire from the device.*

If the error is cancelled by pressing the [F8] key the device is defective.
- *Replace the sensor.*

If the error remains.
- *Check that the wire in its path between the device and the inputs board is not to ground. In the case, operate the repair or replacement of the wire.*
- *Replace the Input board.*

Notice

Note

This error can be disabled from the Programming of a code in the Sock Program (GRAPHITRON).
In the steps chain in which is programmed the Code this error may not intervene.

Attention

If the wire that connects the inputs board to the control device was rough or however interrupted, the error would never appear, then the machine would work without this control.

Messages on the Flat parts (f.e. jacks) rupture

CHuE20: Stop needles during heel

Sensor input:
Pcb_3759 J14 p02

The input board for this signal is Pcb_3759.

This error is due to intervention of the Needles breakage control mechanism.
Generally the “Pin” of the device goes to impact against the needle bent or broken, during the Cylinder rotation in the “Heel” or “Toe”.
This impact determines a temporary closure to mass (Ground) of the control “Pin” and therefore the intervention of the error.

Through a cable is trasmitted this stop signal to the machine.
The correct condition (stop not active) is:
”contact open”
With stop not active, the inputs Autotest displays the value “0”.
With stop active, the inputs Autotest displays the value “1”.

In case of error first check if has been intervened the control device (real error).
- Solve the real problem that has caused the error.

If the control device has not intervened, check the regulation and setting and then proceed as follows.

With error active (non-erasable with [F8] key), access to Inputs Autotest.

Press the [CTRL] + [B] keys in the error window.

If the Inpurs Autoest displays the value “0”:
- *Replace the Input board.*

If the Inpurs Autoest displays the value “1”:
- *To facilitate the failure search, disconnect the control wire from the device.*

If the error is cancelled by pressing the [F8] key the device is defective.
- *Replace the control device.*

If the error remains.
- *Check that the wire in its path between the device and the inputs board is not to ground. In the case, operate the repair or replacement of the wire.*
- *Replace the Input board.*

Notice

Attention

If the wire that connects the inputs board to the control device was rough or however interrupted, the error would never appear, then the machine would work without this control.

CHuE38: Needles butt

Sensor input:

G44J: Pcb_3759 J11 p05 — G54JCT: Pcb_3759 J11 p05 — G54JOT: Pcb_3759 J11 p05 — G615: Pcb_3759 J11 p04 — G615D: Pcb_3759 J11 p04 — G616: Pcb_3759 J11 p04 — G616D: Pcb_3759 J11 p04 — G61Q: Pcb_3759 J11 p03 — G624: Pcb_3759 J11 p04 — G626: Pcb_3759 J11 p04 — GL-544: Pcb_3759 J11 p10 — GL-544CT: Pcb_3759 J11 p10 — GL-615: Pcb_3759 J11 p04 — GL-616: Pcb_3759 J11 p04 — GL-616D: Pcb_3759 J11 p04 — GL-61QCT: Pcb_3759 J11 p04 — GL-_CTE: Pcb_3759 J11 p04

Command output:

G44J: в2 e7 — G54JCT: в3 e6 — G54JOT: в3 e6 — G615: в3 e2 — G615D: в3 e2 — G616: в3 e2 — G616D: в3 e2 — G61Q: в4 e1 — G624: в3 e1 — G626: в3 e7 — GL-544: в2 e6 — GL-544CT: в3 e3 — GL-615: в3 e2 — GL-616: в3 e2 — GL-616D: в3 e2 — GL-61QCT: в3 e8 — GL-616CTE: в3 e2 — GL-615CTE: в16 e6 — GL-616DCTE: в17 e7

The input board for this signal is Pcb_3759.

This error is due to intervention of the Needles breakage control mechanism.
Generally the “Pin” of the device goes to impact against the Needle, that when is broken, during the Cylinder rotation pass through a track where normally should not go.
This impact determines the stable close to mass (Ground) of the control “Pin” (detector device) and therefore the intervention of the error.
The error can be eliminated only by restoring manually the detector device status.
The device is approaching and away from the control position through commands provided to the relevant Solenoid valves by the Sock Program.

Through a cable is trasmitted this stop signal to the machine.
The correct condition (stop not active) is:

”contact open”

With stop not active, the inputs Autotest displays the value “0”.
With stop active, the inputs Autotest displays the value “1”.

In case of error first check if has been intervened the control device (real error).
- Solve the real problem that has caused the error.

If the control device has not intervened, check the regulation and setting and then proceed as follows.

With error active (non-erasable with [F8] key), access to Inputs Autotest.
Press the [CTRL] + [B] keys in the error window.

If the Inpurs Autoest displays the value “0”:

- *Replace the Input board.*

If the Inpurs Autoest displays the value “1”:

- *To facilitate the failure search, disconnect the control wire from the device.*

  If the error is cancelled by pressing the [F8] key the device is defective.

  - *Replace the control device.*

  If the error remains.

  - *Check that the wire in its path between the device and the inputs board is not to ground. In the case, operate the repair or replacement of the wire.*
  - *Replace the Input board.*

Notice

Attention

If the wire that connects the inputs board to the control device was rough or however interrupted, the error would never appear, then the machine would work without this control.

CHuE51: Broken selectors stop motion

Sensor input:

Pcb_3759 J11 p06

The input board for this signal is Pcb_3759.

This error is due to intervention of the “Selector” breakage control mechanism.
Generally the “Pin” of the device goes to impact against the “Selector”, that when is broken, during the Cylinder rotation pass through a track where normally should not go.
This impact determines a temporary closure to mass (Ground) of the control “Pin” and therefore the intervention of the error.

The user, after having removed the error is obliged to run 2 cylinder laps with the [Handle 2] key during which may replace the broken “Selector”, or Reset the Sock Cycle and perform after the repair.

Through a cable is trasmitted this stop signal to the machine.
The correct condition (stop not active) is:

”contact open”

With stop not active, the inputs Autotest displays the value “0”.
With stop active, the inputs Autotest displays the value “1”.

In case of error first check if has been intervened the control device (real error).

- Solve the real problem that has caused the error.

If the control device has not intervened, check the regulation and setting and then proceed as follows.

With error active (non-erasable with [F8] key), access to Inputs Autotest.
Press the [CTRL] + [B] keys in the error window.

If the Inpurs Autoest displays the value “0”:

- *Replace the Input board.*

If the Inpurs Autoest displays the value “1”:

- *To facilitate the failure search, disconnect the control wire from the device.*

  If the error is cancelled by pressing the [F8] key the device is defective.

  - *Replace the control device.*

  If the error remains.

  - *Check that the wire in its path between the device and the inputs board is not to ground. In the case, operate the repair or replacement of the wire.*
  - *Replace the Input board.*

Notice

Attention

If the wire that connects the inputs board to the control device was rough or however interrupted, the error would never appear, then the machine would work without this control.

CHuE70: Brocken selectors Press [F0]

Sensor input:
Pcb_3759 J11 p06
Command output:
G615: в16 e6 — G615D: в3 e3 — G616: в16 e1 — G616D: в16 e1 — GL-544: в11 e5 — GL-544CT: в9 e7 — GL-615: в16 e1 — GL-616: в16 e1 — GL-616D: в7 e8 — GL-61QCT: в12 e1 — GL-616CTE: в4 e6 — GL-615CTE: в12 e3 — GL-616DCTE: в13 e2

The input board for this signal is Pcb_3759.

This error is due to intervention of the “Selector” breakage control mechanism.
Generally the “Pin” of the device goes to impact against the “Selector”, that when is broken, during the Cylinder rotation pass through a track where normally should not go.
This impact determines a temporary closure to mass (Ground) of the control “Pin” and therefore the intervention of the error.
The device is approaching and away from the control position through commands provided to the relevant Solenoid valves by the Sock Program.
This control (error) is enabled only when is active the command that brings the device in the control position.

The user cannot eliminate the error, is forced to clear the Sock Cycle with the [F0] key.
This is because the point where the rupture is detected, the Heel, does not allow an easy replacement of the broken “Selector”, with the risk of further broken.
The repair can be easily carried out with machine at End of Cycle.

Through a cable is trasmitted this stop signal to the machine.
The correct condition (stop not active) is:
”contact open”
With stop not active, the inputs Autotest displays the value “0”.
With stop active, the inputs Autotest displays the value “1”.

In case of error first check if has been intervened the control device (real error).
- Solve the real problem that has caused the error.

If the control device has not intervened, check the regulation and setting and then proceed as follows.

With error active (non-erasable with [F8] key), access to Inputs Autotest.
Press the [CTRL] + [B] keys in the error window.

If the Inpurs Autoest displays the value “0”:
- *Replace the Input board.*

If the Inpurs Autoest displays the value “1”:
- *To facilitate the failure search, disconnect the control wire from the device.*

If the error is cancelled by pressing the [F8] key the device is defective.
- *Replace the control device.*

If the error remains.
- *Check that the wire in its path between the device and the inputs board is not to ground. In the case, operate the repair or replacement of the wire.*
- *Replace the Input board.*

Notice

Attention

If the wire that connects the inputs board to the control device was rough or however interrupted, the error would never appear, then the machine would work without this control.

CHuE35: Latch needles 3

Sensor input:

G44J: Pcb_3759 J11 p04 — G54JCT: Pcb_3759 J11 p02 — G54JOT: Pcb_3759 J11 p02 — GL-544: Pcb_3759 J11 p04 — GL-544CT: Pcb_3759 J11 p04

Command output:

G44J: в15 e3 — G54JCT: в15 e8 — G54JOT: в16 e8 — GL-544: в13 e8 — GL-544CT: в13 e1

The input board for this signal is Pcb_3759.

CHuE36: Latch needles 2

Sensor input:

G44J: Pcb_3759 J11 p03 — G54JCT: Pcb_3759 J11 p03 — G54JOT: Pcb_3759 J11 p03 — G615: Pcb_3759 J11 p03 — G615D: Pcb_3759 J11 p03 — G616: Pcb_3759 J11 p03 — G616D: Pcb_3759 J11 p03 — G624: Pcb_3759 J11 p03 — G626: Pcb_3759 J11 p03 — GL-544: Pcb_3759 J11 p08 — GL-544CT: Pcb_3759 J11 p08 — GL-615: Pcb_3759 J11 p08 — GL-616: Pcb_3759 J11 p08 — GL-616D: Pcb_3759 J11 p08 — GL-61QCT: Pcb_3759 J11 p08 — GL-_CTE: Pcb_3759 J11 p08

Command output:

G44J: в14 e6 — G54JCT: в13 e1 — G54JOT: в14 e1 — G615: в3 e5 — G615D: в3 e5 — G616: в3 e8 — G616D: в3 e8 — G624: в3 e3 — G626: в14 e7 — GL-544: в14 e6 — GL-544CT: в13 e7 — GL-615: в3 e8 — GL-616: в3 e8 — GL-616D: в4 e7 — GL-61QCT: в13 e6 — GL-615CTE: в15 e4 — GL-616DCTE: в16 e2

The input board for this signal is Pcb_3759.

CHuE37: Latch needles 1

Sensor input:

G44J: Pcb_3759 J11 p02 — G54JCT: Pcb_3759 J11 p04 — G54JOT: Pcb_3759 J11 p04 — G615: Pcb_3759 J11 p02 — G615D: Pcb_3759 J11 p02 — G616: Pcb_3759 J11 p02 — G616D: Pcb_3759 J11 p02 — G61Q: Pcb_3759 J11 p02 — G624: Pcb_3759 J11 p02 — G626: Pcb_3759 J11 p02 — GL-544: Pcb_3759 J11 p02 — GL-544CT: Pcb_3759 J11 p02 — GL-615: Pcb_3759 J11 p02 — GL-616: Pcb_3759 J11 p02 — GL-616D: Pcb_3759 J11 p02 — GL-61QCT: Pcb_3759 J11 p02 — GL-_CTE: Pcb_3759 J11 p02

Command output:

G44J: в13 e8 — G54JCT: в3 e5 — G54JOT: в3 e5 — G615: в4 e8 — G615D: в4 e8 — G616: в4 e8 — G616D: в4 e8 — G61Q: в4 e5 — G624: в15 e2 — G626: в14 e6 — GL-544: в15 e6 — GL-544CT: в14 e8 — GL-615: в4 e8 — GL-616: в4 e8 — GL-616D: в3 e7 — GL-61QCT: в14 e5 — GL-616CTE: в3 e8 — GL-615CTE: в16 e4 — GL-616DCTE: в17 e4

The input board for this signal is Pcb_3759.

This error is due to the intervention of the control mechanism for the Needle “Latch”.
Generally the “Pin” of the device goes to impact against the Needle “Latch” not closed, or against the yarn accumulation determined by needles broken or any other cause.
This impact determines a temporary closure to mass (Ground) of the control “Pin” and therefore the intervention of the error.
The device is approaching and away from the control position through commands provided to the relevant Solenoid valves by the Sock Program.

Through a cable is trasmitted this stop signal to the machine.
The correct condition (stop not active) is:

”contact open”

With stop not active, the inputs Autotest displays the value “0”.
With stop active, the inputs Autotest displays the value “1”.

In case of error first check if has been intervened the control device (real error).

- Solve the real problem that has caused the error.

If the control device has not intervened, check the regulation and setting and then proceed as follows.

With error active (non-erasable with [F8] key), access to Inputs Autotest.
Press the [CTRL] + [B] keys in the error window.

If the Inpurs Autoest displays the value “0”:
- *Replace the Input board.*

If the Inpurs Autoest displays the value “1”:
- *To facilitate the failure search, disconnect the control wire from the device.*

If the error is cancelled by pressing the [F8] key the device is defective.
- *Replace the control device.*

If the error remains.
- *Check that the wire in its path between the device and the inputs board is not to ground. In the case, operate the repair or replacement of the wire.*
- *Replace the Input board.*

Notice

Note

This error can be disabled from the Programming of a code in the Sock Program (GRAPHITRON).
In the steps chain in which is programmed the Code this error may not intervene.
This instrument is used by the user to disable this control (error) in the points of the Sock where for the type of working could happen “Pin”/”Latch” contacts that are not indicative of a real problem.
For example in the entry and exit points of the control device.
Generally this possibility is used to avoid the control in certain points in the Sock.

Attention

If the wire that connects the inputs board to the control device was rough or however interrupted, the error would never appear, then the machine would work without this control.

Messages on the Yarn broken

CHuE21: Stop elastic 1

Sensor input:
Pcb_3759 J11 p07

The input board for this signal is Pcb_3759.

CHuE22: Stop elastic 2

Sensor input:
G44J: Pcb_3759 J11 p08 — G54JCT: Pcb_3759 J11 p08 — G54JOT: Pcb_3759 J11 p08 — G615: Pcb_3759 J11 p08 — G615D: Pcb_3759 J11 p08 — G616: Pcb_3759 J11 p08 — G616D: Pcb_3759 J11 p08 — G626: Pcb_3759 J11 p08 — GL-544: Pcb_3759 J11 p03 — GL-544CT: Pcb_3759 J11 p03 — GL-615: Pcb_3759 J11 p03 — GL-616: Pcb_3759 J11 p03 — GL-616D: Pcb_3759 J11 p03 — GL-61QCT: Pcb_3759 J11 p03 — GL-_CTE: Pcb_3759 J11 p03

The input board for this signal is Pcb_3759.

This error is due to intervention of the Elastic yarn breakage control mechanism.
This normally occurs during the operation of the Elastic motor, usually because the Elastic yarn is broken.

Through a cable is trasmitted this stop signal to the machine.
The correct condition (stop not active) is:

”contact open”
With stop not active, the inputs Autotest displays the value “0”.
With stop active, the inputs Autotest displays the value “1”.

In case of error first check if has been intervened the control device (real error).
- Solve the real problem that has caused the error.

If the control device has not intervened, check the regulation and setting and then proceed as follows.

With error active (non-erasable with [F8] key), access to Inputs Autotest.
Press the [CTRL] + [B] keys in the error window.

If the Inpurs Autoest displays the value “0”:
- *Replace the Input board.*

If the Inpurs Autoest displays the value “1”:
- *To facilitate the failure search, disconnect the control wire from the device.*

If the error is cancelled by pressing the [F8] key the device is defective.
- *Proceed to the repair or replacement of the device.*

If the error remains.
- *Check that the wire in its path between the device and the inputs board is not to ground. In the case, operate the repair or replacement of the wire.*
- *Replace the Input board.*

Attention

If the wire that connects the inputs board to the control device was rough or however interrupted, the error would never appear, then the machine would work without this control.

CHuE23: Stop heel and toe take up

Sensor input:
Pcb_3759 J11 p15

The input board for this signal is Pcb_3759.

This error is due to the intervention of the control mechanism for the yarns recovery in the Heel (“Yarn take-up” against the maximum stroke block), usually because a yarn is broken or the yarn recovery that is insufficient.
The “Yarns Take-up” mechanism normally blocked, it will unlock when in the Sock Program are programmed the proper commands.
This happens in the Heel and Toe blocks.
The Solenoid valves relating to these commands are enegized and the various Yarn Take-up are free in their movement to recover the yarn during the alternate motion of the Cylinder.

Through a cable is trasmitted this stop signal to the machine.
This cable also includes a wire that bring properly the Ground (0 Vdc) to the device.
The correct condition (stop not active) is:
”contact open”
With stop not active, the inputs Autotest displays the value “0”.
With stop active, the inputs Autotest displays the value “1”.

In case of error first check if has been intervened the control device (real error).
- Solve the real problem that has caused the error.

If the control device has not intervened, check the regulation and setting and then proceed as follows.

With error active (non-erasable with [F8] key), access to Inputs Autotest.
Press the [CTRL] + [B] keys in the error window.

If the Inpurs Autoest displays the value “0”:

- *Replace the Input board.*

If the Inpurs Autoest displays the value “1”:

- *To facilitate the failure search, disconnect the control wire from the device.*

If the error is cancelled by pressing the [F8] key the device is defective.

- *Proceed to the repair or replacement of the device.*

If the error remains.

- *Check that the wire in its path between the device and the inputs board is not to ground. In the case, operate the repair or replacement of the wire.*
- *Replace the Input board.*

Attention

If the wire that connects the inputs board to the control device was rough or however interrupted, the error would never appear, then the machine would work without this control.

CHuE32: Winders

Sensor input:
Pcb_2008 J28 p08

The input board for this signal is Pcb_2008.

This error is due to the intervention of the internal control mechanism of the “Yarn winder IRO/PRIMO” device.
The “Yarn winder IRO/PRIMO motor” is part of a device (optional) used for the control of the progress of the yarn absorbed by Cylinder during the Sock construction.
This device, as well as by the Yarn Winder motors, is composed by a Transformer 220-42 Vac, by a Pcb_1707 board, by a switch On/Off, and by all the wiring connected.
During the operation, when the yarn present on the Yarn Winder motor falls below a minimum threshold, a signal of error from the Yarn Winder motor arrives to the Pcb_1707 board.
Through a cable is trasmitted this stop signal to the machine.
The correct condition (stop not active) is:
”contact open”
With stop not active, the inputs Autotest displays the value “0”.
With stop active, the inputs Autotest displays the value “1”.

In case of error first check if has been intervened the control device (real error).

- Solve the real problem that has caused the error.

If the control device has not intervened, check the regulation and setting and then proceed as follows.

With error active (non-erasable with [F8] key), access to Inputs Autotest.
Press the [CTRL] + [B] keys in the error window.

If the Inpurs Autoest displays the value “0”:

- *Replace the Input board.*

If the Inpurs Autoest displays the value “1”:

- *To facilitate the failure search, disconnect the control wire from the device.*
  The user to run this operation can simply disconnect the conn. J3 of the Pcb 1707.

If the error is cancelled by pressing the [F8] key the device is defective.

- *The problem therefore still depends from external device.*

Proceed to the repair or replacement of the device.

- *Find the Yarn Winder motor failure and replace it.*
- *Check the wiring integrity and the proper connection to the Ground of the device.*
- *Replace the board Pcb_1707.*

If the error remains.

- *Check that the wire in its path between the device and the inputs board is not to ground. In the case, operate the repair or replacement of the wire.*
- *Replace the Input board.*

Attention

If the wire that connects the inputs board to the control device was rough or however interrupted, the error would never appear, then the machine would work without this control.

CHuE33: Stop yarn antibreak control 1

Sensor input:
Pcb_2008 J17

The input board for this signal is Pcb_2008.

This error is due to the intervention of the “Antibreak” sensors (Optional) placed on the Yarns Creel.
This sensor is a control device which detects and signals that the yarn is blocked or however partly prevented in its movement.
The yarn controlled pass through the sensor, on which is possible to adjust the sensibility of intervention (strength of the spring).
Normally during the operation (machine in rotation) the sensors have a Green Led turned on.
When intervenes a “tear” of the yarn on sensor concerned a Red Led is turned on and a signal is sent to the machine which stops with this error.

- The user must restore the machine functionality (fix the yarn), cancel the error with [F8] and restart the machine.
  Automatically the Red Led turns off and the Green Led turns on.
  The machine is now returned operative.

A “Flat” cable connects all the sensors and therefore is connected to another cable (shielded) coming from the inputs board.
The correct condition (stop not active) is:
”contact open”
With stop not active, the inputs Autotest displays the value “0”.
With stop active, the inputs Autotest displays the value “1”.

In case of error first check if has been intervened the control device (real error).

- Solve the real problem that has caused the error.

If the control device has not intervened, check the regulation and setting and then proceed as follows.

With error active (non-erasable with [F8] key), access to Inputs Autotest.
Press the [CTRL] + [B] keys in the error window.

If the Inpurs Autoest displays the value “0”:

- *Replace the Input board.*

If the Inpurs Autoest displays the value “1”:

- *To facilitate the failure search, disconnect the control wire from the device.*
  Disconnect the external interface connector located between the machine and the “Flat” cable of the sensors.
  If the error is cancelled by pressing the [F8] key the device is defective.
  - *The problem therefore still depends from external device.*
    Proceed to the repair or replacement of the device.
    - *Find the failure sensor and replace it.*
    - *Check the wiring integrity and the proper connection to the Ground of the device.*

  If the error remains.
  - *Check the wiring integrity and the proper connection to the Ground of the device.*
    In particular check the wiring that connects the sensors to the inputs board (shielded cable with 0 VDC to Ground).
  - *Replace the Input board.*

Note

Could happen that randomly and without apparent reason appears this error.

The causes may be electrical and static noise on machine powers and on the yarn control sensor.

- Check the proper connection of the Ground to the carcase of the Yarns Creel.
- Check that the shield of the cable (wiring between sensors and inputs board) is efficient and place to mass (Ground) together the 0 Vdc power sensors.
- Check the presence of eventually noise on power Three-Phase Line of the machine.

Notice

Attention

If the wire that connects the inputs board to the control device was rough or however interrupted, the error would never appear, then the machine would work without this control.

CHuE71: End rack

Sensor input:
Pcb_2008 J28 p12

The input board for this signal is Pcb_2008.

This input is prepared in the software, for the application of any special mechanical sensors for the control of the yarns rupture.
These special mechanical sensors replace or be used simultaneously with the normal yarn sliding sensors.
For their connection is used the same serial cable used for yarn sliding sensors.
These mechanical sensors may control only the yarn rupture.

Through a cable is trasmitted this stop signal to the machine.
The correct condition (stop not active) is:
”contact open”
With stop not active, the inputs Autotest displays the value “0”.
With stop active, the inputs Autotest displays the value “1”.

In case of error first check if has been intervened the control device (real error).

- Solve the real problem that has caused the error.

If the control device has not intervened, check the regulation and setting and then proceed as follows.

With error active (non-erasable with [F8] key), access to Inputs Autotest.
Press the [CTRL] + [B] keys in the error window.

If the Inpurs Autoest displays the value “0”:

- *Replace the Input board.*

If the Inpurs Autoest displays the value “1”:

- *To facilitate the failure search, disconnect the control wire from the device.*

If the error is cancelled by pressing the [F8] key the device is defective.

- *The problem therefore still depends from external device.*

Proceed to the repair or replacement of the device.

- *Find the failure sensor and replace it.*

If the error remains.

- *Check that the wire in its path between the device and the inputs board is not to ground. In the case, operate the repair or replacement of the wire.*
- *Replace the Input board.*

Notice

Attention

If the wire that connects the inputs board to the control device was rough or however interrupted, the error would never appear, then the machine would work without this control.

CHuE82: End bobbin scaffolding

Sensor input:
Pcb_2008 J28 p10

The input board for this signal is Pcb_2008.

To the input relative this error is connected no cabling.
This input is prepared in the software, for the application of any special additional sensors for the control of the yarns.
In particular a control device of the “End of Yarn Bobbin”.

The correct condition (stop not active) is:
”contact open”
With stop not active, the inputs Autotest displays the value “0”.
With stop active, the inputs Autotest displays the value “1”.

In case of error first check if has been intervened the control device (real error).
- Solve the real problem that has caused the error.

If the control device has not intervened, check the regulation and setting and then proceed as follows.

With error active (non-erasable with [F8] key), access to Inputs Autotest.
Press the [CTRL] + [B] keys in the error window.

If the Inpurs Autoest displays the value “0”:
- *Replace the Input board.*

If the Inpurs Autoest displays the value “1”:
- *To facilitate the failure search, disconnect the control wire from the device.*

If the error is cancelled by pressing the [F8] key the device is defective.
- *Proceed to the repair or replacement of the device.*

If the error remains.
- *Check that the wire in its path between the device and the inputs board is not to ground. In the case, operate the repair or replacement of the wire.*
- *Replace the Input board.*

Notice

Attention

If the wire that connects the inputs board to the control device was rough or however interrupted, the error would never appear, then the machine would work without this control.

CHuE08: Stop yarn creel

Sensor input:
Pcb_2008 J29 p04

The input board for this signal is Pcb_2008.

This error is due to the intervention of the various control devices of the status of the yarns on the external Yarns Creel, generally because the yarn is broken or is blocked in its sliding.

The correct condition (stop not active) is:
”contact open”
With stop not active, the inputs Autotest displays the value “0”.
With stop active, the inputs Autotest displays the value “1”.

In case of error first check if has been intervened the control device (real error).
- Solve the real problem that has caused the error.

If the control device has not intervened, check the regulation and setting and then proceed as follows.

With error active (non-erasable with [F8] key), access to Inputs Autotest.
Press the [CTRL] + [B] keys in the error window.

If the Inpurs Autoest displays the value “0”:
- *Replace the Input board.*

If the Inpurs Autoest displays the value “1”:
- *To facilitate the failure search, disconnect the control wire from the device.*

If the error is cancelled by pressing the [F8] key the device is defective.
- *Proceed to the repair or replacement of the device.*

If the error remains.
- *Check that the wire in its path between the device and the inputs board is not to ground. In the case, operate the repair or replacement of the wire.*
- *Replace the Input board.*

Notice

Attention

If the wire that connects the inputs board to the control device was rough or however interrupted, the error would never appear, then the machine would work without this control.

Messages on the Pattern Drums connection

CHuE84: Pattern drum 4 not connected board 1

CHuE85: Pattern drum 3 not connected board 1

CHuE86: Pattern drum 2 not connected board 1

CHuE87: Pattern drum 1 not connected board 1

CHuE89: Drum 8 not connected board 2

CHuE90: Drum 7 not connected board 2

CHuE91: Drum 6 not connected board 2

CHuE92: Drum 5 not connected board 2

CHuE136: Drum 12 not connected board 3

CHuE137: Drum 11 not connected board 3

CHuE138: Drum 10 not connected board 3

CHuE139: Drum 9 not connected board 3

CHuE140: Drum 5 not connected board 1

CHuE141: Drum 6 not connected board 1

This error informs the user that any cable for the Pattern Drums is disconnected from the Pattern Drum itself or from the output board for the Pattern Drums commands.
Within each Pattern Drum cable ther is a control wire that must be to Mass (0 Vdc).
This wire touches the mass (Ground) only when this cable is connected to the Pattern Drum.
This control wire then shall enter into the output board, that detects the possibly error.

The error management is different depending on type of the Pattern Drum mounted (currently “WAC or “MATRIX”).

The errors refers to machines equipped with Pattern Drums type “WAC”.

In case of machine equipped with Pattern Drums of type “WAC” the output board is the Pcb_3850.
The error is not specific for each connector, but is general; each board show a specific message of error.
Therefore is not distinguished the Pattern Drum connected to the board that has caused the error.
The user should assess which are the Pattern Drums connected to that particular board, and check their correct connection, both on the board side or on the Pattern Drum side.
On the board may be present output connectors free, depends on the number of Pattern Drums mounted, therefore by the machine model.
In these connectors must be inserted a cable that simulates the presence of the Pattern Drum, in which a wire brings to Mass (0 Vdc) the input of the control signal, otherwise this error would be always active.

The errors refers to machines equipped with Pattern Drums type “MATRIX”.

In case of machine equipped with Pattern Drums of type “MATRIX” the output board is the Pcb_3819 — Pcb_3819 — Pcb_3819.
The error is specific for each connector of the output board.
The error message will indicate the number of the Pattern Drum detected “not connected”.
The user should assess which are the Pattern Drums connected to that particular board, and check their correct connection, both on the board side or on the Pattern Drum side.
On the board may be present output connectors free, depends on the number of Pattern Drums mounted, therefore by the machine model.
Each connector on the board has associated a “jumper”, whose position may exclude the control regarding that particular connector.
Each free connector must have the associated “jumper” placed in a position to exclude the control, otherwise this error wolud be always active.

Proceed as follows to solve the problem:

- Find the Pattern Drum and check the integrity of the cable to it connected.
- By reading the cables marking, find the output board and eventually the connector related the error.
  Then check the integrity of the connection of the cable to the board.
  In particular the continuity and the connectors input position of the wire for the connection control.
- Check the position of the “jumpers” of any free connectors on the output board.
  In alternative check the correct connection of the connectors for the control exclusion.
- Replace the output board.
- Replace the Pattern Drum.

This error is active only if enabled by Setup.
In these machines models this error is enabled (DEFAULT).

Notice

Note

For these types of machines, there are some models equipped with only one output board, the Pcb_3859.
About this error is valid as exposed for the machines equipped with Pattern Drums of type “MATRIX”, change only the “output board” of reference.

N.C. / C.C. Bar. X - X Output Name

When an error of this type appears, it indicates an error of Short-Circuit (C.C.) or Load not connected (N.C.) on to any load connected to an output machine.
In the name of the error message is indicated:

1. The type of error, Short-circuit (C.C.) or Load not connected (N.C.)
2. The Bar (board) with the relative Output reason of the error.
3. The name of the Output (Solenoid valve) reason of the error.

Reference

For checks relating to these types of error refer to the section:

Management and Control of the Saw movement

The Saw is a device placed on Dial, that by turning cuts the yarns in working exit.

The Normal Saw runs through the movement of a shaft jointly liable to the cylinder movement.
In the machine prepared with Motorized Saw instead the movement may also be determined by a stepping motor properly assembled.

When the Dial is low the Saw normally should turn.
When the Dial is high, the Saw must be stationary, because the possible movement may be dangerous to the operator.

A Release/Hook device through the command to a Solenoid valve performs the operation of engage or disengage of the rotation.
The Solenoid valve, if energized blocks the movement of the Saw (Release), if de-energized causes the towing of the Saw by the cylinder in rotation.

Through the GRAPHITRON programming is possible to control the Release and the Hook of the Saw during the Sock Cycle, but the working speed may not be more than 150 RPM.
Normally this happens with Dial low.

If os raised the Dial with the Saw in rotation for the operator safety the machine cannot put in motion, may be used only the [Handles].
With Dial high, turning with the [Handle] start a Release procedure of the Saw movement, in 2 laps cylinder the Saw is disengaged and therefore it is stopped.
At this point, the running is again enabled.
By lowering the Dial, putting in motion the machine, the Saw automatically is hooked without making any particular procedure (the Solenoid valve is immediately de-energized).

In case of machine prepared with Motorized Saw, the machine can still be working as with the Normal Saw, is sufficient not programming the start of the Saw motor.
The operation of the Motorized Saw provides before the Release of the Saw by the cylinder rotation and then the command to the Saw motor.
There is a protection in the programming software (GRAPHITRON) for which is not accepted a start command of the Saw motor with the Saw mechanically hooked.
This device is useful when the user wants to have a Saw speed greater (different) of the Cylinder speed.
This device is currently available as options on some machine models.

The Dial position is controlled by the software via the value read by position sensor (“Dial down”).
Through these signals the software is able to implement the correct procedures provided according to the Dial position.

The movement status of the Saw is controlled by the software through the reading of a sensor on rotation of the shaft on which is fixed the Saw itself.
This shaft has a “slot” (hollow) with a length of 56°.
When the “Slot” passes under the sensor it is not reading, in all the other positions, the sensor is in reading.
This shaft has a point of phase compared with mechanical Zero.
The signal of this sensor is used by the software to establish the status of rotation of the Saw.
To the achievement of 2 specific “cylinder degrees” the signal shall be respectively “open” and “closed”.

In accordance with the machine model changes the phase of this shaft compared with Zero.
With most machines these 2 control points are at 20° (sensor over “Slot”) and 220°.
In 4-feed machines (e.g. G54J) these 2 points are at 20° and 200°.
The first point is exactly the centre of the “Slot”, the second is the one where surely the reading of the signal must provide as a result “closed”.
With Saw stationary the signal must not vary for all the 360° of the cylinder revolution.

This signal is also used during the procedure for Release and Hook of the Saw for all controls linked to this procedure.
The control is disabled only in the phase of the real movement of Hook/Release, but then is immediately rehabilitated.

Messages on control of the Saw movement

CHuE15:

Sensor input:
Pcb_3759 J14 p01
Command output:
G44J: в15 e8 — G54JOT: в1 e4 — G615: в2 e6 — G615D: в2 e6 — G616: в16 e8 — G616D: в16 e8 — G61Q: в8 e4 — G624: в1 e6 — G626: в1 e4 — GL-544: в16 e1 — GL-615: в16 e8 — GL-616: в16 e8 — GL-616D: в2 e1 — GL-615CTE: в19 e1 — GL-616DCTE: в19 e1

The input board for this signal is Pcb_3759.

This error regards operation of the Normal Saw.
In this condition the Saw may be:
A. Hooked, so in rotation jointly liable with the cylinder, with a precise phase compared with 0°.
B. Released, then stationary.
The software, by reading the phase sensor, check both conditions.

With Saw hooked the Software must read in both the control points the correct status of the sensor.
To these 2 positions corresponds a precise degree compared with 0°.
The 2 points of control are:
1. ”Slot” placed under the phase sensor.
2. ”Slot” placed to the opposite of the phase sensor.
With most machines these 2 control points are at 20° (sensor over “Slot”) and 220°.
In 4-feed machines (e.g. G54J) these 2 points are at 20° and 200°.

With the Saw released the software should not read no change of the sensor status.

This message informs the user that the software control of the Saw movement has assessed the device in a not correct status.
In particular this message indicates the incongruity of the signal detected in correspondence of the point of control:
”Slot” placed under the phase sensor.

In case of error the first thing to check is the integrity of the phase sensor of the Saw.
Assess the status of Inputs Autotest in correspondence of the 2 reading points.

The correct status of the Inputs Autotest is:
- Saw phase sensor over the “Slot” (not obscured):
  Autotest = “0”.
- Saw phase sensor not over the “Slot” (obscured):
  Autotest = “1”.

If the Autotest displays a wrong status with regard to the mechanical stage:
- *Replace the phase sensor.*
- *Check the wiring between the sensor and the board Pcb_3759.*
- *Replace the board Pcb_3759.*

If the Autotest displays a correct status with regard to the mechanical stage:
- *Check the mechanical phase between the Dial and the Cylinder.*
- *Check the correct setting of the mechanical Zero.*
- *Check the status of the mechanism for the Saw Hook/Release.*
- *Check the functionality of the command for the Saw Hook/Release.*
  In particular check the status of the Tube (pipe) and the functioning of the Solenoid valve and of the Command board (Bar).
  Eventually replace these components.

Reference

For the information concerning the management and control of the Saw movement see the the section:
Management and Control of the Saw movement

CHuE16: Saw blade control stop motion -B-

Sensor input:
Pcb_3759 J14 p01
Command output:
G44J: B15 e8 — G54JOT: B1 e4 — G615: B2 e6 — G615D: B2 e6 — G616: B16 e8 — G616D: B16 e8 — G61Q: B8 e4 — G624: B1 e6 — G626: B1 e4 — GL-544: B16 e1 — GL-615: B16 e8 — GL-616: B16 e8 — GL-616D: B2 e1 — GL-615CTE: B19 e1 — GL-616DCTE: B19 e1

The input board for this signal is Pcb_3759.

This error regards operation of the Normal Saw.
In this condition the Saw may be:
A. Hooked, so in rotation jointly liable with the cylinder, with a precise phase compared with 0°.
B. Released, then stationary.
The software, by reading the phase sensor, check both conditions.

With Saw hooked the Software must read in both the control points the correct status of the sensor.
To these 2 positions corresponds a precise degree compared with 0°.
The 2 points of control are:
1. ”Slot” placed under the phase sensor.
2. ”Slot” placed to the opposite of the phase sensor.
With most machines these 2 control points are at 20° (sensor over “Slot”) and 220°.
In 4-feed machines (e.g. G54J) these 2 points are at 20° and 200°.

With the Saw released the software should not read no change of the sensor status.

This message informs the user that the software control of the Saw movement has assessed the device in a not correct status.
In particular this message indicates the incongruity of the signal detected in correspondence of the point of control:
”Slot” placed to the opposite of the phase sensor.

In case of error the first thing to check is the integrity of the phase sensor of the Saw.
Assess the status of Inputs Autotest in correspondence of the 2 reading points.

The correct status of the Inputs Autotest is:
- Saw phase sensor over the “Slot” (not obscured):
  Autotest = “0”.
- Saw phase sensor not over the “Slot” (obscured):
  Autotest = “1”.

If the Autotest displays a wrong status with regard to the mechanical stage:
- *Replace the phase sensor.*
- *Check the wiring between the sensor and the board Pcb_3759.*
- *Replace the board Pcb_3759.*

If the Autotest displays a correct status with regard to the mechanical stage:
- *Check the mechanical phase between the Dial and the Cylinder.*
- *Check the correct setting of the mechanical Zero.*
- *Check the status of the mechanism for the Saw Hook/Release.*
- *Check the functionality of the command for the Saw Hook/Release.*
  In particular check the status of the Tube (pipe) and the functioning of the Solenoid valve and of the Command board (Bar).
  Eventually replace these components.

Reference

For the information concerning the management and control of the Saw movement see the the section:
Management and Control of the Saw movement

CHuE17: Saw blade control stop motion -C-

Sensor input:
Pcb_3759 J14 p01
Command output:
G44J: B15 e8 — G54JOT: B1 e4 — G615: B2 e6 — G615D: B2 e6 — G616: B16 e8 — G616D: B16 e8 — G61Q: B8 e4 — G624: B1 e6 — G626: B1 e4 — GL-544: B16 e1 — GL-615: B16 e8 — GL-616: B16 e8 — GL-616D: B2 e1 — GL-615CTE: B19 e1 — GL-616DCTE: B19 e1

The input board for this signal is Pcb_3759.

This error regards operation of the Normal Saw and the Motorized Saw.

This message informs the user that the Saw is moving at a point at which the software expected it to be stopped.

Functioning in Normal Saw mode

In this condition the Saw may be:
A. Hooked, so in rotation jointly liable with the cylinder, with a precise phase compared with 0°.
B. Released, then stationary.
The software, by reading the phase sensor, check both conditions.

With Saw hooked the Software must read in both the control points the correct status of the sensor.
With the Saw released the software should not read no change of the sensor status.

This message informs the user that the software control of the Saw movement has assessed the device in a not correct status.
In particular this message indicates that the software has found a change of the sensor status:

In case of error the first thing to check is the integrity of the phase sensor of the Saw.
Assess the status of Inputs Autotest in correspondence of the 2 reading points.

The correct status of the Inputs Autotest is:
- Saw phase sensor over the “Slot” (not obscured):
  Autotest = “0”.
- Saw phase sensor not over the “Slot” (obscured):
  Autotest = “1”.

If the Autotest displays a wrong status with regard to the mechanical stage:
- *Replace the phase sensor.*
- *Check the wiring between the sensor and the board Pcb_3759.*
- *Replace the board Pcb_3759.*

If the Autotest displays a correct status with regard to the mechanical stage:
- *Check the mechanical phase between the Dial and the Cylinder.*
- *Check the correct setting of the mechanical Zero.*
- *Check the status of the mechanism for the Saw Hook/Release.*
- *Check the functionality of the command for the Saw Hook/Release.*
  In particular check the status of the Tube (pipe) and the functioning of the Solenoid valve and of the Command board (Bar).
  Eventually replace these components.

Functioning in Motorized Saw mode

With Saw released by the cylinder rotation and Saw motor stopped the Saw must not move.
The software each 40° checks the status of Phase sensor, it must not vary his reading.
A change of the sensor status (in the 360°) is a symptom of a Saw movement.

In case of error the first thing to check is the integrity of the phase sensor of the Saw.
Assess the status of Inputs Autotest in correspondence of the 2 reading points.

The correct status of the Inputs Autotest is:

- Saw phase sensor over the “Slot” (not obscured):
  Autotest = “0”.
- Saw phase sensor not over the “Slot” (obscured):
  Autotest = “1”.

If the Autotest displays a wrong status with regard to the mechanical stage:

- *Replace the phase sensor.*
- *Check the wiring between the sensor and the board Pcb_3759.*
- *Replace the board Pcb_3759.*

If the Autotest displays a correct status with regard to the mechanical stage:

- *Check the really existence of a mechanical draw of the Saw.*
  Identify the cause and solve the problem.
- *Check the status of the mechanism for the Saw Hook/Release.*
- *Check the functionality of the command for the Saw Hook/Release.*
  In particular check the status of the Tube (pipe) and the functioning of the Solenoid valve and of the Command board (Bar).
  Eventually replace these components.
- *Check if the movement of the Saw is determined by the motor, despite the absence of the software programming.*
  Replace the CAN module (board Pcb_3836) associated with the motor indicated in the message.

Reference

For the information concerning the management and control of the Saw movement see the the section:
Management and Control of the Saw movement

CHuE18: Saw blade control stop motion -D-

Sensor input:
Pcb_3759 J14 p01
Command output:
G44J: в15 e8 — G54JOT: в1 e4 — G615: в2 e6 — G615D: в2 e6 — G616: в16 e8 — G616D: в16 e8 — G61Q: в8 e4 — G624: в1 e6 — G626: в1 e4 — GL-544: в16 e1 — GL-615: в16 e8 — GL-616: в16 e8 — GL-616D: в2 e1 — GL-615CTE: в19 e1 — GL-616DCTE: в19 e1

The input board for this signal is Pcb_3759.

This message refers to the operation with the motorized “Saw”.
This message informs the user that the Saw is stopped at a point at which the software expected it in movement.

With Saw released from the cylinder rotation and Saw motor in rotation, the Saw should turn at the motor speed.
The software each 20° checks the status of Phase sensor, in the arc of 640° it must send a signal corresponding to the reading of the “Slot”.
A signal of “sensor not obscured” (“Slot” reading) is a sign of a Saw movement.
Otherwise appears this error.

In case of error the first thing to check is the integrity of the phase sensor of the Saw.
Assess the status of Inputs Autotest in correspondence of the 2 reading points.

The correct status of the Inputs Autotest is:

- Saw phase sensor over the “Slot” (not obscured):
  Autotest = “0”.
- Saw phase sensor not over the “Slot” (obscured):
  Autotest = “1”.

If the Autotest displays a wrong status with regard to the mechanical stage:

- *Replace the phase sensor.*
- *Check the wiring between the sensor and the board Pcb_3759.*

- *Replace the board Pcb_3759.*

If the Autotest displays a correct status with regard to the mechanical stage:

- *Check the really existence of a mechanical block of the Saw.*
  Identify the cause and solve the problem.
- *Check the status of the mechanism for the Saw Hook/Release.*
- *Check the functionality of the command for the Saw Hook/Release.*
  In particular check the status of the Tube (pipe) and the functioning of the Solenoid valve and of the Command board (Bar).
  Eventually replace these components.
- *Check if the motor movement has found mechanical obstacles or a very high resistance.*
- *Check the wiring that connect the sensor and the motor to the command board (in general the Pcb_3836 board).*
- *Replace the stepping motor indicated in the message.*
- *Replace the CAN module (board Pcb_3836) associated with the motor indicated in the message.*

Reference

For the information concerning the management and control of the Saw movement see the the section:

Management and Control of the Saw movement

Messages on the Picker (Piker) movement

CHuE52: Stop dropper on the left

Sensor input:

Pcb_3759 J11 p13

Command output:

G44J: в14 e5 — G54JCT: в13 e4 — G54JOT: в14 e4 — G615: в3 e7 — G615D: в3 e7 — G616: в3 e7 — G616D: в3 e7 — G61Q: в4 e6 — G624: в14 e1 — G626: в14 e8 — GL-544: в12 e5 — GL-544CT: в11 e3 — GL-615: в3 e7 — GL-616: в3 e7 — GL-616D: в5 e7 — GL-61QCT: в14 e4 — GL-615CTE: в15 e2 — GL-616DCTE: в15 e4

The input board for this signal is Pcb_3759.

CHuE55: Stop dropper on the right

Sensor input:

Pcb_3759 J11 p11

Command output:

G44J: в3 e8 — G54JCT: в3 e1 — G54JOT: в3 e1 — G615: в4 e4 — G615D: в4 e4 — G616: в3 e4 — G616D: в3 e4 — G61Q: в4 e4 — G624: в3 e6 — G626: в3 e1 — GL-544: в5 e2 — GL-544CT: в6 e5 — GL-615: в3 e4 — GL-616: в3 e4 — GL-616D: в6 e4 — GL-61QCT: в13 e5 — GL-616CTE: в3 e7 — GL-615CTE: в13 e1 — GL-616DCTE: в14 e5

The input board for this signal is Pcb_3759.

After that in the first part of the Heel the mechanical “Needle-raising Piker” have raised a certain number of needles, in the second part of the Heel the “Needle-lowering Piker”(right and left) devices will lower the same needles, 2 for each alternating rotation of the Cylinder.
The procedure for the Pioker operation provides a series of commands and controls.
The position of the “Needle-lowering Piker” (high and low) is controlled by a “Hall sensor” mounted on a small board that is an integral part of the Piker device itself.
The ON or OFF status of the “Led” place on this board visually indicates to the user the status of this control input for the Piker position.
According to the type of problem that can be present in the routine are displaying specific errors.

The rest condition at End of cycle is:

Piker in up position:

Solenoid valve not excited - Led OFF - Inputs Autotest = “0”.
Until the entry into the Heel, about the piker, no command is active and no control is active.

At the entry into the Heel, and for all the first part of the Heel is active the command that lowers the Piker.
At the same time is activated a procedure for the control of the Piker position.
The right codition in this zone of the sock is:
Piker in down position:
Solenoid valve excited - Led ON - Inputs Autotest = “1”.
Otherwise appears this error.
It indicates to the user that the Piker has not reached the low position.

In case of error first check if has been intervened the control device (real error).
Eventually solve the problem.
- Then check the condition of movement and mechanical functionality of the Piker.

If the control device has not intervened, proceed as follows.

With error active (non-erasable with [F8] key), access to Inputs Autotest.
Press the [CTRL] + [B] keys in the error window.
If the Inpurs Autoest displays the value “1”:
- *Replace the Input board.*

If the Inpurs Autoest displays the value “0”:
- *Check the correct adjustment of the position sensor, and possibly replace it.*
  In this case the position sensor (Hall effect sensor) is represented by the control board: G1840130
- *Check the connecting cables between the sensor and the inputs board.*
- *Replace the Input board.*

CHuE53: Dropper error on the left Needle not drop.

Sensor input:
Pcb_3759 J11 p13
Command output:
G44J: в14 e5 — G54JCT: в13 e4 — G54JOT: в14 e4 — G615: в3 e7 — G615D: в3 e7 — G616: в3 e7 — G616D: в3 e7 — G61Q: в4 e6 — G624: в14 e1 — G626: в14 e8 — GL-544: в12 e5 — GL-544CT: в11 e3 — GL-615: в3 e7 — GL-616: в3 e7 — GL-616D: в5 e7 — GL-61QCT: в14 e4 — GL-615CTE: в15 e2 — GL-616DCTE: в15 e4

The input board for this signal is Pcb_3759.

CHuE56: Dropper err. on the right Needle not drop.

Sensor input:
Pcb_3759 J11 p11
Command output:
G44J: в3 e8 — G54JCT: в3 e1 — G54JOT: в3 e1 — G615: в4 e4 — G615D: в4 e4 — G616: в3 e4 — G616D: в3 e4 — G61Q: в4 e4 — G624: в3 e6 — G626: в3 e1 — GL-544: в5 e2 — GL-544CT: в6 e5 — GL-615: в3 e4 — GL-616: в3 e4 — GL-616D: в6 e4 — GL-61QCT: в13 e5 — GL-616CTE: в3 e7 — GL-615CTE: в13 e1 — GL-616DCTE: в14 e5

The input board for this signal is Pcb_3759.

After that in the first part of the Heel the mechanical “Needle-raising Piker” have raised a certain number of needles, in the second part of the Heel the “Needle-lowering Piker”(right and left) devices will lower the same needles, 2 for each alternating rotation of the Cylinder.
The procedure for the Pioker operation provides a series of commands and controls.
The position of the “Needle-lowering Piker” (high and low) is controlled by a “Hall sensor” mounted on a small board that is an integral part of the Piker device itself.
The ON or OFF status of the “Led” place on this board visually indicates to the user the status of this control input for the Piker position.

According to the type of problem that can be present in the routine are displaying specific errors.

The rest condition at End of cycle is:
Piker in up position:
Solenoid valve not excited - Led OFF - Inputs Autotest = “0”.
Until the entry into the Heel, about the piker, no command is active and no control is active.

At the entry into the Heel, and for all the first part of the Heel is active the command that lowers the Piker.
At the same time is activated a procedure for the control of the Piker position.
The right codition in this zone of the sock is:
Piker in down position:
Solenoid valve excited - Led ON - Inputs Autotest = “1”.

When starts the second part of the Heel, the Piker must lower 2 needles for each time.
Therefore is activated a routine with a sequence of commands and controls.
The command is disabled and the Piker gets up awaiting to meet the needles that should be lowered, what will happen to a certain point during the Cylinder rotation.
Reached a certain Cylinder degree the software will run a control on the status of the input signal related the device.
The right codition in this zone of the sock is:
Piker in up position:
Solenoid valve not excited - Led OFF - Inputs Autotest = “0”.
Otherwise appears this error.
It indicates to the user that the Piker is stuck in low position and it was not raised.

In case of error first check if has been intervened the control device (real error).
Eventually solve the problem.
- Then check the condition of movement and mechanical functionality of the Piker.

If the control device has not intervened, proceed as follows.

With error active (non-erasable with [F8] key), access to Inputs Autotest.
Press the [CTRL] + [B] keys in the error window.
If the Inpurs Autoest displays the value “0”:
- *Replace the Input board.*

If the Inpurs Autoest displays the value “1”:
- *To facilitate the failure search, disconnect the control wire from the device.*

If the error is cancelled by pressing the [F8] key the device is defective.
- *Check the correct adjustment of the position sensor, and possibly replace it.*
  In this case the position sensor (Hall effect sensor) is represented by the control board:
  G1840130
- *Replace the Input board.*

If the error remains.
- *Check that the wire in its path between the device and the inputs board is not to ground.*
  In the case, operate the repair or replacement of the wire.
- *Replace the Input board.*

CHuE54: Dropper error on the left Halted.

Sensor input:
Pcb_3759 J11 p13
Command output:
G44J: в14 e5 — G54JCT: в13 e4 — G54JOT: в14 e4 — G615: в3 e7 — G615D: в3 e7 — G616: в3 e7 — G616D: в3 e7 — G61Q: в4 e6 — G624: в14 e1 — G626: в14 e8 — GL-544: в12 e5 — GL-544CT: в11 e3 — GL-615: в3 e7 — GL-616: в3 e7 — GL-616D: в5 e7 — GL-61QCT: в14 e4 — GL-615CTE: в15 e2 — GL-616DCTE: в15 e4

The input board for this signal is Pcb_3759.

CHuE57: Dropper err. on the right Halted.

Sensor input:

Pcb_3759 J11 p11

Command output:

G44J: в3 e8 — G54JCT: в3 e1 — G54JOT: в3 e1 — G615: в4 e4 — G615D: в4 e4 — G616: в3 e4 — G616D: в3 e4 — G61Q: в4 e4 — G624: в3 e6 — G626: в3 e1 — GL-544: в5 e2 — GL-544CT: в6 e5 — GL-615: в3 e4 — GL-616: в3 e4 — GL-616D: в6 e4 — GL-61QCT: в13 e5 — GL-616CTE: в3 e7 — GL-615CTE: в13 e1 — GL-616DCTE: в14 e5

The input board for this signal is Pcb_3759.

After that in the first part of the Heel the mechanical “Needle-raising Piker” have raised a certain number of needles, in the second part of the Heel the “Needle-lowering Piker”(right and left) devices will lower the same needles, 2 for each alternating rotation of the Cylinder.
The procedure for the Pioker operation provides a series of commands and controls.
The position of the “Needle-lowering Piker” (high and low) is controlled by a “Hall sensor” mounted on a small board that is an integral part of the Piker device itself.
The ON or OFF status of the “Led” place on this board visually indicates to the user the status of this control input for the Piker position.
According to the type of problem that can be present in the routine are displaying specific errors.

The rest condition at End of cycle is:

Piker in up position:

Solenoid valve not excited - Led OFF - Inputs Autotest = “0”.

Until the entry into the Heel, about the piker, no command is active and no control is active.

At the entry into the Heel, and for all the first part of the Heel is active the command that lowers the Piker.
At the same time is activated a procedure for the control of the Piker position.
The right codition in this zone of the sock is:

Piker in down position:

Solenoid valve excited - Led ON - Inputs Autotest = “1”.

When starts the second part of the Heel, the Piker must lower 2 needles for each time.
Therefore is activated a routine with a sequence of commands and controls.
The command is disabled and the Piker gets up awaiting to meet the needles that should be lowered, what will happen to a certain point during the Cylinder rotation.
Reached a certain Cylinder degree the software will run a control on the status of the input signal related the device.
The right codition in this zone of the sock is:

Piker in up position:

Solenoid valve not excited - Led OFF - Inputs Autotest = “0”.

Continuing with the Cylinder rotation the needles hit the Piker, whose “Blade” has a recess that may contain 2 needles.
The piker hit by the needles is lowered bringing with itself the 2 needles in the hollow.
Normally in the Sock Program is set the function “Piker Stop”.
With this programming in the second part of the Heel, just the software receives the signal of Piker low (caused by the impact of needles against the Piker itself) is activated the Piker command.
It will therefore retained low.
The right codition in this zone of the sock is:

Piker in down position:

Solenoid valve excited - Led ON - Inputs Autotest = “1”.

The Solenoid valve is energized only if is programmed the “Piker Stop” function.

Otherwise appears this error.
It indicates to the user that the Piker has not reached the low position.
The impact of the needles has not been corrected and the Piker has not lowered until the intended quota.

Finished the stage of lowering of these needles, in the step (economizer) following the piker gets up again, ready to repeat the same sequence with other needles.
This will continue until have been lowered all the needles envisaged in the Sock Program (Heel economizers).

In case of error first check if has been intervened the control device (real error).
Eventually solve the problem.

- Then check the condition of movement and mechanical functionality of the Piker.

If the control device has not intervened, proceed as follows.

With error active (non-erasable with [F8] key), access to Inputs Autotest.
Press the [CTRL] + [B] keys in the error window.

If the Inpurs Autoest displays the value “1”:

- *Replace the Input board.*

If the Inpurs Autoest displays the value “0”:

- *Check the correct adjustment of the position sensor, and possibly replace it.*
  In this case the position sensor (Hall effect sensor) is represented by the control board:
  G1840130
- *Check the connecting cables between the sensor and the inputs board.*
- *Replace the Input board.*

Dial management for Traditional Toe Closure procedure

Some models of GOAL machine produce socks in which the Toe is closed using the “Traditional” system.
The sock construction begins from the “Toe”, then with its closure, and ends with the construction of the “Welt”.
During the Toe construction, to run the closure procedure, the Dial must perform a series of special movements, determined by a series of commands controlled by the reading of a series of sensors.
This procedure is complicated, it is controlled in its various stages and therefore several errors alerts the user if are found anomalies in the operation.
In these paragraphs is described the procedure in its main stages, are listed the specific controls which are involved, are listed the sensors with their task of control.

Sequence 1 (Toe Closure position)

This sequence is on the procedure which shall prepare the Dial for the Toe closure.

1. The sequence begins with the stop of the machine.
2. Intervenes the “Dial Brake” command in order to block the half of the “Jacks Dial” not used for the Toe closure.
   It thus remains jointly liable with the Dial unit and be released from the “Jacks Dial Toe side”.
3. The Dial raiser motor raises the Dial up to a share that allows the following overturning of the Dial.
4. Intervenes the “Dial Raising” command, the Dial unit gets up, except the “Jacks Dial Toe side” part, which should then turn around.
   The transmission organs that transmit the Cylinder motion are jointly liable with this part of the Dial and are at this point released from the rest of the Dial unit.
   Correct Dial movement is controlled by the software with reading of the status of the 2 sensors:
   Dial lift control upper sensor
   Dial lift control lower sensor
5. Intervenes the “Dial Tilting” command, shall enter a rack that determines the overturning of the “Jacks Dial Toe side”.
   Correct Dial movement is controlled by the software with reading of the status of the 2 sensors:
   Dial control normal position
   Dial control capsize position
6. The cylinder begins to turn for about 180° then stop.
   The cylinder rotation shall also be forwarded to the part of Dial overturned, which jointly run it, too.
   This part of Dial so back in its original position, but overturned of 180°.
   The Jacks previously present on the high part of this Dial are now in the lower part.
   They may be used for the closure of Toe closure.
7. Intervenes the “Dial Closing” command, the Dial unit gets down, is removed the “Dial Brake” command.
   At this point the Dial unit back compacted in all its parts and is ready to run the Toe Closure.
8. The Dial raiser motor lowers the Dial in the working position.
9. The Cylinder (machine) will return in rotation with the Dial in condition to run the Toe Closure.

Sequence 2A (return in Transfer Dial Jacks position)

This sequence is on the procedure that determines the return of the Dial in the normal status of Transfer Dial Jacks, using the system with a stop of the machine (so without Rephaser).
The sequence begins at the end of the operation of Toe Closure.

1. The sequence begins with the stop of the machine.
2. The Dial raiser motor raises the Dial up to a share that allows the following overturning of the Dial.
3. Intervenes the “Dial Brake” command in order to block the half of the “Jacks Dial” not used for the Toe closure.

It thus remains jointly liable with the Dial unit and be released from the “Jacks Dial Toe side”.

4. Intervenes the “Dial Raising” command, the Dial unit gets up, except the “Jacks Dial Toe side” part, which should then turn around.
   The transmission organs that transmit the Cylinder motion are jointly liable with this part of the Dial and are at this point released from the rest of the Dial unit.
   Correct Dial movement is controlled by the software with reading of the status of the 2 sensors:
   Dial lift control upper sensor
   Dial lift control lower sensor
5. Intervenes the “Dial Tilting” command, shall enter a rack that determines the overturning of the “Jacks Dial Toe side”.
   Correct Dial movement is controlled by the software with reading of the status of the 2 sensors:
   Dial control normal position
   Dial control capsize position
6. The cylinder begins to turn for about 180° then stop.
   The cylinder rotation shall also be forwarded to the part of Dial overturned, which jointly run it, too.
   This part of Dial so back in its original position, but overturned of 180°.
   The Jacks previously present on the high part of this Dial are now in the lower part.
   They may be used for the normal Transfer Dial Jacks.
7. Intervenes the “Dial Closing” command, the Dial unit gets down, is removed the “Dial Brake” command.
   At this point the Dial unit back compacted in all its parts and is ready to run the normal Transfer Dial Jacks.
8. The Dial raiser motor lowers the Dial in the working position.
9. The Cylinder (machine) will return in rotation with the Dial in normal condition to run the Transfer Dial Jacks.

Sequence 2B (return in Transfer Dial Jacks position by the Rephaser)

This sequence is on the procedure that determines the return of the Dial in the normal status of Transfer Dial Jacks, using the system without the stop of the machine (so with Rephaser).
The machine at the end of the operation of Toe Closure continues with the Sock production with the Dial in the condition of Toe Closure (partly overturned).
This Phase control procedure (return of the Dial in “Normal” condition) begins when the Sock Cycle is in the Heel, a zona where are not programmed yarn-fingers change, in that they involve the use of the Saw device to cut the yarn.

1. Intervenes the “Saw release” command, a mechanism released the rotation of the Saw (Dial) by the Cylinder rotation.
   Correct operation movement is controlled by the software with reading of the status of the sensors:
   Rephaser clutch proximity switch
   Rephaser engage stage stop prox.switch
2. The Dial raiser motor raises the Dial up to a share that allows the following overturning of the Dial.
3. Intervenes the “Dial Brake” command in order to block the half of the “Jacks Dial” not used for the Toe closure.
   It thus remains jointly liable with the Dial unit and be released from the “Jacks Dial Toe side”.
4. Intervenes the “Dial Raising” command, the Dial unit gets up, except the “Jacks Dial Toe side” part, which should then turn around.
   Correct Dial movement is controlled by the software with reading of the status of the 2 sensors:
   Dial lift control upper sensor
   Dial lift control lower sensor
5. Intervenes the Rephaser mechanism which rotates the “Jacks Dial Toe side” for about 180°.
   The commands used by this mechanism, are:
   Dial reposition
   Dial phase
   Correct operation movement is controlled by the software with reading of the status of the sensors:
   Rephaser clutch proximity switch
6. Intervenes the “Dial Tilting” command, shall enter a rack that determines the overturning of the “Jacks Dial Toe side”.
   Correct Dial movement is controlled by the software with reading of the status of the 2 sensors:
   Dial control normal position
   Dial control capsize position
7. Intervenes the “Dial Closing” command, the Dial unit gets down, is removed the “Dial Brake” command.
   At this point the Dial unit back compacted in all its parts and is ready to run the normal Transfer Dial Jacks.
8. The Dial raiser motor lowers the Dial in the working position.
9. Intervenes again the Rephaser mechanism to return in the original position, ready to operate in the next sock.
   The commands used by this mechanism, are:

Dial reposition
Dial phase
Correct operation movement is controlled by the software with reading of the status of the sensors:
Rephaser clutch proximity switch
Dial phase control - 0 position

10. Intervenes the “Saw release” command, a mechanism hooked the rotation of the Saw (Dial) to the Cylinder rotation.
Correct operation movement is controlled by the software with reading of the status of the sensors:
Rephaser clutch proximity switch
Rephaser engage stage stop prox.switch

11. The Cylinder (machine) will return in rotation with the Dial in normal condition to run the Transfer Dial Jacks.

Sensor of control

The sensors of control (proximity or contacts) relating to the Dial management for the “Traditional Closed Toe” are:

- Rephaser clutch proximity switch
  Dial phase control
  This sensor controls the operation of the towing Hook and Release of the Saw (Dial) with the Cylinder motion.
  This sensor controls the movement of Dial rephasing executed through the Rephaser device.
  These operations must correctly follow the engage and disengage phases which are controlled by this sensor.
- Rephaser engage stage stop prox.switch
  This sensor, during the Release/Hook operation on the Saw towing, check if the operation fails because of the rupture of a particular transmission gearing.
  Will appear an alalrm, the user will be forced to turn off the machine and solve the mechanical problem.
- Dial phase control - 0 position
  This sensor controls the movement of Dial rephasing executed through the Rephaser device.
  At the end of the procedure the “Jacks Dial Toe side” rotates around 180°.
- Dial lift control upper sensor
  This sensor is positioned so that be in reading (closed) when the Dial is low in rest position.
  This then is also used in the various checks during the Dial movements (raises and close Dial).
- Dial lift control lower sensor
  This sensor is positioned so that be in reading (closed) when the Dial is high in overturning position of the “Jacks Dial Toe side”.
  This then is also used in the various checks during the Dial movements (raises and close Dial).
- Dial control normal position
  This sensor (the most in the top of 2) is positioned so that be in reading (closed) when the “Jacks Dial Toe side” is in “Normal” position.
- Dial control capsize position
  This sensor (the most in the down of 2) is positioned so that be in reading (closed) when the “Jacks Dial Toe side” is in “Overturning” position.

Commands

The Commands on the Dial management for the “Traditional Closed Toe” are:

- Dial raiser motor
  This motor is used to raise the Dial unit so as to enable the overturning of the “Jacks Dial Toe side”.
  At the end of the operations of overturning in “Normal” position or in “Overturned” position, the Dial unit back low in the working position.
- Dial raising
  This command raises the Dial unit, excluding the “Jacks Dial Toe side”.
  This half of the Jacks Dial remains in low position where can run the overturning and then the rotation.
  This command is removed when is activated the function of Dial closing, which lowers the Dial unit.
- Dial closing
  This command lowers the Dial unit, which is compacted with the half of the Jacks Dial left at its original height.
  The working height of the Dial so compacted is different between the 2 possible condition, the one with “Jacks Dial Toe side” in “Normal” position and that in “Overturned” position.
  These 2 heights correspond to the condition of “Transfer Dial Jacks” (“Normal”) and to the condition of “Toe Closure” (Capsize).

This command is removed when is activated the function of Dial opening, which raises the Dial unit.

- Dial brake
  This command locks the half of the Jacks Dial that must remain jointly liable with the Dial unit when it rises. This always happens before of the "Dial Raising" command.
  This command is removed after the execution of the "Dial Closing" command, so that all the Jacks Dial can turn jointly with the cylinder.
- Dial tilting
  >This command places the "Jacks Dial Toe side" in "Normal" position (Condition for the Transfer Dial Jacks) or in "Overturned" position (Condition for the Toe Closure).
- Saw blade release
  This command active the procedure of Release or Hooking of the Saw towing.
  This command performs a mechanical engage which may cause (or no) the movement of the Saw (Dial) jointly with the Cylinder.
- Dial phase
  This command is part of the mechanical procedure for the re-phasing of the "Jacks Dial Toe side".
- Dial reposition
  This command is part of the mechanical procedure for the re-phasing of the "Jacks Dial Toe side".

Messages on the Dial out of position (Mc. CT internal)

CHuE58: Dial not in position Lower proxim. A

CHuE59: Dial not in position Lower proxim. B

CHuE60: Dial not in position Lower proxim. C

CHuE61: Dial not in position Lower proxim. D

CHuE62: Dial not in position Lower proxim. E

Sensor input:
Pcb_3759 J14 p12
Command output:
Dial raising
G54JCT: въ16 e4 — GL-544CT: въ16 e4 — GL-61QCT: въ16 e4
Dial closing
G54JCT: въ16 e5 — GL-544CT: въ16 e5 — GL-61QCT: въ16 e5

The input board for this signal is Pcb_3759.

This message exists in the only machine prepared with "Traditional Closed Toe".
This message refers to control of the Up/Down movement of the Dial Unit, which is required for next tilting of the "Jack Dial toe side".
This movement is determined by the command that reaches the relative Solenoid Valve.

The Dial unit may be in 3 stable conditions:

1. Low in position of Transfer Dial Jacks.
2. Low in position of Toe Closure.
3. High in position to allow the Tilting movement of the "Jack Dial".

A couple of sensors check the coherency of the position than expected by the Program.
This couple of sensors also check the various stages of the sequence of Raisings and Closing of the Dial unit.

The conditions for this working status of the Dial are:

Low in position of Transfer Dial Jacks.

A. High sensor for:
Dial lift control upper sensor
Input status = "Closed".

Autotest = “1”.

B. Low sensor for:
Dial lift control lower sensor
Input status = “Open”.
Autotest = “0”.

Low in position of Toe Closure.

A. High sensor for:
Dial lift control upper sensor
Input status = “Open”.
Autotest = “0”.

B. Low sensor for:
Dial lift control lower sensor
Input status = “Open”.
Autotest = “0”.

High in position to allow the Tilting movement of the “Jack Dial”.

A. High sensor for:
Dial lift control upper sensor
Input status = “Open”.
Autotest = “0”.

B. Low sensor for:
Dial lift control lower sensor
Input status = “Closed”.
Autotest = “1”.

This error appears when the software detects an inputs status different from that provided in that point of the Program.
In particular this error indicates the user an incoherence in the signal from the sensor:
Dial lift control lower sensor

This error may appear in the case of malfunctions detected in the Dial Raises/Lowers sequence.

This specific error may appear during the sequence related the movement of:
Raising of the Dial from the position of Toe Closure
Closure of the Dial with arrival to the position of Toe Closure
This error is specific because at the end is added a letter (A, B, C, D, D) which specifies the point of the sequence where the software has found the error.
This thorough control management may help the operator in the identification of the wrong movement and therefore in the problem resolution.

A generic error, equal in the message, but without the addition of the final letter may appear in the event of malfunction during the other 2 sequences used:
Raising of the Dial from the rest position (Transfer Dial Jacks)
Closure of the Dial with return to the rest position (Transfer Dial Jacks)
This generic error is that which appears in the event of incoherence of the sensor signalr in stable working conditions of the Dial.
The logic of error is however equal, as well as his resolution.

This error alerts the user of a problem on the moveable device movement.
In general, the problem is due to:
- Mechanical malfunction of the device (not reached the intended position).
- Slow response of the solenoid valve of command.
- Sensor adjustment not correct.
- Malfunction of the sensor.

Reference

For the information on the procedure of Toe Closure see the heading:
Dial management for Traditional Toe Closure procedure

For the analysis and the solution of this type of errors make reference to the chapter dedicated to the procedures for the resolution of faults relative the position error of the moveable devices (for example the moveable cams).

For the information on the procedure of troubleshooting relating Moveable cams errors see the heading:
Position errors: Moveable device (Moveable Cam)

CHuE63: Dial not in position Upper proxim. A

CHuE64: Dial not in position Upper proxim. B

CHuE65: Dial not in position Upper proxim. C

CHuE66: Dial not in position Upper proxim. D

CHuE67: Dial not in position Upper proxim. E

Sensor input:
Pcb_3759 J14 p14
Command output:
Dial raising
G54JCT: въ16 e4 — GL-544CT: въ16 e4 — GL-61QCT: въ16 e4
Dial closing
G54JCT: въ16 e5 — GL-544CT: въ16 e5 — GL-61QCT: въ16 e5

The input board for this signal is Pcb_3759.

This message exists in the only machine prepared with “Traditional Closed Toe”.
This message refers to control of the Up/Down movement of the Dial Unit, which is required for next tilting of the “Jack Dial toe side”.
This movement is determined by the command that reaches the relative Solenoid Valve.

The Dial unit may be in 3 stable conditions:
1. Low in position of Transfer Dial Jacks.
2. Low in position of Toe Closure.
3. High in position to allow the Tilting movement of the “Jack Dial”.

A couple of sensors check the coherency of the position than expected by the Program.
This couple of sensors also check the various stages of the sequence of Raisings and Closing of the Dial unit.

The conditions for this working status of the Dial are:

Low in position of Transfer Dial Jacks.

A. High sensor for:
Dial lift control upper sensor
Input status = “Closed”.
Autotest = “1”.

B. Low sensor for:
Dial lift control lower sensor
Input status = “Open”.
Autotest = “0”.

Low in position of Toe Closure.

A. High sensor for:
Dial lift control upper sensor
Input status = “Open”.
Autotest = “0”.

B. Low sensor for:
Dial lift control lower sensor
Input status = “Open”.
Autotest = “0”.

High in position to allow the Tilting movement of the “Jack Dial”.

A. High sensor for:

Dial lift control upper sensor
Input status = “Open”.
Autotest = “0”.

B. Low sensor for:
Dial lift control lower sensor
Input status = “Closed”.
Autotest = “1”.

This error appears when the software detects an inputs status different from that provided in that point of the Program.
In particular this error indicates the user an incoherence in the signal from the sensor:
Dial lift control upper sensor

This error may appear in the case of malfunctions detected in the Dial Raises/Lowers sequence.

This specific error may appear during the sequence related the movement of:
Raising of the Dial from the position of Toe Closure
Closure of the Dial with arrival to the position of Toe Closure
This error is specific because at the end is added a letter (A, B, C, D, D) which specifies the point of the sequence where the software has found the error.
This thorough control management may help the operator in the identification of the wrong movement and therefore in the problem resolution.

A generic error, equal in the message, but without the addition of the final letter may appear in the event of malfunction during the other 2 sequences used:
Raising of the Dial from the rest position (Transfer Dial Jacks)
Closure of the Dial with return to the rest position (Transfer Dial Jacks)
This generic error is that which appears in the event of incoherence of the sensor signalr in stable working conditions of the Dial.
The logic of error is however equal, as well as his resolution.

This error alerts the user of a problem on the moveable device movement.
In general, the problem is due to:
- Mechanical malfunction of the device (not reached the intended position).
- Slow response of the solenoid valve of command.
- Sensor adjustment not correct.
- Malfunction of the sensor.

Reference

For the information on the procedure of Toe Closure see the heading:
Dial management for Traditional Toe Closure procedure

For the analysis and the solution of this type of errors make reference to the chapter dedicated to the procedures for the resolution of faults relative the position error of the moveable devices (for example the moveable cams).
For the information on the procedure of troubleshooting relating Moveable cams errors see the heading:
Position errors: Moveable device (Moveable Cam)

CHuE124: Dial not in position. Lower proximity

Sensor input:
Pcb_3759 J14 p12
Command output:
Dial raising
G54JCT: въ16 e4 — GL-544CT: въ16 e4 — GL-61QCT: въ16 e4
Dial closing
G54JCT: въ16 e5 — GL-544CT: въ16 e5 — GL-61QCT: въ16 e5

The input board for this signal is Pcb_3759.

This message exists in the only machine prepared with “Traditional Closed Toe”.
This message refers to control of the Up/Down movement of the Dial Unit, which is required for next tilting of the “Jack Dial toe side”.
This movement is determined by the command that reaches the relative Solenoid Valve.

The Dial unit may be in 3 stable conditions:

1. Low in position of Transfer Dial Jacks.
2. Low in position of Toe Closure.
3. High in position to allow the Tilting movement of the “Jack Dial”.

A couple of sensors check the coherency of the position than expected by the Program.
This couple of sensors also check the various stages of the sequence of Raisings and Closing of the Dial unit.

The conditions for this working status of the Dial are:

Low in position of Transfer Dial Jacks.

A. High sensor for:
Dial lift control upper sensor
Input status = “Closed”.
Autotest = “1”.

B. Low sensor for:
Dial lift control lower sensor
Input status = “Open”.
Autotest = “0”.

Low in position of Toe Closure.

A. High sensor for:
Dial lift control upper sensor
Input status = “Open”.
Autotest = “0”.

B. Low sensor for:
Dial lift control lower sensor
Input status = “Open”.
Autotest = “0”.

High in position to allow the Tilting movement of the “Jack Dial”.

A. High sensor for:
Dial lift control upper sensor
Input status = “Open”.
Autotest = “0”.

B. Low sensor for:
Dial lift control lower sensor
Input status = “Closed”.
Autotest = “1”.

This error appears when the software detects an inputs status different from that provided in that point of the Program.
In particular this error indicates the user an incoherence in the signal from the sensor:
Dial lift control lower sensor

This generic error may appear, as well as a result of control of one of stable conditions expected for the Dial unit, even in the event of malfunctions detected in the sequence on the movement of:
Raising of the Dial from the rest position (Transfer Dial Jacks)
Closure of the Dial with return to the rest position (Transfer Dial Jacks)

A specific error, equal in the message, but with the addition of the final letter (A, B, C, D, E) which specifies the point of the sequence where the software has found the error, may appear in the event of malfunction during the other 2 sequences used:
Raising of the Dial from the position of Toe Closure
Closure of the Dial with arrival to the position of Toe Closure
The logic of error is however equal, as well as his resolution.

This error alerts the user of a problem on the moveable device movement.

In general, the problem is due to:
- Mechanical malfunction of the device (not reached the intended position).
- Slow response of the solenoid valve of command.
- Sensor adjustment not correct.
- Malfunction of the sensor.

Reference

For the information on the procedure of Toe Closure see the heading:
Dial management for Traditional Toe Closure procedure

For the analysis and the solution of this type of errors make reference to the chapter dedicated to the procedures for the resolution of faults relative the position error of the moveable devices (for example the moveable cams).
For the information on the procedure of troubleshooting relating Moveable cams errors see the heading:
Position errors: Moveable device (Moveable Cam)

CHuE125: Dial not in position. Upper proximity

Sensor input:
Pcb_3759 J14 p14
Command output:
Dial raising
G54JCT: въ16 e4 — GL-544CT: въ16 e4 — GL-61QCT: въ16 e4
Dial closing
G54JCT: въ16 e5 — GL-544CT: въ16 e5 — GL-61QCT: въ16 e5

The input board for this signal is Pcb_3759.

This message exists in the only machine prepared with “Traditional Closed Toe”.
This message refers to control of the Up/Down movement of the Dial Unit, which is required for next tilting of the “Jack Dial toe side”.
This movement is determined by the command that reaches the relative Solenoid Valve.

The Dial unit may be in 3 stable conditions:
1. Low in position of Transfer Dial Jacks.
2. Low in position of Toe Closure.
3. High in position to allow the Tilting movement of the “Jack Dial”.

A couple of sensors check the coherency of the position than expected by the Program.
This couple of sensors also check the various stages of the sequence of Raisings and Closing of the Dial unit.

The conditions for this working status of the Dial are:

Low in position of Transfer Dial Jacks.

A. High sensor for:
Dial lift control upper sensor
Input status = “Closed”.
Autotest = “1”.

B. Low sensor for:
Dial lift control lower sensor
Input status = “Open”.
Autotest = “0”.

Low in position of Toe Closure.

A. High sensor for:
Dial lift control upper sensor
Input status = “Open”.
Autotest = “0”.

B. Low sensor for:
Dial lift control lower sensor

Input status = “Open”.
Autotest = “0”.

High in position to allow the Tilting movement of the “Jack Dial”.

A. High sensor for:
Dial lift control upper sensor
Input status = “Open”.
Autotest = “0”.

B. Low sensor for:
Dial lift control lower sensor
Input status = “Closed”.
Autotest = “1”.

This error appears when the software detects an inputs status different from that provided in that point of the Program.
In particular this error indicates the user an incoherence in the signal from the sensor:
Dial lift control upper sensor

This generic error may appear, as well as a result of control of one of stable conditions expected for the Dial unit, even in the event of malfunctions detected in the sequence on the movement of:
Raising of the Dial from the rest position (Transfer Dial Jacks)
Closure of the Dial with return to the rest position (Transfer Dial Jacks)

A specific error, equal in the message, but with the addition of the final letter (A, B, C, D, E) which specifies the point of the sequence where the software has found the error, may appear in the event of malfunction during the other 2 sequences used:
Raising of the Dial from the position of Toe Closure
Closure of the Dial with arrival to the position of Toe Closure
The logic of error is however equal, as well as his resolution.

This error alerts the user of a problem on the moveable device movement.
In general, the problem is due to:
- Mechanical malfunction of the device (not reached the intended position).
- Slow response of the solenoid valve of command.
- Sensor adjustment not correct.
- Malfunction of the sensor.

Reference

For the information on the procedure of Toe Closure see the heading:
Dial management for Traditional Toe Closure procedure

For the analysis and the solution of this type of errors make reference to the chapter dedicated to the procedures for the resolution of faults relative the position error of the moveable devices (for example the moveable cams).
For the information on the procedure of troubleshooting relating Moveable cams errors see the heading:
Position errors: Moveable device (Moveable Cam)

Messages on the Dial rephaser management (Mc. CT internal)

CHuE120: Dial phase contr. stop motio. 0 position

Sensor input:
Pcb_3759 J14 p06
Command output:
Dial reposition
G54JCT: въ16 e2 — GL-544CT: въ16 e2 — GL-61QCT: въ16 e2
Dial phase
G54JCT: въ16 e1 — GL-544CT: въ16 e1 — GL-61QCT: въ16 e1

The input board for this signal is Pcb_3759.

This message exists in the only machine prepared with “Traditional Closed Toe”.
This message refers to control of the Dial Phase procedure (return in “Normal” condition of the Dial).
This movement is determined by the command that reaches the relative Solenoid Valve.
The control is carried out through the signals given by the sensor:

Dial phase control - 0 position

This error appears at the end of the second Re-phasing procedure, if the sensor is found in a not correct status at the end of the Re-phasing sequence.
After the Dial re-phasing, the Rephaser mechanism must be reported in its original position, ready to operate in the next sock.

At the end of the Re-phasing procedure and until the successive intervention of the Rephaser, the sensor “reads” always the mechanical part.
This condition is also that of rest.
The right status of the sensor in this phase is:

Input status = “Closed”.
Autotest = “1”.

Otherwise appears this error.

This error alerts the user of a problem on the moveable device movement.
In general, the problem is due to:

- Mechanical malfunction of the device (not reached the intended position).
- Slow response of the solenoid valve of command.
- Sensor adjustment not correct.
- Malfunction of the sensor.

Reference

For the information on the procedure of Toe Closure see the heading:

Dial management for Traditional Toe Closure procedure

For the analysis and the solution of this type of errors make reference to the chapter dedicated to the procedures for the resolution of faults relative the position error of the moveable devices (for example the moveable cams).
For the information on the procedure of troubleshooting relating Moveable cams errors see the heading:

Position errors: Moveable device (Moveable Cam)

CHuE131: Dial phase control stop motion

Sensor input:

G54JCT: Pcb_3759 J14 p05 — GL-544CT: Pcb_3759 J14 p11 — GL-61QCT: Pcb_3759 J14 p11

Command output:

Dial reposition
G54JCT: въ16 e2 — GL-544CT: въ16 e2 — GL-61QCT: въ16 e2
Dial phase
G54JCT: въ16 e1 — GL-544CT: въ16 e1 — GL-61QCT: въ16 e1

The input board for this signal is Pcb_3759.

This message exists in the only machine prepared with “Traditional Closed Toe”.
This message refers to control of the Dial Phase procedure (return in “Normal” condition of the Dial).
This movement is determined by the command that reaches the relative Solenoid Valve.
The control is carried out through the signals given by the sensor:

Dial phase control

This sensor is the main control instrument of the procedures of Dial Release/Hook and Re-phasing.
This sensor is placed in reading on a special gear, the sequence of Reading (empty and full) is controlled by the software.
The lack of respect of these sequences, depending on the controlled movement, determines the appearance of a spe-

cific error/alarm message.

This error appears at the end of the second Re-phasing procedure, if the sensor is found in a not correct status at the end of the Re-phasing sequence.
This sequence is performed with time sequence, and the tests on the inputs status are multiple, testing in this way all the sequence stages.
In case of error, if it is cancelled the software repeats the attempt of Re-phasing.
If the operation ends correctly the Sock Cycle can continue, otherwise reset the Cycle and analyse the problem.

This error alerts the user of a problem on the moveable device movement.
In general, the problem is due to:
- Mechanical malfunction of the device (not reached the intended position).
- Slow response of the solenoid valve of command.
- Sensor adjustment not correct.
- Malfunction of the sensor.

Reference

For the information on the procedure of Toe Closure see the heading:
Dial management for Traditional Toe Closure procedure

For the analysis and the solution of this type of errors make reference to the chapter dedicated to the procedures for the resolution of faults relative the position error of the moveable devices (for example the moveable cams).
For the information on the procedure of troubleshooting relating Moveable cams errors see the heading:
Position errors: Moveable device (Moveable Cam)

Messages on the Saw Release/Hook management (Mc. CT internal)

CHuE128: Saw blade engage in wrong position

Sensor input:
G54JCT: Pcb_3759 J14 p05 — GL-544CT: Pcb_3759 J14 p11 — GL-61QCT: Pcb_3759 J14 p11
Command output:
Saw blade release
G54JCT: въ16 e7 — GL-544CT: въ16 e7 — GL-61QCT: въ16 e7

The input board for this signal is Pcb_3759.

This message exists in the only machine prepared with “Traditional Closed Toe”.
This message concerns control of the Release procedure, i.e. return of movement transmission between Cylinder and Saw (Dial).
This movement is determined by the command that reaches the relative Solenoid Valve.
The control is carried out through the signals given by the sensor:
Dial phase control
This sensor is the main control instrument of the procedures of Dial Release/Hook and Re-phasing.
This sensor is placed in reading on a special gear, the sequence of Reading (empty and full) is controlled by the software.
The lack of respect of these sequences, depending on the controlled movement, determines the appearance of a specific error/alarm message.

This error appears during the Hooking procedure, if the sensor is found in a not correct status during or at the end of the Hooking sequence.
In sequence is first controlled at 170° if the sensor is “closed” (Autotest = “1”), then at 203° if the sensor is “open” (Autotest = “0”).
Otherwise appears this error.

The software continues to check the input, if the right status is restored the routine can continue.

If the signals are correct means that the Hooking procedure is ended successfully.
The control then will return to the standard condition, active outside of the various procedures of Release/Hook and Re-phasing, in which practically is verified only the sensor functionality.

This error alerts the user of a problem on the moveable device movement.
In general, the problem is due to:

- Mechanical malfunction of the device (not reached the intended position).
- Slow response of the solenoid valve of command.
- Sensor adjustment not correct.
- Malfunction of the sensor.

Reference

For the information on the procedure of Toe Closure see the heading:
Dial management for Traditional Toe Closure procedure

For the analysis and the solution of this type of errors make reference to the chapter dedicated to the procedures for the resolution of faults relative the position error of the moveable devices (for example the moveable cams).
For the information on the procedure of troubleshooting relating Moveable cams errors see the heading:
Position errors: Moveable device (Moveable Cam)

CHuE129: Saw blade release in wrong position

Sensor input:
G54JCT: Pcb_3759 J14 p05 — GL-544CT: Pcb_3759 J14 p11 — GL-61QCT: Pcb_3759 J14 p11
Command output:
Saw blade release
G54JCT: въ16 e7 — GL-544CT: въ16 e7 — GL-61QCT: въ16 e7

The input board for this signal is Pcb_3759.

This message exists in the only machine prepared with “Traditional Closed Toe”.
This message concerns control of the Hook procedure, i.e. detachment of movement transmission between Cylinder and Saw (Dial).
This movement is determined by the command that reaches the relative Solenoid Valve.
The control is carried out through the signals given by the sensor:
Dial phase control
This sensor is the main control instrument of the procedures of Dial Release/Hook and Re-phasing.
This sensor is placed in reading on a special gear, the sequence of Reading (empty and full) is controlled by the software.
The lack of respect of these sequences, depending on the controlled movement, determines the appearance of a specific error/alarm message.

This error appears when begins the Release procedure, immediately after the Release command, if the sensor is detected in a not correct status.
The right status of the sensor in this phase is:
Input status = “Closed”.
Autotest = “1”.
Otherwise appears this error.
The software continues to check the input, if the right status is restored the routine can continue.

This error alerts the user of a problem on the moveable device movement.
In general, the problem is due to:

- Mechanical malfunction of the device (not reached the intended position).
- Slow response of the solenoid valve of command.
- Sensor adjustment not correct.
- Malfunction of the sensor.

Reference

For the information on the procedure of Toe Closure see the heading:
Dial management for Traditional Toe Closure procedure

For the analysis and the solution of this type of errors make reference to the chapter dedicated to the procedures for the resolution of faults relative the position error of the moveable devices (for example the moveable cams).
For the information on the procedure of troubleshooting relating Moveable cams errors see the heading:
Position errors: Moveable device (Moveable Cam)

CHuE132: Saw blade release failure!! Press [F0]

Sensor input:
G54JCT: Pcb_3759 J14 p05 — GL-544CT: Pcb_3759 J14 p11 — GL-61QCT: Pcb_3759 J14 p11
Command output:
Saw blade release
G54JCT: въ16 e7 — GL-544CT: въ16 e7 — GL-61QCT: въ16 e7

The input board for this signal is Pcb_3759.

This message exists in the only machine prepared with “Traditional Closed Toe”.
This message refers to control of the Dial Phase procedure (return in “Normal” condition of the Dial).
This movement is determined by the command that reaches the relative Solenoid Valve.
The control is carried out through the signals given by the sensor:
Dial phase control
This sensor is the main control instrument of the procedures of Dial Release/Hook and Re-phasing.
This sensor is placed in reading on a special gear, the sequence of Reading (empty and full) is controlled by the software.
The lack of respect of these sequences, depending on the controlled movement, determines the appearance of a specific error/alarm message.

This error appears during the Re-phasing procedure, if the sensor is found in not correct status during or at the end of the Re-phasing sequence.
This sequence is performed with time sequence, and the tests on the inputs status are multiple, testing in this way all the sequence stages.
In case of error, if it is cancelled the software repeats the attempt of Re-phasing.
If the operation ends correctly the Sock Cycle can continue, otherwise reset the Cycle and analyse the problem.

This error alerts the user of a problem on the moveable device movement.
In general, the problem is due to:
- Mechanical malfunction of the device (not reached the intended position).
- Slow response of the solenoid valve of command.
- Sensor adjustment not correct.
- Malfunction of the sensor.

Reference

For the information on the procedure of Toe Closure see the heading:
Dial management for Traditional Toe Closure procedure

For the analysis and the solution of this type of errors make reference to the chapter dedicated to the procedures for the resolution of faults relative the position error of the moveable devices (for example the moveable cams).
For the information on the procedure of troubleshooting relating Moveable cams errors see the heading:
Position errors: Moveable device (Moveable Cam)

Messages on Elastic for the Toe Closure (Mc. CT internal)

CHuE121: Upper elastic feed 1 stop motion

Sensor input:

Pcb_3759 J14 p08

The input board for this signal is Pcb_3759.

This message exists in the only machine prepared with “Traditional Closed Toe”.
For the Toe Closure is used a yarn of elastic type whose supplyr is also determined by a stepping motor (called “Elastic feed 1”) and by a Yarn Takeup system.
The system “Motor and Yarn Takeup” has the task of maintaining the proper tension on the Elastic yarn used into the seam of Toe Closure.
The position of the Yarn Takeup is controlled through 2 sensors, that determine, one the start and one the stop of the Elastic motor during the Toe Closure procedure.

The conditions of “Start” and “stop” of the motor are the following:

A. Lower sensor obscured = Start for Elastic motor.
   The yarn tension is high, so the motor starts, feeding the Elastic yarn used for the seam.
B. Upper sensor obscured = Stop for Elastic motor.
   The yarn tension is low, so the motor stops, blocking the feeder of the Elastic yarn used for the seam.

The rest condition, present at End of Cycle, and in any case at the Start and at the End of the Toe Closure procedure is the following:

- Upper sensor obscured = Stop for Elastic motor.

Outside the 2 sensors of control of the Yarn Takeup movement are placed 2 points that can block the Yarn Takeup movement (protruding screws for the upper and lower End of Run).
To each of these screws is connected a sensor for the End of Run stop.
When the Yarn Takeup impacts against one of these 2 screws, the relative signal (software) determines the stop of the machine with the proper error.

This error is due to the intervention of control mechanism of the Yarn Takeup on the Elastic yarn used in the Toe Closure.
This control refers to the Top limit switch.
Therefore probably the yarn is broken or its tension is very low.

Through a cable is trasmitted this stop signal to the machine.
The correct condition (stop not active) is:
”contact open”
With stop not active, the inputs Autotest displays the value “0”.
With stop active, the inputs Autotest displays the value “1”.

In case of error first check if has been intervened the control device (real error).

- Solve the real problem that has caused the error.

This problem can have many causes, mechanical and electric, therefore:

- Assess and resolve a possible textile or mechanical problem.
- Check the cable concerning the sensor of control:
  ”Upper elastic feed 1 sensor”
- Replace the sensor of control:
  ”Upper elastic feed 1 sensor”
- Replace the Input board.
- Check the wiring that connect the sensor and the motor to the command board (in general the Pcb_3836 board).
- Replace the stepping motor indicated in the message.
- Replace the CAN module (board Pcb_3836) associated with the motor indicated in the message.

If the control device has not intervened, check the regulation and setting and then proceed as follows.

With error active (non-erasable with [F8] key), access to Inputs Autotest.
Press the [CTRL] + [B] keys in the error window.

If the Inpurs Autoest displays the value “0”:

- *Replace the Input board.*

If the Inpurs Autoest displays the value “1”:

- *To facilitate the failure search, disconnect the control wire from the device.*

  If the error is cancelled by pressing the [F8] key the device is defective.

  - *Replace the control device.*

  If the error remains.

  - *Check that the wire in its path between the device and the inputs board is not to ground. In the case, operate the repair or replacement of the wire.*
  - *Replace the Input board.*

CHuE122: Lower elastic feed 1 stop motion

Sensor input:
Pcb_3759 J14 p07

The input board for this signal is Pcb_3759.

This message exists in the only machine prepared with “Traditional Closed Toe”.
For the Toe Closure is used a yarn of elastic type whose supplyr is also determined by a stepping motor (called “Elastic feed 1”) and by a Yarn Takeup system.
The system “Motor and Yarn Takeup” has the task of maintaining the proper tension on the Elastic yarn used into the seam of Toe Closure.
The position of the Yarn Takeup is controlled through 2 sensors, that determine, one the start and one the stop of the Elastic motor during the Toe Closure procedure.

The conditions of “Start” and “stop” of the motor are the following:

A. Lower sensor obscured = Start for Elastic motor.
   The yarn tension is high, so the motor starts, feeding the Elastic yarn used for the seam.
B. Upper sensor obscured = Stop for Elastic motor.
   The yarn tension is low, so the motor stops, blocking the feeder of the Elastic yarn used for the seam.

The rest condition, present at End of Cycle, and in any case at the Start and at the End of the Toe Closure procedure is the following:

- Upper sensor obscured = Stop for Elastic motor.

Outside the 2 sensors of control of the Yarn Takeup movement are placed 2 points that can block the Yarn Takeup movement (protruding screws for the upper and lower End of Run).
To each of these screws is connected a sensor for the End of Run stop.
When the Yarn Takeup impacts against one of these 2 screws, the relative signal (software) determines the stop of the machine with the proper error.

This error is due to the intervention of control mechanism of the Yarn Takeup on the Elastic yarn used in the Toe Closure.
This control refers to the Bottom limit switch.
Therefore probably the yarn tension is very high.

Through a cable is trasmitted this stop signal to the machine.
The correct condition (stop not active) is:
”contact open”
With stop not active, the inputs Autotest displays the value “0”.
With stop active, the inputs Autotest displays the value “1”.

In case of error first check if has been intervened the control device (real error).

- Solve the real problem that has caused the error.

This problem can have many causes, mechanical and electric, therefore:

- Assess and resolve a possible textile or mechanical problem.
- Check the cable concerning the sensor of control:
  ”Lower elastic feed 1 sensor”
- Replace the sensor of control:
  ”Lower elastic feed 1 sensor”
- Replace the Input board.

- Check the wiring that connect the sensor and the motor to the command board (in general the Pcb_3836 board).
- Replace the stepping motor indicated in the message.
- Replace the CAN module (board Pcb_3836) associated with the motor indicated in the message.

If the control device has not intervened, check the regulation and setting and then proceed as follows.

With error active (non-erasable with [F8] key), access to Inputs Autotest.
Press the [CTRL] + [B] keys in the error window.

If the Inpurs Autoest displays the value “0”:
- *Replace the Input board.*

If the Inpurs Autoest displays the value “1”:
- *To facilitate the failure search, disconnect the control wire from the device.*

If the error is cancelled by pressing the [F8] key the device is defective.
- *Replace the control device.*

If the error remains.
- *Check that the wire in its path between the device and the inputs board is not to ground. In the case, operate the repair or replacement of the wire.*
- *Replace the Input board.*

CHuE123: Elastic feed 1 broken

Sensor input:
Pcb_3759 J14 p09

The input board for this signal is Pcb_3759.

This message exists in the only machine prepared with “Traditional Closed Toe”.
This error is due to intervention of the Elastic yarn breakage control mechanism (elastic motor out), generally because the yarn has broken.
The Elastic motor on this error is that used in the Toe Closure.

Through a cable is trasmitted this stop signal to the machine.
The correct condition (stop not active) is:
”contact open”
With stop not active, the inputs Autotest displays the value “0”.
With stop active, the inputs Autotest displays the value “1”.

In case of error first check if has been intervened the control device (real error).
- Solve the real problem that has caused the error.

If the control device has not intervened, check the regulation and setting and then proceed as follows.

With error active (non-erasable with [F8] key), access to Inputs Autotest.
Press the [CTRL] + [B] keys in the error window.

If the Inpurs Autoest displays the value “0”:
- *Replace the Input board.*

If the Inpurs Autoest displays the value “1”:
- *To facilitate the failure search, disconnect the control wire from the device.*

If the error is cancelled by pressing the [F8] key the device is defective.
- *Replace the control device.*

If the error remains.
- *Check that the wire in its path between the device and the inputs board is not to ground. In the case, operate the repair or replacement of the wire.*
- *Replace the Input board.*

Notice

Attention

If the wire that connects the inputs board to the control device was rough or however interrupted, the error would never appear, then the machine would work without this control.

CHuE130: Elastic motor feed 1 not at zero

Sensor input:
Pcb_3759 J14 p08

The input board for this signal is Pcb_3759.

This message exists in the only machine prepared with “Traditional Closed Toe”.
For the Toe Closure is used a yarn of elastic type whose supplyr is also determined by a stepping motor (called “Elastic feed 1”) and by a Yarn Takeup system.
The system “Motor and Yarn Takeup” has the task of maintaining the proper tension on the Elastic yarn used into the seam of Toe Closure.
The position of the Yarn Takeup is controlled through 2 sensors, that determine, one the start and one the stop of the Elastic motor during the Toe Closure procedure.

The conditions of “Start” and “stop” of the motor are the following:

A. Lower sensor obscured = Start for Elastic motor.
The yarn tension is high, so the motor starts, feeding the Elastic yarn used for the seam.

B. Upper sensor obscured = Stop for Elastic motor.
The yarn tension is low, so the motor stops, blocking the feeder of the Elastic yarn used for the seam.

The rest condition, present at End of Cycle, and in any case at the Start and at the End of the Toe Closure procedure is the following:

- Upper sensor obscured = Stop for Elastic motor.

This error appears when, completed the procedure for the Toe Closure, and despite the software has commanded the motor, the sensor that check the upper position of the Yarn Takeup movement is obscured.
The Elastic motor Feed 1 has led the the Yarn Takeup in the correct final position.

This error is only a warning for the user, eliminating the error with [F8], the machine can be restarted.
The user, if he want, will only manually restore the correct Elastic yarn tension.

In case, the motor does not function properly, the following cycle of Toe Closure will appear the errors:
CHuE121
CHuE122

Messages on the Normal/Capsize position of the Dial (Mc. CT internal)

CHuE126: Capsize position not corrected

CHuE133: Capsize position not corrected

Sensor input:
Pcb_3759 J14 p16
Command output:
Dial tilting
G54JCT: въ16 e6 — GL-544CT: въ16 e6 — GL-61QCT: въ16 e6

The input board for this signal is Pcb_3759.

This message exists in the only machine prepared with “Traditional Closed Toe”.

This message refers to control of the Tilting movement of the “Jack Dial toe side”.
This movement is determined by the command that reaches the relative Solenoid Valve.

This part of the Dial may be in 2 final conditions:

1. Position for the Transfer Dial Jacks (“Normal”).
   In this condition the solenoid valve is de-energized.
2. Position for the Toe Closure (“Capsize”).
   In this condition the solenoid valve is energized.

A couple of sensors check the coherency of the position than expected by the Program.
The conditions for this working status of the Dial are:

Position for the Toe Closure (“Capsize”).

A. High sensor for:
   Dial control normal position
   Input status = “Open”.
   Autotest = “0”.
B. Low sensor for:
   Dial control capsize position
   Input status = “Closed”.
   Autotest = “1”.

This error appears when the software detects an inputs status different from that provided in that point of the Program.
In particular the signal of the sensors does not correspond to the position of:
”Dial in Tilting position”

This error alerts the user of a problem on the moveable device movement.
In general, the problem is due to:

- Mechanical malfunction of the device (not reached the intended position).
- Slow response of the solenoid valve of command.
- Sensor adjustment not correct.
- Malfunction of the sensor.

Reference

For the information on the procedure of Toe Closure see the heading:
Dial management for Traditional Toe Closure procedure

For the analysis and the solution of this type of errors make reference to the chapter dedicated to the procedures for the resolution of faults relative the position error of the moveable devices (for example the moveable cams).
For the information on the procedure of troubleshooting relating Moveable cams errors see the heading:
Position errors: Moveable device (Moveable Cam)

CHuE127: Normal position not corrected

CHuE134: Normal position not corrected

Sensor input:
Pcb_3759 J14 p15
Command output:
Dial tilting
G54JCT: въ16 e6 — GL-544CT: въ16 e6 — GL-61QCT: въ16 e6

The input board for this signal is Pcb_3759.

This message exists in the only machine prepared with “Traditional Closed Toe”.
This message refers to control of the Tilting movement of the “Jack Dial toe side”.
This movement is determined by the command that reaches the relative Solenoid Valve.

This part of the Dial may be in 2 final conditions:

1. Position for the Transfer Dial Jacks (“Normal”).
   In this condition the solenoid valve is de-energized.
2. Position for the Toe Closure (“Capsize”).
   In this condition the solenoid valve is energized.

A couple of sensors check the coherency of the position than expected by the Program.
The conditions for this working status of the Dial are:

Position for the Transfer Dial Jacks (“Normal”).

A. High sensor for:
   Dial control normal position
   Input status = “Closed”.
   Autotest = “1”.

B Low sensor for:
   Dial control capsize position
   Input status = “Open”.
   Autotest = “0”.

This error appears when the software detects an inputs status different from that provided in that point of the Program.
In particular the signal of the sensors does not correspond to the position of:
”Dial in Normal position”.

This error alerts the user of a problem on the moveable device movement.
In general, the problem is due to:

- Mechanical malfunction of the device (not reached the intended position).
- Slow response of the solenoid valve of command.
- Sensor adjustment not correct.
- Malfunction of the sensor.

Reference

For the information on the procedure of Toe Closure see the heading:
Dial management for Traditional Toe Closure procedure

For the analysis and the solution of this type of errors make reference to the chapter dedicated to the procedures for the resolution of faults relative the position error of the moveable devices (for example the moveable cams).
For the information on the procedure of troubleshooting relating Moveable cams errors see the heading:
Position errors: Moveable device (Moveable Cam)

Messages on Yarnfingers plate movement

CHuE167: Stop yarnfinger plate position

Sensor input:
Pcb_3759 J14 p04
Command output:
GL-544: в6 e2 — GL-544CT: в7 e7 — GL-615: в16 e4 — GL-616: в16 e4 — GL-616D: в7 e1 — GL-61QCT: в11 e2 — GL-616CTE: в9 e5 — GL-615CTE: в11 e5 — GL-616DCTE: в13 e3

The input board for this signal is Pcb_3759.

With the series “GL” machines there is a new functionality.
Through appropriate controls is possible raise and lower the “Yarn fingers Plate”.
The main reason for which was implemented this functionality is the application of an external “Robot” that run the Toe Closure.
The Yarn fingers Plate must be able to be raised in order to allow the Sock Transfer device to carry out its task (enter

the cylinder, take the sock, exit from the Cylinder).
This functionality is also useful in case of maintenance of the parties related to Cylinder.

These machines models are always prepared with the “Dial raiser” motor, on which is mounted an encoder for control of its position.
The “Dial raiser” motor, in addition to its basic function (ial movement) is also used for the “Yarn fingers Plate”.
A pneumatic piston however helps the motor in its further task.

A Release/Hook mechanism makes jointly liable the Dial movement with the Yar fingers Plate movement, when it is provided by Sock Program a movement of raising or descent of the Yarn fingers Plate.
Is necessary that each movement of the Yarn fingers Plate is executed with the Dial jointly liable to this movement.

The normal working condition (sock construction) for the “Yarn fingers Plate” is the one at the lower End of Run.
This Yarn fingers Plate position is controlled by a sensor, in reading when it is low.

This error appears in all situations where is provided that the Yarn fingers Plate is low, but the control sensor does not give the software the right signal.

The sensor of control is of the type “Normally Closed”.
The working conditions are the following:

A. Plate down.
In this condition the control contact is open on the Ground.
The inputs Autotest therefore displays the value “0”.

B. Plate up.
In this condition the control contact is closed on the Ground.
The inputs Autotest therefore displays the value “1”.

Error control

It is always advisable try to cancel the error visualized on the Display by pressing the [F8] key, so testing if it’s still active.
At this point we will have two possibilities:

1: The error is cancelled and the machine resumes its functioning.
2. The error is not cancelled, and the machine is blocked with the error displayed.

1st case: the error is cancelled with the [F8] key

This type of error not persistent must not be understimated, as it indicates an anomalous movement of the mechanical device (too delayed).
The error is displayed because the mechanical device, altough it’s in the right position, carried out the movement in too much time.
Proceed as follows to solve the problem:

- Check that the movement of the device is not slowed down or blocked by mechanical obstacoles.
- Check that the internal compressed air ducts of the mechanical device are not blocked and/or clogged.
- Check that the external compressed air ducts (tubes) are not blocked and/or clogged.
- Check that the pneumatic part of the Solenoid valves is no blocked and/or clogged, or mechanically damaged.

2nd case: the error is not cancelled with the [F8] key

Should the error not be cancelled, means that the mechanical part concerned shall not be in the right position, or the sensor or the electronic boards has not detected correctly the new position of mechanical part.
Proceed as follows to solve the problem:
Visually check the position taken by the mechanical part concerned the movement.

A. If the mechanical part is not in the right position proceed with the point:

Mechanical device out of position

Should the mechanical device actually be out of position, there are two possible types of problems:

1. Mechanical problem

The mechanical device is blocked in its movement.

- *Check that the movement of the mechanical part can be carried out without problems.*

- *Check the mechanical functionality of the components linked to the motor movement.*

2. *Electric or electronic problem*

The failure movement is due to the “Dial raiser” motor.

- *Check the wiring that connect the sensor and the motor to the command board (in general the Pcb_3836 board).*
- *Replace the stepping motor indicated in the message.*
- *Replace the CAN module (board Pcb_3836) associated with the motor indicated in the message.*

B. If the mechanical part is in the right position proceed with the point:

Mechanical device in right position

If the mechanical part concerned is in the right position, the control sequence was carried out correctly.

The problem may be caused by position sensor that has not found the new position.

- *Check the correct adjustment of the position sensor, and possibly replace it.*
- *Check the connecting cables between the sensor and the inputs board.*
- *Replace the Input board.*

CHuE168: Stop yarnfinger plate lock

Sensor input:

Pcb_3759 J14 p05

Command output:

GL-544: в6 e2 — GL-544CT: в7 e7 — GL-615: в16 e4 — GL-616: в16 e4 — GL-616D: в7 e1 — GL-61QCT: в11 e2 — GL-616CTE: в9 e5 — GL-615CTE: в11 e5 — GL-616DCTE: в13 e3

The input board for this signal is Pcb_3759.

With the series “GL” machines there is a new functionality.
Through appropriate controls is possible raise and lower the “Yarn fingers Plate”.
The main reason for which was implemented this functionality is the application of an external “Robot” that run the Toe Closure.
The Yarn fingers Plate must be able to be raised in order to allow the Sock Transfer device to carry out its task (enter the cylinder, take the sock, exit from the Cylinder).
This functionality is also useful in case of maintenance of the parties related to Cylinder.

These machines models are always prepared with the “Dial raiser” motor, on which is mounted an encoder for control of its position.
The “Dial raiser” motor, in addition to its basic function (ial movement) is also used for the “Yarn fingers Plate”.
A pneumatic piston however helps the motor in its further task.

A Release/Hook mechanism makes jointly liable the Dial movement with the Yar fingers Plate movement, when it is provided by Sock Program a movement of raising or descent of the Yarn fingers Plate.
Is necessary that each movement of the Yarn fingers Plate is executed with the Dial jointly liable to this movement.
A control sensor shall verify the status of this Release/Hook mechanism, and only if the situation is corect allows any movements of the Yarn fingers Plate.

This error appears in all situations in which is expected that Dial and Plate are jontly (hooked), but the control sensor does not send to the software the right signal.

The sensor of control is of the type “Normally Closed”.
The working conditions are the following:

A. With command not active (Solenoid valve de-energized) the devices are not hooked.
In this condition the control contact is closed on the Ground.
The inputs Autotest therefore displays the value “1”.

B. With command active (Solenoid valve energized) the devices are hooked.
In this condition the control contact is open on the Ground.
The inputs Autotest therefore displays the value “0”.

Error control

It is always advisable try to cancel the error visualized on the Display by pressing the [F8] key, so testing if it's still active.
At this point we will have two possibilities:

1. The error is cancelled and the machine resumes its functioning.
2. The error is not cancelled, and the machine is blocked with the error displayed.

1st case: the error is cancelled with the [F8] key

This type of error not persistent must not be understimated, as it indicates an anomalous movement of the mechanical device (too delayed).
The error is displayed because the mechanical device, altough it's in the right position, carried out the movement in too much time.
Proceed as follows to solve the problem:

- Check that the movement of the device is not slowed down or blocked by mechanical obstacoles.
- Check that the internal compressed air ducts of the mechanical device are not blocked and/or clogged.
- Check that the external compressed air ducts (tubes) are not blocked and/or clogged.
- Check that the pneumatic part of the Solenoid valves is no blocked and/or clogged, or mechanically damaged.

2nd case: the error is not cancelled with the [F8] key

Should the error not be cancelled, means that the mechanical part concerned shall not be in the right position, or the sensor or the electronic boards has not detected correctly the new position of mechanical part.
Proceed as follows to solve the problem:
Visually check the position taken by the mechanical part concerned the movement.

A. If the mechanical part is not in the right position proceed with the point:
Mechanical device out of position
Should the mechanical device actually be out of position, there are two possible types of problems:
1. Mechanical problem
The mechanical device's movement is blocked, or the Solenoid valve, even though it's properly activated, does not allow the passage of the compressed air toward the exit.
- *Check that the movement of the mechanical part can be carried out without problems.*
Therefore, if necessary, replace the Solenoid valve concerned.

2. Electric or electronic problem
The failed movement is due to lack of compressed air from the Solenoid valve.
- *Replace the Solenoid valve concerned.*
- *Replace the Output board corresponding to the command.*

B. If the mechanical part is in the right position proceed with the point:
Mechanical device in right position
If the mechanical part concerned is in the right position, the control sequence was carried out correctly.
Therefore, also the corresponding Solenoid valve functions properly.
The problem may be caused by position sensor that has not found the new position.
- *Check the correct adjustment of the position sensor, and possibly replace it.*
- *Check the connecting cables between the sensor and the inputs board.*
- *Replace the Input board.*

CHuE171: Problems dial on detachment

Sensor input:
Yarnfingers plate position
Pcb_3759 J14 p04
Yarnfingers plate lock
Pcb_3759 J14 p05
Command output:
GL-544: в6 e2 — GL-544CT: в7 e7 — GL-615: в16 e4 — GL-616: в16 e4 — GL-616D: в7 e1 — GL-61QCT: в11 e2 — GL-616CTE: в9 e5 — GL-615CTE: в11 e5 — GL-616DCTE: в13 e3

The input board for this signal is Pcb_3759.

With the series “GL” machines there is a new functionality.
Through appropriate controls is possible raise and lower the “Yarn fingers Plate”.
The main reason for which was implemented this functionality is the application of an external “Robot” that run the Toe Closure.
The Yarn fingers Plate must be able to be raised in order to allow the Sock Transfer device to carry out its task (enter the cylinder, take the sock, exit from the Cylinder).
This functionality is also useful in case of maintenance of the parties related to Cylinder.

These machines models are always prepared with the “Dial raiser” motor, on which is mounted an encoder for control of its position.
The “Dial raiser” motor, in addition to its basic function (ial movement) is also used for the “Yarn fingers Plate”.
A pneumatic piston however helps the motor in its further task.

A Release/Hook mechanism makes jointly liable the Dial movement with the Yar fingers Plate movement, when it is provided by Sock Program a movement of raising or descent of the Yarn fingers Plate.
Is necessary that each movement of the Yarn fingers Plate is executed with the Dial jointly liable to this movement.
A control sensor shall verify the status of this Release/Hook mechanism, and only if the situation is corect allows any movements of the Yarn fingers Plate.

The normal working condition (sock construction) for the “Yarn fingers Plate” is the one at the lower End of Run.
This Yarn fingers Plate position is controlled by a sensor, in reading when it is low.

By the reading of the signals from the various sensors and from the Dial motor Encoder, the software performs a series of controls to verify the correctness of the “Raises and Lowers Plate” movements.
If are found anomalies, the machine is stop with this error.

The conditions for which may appear this error are different, for the resolution of the problem need to follow the same passages referring to the errors:
CHuE168
CHuE169

Messages on the functioning of the SOLIS Turning device

CHuE169: Stop Solis reverser pressure

Sensor input:
Pcb_2008 J30 p03

The input board for this signal is Pcb_2008.

The SOLIS Turning device is assembled on the machine to customer request and that makes the overturning of the sock.
This error indicates mainly the lack of sufficient suction in the “Sock Turning device”.
When the “Vacuum Valve” is in suction, the closure of the Sock Overturning device is maintained by this suction.
A contact on the device performs this control.
Through a cable is trasmitted this stop signal to the machine.
This cable also includes a wire that bring properly the Ground (0 Vdc) to the device.

The correct condition (stop not active) is:
”contact open”
With stop not active, the inputs Autotest displays the value “0”.
With stop active, the inputs Autotest displays the value “1”.

In certain conditions the “Vacuum Valve” is programmed to close the suction (for example during the “Welt” construction and during the Sock expulsion).
The user should disable the control of this error in the chain steps in which the “Vacuum Valve” does not suck.
Otherwise the software, noting the “contact closed”, would stop the machine with this error.

A typical situation in which may appear this error is in response to a sequence of non expulsions of the produced sock. These socks fill the Tube of expulsion, up to prevent the proper closing of the device, with consequent displaying of this error.

In case of error first check if has been intervened the control device (real error).

- Solve the real problem that has caused the error.

If the control device has not intervened, check the regulation and setting and then proceed as follows.

With error active (non-erasable with [F8] key), access to Inputs Autotest.
Press the [CTRL] + [B] keys in the error window.

If the Inpurs Autoest displays the value “0”:

- *Replace the Input board.*

If the Inpurs Autoest displays the value “1”:

If air suction is not present on the device:

Given these conditions:

- *Check the correct programming of the enabling codes for this control, assuming in this case the correct position of the “Vacuum Valve”.*
- *Check the correct position of the “Vacuum Valve”, assuming in this case that it should be in position to determine the suction from the device.*

If air suction is present on the device:

Given these conditions:

- *Check that no cause prevent the correct closure of the device.*
- *Check the wiring between the control device and the input board.*
- *Replace the Input board.*

Notice

Attention

If the wire that connects the inputs board to the control device was rough or however interrupted, the error would never appear, then the machine would work without this control.

CHuE170: Stop Solis reverser inspection

Sensor input:
Pcb_2008 J30 p04

The input board for this signal is Pcb_2008.

The SOLIS Turning device is assembled on the machine to customer request and that makes the overturning of the sock.
On this device is available a “Door for the inspection”, whose status (Open/Closed) is controlled through a Contact.
A contact on the device performs this control.
Through a cable is trasmitted this stop signal to the machine.

The correct condition (stop not active) is:
”contact closed”
With stop not active, the inputs Autotest displays the value “1”.
With stop active, the inputs Autotest displays the value “0”.

In case of error first check if has been intervened the control device (real error).

- Solve the real problem that has caused the error.

If the control device has not intervened, check the regulation and setting and then proceed as follows.

With error active (non-erasable with [F8] key), access to Inputs Autotest.
Press the [CTRL] + [B] keys in the error window.

If the Inpurs Autoest displays the value “1”:

- *Replace the Input board.*

If the Inpurs Autoest displays the value “0”:

- *Check that no cause prevent the correct closure of the device.*
- *Check the wiring between the control device and the input board.*
- *Replace the Input board.*

Messages on the Cams movement

CHuE34: Throat plate

Sensor input:
Pcb_3759 J11 p01
Command output:
G44J: в15 e5 — G54JCT: в6 e6 — G54JOT: в6 e6 — G615: в4 e6 — G615D: в4 e6 — G616: в3 e5 — G616D: в3 e5 — G61Q: в3 e5 — G624: в16 e2 — G626: в15 e4 — GL-544: в15 e5 — GL-544CT: в14 e7 — GL-615: в3 e5 — GL-616: в3 e5 — GL-616D: в3 e5 — GL-61QCT: в14 e8 — GL-616CTE: в3 e5 — GL-615CTE: в18 e2 — GL-616DCTE: в18 e2

The input board for this signal is Pcb_3759.

This error is related the movement of the device:
Piston for the protection against the accidental closure of the needle Latch
This movement is determined by the command that reaches the relative Solenoid Valve.
For this device is present a control input.

When the Cam is not commanded (Solenoid valve de-energized) it allows the possible opening of the needle Latch.
In this condition the control contact is closed on the Ground.
The inputs Autotest therefore displays the value “1”.

When the Cam is commanded (Solenoid valve energized) it does not allow the accidental opening of the needle Latch.
In this condition the control contact is open on the Ground.
The inputs Autotest therefore displays the value “0”.

This error alerts the user of a problem on the moveable device movement.
In general, the problem is due to:
- Slow response of the solenoid valve of command.
- Sensor adjustment not correct.
- Malfunction of the sensor.

Reference

For the analysis and the solution of this type of errors make reference to the chapter dedicated to the procedures for the resolution of faults relative the position error of the moveable devices (for example the moveable cams).
For the information on the procedure of troubleshooting relating Moveable cams errors see the heading:
Position errors: Moveable device (Moveable Cam)

CHuE39: Raising needles heel return

Sensor input:
G615: Pcb_3759 J12 p01 — G615D: Pcb_3759 J12 p01 — G616: Pcb_3759 J12 p02 — G616D: Pcb_3759 J12 p02 — GL-615: Pcb_3759 J12 p02 — GL-616: Pcb_3759 J12 p02 — GL-616D: Pcb_3759 J12 p02 — GL-61QCT: Pcb_3759 J12 p02 — GL-_CTE: Pcb_3759 J12 p02
Command output:
Raising needles heel return PA
G615: в6 e7 — G615D: в6 e7 — G616: в5 e6 — G616D: в5 e6 — GL-615: в5 e6 — GL-616: в5 e6 — GL-616D: в5 e5 — GL-61QCT: в13 e1 — GL-616CTE: в5 e5 — GL-615CTE: в15 e1 — GL-616DCTE: в16 e4
Raising needles heel return PB
G615: в6 e8 — G615D: в6 e8 — G616: в5 e7 — G616D: в5 e7 — GL-615: в5 e7 — GL-616: в5 e7 — GL-616D: в5 e6 — GL-61QCT: в13 e2 — GL-616CTE: в5 e6 — GL-615CTE: в14 e4 — GL-616DCTE: в16 e3

The input board for this signal is Pcb_3759.

CHuE40: Lowering needles elastic

Sensor input:

G615: Pcb_3759 J12 p02 — G615D: Pcb_3759 J12 p02 — G616: Pcb_3759 J12 p03 — G616D: Pcb_3759 J12 p03 — G61Q: Pcb_3759 J12 p03 — G626: Pcb_3759 J12 p03 — GL-615: Pcb_3759 J12 p03 — GL-616: Pcb_3759 J12 p03 — GL-616D: Pcb_3759 J12 p03 — GL-_CTE: Pcb_3759 J12 p03

Command output:

Lowering needles elast. pos. A

G615: в5 e8 — G615D: в5 e8 — G616: в5 e8 — G616D: в5 e8 — G61Q: в4 e7 — G626: в13 e5 — GL-615: в5 e8 — GL-616: в5 e8 — GL-616D: в5 e8 — GL-61QCT: в12 e6 — GL-616CTE: в5 e7 — GL-615CTE: в14 e3 — GL-616DCTE: в15 e3

Lowering needles elast. pos. B

G615: в4 e5 — G615D: в4 e5 — G616: в7 e6 — G616D: в7 e6 — G61Q: в4 e8 — G626: в13 e4 — GL-615: в7 e6 — GL-616: в7 e6 — GL-616D: в6 e5 — GL-61QCT: в12 e5 — GL-616CTE: в5 e8 — GL-615CTE: в14 e2 — GL-616DCTE: в15 e2

The input board for this signal is Pcb_3759.

CHuE42: Lowering needles cam out heel and toe

Sensor input:

G44J: Pcb_3759 J12 p02 — G54JCT: Pcb_3759 J13 p11 — G54JOT: Pcb_3759 J13 p11 — G615: Pcb_3759 J12 p04 — G615D: Pcb_3759 J12 p04 — G616: Pcb_3759 J12 p06 — G616D: Pcb_3759 J12 p06 — G61Q: Pcb_3759 J12 p04 — G624: Pcb_3759 J12 p04 — G626: Pcb_3759 J12 p02 — GL-544: Pcb_3759 J12 p01 — GL-544CT: Pcb_3759 J12 p01 — GL-615: Pcb_3759 J12 p06 — GL-616: Pcb_3759 J12 p06 — GL-616D: Pcb_3759 J12 p06 — GL-61QCT: Pcb_3759 J12 p01 — GL-_CTE: Pcb_3759 J12 p06

Command output:

G44J: в13 e5 — G54JCT: в11 e6 — G54JOT: в12 e6 — G615: в5 e7 — G615D: в5 e7 — G616: в7 e7 — G616D: в7 e7 — G61Q: в6 e7 — G624: в14 e2 — G626: в13 e8 — GL-544: в3 e8 — GL-544CT: в4 e5 — GL-615: в7 e7 — GL-616: в7 e7 — GL-616D: в6 e8 — GL-61QCT: в13 e3 — GL-616CTE: в7 e7 — GL-615CTE: в13 e3 — GL-616DCTE: в14 e3

The input board for this signal is Pcb_3759.

CHuE43: Raiser needles enter heel and toe

Sensor input:

G44J: Pcb_3759 J12 p11 — G54JCT: Pcb_3759 J13 p02 — G54JOT: Pcb_3759 J13 p02 — G615: Pcb_3759 J12 p05 — G615D: Pcb_3759 J12 p05 — G616: Pcb_3759 J12 p07 — G616D: Pcb_3759 J12 p07 — G61Q: Pcb_3759 J12 p06 — G624: Pcb_3759 J12 p07 — G626: Pcb_3759 J12 p10 — GL-544: Pcb_3759 J12 p12 — GL-544CT: Pcb_3759 J12 p12 — GL-615: Pcb_3759 J12 p07 — GL-616: Pcb_3759 J12 p07 — GL-616D: Pcb_3759 J12 p07 — GL-61QCT: Pcb_3759 J12 p08 — GL-_CTE: Pcb_3759 J12 p07

Command output:

Raise L & M butt needles

G61Q: в6 e6 — G624: в13 e3 — G626: в5 e4 — GL-61QCT: в6 e7

Raise long butt needles pos. A

G54JCT: в5 e5 — G54JOT: в5 e5

Raise long butt needles

G44J: в12 e1 — G615: в6 e6 — G615D: в6 e6 — G616: в7 e5 — G616D: в7 e5 — G61Q: в6 e5 — G624: в13 e4 — G626: в5 e3 — GL-544: в5 e7 — GL-544CT: в7 e3 — GL-615: в7 e5 — GL-616: в7 e5 — GL-616D: в7 e5 — GL-61QCT: в6 e6 — GL-616CTE: в7 e6 — GL-615CTE: в13 e2 — GL-616DCTE: в14 e2

The input board for this signal is Pcb_3759.

CHuE69: Lowering needles transfer cam

Sensor input:
Pcb_3759 J12 p06
Command output:
Lower.needles cam trans.pos.A
G624: в13 e6 — G626: в5 e5
Lower.needles cam trans.pos.B
G624: в13 e5 — G626: в5 e6

The input board for this signal is Pcb_3759.

CHuE73: Latch opener transfer cam

Sensor input:
G61Q: Pcb_3759 J12 p05 — G624: Pcb_3759 J12 p05 — G626: Pcb_3759 J12 p11
Command output:
Latch opener trans. cam pos. A
G61Q: в5 e7 — G624: в13 e8 — G626: в5 e7
Latch opener trans. cam pos. B
G61Q: в5 e8 — G624: в13 e7 — G626: в5 e8 — GL-616CTE: в3 e4

The input board for this signal is Pcb_3759.

CHuE110: Lowering needles clearing cam

Sensor input:
Pcb_3759 J13 p03
Command output:
G54JCT: в5 e6

The input board for this signal is Pcb_3759.

CHuE118: Raise fabric closed toe

Sensor input:
G54JCT: Pcb_3759 J13 p07 — GL-544: Pcb_3759 J13 p05 — GL-544CT: Pcb_3759 J13 p05 — GL-_CTE: Pcb_3759 J12 p16
Command output:
G54JCT: в5 e7 — GL-544CT: в5 e3 — GL-616CTE: в7 e4 — GL-615CTE: в12 e8 — GL-616DCTE: в15 e7

The input board for this signal is Pcb_3759.

CHuE119: Raiser needles transfer

Sensor input:
G54JCT: Pcb_3759 J13 p01 — GL-61QCT: Pcb_3759 J12 p09
Command output:
Raise needles transfer pos. A
G54JCT: в5 e3 — GL-61QCT: в6 e3
Raise needles transfer pos. B
G54JCT: в5 e2 — GL-61QCT: в6 e4

The input board for this signal is Pcb_3759.

CHuE178: Needle down welt discharge

Sensor input:
Pcb_3759 J12 p12

Command output:
Lower.needles cam trans.pos.A
G624: в13 e6 — G626: в5 e5
Lower.needles cam trans.pos.B
G624: в13 e5 — G626: в5 e6

The input board for this signal is Pcb_3759.

CHuE192: Lowering needles elastic position A

Sensor input:
Pcb_3759 J12 p05
Command output:
G615: в5 e8 — G615D: в5 e8 — G616: в5 e8 — G616D: в5 e8 — G61Q: в4 e7 — G626: в13 e5 — GL-615: в5 e8 — GL-616: в5 e8 — GL-616D: в5 e8 — GL-61QCT: в12 e6 — GL-616CTE: в5 e7 — GL-615CTE: в14 e3 — GL-616DCTE: в15 e3

The input board for this signal is Pcb_3759.

CHuE193: Lowering needles elastic position B

Sensor input:
Pcb_3759 J12 p04
Command output:
G615: в4 e5 — G615D: в4 e5 — G616: в7 e6 — G616D: в7 e6 — G61Q: в4 e8 — G626: в13 e4 — GL-615: в7 e6 — GL-616: в7 e6 — GL-616D: в6 e5 — GL-61QCT: в12 e5 — GL-616CTE: в5 e8 — GL-615CTE: в14 e2 — GL-616DCTE: в15 e2

The input board for this signal is Pcb_3759.

CHuE196: Stop lowering needles ladderproof closing

Sensor input:
Pcb_3759 J13 p02
Command output:
GL-544CT: в6 e2

The input board for this signal is Pcb_2008.

CHuE197: Stop needle-levelling enter heel

Sensor input:
Pcb_3759 J12 p07
Command output:
GL-61QCT: в6 e8 — GL-616CTE: в2 e8

The input board for this signal is Pcb_2008.

These errors are related to the movement of the various Cams that act directly on needles in the various points of the cylinder, causing their rising or descent.

This movement is determined by the command that reaches the relative Solenoid Valve.
The purpose of this device is to make the Needles move to the point of the cylinder where the Needle Cam starts working.
For this device is present a control input.
It is placed in the rear part of the device.

When the Needle Cam is not controlled (solenoid valve de-energized), it is in the rest position, away from the cylinder.
In this condition the control contact is closed on the Ground.
The inputs Autotest therefore displays the value “1”.

When the Needle Cam is operated (solenoid valve energized), it is in the work position, close to the cylinder.
In this condition the control contact is open on the Ground.
The inputs Autotest therefore displays the value “0”.

This error alerts the user of a problem on the moveable device movement.
In general, the problem is due to:

- Slow response of the solenoid valve of command.
- Sensor adjustment not correct.
- Malfunction of the sensor.

Reference

For the analysis and the solution of this type of errors make reference to the chapter dedicated to the procedures for the resolution of faults relative the position error of the moveable devices (for example the moveable cams).
For the information on the procedure of troubleshooting relating Moveable cams errors see the heading:
Position errors: Moveable device (Moveable Cam)

CHuE117: Central cam stop

Sensor input:
G54JCT: Pcb_3759 J13 p08 — GL-544: Pcb_3759 J13 p06 — GL-544CT: Pcb_3759 J13 p06 — GL-61QCT: Pcb_3759 J12 p13
Command output:
G54JCT: въ16 e8 — GL-544CT: въ16 e8 — GL-61QCT: въ16 e8

The input board for this signal is Pcb_3759.

This error is related the movement of the device:
Central cam stop
This movement is determined by the command that reaches the relative Solenoid Valve.
The purpose of this device is to make the Needles move to the point of the cylinder where the Needle Cam starts working.
For this device is present a control input.
It is placed in the rear part of the device.

When the Needle Cam is not controlled (solenoid valve de-energized), it is in the rest position, away from the cylinder.
In this condition the control contact is closed on the Ground.
The inputs Autotest therefore displays the value “1”.

When the Needle Cam is operated (solenoid valve energized), it is in the work position, close to the cylinder.
This is also the Cam position at the End of Cycle step.
In this condition the control contact is open on the Ground.
The inputs Autotest therefore displays the value “0”.

This error alerts the user of a problem on the moveable device movement.
In general, the problem is due to:

- Slow response of the solenoid valve of command.
- Sensor adjustment not correct.
- Malfunction of the sensor.

Reference

For the analysis and the solution of this type of errors make reference to the chapter dedicated to the procedures for the resolution of faults relative the position error of the moveable devices (for example the moveable cams).
For the information on the procedure of troubleshooting relating Moveable cams errors see the heading:
Position errors: Moveable device (Moveable Cam)

CHuE41: Clearing cam feed 1

Sensor input:

G615: Pcb_3759 J12 p03 — G615D: Pcb_3759 J12 p03 — G616: Pcb_3759 J12 p05 — G616D: Pcb_3759 J12 p05 — G61Q: Pcb_3759 J12 p12 — G624: Pcb_3759 J12 p09 — GL-615: Pcb_3759 J12 p05 — GL-616: Pcb_3759 J12 p05 — GL-616D: Pcb_3759 J12 p05 — GL-61QCT: Pcb_3759 J12 p03 — GL-_CTE: Pcb_3759 J12 p05

Command output:

Clearing cam pos. A feed 1

G615: в5 e6 — G615D: в5 e6 — G616: в6 e7 — G616D: в6 e7 — G61Q: в8 e1 — G624: в5 e3 — GL-615: в6 e7 — GL-616: в6 e7 — GL-616D: в6 e6 — GL-61QCT: в12 e8 — GL-616CTE: в6 e8 — GL-615CTE: в14 e1 — GL-616DCTE: в15 e1

Clearing cam pos. B feed 1

G615: в5 e5 — G615D: в5 e5 — G616: в6 e8 — G616D: в6 e8 — G61Q: в8 e2 — G624: в5 e4 — GL-615: в6 e8 — GL-616: в6 e8 — GL-616D: в6 e7 — GL-61QCT: в12 e7 — GL-615CTE: в13 e4 — GL-616DCTE: в14 e1

The input board for this signal is Pcb_3759.

CHuE97: Clearing cam feed 2

Sensor input:

Pcb_3759 J12 p02

Command output:

Clearing cam pos. A feed 2

G54JCT: в13 e7 — G54JOT: в14 e7

Clearing cam pos. B feed 2

G54JCT: в13 e8 — G54JOT: в14 e8 — GL-616CTE: в16 e8

The input board for this signal is Pcb_3759.

This errors are related the movement of the Cams:

Clearing

This movement is determined by the command that reaches the relative Solenoid Valve.
The purpose of this device is to make the Needles move to the point of the cylinder where the Needle Cam starts working.
For this device is present a control input.
It is placed in the rear part of the device.

When the Needle Cam is not controlled (solenoid valve de-energized), it is in the rest position, away from the cylinder.
In this condition the control contact is closed on the Ground.
The inputs Autotest therefore displays the value “1”.

When the Needle Cam is operated (solenoid valve energized), it is in the work position, close to the cylinder.
In this condition the control contact is open on the Ground.
The inputs Autotest therefore displays the value “0”.

This error alerts the user of a problem on the moveable device movement.
In general, the problem is due to:

- Slow response of the solenoid valve of command.
- Sensor adjustment not correct.
- Malfunction of the sensor.

Reference

For the analysis and the solution of this type of errors make reference to the chapter dedicated to the procedures for the resolution of faults relative the position error of the moveable devices (for example the moveable cams).
For the information on the procedure of troubleshooting relating Moveable cams errors see the heading:

Position errors: Moveable device (Moveable Cam)

CHuE44: Tucking cam feed 1

Sensor input:

G44J: Pcb_3759 J12 p16 — G54JCT: Pcb_3759 J12 p16 — G54JOT: Pcb_3759 J12 p16 — G615: Pcb_3759 J12 p09 — G615D: Pcb_3759 J12 p09 — G616: Pcb_3759 J12 p10 — G616D: Pcb_3759 J12 p10 — G61Q: Pcb_3759 J12 p09 — G624: Pcb_3759 J12 p10 — G626: Pcb_3759 J12 p13 — GL-615: Pcb_3759 J12 p10 — GL-616: Pcb_3759 J12 p10 — GL-616D: Pcb_3759 J12 p10 — GL-61QCT: Pcb_3759 J12 p10 — GL-_CTE: Pcb_3759 J12 p10

Command output:

Tucking cam pos. A feed 1

G44J: в5 e5 — G54JCT: в4 e6 — G54JOT: в4 e6 — G615: в7 e2 — G615D: в7 e2 — G616: в8 e2 — G616D: в5 e2 — G61Q: в6 e3 — G624: в5 e1 — G626: в4 e1 — GL-544: в4 e8 — GL-544CT: в6 e3 — GL-615: в8 e2 — GL-616: в8 e2 — GL-616D: в6 e2 — GL-61QCT: в6 e2 — GL-616CTE: в8 e5 — GL-615CTE: в11 e8 — GL-616DCTE: в14 e7

Tucking cam pos. B feed 1

G44J: в5 e6 — G54JCT: в4 e5 — G54JOT: в4 e5 — G615: в7 e1 — G615D: в7 e1 — G616: в8 e3 — G616D: в5 e3 — G61Q: в6 e4 — G624: в5 e2 — G626: в4 e2 — GL-544: в5 e1 — GL-544CT: в6 e4 — GL-615: в8 e3 — GL-616: в8 e3 — GL-616D: в6 e3 — GL-61QCT: в6 e1 — GL-615CTE: в11 e7 — GL-616DCTE: в14 e6

The input board for this signal is Pcb_3759.

CHuE45: Tucking cam feed 2

Sensor input:

Pcb_3759 J12 p01

Command output:

Tucking cam pos. A feed 2

G44J: в13 e7 — G54JCT: в13 e5 — G54JOT: в14 e5 — G624: в14 e8 — G626: в13 e7 — GL-544: в13 e3 — GL-544CT: в12 e4

Tucking cam pos. B feed 2

G44J: в13 e6 — G54JCT: в13 e6 — G54JOT: в14 e6 — G624: в14 e7 — G626: в13 e6 — GL-544: в13 e2 — GL-544CT: в12 e3

The input board for this signal is Pcb_3759.

CHuE100: Tucking cam feed 3

Sensor input:

Pcb_3759 J12 p06

Command output:

Tucking cam pos. A feed 3

G54JCT: в12 e3 — G54JOT: в13 e3

Tucking cam pos. B feed 3

G54JCT: в12 e4 — G54JOT: в13 e4

The input board for this signal is Pcb_3759.

CHuE114: Tucking cam feed 4

Sensor input:

Pcb_3759 J12 p11

Command output:

Tucking cam pos. A feed 4

G54JCT: в12 e7 — G54JOT: в13 e7

Tucking cam pos. B feed 4

G54JCT: в12 e8 — G54JOT: в13 e8 — GL-616CTE: в8 e1

The input board for this signal is Pcb_3759.

CHuE172: Feed 1 tuck posn.A

Sensor input:

G44J: Pcb_3759 J12 p16 — G54JCT: Pcb_3759 J12 p16 — G54JOT: Pcb_3759 J12 p16 — G615: Pcb_3759 J12 p09 — G615D: Pcb_3759 J12 p09 — G616: Pcb_3759 J12 p10 — G616D: Pcb_3759 J12 p10 — G61Q: Pcb_3759 J12 p09 — G624: Pcb_3759 J12 p10 — G626: Pcb_3759 J12 p13 — GL-615: Pcb_3759 J12 p10 — GL-616: Pcb_3759 J12 p10 — GL-616D: Pcb_3759 J12 p10 — GL-61QCT: Pcb_3759 J12 p10 — GL-_CTE: Pcb_3759 J12 p10

Command output:

G44J: в5 e5 — G54JCT: в4 e6 — G54JOT: в4 e6 — G615: в7 e2 — G615D: в7 e2 — G616: в8 e2 — G616D: в5 e2 — G61Q: в6 e3 — G624: в5 e1 — G626: в4 e1 — GL-544: в4 e8 — GL-544CT: в6 e3 — GL-615: в8 e2 — GL-616: в8 e2 — GL-616D: в6 e2 — GL-61QCT: в6 e2 — GL-616CTE: в8 e5 — GL-615CTE: в11 e8 — GL-616DCTE: в14 e7

The input board for this signal is Pcb_3759.

CHuE173: Feed 2 tuck posn.A

Sensor input:

Pcb_3759 J12 p01

Command output:

G44J: в13 e7 — G54JCT: в13 e5 — G54JOT: в14 e5 — G624: в14 e8 — G626: в13 e7 — GL-544: в13 e3 — GL-544CT: в12 e4

The input board for this signal is Pcb_3759.

This errors are related the movement of the Cams:

Tucking

This movement is determined by the command that reaches the relative Solenoid Valve.
The purpose of this device is to make the Needles move to the point of the cylinder where the Needle Cam starts working.
For this device is present a control input.
It is placed in the rear part of the device.

When the Needle Cam is not controlled (solenoid valve de-energized), it is in the rest position, away from the cylinder.
In this condition the control contact is closed on the Ground.
The inputs Autotest therefore displays the value “1”.

When the Needle Cam is operated (solenoid valve energized), it is in the work position, close to the cylinder.
In this condition the control contact is open on the Ground.
The inputs Autotest therefore displays the value “0”.

This error alerts the user of a problem on the moveable device movement.
In general, the problem is due to:

- Slow response of the solenoid valve of command.
- Sensor adjustment not correct.
- Malfunction of the sensor.

Reference

For the analysis and the solution of this type of errors make reference to the chapter dedicated to the procedures for the resolution of faults relative the position error of the moveable devices (for example the moveable cams).
For the information on the procedure of troubleshooting relating Moveable cams errors see the heading:

Position errors: Moveable device (Moveable Cam)

CHuE46: Heel and toe stitch cam pos. B

Sensor input:

G44J: Pcb_3759 J13 p02 — G54JCT: Pcb_3759 J13 p04 — G54JOT: Pcb_3759 J13 p04 — G615: Pcb_3759 J12 p10 — G615D: Pcb_3759 J12 p10 — G616: Pcb_3759 J12 p11 — G616D: Pcb_3759 J12 p11 — G61Q: Pcb_3759 J12 p10 — G624: Pcb_3759 J12 p11 — G626: Pcb_3759 J12 p15 — GL-544: Pcb_3759 J13 p03 — GL-544CT: Pcb_3759 J13 p03 — GL-615: Pcb_3759 J12 p11 — GL-616: Pcb_3759 J12 p11 — GL-616D: Pcb_3759 J12 p11 — GL-61QCT: Pcb_3759 J12 p11 — GL-_CTE: Pcb_3759 J12 p11

Command output:

G44J: в5 e2 — G54JCT: в4 e1 — G54JOT: в4 e1 — G615: в6 e1 — G615D: в6 e1 — G616: в7 e4 — G616D: в7 e4 — G61Q: в6 e2 — G624: в4 e6 — G626: в5 e2 — GL-544: в4 e5 — GL-544CT: в5 e5 — GL-615: в7 e4 — GL-616: в7 e4 — GL-616D: в5 e4 — GL-61QCT: в5 e6 — GL-615CTE: в12 e6 — GL-616DCTE: в15 e5

The input board for this signal is Pcb_3759.

CHuE47: Heel and toe stitch cam pos. A

Sensor input:

G44J: Pcb_3759 J13 p03 — G54JCT: Pcb_3759 J13 p05 — G54JOT: Pcb_3759 J13 p05 — G615: Pcb_3759 J12 p11 — G615D: Pcb_3759 J12 p11 — G616: Pcb_3759 J12 p12 — G616D: Pcb_3759 J12 p12 — G61Q: Pcb_3759 J12 p11 — G624: Pcb_3759 J12 p12 — G626: Pcb_3759 J12 p16 — GL-544: Pcb_3759 J13 p04 — GL-544CT: Pcb_3759 J13 p04 — GL-615: Pcb_3759 J12 p12 — GL-616: Pcb_3759 J12 p12 — GL-616D: Pcb_3759 J12 p12 — GL-61QCT: Pcb_3759 J12 p12 — GL-_CTE: Pcb_3759 J12 p12

Command output:

G44J: в5 e1 — G54JCT: в4 e2 — G54JOT: в4 e2 — G615: в6 e2 — G615D: в6 e2 — G616: в7 e3 — G616D: в7 e3 — G61Q: в6 e1 — G624: в4 e5 — G626: в5 e1 — GL-544: в4 e4 — GL-544CT: в5 e4 — GL-615: в7 e3 — GL-616: в7 e3 — GL-616D: в5 e3 — GL-61QCT: в5 e5 — GL-616CTE: в8 e2 — GL-615CTE: в12 e7 — GL-616DCTE: в15 e6

The input board for this signal is Pcb_3759.

CHuE48: Stitch cam feed 1

Sensor input:

Pcb_3759 J12 p12

Command output:

G615: в6 e3 — G615D: в6 e3 — GL-616CTE: в6 e2

The input board for this signal is Pcb_3759.

CHuE98: Stitch cam feed 2 pos. A

Sensor input:

G44J: Pcb_3759 J12 p05 — G54JCT: Pcb_3759 J12 p04 — G54JOT: Pcb_3759 J12 p04 — G624: Pcb_3759 J12 p03 — G626: Pcb_3759 J12 p07 — GL-544: Pcb_3759 J12 p05 — GL-544CT: Pcb_3759 J12 p05

Command output:

G44J: в13 e1 — G54JCT: в12 e1 — G54JOT: в13 e1 — G624: в14 e6 — G626: в13 e3 — GL-544: в13 e1 — GL-544CT: в11 e7

The input board for this signal is Pcb_3759.

CHuE99: Stitch cam feed 2 pos. B

Sensor input:

G44J: Pcb_3759 J12 p04 — G54JCT: Pcb_3759 J12 p03 — G54JOT: Pcb_3759 J12 p03 — G624: Pcb_3759 J12 p02 — G626: Pcb_3759 J12 p06 — GL-544: Pcb_3759 J12 p04 — GL-544CT: Pcb_3759 J12 p04

Command output:

G44J: в13 e2 — G54JCT: в12 e2 — G54JOT: в13 e2 — G624: в14 e5 — G626: в13 e2 — GL-544: в12 e8 — GL-544CT: в11 e6

The input board for this signal is Pcb_3759.

CHuE101: Stitch cam feed 1 pos. A

Sensor input:

G44J: Pcb_3759 J13 p05 — G54JCT: Pcb_3759 J13 p09 — G54JOT: Pcb_3759 J13 p07 — G616: Pcb_3759 J12 p15 — G616D: Pcb_3759 J12 p15 — G624: Pcb_3759 J12 p13 — G626: Pcb_3759 J13 p02 — GL-544: Pcb_3759 J13 p07 — GL-544CT: Pcb_3759 J13 p07 — GL-615: Pcb_3759 J12 p15 — GL-616: Pcb_3759 J12 p15 — GL-616D: Pcb_3759 J12 p15 — GL-61QCT: Pcb_3759 J12 p14 — GL-_CTE: Pcb_3759 J12 p14

Command output:

G44J: Pcb_3759 J13 p05 — G54JCT: Pcb_3759 J13 p09 — G54JOT: Pcb_3759 J13 p07 — G616: Pcb_3759 J12 p15 — G616D: Pcb_3759 J12 p15 — G624: Pcb_3759 J12 p13 — G626: Pcb_3759 J13 p02 — GL-544: Pcb_3759 J13 p07 — GL-544CT: Pcb_3759 J13 p07 — GL-615: Pcb_3759 J12 p15 — GL-616: Pcb_3759 J12 p15 — GL-616D: Pcb_3759 J12 p15 — GL-61QCT: Pcb_3759 J12 p14 — GL-_CTE: Pcb_3759 J12 p14

The input board for this signal is Pcb_3759.

CHuE102: Stitch cam feed 1 pos. B

Sensor input:

G44J: Pcb_3759 J13 p04 — G54JCT: Pcb_3759 J13 p10 — G54JOT: Pcb_3759 J13 p08 — G616: Pcb_3759 J12 p14 — G616D: Pcb_3759 J12 p14 — G624: Pcb_3759 J12 p14 — G626: Pcb_3759 J13 p03 — GL-544: Pcb_3759 J13 p08 — GL-544CT: Pcb_3759 J13 p08 — GL-615: Pcb_3759 J12 p14 — GL-616: Pcb_3759 J12 p14 — GL-616D: Pcb_3759 J12 p14 — GL-61QCT: Pcb_3759 J12 p15 — GL-_CTE: Pcb_3759 J12 p15

Command output:

G44J: в4 e6 — G54JCT: в4 e3 — G54JOT: в4 e3 — G616: в6 e3 — G616D: в6 e3 — G624: в4 e2 — G626: в4 e4 — GL-544: в4 e2 — GL-544CT: в4 e8 — GL-615: в6 e3 — GL-616: в6 e3 — GL-616D: в4 e3 — GL-61QCT: в5 e1 — GL-615CTE: в13 e8

The input board for this signal is Pcb_3759.

CHuE103: Stitch cam feed 3 pos. B

Sensor input:

Pcb_3759 J12 p08

Command output:

G44J: в12 e4 — G54JCT: в12 e6 — G54JOT: в13 e6 — GL-544: в12 e2 — GL-544CT: в10 e6

The input board for this signal is Pcb_3759.

CHuE111: Stitch cam feed 4 pos. A

Sensor input:

G44J: Pcb_3759 J12 p14 — G54JCT: Pcb_3759 J12 p14 — G54JOT: Pcb_3759 J12 p14 — GL-544: Pcb_3759 J12 p15 — GL-544CT: Pcb_3759 J12 p15

Command output:

G44J: в6 e1 — G54JCT: в5 e8 — G54JOT: в5 e8 — GL-544: в5 e5 — GL-544CT: в6 e8

The input board for this signal is Pcb_3759.

CHuE113: Stitch cam feed 4 pos. B

Sensor input:
G44J: Pcb_3759 J12 p13 — G54JCT: Pcb_3759 J12 p13 — G54JOT: Pcb_3759 J12 p13 — GL-544: Pcb_3759 J12 p14 — GL-544CT: Pcb_3759 J12 p14
Command output:
G44J: в6 e2 — G54JCT: в11 e3 — G54JOT: в12 e3 — GL-544: в5 e6 — GL-544CT: в7 e1 — GL-616CTE: в1 e3

The input board for this signal is Pcb_3759.

CHuE115: Stitch cam feed 3 pos. A

Sensor input:
Pcb_3759 J12 p09
Command output:
G44J: в12 e3 — G54JCT: в12 e5 — G54JOT: в13 e5 — GL-544: в12 e1 — GL-544CT: в10 e7

The input board for this signal is Pcb_3759.

This errors are related the movement of the Cams:
Stitch cam
This movement is determined by the command that reaches the relative Solenoid Valve.
There are two commands for each Needle Cam, one for position “A” and one for position “B” (intermediate and final when the Needle Cam enters the cylinder).
For each Needle Cam there is 1 or 2 control inputs, one regading position “A” and the other position “B” (control of intermediate and final position of the Needle Cam on the cylinder).

When the Needle Cam is not controlled (solenoid valves de-energized), it is in the rest position, away from the cylinder.
In this condition the control contact is closed on the Ground.
The inputs Autotest therefore displays the value “1”.

When the Needle Cam is controlled (solenoid valves energized), it can move to position “A” or “B” (2 commands) towards the cylinder.
In this condition the control contact is open on the Ground.
The inputs Autotest therefore displays the value “0”.

This error alerts the user of a problem on the moveable device movement.
In general, the problem is due to:
- Slow response of the solenoid valve of command.
- Sensor adjustment not correct.
- Malfunction of the sensor.

Reference

For the analysis and the solution of this type of errors make reference to the chapter dedicated to the procedures for the resolution of faults relative the position error of the moveable devices (for example the moveable cams).
For the information on the procedure of troubleshooting relating Moveable cams errors see the heading:
Position errors: Moveable device (Moveable Cam)

CHuE49: Elastic selectors exclusion

Sensor input:
G615: Pcb_3759 J13 p13 — G615D: Pcb_3759 J13 p13 — G616: Pcb_3759 J13 p13 — G616D: Pcb_3759 J13 p13 — G626: Pcb_3759 J13 p14 — GL-615: Pcb_3759 J13 p13 — GL-616: Pcb_3759 J13 p13 — GL-616D: Pcb_3759 J13 p13 — GL-61QCT: Pcb_3759 J13 p13 — GL-_CTE: Pcb_3759 J13 p13
Command output:

G615: в7 e7 — G615D: в7 e7 — G616: в8 e5 — G616D: в8 e5 — G626: в12 e5 — GL-615: в8 e5 — GL-616: в8 e5 — GL-616D: в7 e6 — GL-61QCT: в12 e3 — GL-616CTE: в8 e7 — GL-615CTE: в11 e6 — GL-616DCTE: в14 e4

The input board for this signal is Pcb_3759.

CHuE50: Selectors exclusion feed 1

Sensor input:
G615: Pcb_3759 J13 p12 — G615D: Pcb_3759 J13 p12 — G616: Pcb_3759 J13 p12 — G616D: Pcb_3759 J13 p12 — G626: Pcb_3759 J13 p13 — GL-615: Pcb_3759 J13 p12 — GL-616: Pcb_3759 J13 p12 — GL-616D: Pcb_3759 J13 p12 — GL-61QCT: Pcb_3759 J13 p12 — GL-_CTE: Pcb_3759 J13 p12
Command output:
G615: в7 e8 — G615D: в7 e8 — G616: в8 e6 — G616D: в8 e6 — G626: в12 e4 — GL-615: в8 e6 — GL-616: в8 e6 — GL-616D: в7 e7 — GL-61QCT: в12 e2 — GL-615CTE: в12 e4 — GL-616DCTE: в13 e1

The input board for this signal is Pcb_3759.

CHuE179: Cancel selectors feed 2

Sensor input:
G626: Pcb_3759 J13 p12
Command output:
G626: в12 e3

The input board for this signal is Pcb_3759.

This errors are related the movement of the Cams:
Extraction of pattern drum selectors
This movement is determined by the command that reaches the relative Solenoid Valve.
This device determines the selectors extraction, in order to allow the Pattern Drum the selection of needles that must rise to knitting the yarn.
For this device is present a control input.
It is placed in the rear part of the device.

When the Needle Cam is not controlled (solenoid valve de-energized), it is in the rest position, away from the cylinder.
In this condition the control contact is open on the Ground.
The inputs Autotest therefore displays the value “0”.

When the Needle Cam is operated (solenoid valve energized), it is in the work position, close to the cylinder.
The selectors are extracted, the Pattern Drum then cancel those that must not knitting the yarn.
In this condition the control contact is closed on the Ground.
The inputs Autotest therefore displays the value “1”.

This error alerts the user of a problem on the moveable device movement.
In general, the problem is due to:
- Slow response of the solenoid valve of command.
- Sensor adjustment not correct.
- Malfunction of the sensor.

Reference

For the analysis and the solution of this type of errors make reference to the chapter dedicated to the procedures for the resolution of faults relative the position error of the moveable devices (for example the moveable cams).
For the information on the procedure of troubleshooting relating Moveable cams errors see the heading:
Position errors: Moveable device (Moveable Cam)

CHuE74: Jacks extraction drum 1

Sensor input:
G54JCT: Pcb_3759 J13 p15 — G54JOT: Pcb_3759 J13 p15 — G61Q: Pcb_3759 J13 p16 — G624: Pcb_3759 J13 p16
Command output:
G54JCT: в7 e8 — G54JOT: в7 e8 — G61Q: в7 e1 — G624: в12 e1

The input board for this signal is Pcb_3759.

CHuE75: Jacks extraction drum 2

Sensor input:
Pcb_3759 J13 p12
Command output:
G54JCT: в7 e7 — G54JOT: в7 e7

The input board for this signal is Pcb_3759.

CHuE76: Jacks extraction drum 3

Sensor input:
G54JCT: Pcb_3759 J13 p13 — G54JOT: Pcb_3759 J13 p13 — G61Q: Pcb_3759 J13 p12 — G624: Pcb_3759 J13 p12
Command output:
G54JCT: в7 e6 — G54JOT: в7 e6 — G61Q: в7 e2 — G624: в12 e2

The input board for this signal is Pcb_3759.

CHuE77: Jacks extraction drum 4

Sensor input:
G54JCT: Pcb_3759 J13 p14 — G54JOT: Pcb_3759 J13 p14 — G61Q: Pcb_3759 J13 p13 — G624: Pcb_3759 J13 p13
Command output:
G54JCT: в7 e5 — G54JOT: в7 e5 — G61Q: в7 e3 — G624: в12 e3

The input board for this signal is Pcb_3759.

CHuE78: Jacks extraction drum 5

Sensor input:
Pcb_3759 J13 p14
Command output:
G61Q: в7 e4 — G624: в12 e4

The input board for this signal is Pcb_3759.

CHuE79: Jacks extraction drum 6

Sensor input:
Pcb_3759 J13 p15
Command output:
G61Q: в7 e5 — G624: в12 e5

The input board for this signal is Pcb_3759.

CHuE142: Jacks extraction feed 1

Sensor input:
Pcb_3759 J13 p14
Command output:
G44J: в11 e5 — GL-544: в11 e7 — GL-544CT: в10 e2

The input board for this signal is Pcb_3759.

CHuE143: Jacks extraction feed 2

Sensor input:
Pcb_3759 J13 p15
Command output:
G44J: в6 e5 — GL-544: в11 e6 — GL-544CT: в10 e1

The input board for this signal is Pcb_3759.

CHuE144: Jacks extraction feed 3

Sensor input:
Pcb_3759 J13 p12
Command output:
G44J: в11 e7 — GL-544: в11 e4 — GL-544CT: в7 e6

The input board for this signal is Pcb_3759.

CHuE145: Jacks extraction feed 4

Sensor input:
Pcb_3759 J13 p13
Command output:
G44J: в11 e6 — GL-544: в11 e3 — GL-544CT: в9 e8

The input board for this signal is Pcb_3759.

This errors are related the movement of the Cams:
Extraction of pattern drum selectors
This movement is determined by the command that reaches the relative Solenoid Valve.
This device determines the selectors extraction, in order to allow the Pattern Drum the selection of needles that must rise to knitting the yarn.
For this device is present a control input.
It is placed in the rear part of the device.

When the Needle Cam is not controlled (solenoid valve de-energized), it is in the rest position, away from the cylinder.
In this condition the control contact is open on the Ground.
The inputs Autotest therefore displays the value “0”.

When the Needle Cam is operated (solenoid valve energized), it is in the work position, close to the cylinder.
The selectors are extracted, the Pattern Drum then cancel those that must not knitting the yarn.
In this condition the control contact is closed on the Ground.
The inputs Autotest therefore displays the value “1”.

This error alerts the user of a problem on the moveable device movement.
In general, the problem is due to:
- Slow response of the solenoid valve of command.
- Sensor adjustment not correct.
- Malfunction of the sensor.

Reference

For the analysis and the solution of this type of errors make reference to the chapter dedicated to the procedures for the resolution of faults relative the position error of the moveable devices (for example the moveable cams).
For the information on the procedure of troubleshooting relating Moveable cams errors see the heading:
Position errors: Moveable device (Moveable Cam)

CHuE80: Raise medium jacks heel and toe forward

Sensor input:
Pcb_3759 J12 p01
Command output:
Selector raising heel pos. A
G61Q: в5 e5
Selector raising heel pos. B
G61Q: в5 e6

The input board for this signal is Pcb_3759.

CHuE81: Raising needles col. 4

Sensor input:
Pcb_3759 J12 p02
Command output:
G61Q: в6 e8

The input board for this signal is Pcb_3759.

CHuE106: Raise medium jacks colour 1

Sensor input:
Pcb_3759 J12 p07
Command output:
Col 1 rais. medium jacks pos A
G54JCT: в11 e1 — G54JOT: в12 e1
Selector raising col. 1 pos. B
G54JCT: в11 e7 — G54JOT: в12 e7

The input board for this signal is Pcb_3759.

CHuE107: Raise medium jacks colour 2

Sensor input:
Pcb_3759 J12 p12
Command output:
Col 2 rais. medium jacks pos A
G54JCT: в11 e2 — G54JOT: в12 e2
Selector raising col. 2 pos. B
G54JCT: в11 e8 — G54JOT: в12 e8

The input board for this signal is Pcb_3759.

CHuE151: Rise footlet medium jacks 1

Sensor input:
Pcb_3759 J12 p09
Command output:
G616: в8 e4 — G616D: в5 e4 — GL-615: в8 e4 — GL-616: в8 e4 — GL-616D: в8 e6 — GL-616CTE: в7

e5 — GL-615CTE: в10 e3 — GL-616DCTE: в12 e5

The input board for this signal is Pcb_3759.

CHuE152: Rise footlet medium jacks 2

Sensor input:
Pcb_3759 J12 p01
Command output:
G616: в6 e5 — G616D: в6 e5 — GL-615: в6 e5 — GL-616: в6 e5 — GL-616D: в8 e7 — GL-616CTE: в6 e5 — GL-615CTE: в10 e2 — GL-616DCTE: в12 e4

The input board for this signal is Pcb_3759.

CHuE153: Rise footlet medium jacks 3

Sensor input:
Pcb_3759 J12 p04
Command output:
G616: в6 e6 — G616D: в6 e6 — GL-615: в6 e6 — GL-616: в6 e6 — GL-616D: в8 e8 — GL-616CTE: в6 e6 — GL-615CTE: в10 e1 — GL-616DCTE: в12 e3

The input board for this signal is Pcb_3759.

CHuE177: Selector up colour 6

Sensor input:
Pcb_3759 J12 p04
Command output:
G626: в13 e1

The input board for this signal is Pcb_3759.

CHuE195: Stop raise medium jacks ladderproof closing

Sensor input:
Pcb_3759 J13 p09
Command output:
GL-544CT: в6 e1

The input board for this signal is Pcb_2008.

This errors are related the movement of the Cams:
Rise Jacks
This movement is determined by the command that reaches the relative Solenoid Valve.
The purpose of this device is to make the Jacks move to the point of the cylinder where the Needle Cam starts working.
For this device is present a control input.
It is placed in the rear part of the device.

When the Needle Cam is not controlled (solenoid valve de-energized), it is in the rest position, away from the cylinder.
In this condition the control contact is closed on the Ground.
The inputs Autotest therefore displays the value “1”.

When the Needle Cam is operated (solenoid valve energized), it is in the work position, close to the cylinder.
In this condition the control contact is open on the Ground.
The inputs Autotest therefore displays the value “0”.

This error alerts the user of a problem on the moveable device movement.
In general, the problem is due to:

- Slow response of the solenoid valve of command.
- Sensor adjustment not correct.
- Malfunction of the sensor.

Reference

For the analysis and the solution of this type of errors make reference to the chapter dedicated to the procedures for the resolution of faults relative the position error of the moveable devices (for example the moveable cams).
For the information on the procedure of troubleshooting relating Moveable cams errors see the heading:

Position errors: Moveable device (Moveable Cam)

CHuE104: Lowering needles colour 1

Sensor input:

G44J: Pcb_3759 J13 p01 — G54JCT: Pcb_3759 J12 p10 — G54JOT: Pcb_3759 J12 p10

Command output:

G44J: в5 e4 — G54JCT: в11 e4 — G54JOT: в12 e4

The input board for this signal is Pcb_3759.

CHuE105: Lowering needles colour 3

Sensor input:

G44J: Pcb_3759 J12 p10 — G54JCT: Pcb_3759 J12 p05 — G54JOT: Pcb_3759 J12 p05 — GL-544: Pcb_3759 J12 p10 — GL-544CT: Pcb_3759 J12 p10

Command output:

G44J: в11 e8 — G54JCT: в11 e5 — G54JOT: в12 e5 — GL-544: в12 e4 — GL-544CT: в10 e3

The input board for this signal is Pcb_3759.

CHuE112: Lowering needles colour 2

Sensor input:

G44J: Pcb_3759 J12 p15 — G54JCT: Pcb_3759 J12 p15 — G54JOT: Pcb_3759 J12 p15 — GL-544: Pcb_3759 J12 p16 — GL-544CT: Pcb_3759 J12 p16

Command output:

G44J: в5 e7 — G54JCT: в6 e7 — G54JOT: в6 e7 — GL-544: в5 e3 — GL-544CT: в6 e6

The input board for this signal is Pcb_3759.

CHuE149: Lowering needles colour 4

Sensor input:

G44J: Pcb_3759 J12 p06 — GL-544: Pcb_3759 J12 p06 — GL-544CT: Pcb_3759 J12 p06

Command output:

G44J: в12 e7 — GL-544: в12 e6 — GL-544CT: в11 e4

The input board for this signal is Pcb_3759.

CHuE180: Stop needle down colour 5

Sensor input:

Pcb_3759 J12 p09

Command output:

G626: в6 e1

The input board for this signal is Pcb_3759.

CHuE181: Stop needle down colour 6

Sensor input:
Pcb_3759 J12 p05
Command output:
G626: в12 e8

The input board for this signal is Pcb_3759.

This errors are related the movement of the Cams:
Lowering needles colour
This movement is determined by the command that reaches the relative Solenoid Valve.
The purpose of this device is to make the Needles move to the point of the cylinder where the Needle Cam starts working.
For this device is present a control input.
It is placed in the rear part of the device.

When the Needle Cam is not controlled (solenoid valve de-energized), it is in the rest position, away from the cylinder.
In this condition the control contact is closed on the Ground.
The inputs Autotest therefore displays the value “1”.

When the Needle Cam is operated (solenoid valve energized), it is in the work position, close to the cylinder.
In this condition the control contact is open on the Ground.
The inputs Autotest therefore displays the value “0”.

This error alerts the user of a problem on the moveable device movement.
In general, the problem is due to:
- Slow response of the solenoid valve of command.
- Sensor adjustment not correct.
- Malfunction of the sensor.

Reference

For the analysis and the solution of this type of errors make reference to the chapter dedicated to the procedures for the resolution of faults relative the position error of the moveable devices (for example the moveable cams).
For the information on the procedure of troubleshooting relating Moveable cams errors see the heading:
Position errors: Moveable device (Moveable Cam)

CHuE116: Sole splicing cam feed 1

Sensor input:
Pcb_3759 J13 p06
Command output:
G54JCT: в6 e8 — G54JOT: в6 e8

The input board for this signal is Pcb_3759.

CHuE146: Sole splicing cam feed 2

Sensor input:
Pcb_3759 J12 p03
Command output:
G44J: в13 e4 — G54JCT: в10 e3 — G54JOT: в11 e3

The input board for this signal is Pcb_3759.

CHuE147: Sole splicing cam feed 3

Sensor input:
Pcb_3759 J12 p07
Command output:
G44J: в12 e6 — G54JCT: в10 e4 — G54JOT: в11 e4

The input board for this signal is Pcb_3759.

CHuE148: Sole splicing cam feed 4

Sensor input:
Pcb_3759 J12 p12
Command output:
G44J: в6 e4 — G54JCT: в10 e5 — G54JOT: в11 e5

The input board for this signal is Pcb_3759.

CHuE150: Sole splicing cam

Sensor input:
G616: Pcb_3759 J12 p13 — G616D: Pcb_3759 J12 p13 — GL-615: Pcb_3759 J12 p13 — GL-616: Pcb_3759 J12 p13 — GL-616D: Pcb_3759 J12 p13 — GL-61QCT: Pcb_3759 J12 p16 — GL-_CTE: Pcb_3759 J12 p13
Command output:
G615: в6 e4 — G615D: в6 e4 — G616: в7 e2 — G616D: в7 e2 — G61Q: в5 e3 — G624: в4 e4 — G626: в4 e8 — GL-615: в7 e2 — GL-616: в7 e2 — GL-616D: в5 e2 — GL-61QCT: в5 e4 — GL-615CTE: в13 e5 — GL-616DCTE: в15 e8

The input board for this signal is Pcb_3759.

CHuE174: Feed 2 sole reinf posn.A

Sensor input:
Pcb_3759 J12 p03
Command output:
Sole splicing cam feed 2 pos.A
GL-544: в10 e8 — GL-544CT: в12 e2
Sole splicing cam feed 2 pos.B
GL-544: в10 e7 — GL-544CT: в12 e1

The input board for this signal is Pcb_3759.

CHuE175: Feed 3 sole reinf posn.A

Sensor input:
Pcb_3759 J12 p07
Command output:
Sole splicing cam feed 3 pos.A
GL-544: в10 e5 — GL-544CT: в11 e2
Sole splicing cam feed 3 pos.B
GL-544: в10 e4 — GL-544CT: в11 e1

The input board for this signal is Pcb_3759.

CHuE176: Feed 4 sole reinf posn.A

Sensor input:
Pcb_3759 J12 p12
Command output:
Sole splicing cam feed 4 pos.A
GL-544: в6 e7 — GL-544CT: в7 e4
Sole splicing cam feed 4 pos.B
GL-544: в6 e8 — GL-544CT: в7 e5

The input board for this signal is Pcb_3759.

This errors are related the movement of the Cams:
Sole splicing cam
This movement is determined by the command that reaches the relative Solenoid Valve.
The purpose of this device is to make the Needles move to the point of the cylinder where the Needle Cam starts working.
For this device is present a control input.
It is placed in the rear part of the device.

When the Needle Cam is not controlled (solenoid valve de-energized), it is in the rest position, away from the cylinder.
In this condition the control contact is closed on the Ground.
The inputs Autotest therefore displays the value “1”.

When the Needle Cam is operated (solenoid valve energized), it is in the work position, close to the cylinder.
In this condition the control contact is open on the Ground.
The inputs Autotest therefore displays the value “0”.

This error alerts the user of a problem on the moveable device movement.
In general, the problem is due to:
- Slow response of the solenoid valve of command.
- Sensor adjustment not correct.
- Malfunction of the sensor.

Reference

For the analysis and the solution of this type of errors make reference to the chapter dedicated to the procedures for the resolution of faults relative the position error of the moveable devices (for example the moveable cams).
For the information on the procedure of troubleshooting relating Moveable cams errors see the heading:
Position errors: Moveable device (Moveable Cam)

CHuE157: Stop open palette

Sensor input:
Pcb_3759 J13 p11
Command output:
GL-61QCT: в14 e6

The input board for this signal is Pcb_3759.

This errors are related the movement of the Cams:
Latch opener
This movement is determined by the command that reaches the relative Solenoid Valve.
This devices opens the Needle Latches during overturning of the Dial at the Toe seaming stage.
For this device is present a control input.
It is placed in the rear part of the device.

When the Needle Cam is not controlled (solenoid valve de-energized), it is in the rest position, away from the cylinder.
In this condition the control contact is closed on the Ground.

The inputs Autotest therefore displays the value “1”.

When the Needle Cam is operated (solenoid valve energized), it is in the work position, close to the cylinder.
In this condition the control contact is open on the Ground.
The inputs Autotest therefore displays the value “0”.

This error alerts the user of a problem on the moveable device movement.
In general, the problem is due to:

- Slow response of the solenoid valve of command.
- Sensor adjustment not correct.
- Malfunction of the sensor.

Reference

For the analysis and the solution of this type of errors make reference to the chapter dedicated to the procedures for the resolution of faults relative the position error of the moveable devices (for example the moveable cams).
For the information on the procedure of troubleshooting relating Moveable cams errors see the heading:
Position errors: Moveable device (Moveable Cam)

CHuE194: Latch closer stop

Sensor input:
Pcb_3759 J13 p10
Command output:
GL-61QCT: в13 e4

The input board for this signal is Pcb_3759.

This errors are related the movement of the Cams:
Latch closer
This movement is determined by the command that reaches the relative Solenoid Valve.
This devices closes the Needle Latches during overturning of the Dial at the Toe seaming stage.
For this device is present a control input.
It is placed in the rear part of the device.

When the Needle Cam is not controlled (solenoid valve de-energized), it is in the rest position, away from the cylinder.
In this condition the control contact is closed on the Ground.
The inputs Autotest therefore displays the value “1”.

When the Needle Cam is operated (solenoid valve energized), it is in the work position, close to the cylinder.
In this condition the control contact is open on the Ground.
The inputs Autotest therefore displays the value “0”.

This error alerts the user of a problem on the moveable device movement.
In general, the problem is due to:

- Slow response of the solenoid valve of command.
- Sensor adjustment not correct.
- Malfunction of the sensor.

Reference

For the analysis and the solution of this type of errors make reference to the chapter dedicated to the procedures for the resolution of faults relative the position error of the moveable devices (for example the moveable cams).
For the information on the procedure of troubleshooting relating Moveable cams errors see the heading:
Position errors: Moveable device (Moveable Cam)

CHuE183: Stop Dial jacks enter 1

Sensor input:

Pcb_2008 J39 p04
Command output:
G44J: в1 e3 — G54JCT: в1 e1 — G54JOT: в1 e1 — G615: в1 e1 — G615D: в1 e1 — G616: в1 e1 — G616D: в1 e1 — G61Q: в1 e1 — G624: в1 e1 — G626: в1 e1 — GL-544: в1 e2 — GL-544CT: в1 e2 — GL-615: в1 e1 — GL-616: в1 e1 — GL-616D: в1 e1 — GL-61QCT: в1 e2 — GL-616CTE: в1 e2 — GL-615CTE: в19 e8 — GL-616DCTE: в19 e8

The input board for this signal is Pcb_2008.

CHuE184: Stop Dial jacks enter 2

Sensor input:
Pcb_2008 J39 p12
Command output:
G44J: в1 e4 — G54JCT: в1 e2 — G54JOT: в1 e2 — G615: в1 e2 — G615D: в1 e2 — G616: в1 e2 — G616D: в1 e2 — G61Q: в1 e2 — G624: в1 e2 — G626: в1 e2 — GL-544: в1 e3 — GL-544CT: в1 e3 — GL-615: в1 e2 — GL-616: в1 e2 — GL-616D: в1 e2 — GL-61QCT: в1 e3 — GL-616CTE: в9 e2 — GL-615CTE: в19 e7 — GL-616DCTE: в19 e7

The input board for this signal is Pcb_2008.

CHuE185: Stop Dial jacks partial enter 1

Sensor input:
Pcb_2008 J39 p13
Command output:
G54JCT: в1 e3 — GL-544CT: в1 e7 — GL-61QCT: в1 e4

The input board for this signal is Pcb_2008.

CHuE186: Stop Dial jacks partial enter 2

Sensor input:
Pcb_2008 J39 p05
Command output:
G54JCT: в1 e4 — GL-544CT: в1 e8 — GL-61QCT: в1 e5 — GL-616CTE: в1 e5

The input board for this signal is Pcb_2008.

CHuE187: Stop Dial jacks exit 1

Sensor input:
Pcb_2008 J39 p03
Command output:
G44J: в1 e6 — G54JCT: в1 e5 — G54JOT: в1 e5 — G615: в1 e3 — G615D: в1 e3 — G616: в1 e3 — G616D: в1 e3 — G61Q: в1 e3 — G624: в1 e3 — G626: в1 e5 — GL-544: в1 e6 — GL-544CT: в1 e6 — GL-615: в1 e3 — GL-616: в1 e3 — GL-616D: в1 e3 — GL-61QCT: в1 e6 — GL-616CTE: в1 e4 — GL-615CTE: в19 e6 — GL-616DCTE: в19 e6

The input board for this signal is Pcb_2008.

CHuE188: Stop Dial jacks exit 2

Sensor input:
Pcb_2008 J39 p11
Command output:
G44J: в1 e7 — G54JCT: в1 e6 — G54JOT: в1 e6 — G615: в1 e4 — G615D: в1 e4 — G616: в1 e4 —

G616D: в1 e4 — G61Q: в1 e4 — G624: в1 e4 — G626: в1 e6 — GL-544: в1 e5 — GL-544CT: в1 e5 — GL-615: в1 e4 — GL-616: в1 e4 — GL-616D: в1 e4 — GL-61QCT: в1 e7 — GL-615CTE: в19 e5 — GL-616DCTE: в19 e5

The input board for this signal is Pcb_2008.

CHuE189: Stop Dial jacks enter for pattern 2

Sensor input:
Pcb_2008 J39 p14
Command output:
G44J: в16 e5 — G54JCT: в1 e7 — G54JOT: в1 e7 — G615: в1 e5 — G615D: в1 e5 — G616: в1 e5 — G616D: в1 e5 — G61Q: в8 e3 — G624: в1 e5 — G626: в1 e7 — GL-544: в16 e5 — GL-544CT: в15 e5 — GL-615: в1 e5 — GL-616: в1 e5 — GL-616D: в1 e5 — GL-61QCT: в1 e8 — GL-616CTE: в1 e1 — GL-615CTE: в19 e4 — GL-616DCTE: в19 e4

The input board for this signal is Pcb_2008.

This errors are related the movement of the Cams:
Dial jacks enter / Dial jacks exit
This movement is determined by the command that reaches the relative Solenoid Valve.
This device determines thhe movement in entry/exit of the Dial Jacks on the Dial.
For this device is present a control input.
It is placed in the rear part of the device.

When the Needle Cam is not controlled (solenoid valve de-energized), it is in the rest position.
In this condition the control contact is closed on the Ground.
The inputs Autotest therefore displays the value “1”.

When the Needle Cam is operated (solenoid valve energized), it is in the work position.
In this condition the control contact is open on the Ground.
The inputs Autotest therefore displays the value “0”.

This error alerts the user of a problem on the moveable device movement.
In general, the problem is due to:
- Slow response of the solenoid valve of command.
- Sensor adjustment not correct.
- Malfunction of the sensor.

Reference

For the analysis and the solution of this type of errors make reference to the chapter dedicated to the procedures for the resolution of faults relative the position error of the moveable devices (for example the moveable cams).
For the information on the procedure of troubleshooting relating Moveable cams errors see the heading:
Position errors: Moveable device (Moveable Cam)

Input status messages

The information provided applies to the following models:
Stitch-by-stitch models.

Before enabling machine running, the software tests the inputs: if a signal does not comply with the safety conditions, a specific error will appear.

Besides displaying the messages, the section indicates the position of the inputs and the associated output, if any.
The correct signal value must also be specified.
A fault-solving method is detailed further on.

Refer to item:
Explanation

Input sensors detect that the operation progresses stage by stage correctly and safely for the operator.
Each movement is generated by an actuator
The actuator can be pneumatic (solenoid valve) or electric (motor).
The solenoid valves are controlled via the “Serial Line”.
The motors are controlled via the “CAN Line”.
When the motor returns to the paired position, it goes out of tolerance compared to point zero (sensor).

I/O Serial line

The outputs and inputs boards are part of a “I/O Serial Line” that connects them to a main board to which is left their management.
The “I/O serial line” circuit originates from the board Pcb_2008.
From it the “I/O Serial Line” reaches all the various Inputs and Ouputs boards placed outside the Electronic Cabin.
Main inputs board is the Pcb_3759, which is the main external branch point of the “I/O Serial Line”.
The input signal to the specified board originates from the board:
Pcb_3896

CHuE300: Cylinder locking piston

Sensor input:	Command output:	
Pcb_3896 J04 p08	в9 e6	

With the machine in the “Working” status, on hold at Step Zero, the input Autotest indicates correct outfit with the value = “1”.

CHuE303: Cylinder knit pusher DOWN

Sensor input:	Command output:	
Pcb_3896 J01 p08	вM e3	

With the machine in the “Working” status, on hold at Step Zero, the input Autotest indicates correct outfit with the value = “1”.

CHuE304: Cylinder knit pusher UP

Sensor input:	Command output:	
Pcb_3896 J01 p07	вM e3	

With the machine stopped at Step Zero in “Working” status, the input Autotest indicates correct positioning with the value = “0”.

CHuE305: Pickup piston in

Sensor input:	Command output:	
Pcb_3896 J01 p09	вM e5	

With the machine in the “Working” status, on hold at Step Zero, the input Autotest indicates correct outfit with the value = “1”.

CHuE306: Pickup piston out

Sensor input:	Command output:	
Pcb_3896 J01 p10	вM e4	

With the machine stopped at Step Zero in “Working” status, the input Autotest indicates correct positioning with the value = “0”.

CHuE307: Pin holder knit pusher

Sensor input:	Command output:	
Pcb_3896 J02 p08	BN e3	

With the machine stopped at Step Zero in “Working” status, the input Autotest indicates correct positioning with the value = “0”.

CHuE308: Sewing device roller forward

Sensor input:	Command output:	
Pcb_3896 J03 p07	BM e7	

With the machine stopped at Step Zero in “Working” status, the input Autotest indicates correct positioning with the value = “0”.

CHuE309: Sewing device roller backward

Sensor input:	Command output:	
Pcb_3896 J03 p08	BM e6	

With the machine in the “Working” status, on hold at Step Zero, the input Autotest indicates correct outfit with the value = “1”.

CHuE310: Sewing device yarn

Sensor input:	Command output:	
Pcb_3896 J03 p06	BM e8	

With the machine stopped at Step Zero in “Working” status, the input Autotest indicates correct positioning with the value = “0”.

CHuE311: Pin holder unit rotation lever

Sensor input:	Command output:	
Pcb_3896 J02 p06	BN e1	

With the machine in the “Working” status, on hold at Step Zero, the input Autotest indicates correct outfit with the value = “1”.

The input signal to the specified board originates from the board:
Pcb_4768.

CHuE312: Pin holder unit rotation prox. switch

Sensor input:	Command output:	
Pcb_3896 J02 p07	BN e1	

With the machine stopped at Step Zero in “Working” status, the input Autotest indicates correct positioning with the value = “0”.

The input signal to the specified board originates from the board:
Pcb_4768.

CHuE313: Pin holder

Sensor input:	Command output:	
Pcb_3896 J02 p05	BN e2	

With the machine in the “Working” status, on hold at Step Zero, the input Autotest indicates correct outfit with the value = “1”.
The software must receive authorisation from the sensor to activate the associated output.

The input signal to the specified board originates from the board:
Pcb_4768.

CHuE314: Turning device locking piston down

Sensor input:	Command output:	
Pcb_3896 J03 p11	BL e7	

With the machine stopped at Step Zero in “Working” status, the input Autotest indicates correct positioning with the value = “0”.

CHuE315: Turning motor HIGH lim. switch not reached

Sensor input:	Command output:	
Pcb_3896 J05 p05	Motor	

With the machine stopped at Step Zero in “Working” status, the input Autotest indicates correct positioning with the value = “0”.

CHuE316: Knit transfer piston down

Sensor input:	Command output:	
Pcb_3896 J03 p09	BM e1	

With the machine in the “Working” status, on hold at Step Zero, the input Autotest indicates correct outfit with the value = “1”.

CHuE317: Knit transfer piston up

Sensor input:	Command output:	
Pcb_3896 J03 p10	BL e8	

With the machine stopped at Step Zero in “Working” status, the input Autotest indicates correct positioning with the value = “0”.

CHuE318: Top turn. roller tube locking cam blocked

Sensor input:	Command output:	
Pcb_3896 J05 p07	BN e8	

With the machine in the “Working” status, on hold at Step Zero, the input Autotest indicates correct outfit with the value = “1”.

CHuE319: Top turn. roller tube locking cam released

Sensor input:	Command output:	
Pcb_3896 J05 p08	BN e7	

With the machine stopped at Step Zero in “Working” status, the input Autotest indicates correct positioning with the value = “0”.

CHuE320: Internal knit raising tube

Sensor input:	Command output:	

Pcb_3896 J04 p07	вg e8	

With the machine in the “Working” status, on hold at Step Zero, the input Autotest indicates correct outfit with the value = “1”.

CHuE321: Sock present photocell

Sensor input:	Pcb_3896 J04 p11	

With the machine stopped at Step Zero in “Working” status, the input Autotest indicates correct positioning with the value = “0”.

CHuE322: Sock present control rod at zero

Sensor input:	Pcb_3896 J04 p09	

With the machine in the “Working” status, on hold at Step Zero, the input Autotest indicates correct outfit with the value = “1”.

The input signal to the specified board originates from the board:
Pcb_4778.

CHuE331: Sock present control rod working

Sensor input:	Command output:	
Pcb_3896 J04 p10	вM e2	

With the machine stopped at Step Zero in “Working” status, the input Autotest indicates correct positioning with the value = “0”.

The input signal to the specified board originates from the board:
Pcb_4778.

CHuE327: Sewing device cutter

Sensor input:	Command output:	
Pcb_3896 J03 p05	вM e8	

With the machine in the “Working” status, on hold at Step Zero, the input Autotest indicates correct outfit with the value = “1”.

CHuE333: Pickup arm motors not resettable automatically

The software has detected a defect on any of the following inputs:

Sensor input:	Command output:	
Pcb_3896 J02 p05	вN e2	
Pcb_3896 J02 p06	вN e1	

Therefore:
Impossible to Reset any of the following motors:
26- Angle arm
29- Pin frwd. Motor
In practice:
The cause for each motor can be the following, respectively.
26- The moving part of the pin holder dome unit is not in a safe position.
This condition prevented the motor from resetting.
29- Pin unit rotatio lever
The mechanical part remains inserted in the plug.
This condition prevented the motor from resetting.

Reference

For the position of the input and corresponding output, refer to the instructions given in the message:
CHuE313
CHuE311

CHuE328: Mov. of angle pickup arm obstructed

Sensor input:	Pcb_3896 J01 p11	

With the machine stopped at Step Zero in “Working” status, the input Autotest indicates correct positioning with the value = “0”.

CHuE329: TOP turning device piston blocked UP

Sensor input:	Command output:	
Pcb_3896 J05 p09	BN e4	

With the machine in the “Working” status, on hold at Step Zero, the input Autotest indicates correct outfit with the value = “1”.

CHuE330: TOP turning device piston blocked DOWN

Sensor input:	Command output:	
Pcb_3896 J05 p10	BN e5	

With the machine stopped at Step Zero in “Working” status, the input Autotest indicates correct positioning with the value = “0”.

CHuE332: Top turning device guards open

Sensor input:	Pcb_3896 J05 p06	

With the machine stopped at Step Zero in “Working” status, the input Autotest indicates correct positioning with the value = “0”.

CHuE334: Sock stretching sector position 0

Sensor input:	Command output:	
Pcb_3896 J05 p11	BN e6	

With the machine stopped at Step Zero in “Working” status, the input Autotest indicates correct positioning with the value = “0”.
Since the software is subject to improvement, it may be replaced with updated and reviewed versions.
In previous versions this component was identified differently.
In this case, refer to the message code.

The input signal to the specified board originates from the board:
Pcb_4767.
The signal also originates from the board:
Pcb_4789.

CHuE335: Sock stretching sector position 1

Sensor input:	Command output:	
Pcb_3896 J05 p12	BN e6	

With the machine stopped at Step Zero in “Working” status, the input Autotest indicates correct positioning with the value = “0”.
In previous versions this component was identified differently.
In this case, refer to the message code.

The input signal to the specified board originates from the board:

Pcb_4767.
The signal also originates from the board:
Pcb_4789.

CHuE340: Vertical pickup arm motor position

Sensor input:	Pcb_3896 J04 p12	

With the machine stopped at Step Zero in “Working” status, the input Autotest indicates correct positioning with the value = “0”.
This message cannot be displayed if the model is configured for the component:
Double screw
To this end, refer to the menu:
-ANGLE PICK-UP ARM CONTROL

Reference

For further information, refer to the item:
CHuE344

Explanation

The messages may appear under the following condition:
A) In the “Working” status, with the machine on hold at Step Zero.

B) In the “Working” status with the Machine running, and the Seaming Device free.

In detail

A) In the “Working” status, with the machine on hold at Step Zero.
Before enabling machine running, the software tests the inputs: if a signal does not comply with the safety conditions, a specific error will appear.
Under this condition, run cannot be started.
To restore machine operation, remove the cause of error and then erase the message via the command provided.
► Refer to item:
Problem-solving

B) In the “Working” status with the Machine running, and the Seaming Device free.
The Seaming Device is free on completion of its cycle, or it has extracted, sewn and ejected the sock and waits the next one for the following cycle.
To restore machine operation, remove the cause of error and then erase the message via the command provided.
► Refer to item:
Problem-solving

Messages CANNOT be displayed under the following condition:
C) In the “Working” state, with the Machine running, and the Seaming Device occupied.
The Seaming Device is occupied since it has not yet expelled the extracted sock, and thus it is not ready to start a new cycle.
During work, the robot defect does not stops the machine. The error can be viewed in the device dedicated window.
For access to the menu, press:
[Fn] + [C].
Robot malfunction is shwon in the Main Window by means of a red flag below the machine name.

Attention

The robot catch stops the machine when the item must be picked up.
► To this end, please refer to:
CHuE325

Reference

Each input signal value is shown in the dedicated Autotest menu page.
The “Output Autotest” can be sued to check operation of the solenoid valves or the motors and the associated control signal.

Problem-solving

In case of error first check if has been intervened the control device (real error).
Proceed as follows if the sensor indicates a real defect.

- Solve the real problem that has caused the error.
  At this point erase the error with [F8] and start the machine.

If the control device has not intervened, proceed as follows.

With error active (non-erasable with [F8] key), access to Inputs Autotest.
Press the [CTRL] + [B] keys in the error window.

If the input Autotest displays the value indicating regular outfit:

- *Replace the Input board.*

If the input Autotest DOES NOT display the correct value:

- *Check circuit continuity if the signal comes from upstream boards or components.*
- *Check the correct adjustment of the position sensor, and possibly replace it.*
- *Check that the signalling device works properly, and replace it if necessary.*
- *Check that the previous item has not got entangled.*
- *Check whether the (stop) sensor wiring also comprises a ground wire (0V DC), instead of reading the grounding signal from the metal housing when the contact is closed. In this case, check the power cable along the entire route.*
- *To facilitate the failure search, disconnect the control wire from the device.*

  If the error is cancelled by pressing the [F8] key the device is defective.
  - *Proceed to the repair or replacement of the device.*

  If the error remains.
  - *Check that the wire in its path between the device and the inputs board is not to ground. In the case, operate the repair or replacement of the wire.*
  - *Replace the Input board.*

Reference

For further information, refer to the brochure:
Position of machine inputs

The information provided applies to the following models:
Stitch-by-stitch models.

Before enabling machine running, the software tests the inputs: if a signal does not comply with the safety conditions, a specific error will appear.

Besides displaying the messages, the section indicates the position of the inputs and the associated output, if any.
The correct signal value must also be specified.
A fault-solving method is detailed further on.
Refer to item:
Explanation

CHuE325: Sew. Dev. stop button pressed or sew.dev.error

Sensor input:	Pcb_3896 J04 p06	

The input board associated with this signal is Pcb_3896.
With the machine stopped at Step Zero in “Working” status, the input Autotest indicates correct positioning with the value = “0”.

Explanation

This message only refers to the input state, if it comes on when switching the key to Work at Step Zero.

► In this case, refer to the section:
  Input status messages

If the message appears during item pick-up, it has a more general meaning.
This message indicates that the current item cannot be picked up because the Seaming Device is occupied.
The Seaming Device is occupied since it has not yet expelled the extracted sock, and thus it is not ready to start a new cycle.
In general this is caused by:

- The device stop button, with a retainer, remains active (pressed).
- The device operating mode is:
  Phase stop
  The machine awaits the specific command to move the device forward.
- The device is stopped due to a malfunction.

During work, the robot defect does not stops the machine. The error can be viewed in the device dedicated window.
Robot malfunction is shwon in the Main Window by means of a red flag below the machine name.

Problem-solving

Press the key:
[F8].
If you press the button specified, you have direct access to the device menu.
The first rows of the menu show details on the cause of the stop.

► In this case, refer to the section:
Seaming Device dedicated messages

CHuE342: Barrier obstructed

The input board for this signal is Pcb_2008.

The control signal reaches directly the Pcb_2008 board.
Connector
J56
With the machine in the “Working” status, on hold at Step Zero, the input Autotest indicates correct outfit with the value = “1”.
Safety barriers are enabled from item pick up to its expulsion.
This message only refers to the input state, if it comes on when switching the key to Work at Step Zero.
In this case, refer to the section:
Input status messages

Messages on various Management and Operations - S by S

The information provided applies to the following models:
Stitch-by-stitch models.

CHuE341: Pin feed motor: prox.zero out of tol. [Fn+T]

Pin frwd. Motor

The motor position is controlled by an encoder.
If the motor position differs from the software instruction, an error is displayed.
From this error window the user can restore the correct position by pressing the keys:
[Fn]+[T]

The encoder signals associated with this motor are then sent to the board:
Pcb_3836 Nr. 2

Generally this message appears when the machine is turned on after a Black-Out procedure.
When the motor returns to the paired position, it goes out of tolerance compared to point zero (sensor).
Try to restore the correct position using the control specified.
If the error persists, the following registration must be repeated:
First pin position calibration
The following message appears after the intervention:

CHuE301

CHuE323: Max number of turning movements exceeded

The software detects through the photocell that the sock covers the reflector.
The check is performed after a certain number of manoeuvres by the pincers that uncover the tube.
The problem is probably due to a particularly long sock or a yarn that cannot be picked up by the pincers, or again the reflector stripe has detached from the pipe.

Reference

In the event of a false electronic error, refer to the following instructions:
By false error is meant a defect signal not generated by an actually dangerous situation but only electric disturbances and/or hardware defects.
For the position of the input and corresponding output, refer to the instructions given in the message:
CHuE321
CHuE334
CHuE335

CHuE336: Sock sewing procedure time too long

Stage: toe seaming

From the software, the phase interval has a threshold.
If the phase exceeds the time limit, a message is displayed.

Due to unknown causes,the seaming as not completed
The signal is by nature generic.
Inspect the mechanical unit.

CHuE343: Timeout of error reception from stepping motor

This is a system error, it means that in the maximum time for the operation on the CAN line, the system has not been answered (logic timeout).
This problem is probably due to a software failure, and it is supposed it will never be displayed to the user.
However, can exist situations or hardware broken that could cause the appearance of this error.

In case of the occurrence of this error after a Software Update.

- *Run again the Updating procedure, is possible that the copy operation of Software in FLASH memory is not carried out correctly.*

Even if not specific with respect to the real problem, this error may appear in the event of an hardware problem (a fault):

- *To any CAN module.*
- *To the board Pcb_2008.*
- *To the wirings between these boards.*

- A problem in the software writing, an hardware problem on the CAN boards, a disorder on the CAN transmission:
  All these conditions may cause CAN Errors/Alarms not related to the real failure, but General of the CAN system.

Therefore in general, for all the CAN Errors/Alarms, after having evaluated the specific problem indicated by error, also to assess as a possible cause a general problem of the CAN system (software and hardware).

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Adjustment request messages

The information provided applies to the following models:
Stitch-by-stitch models.

General meaning of these messages

The message indicates that the software has detected the absence of a key data in the process.
This may be, for example after a software update of the machine, or in the case of Setup Reset or replacement of the Pcb_2007 board with a new one.

Problem-solving

Proceed as follows to solve the problem:
Repeat the acquisition procedure.
For this section, refer to the specific brochure:
Software parameter re-acquisition

Or:

Proceed as follows to solve the problem:
Activate the *.up file specific for the Setup data involved.

Note

In this case, the file can be used on a specific machine only. The machine should not have undergone major mechanical maintenance interventions since creation of the file and its application.
Refer to the menu:
-SOFTWARE MANAGEMENT
The specific file is entitled:
SETCUCI.UP.
The file comprises all the device calibration data.

CHuE326: Sewing device setup data not complete

The dedicated memory is completely empty.
The message indicates the need to repeat the procedure:
1. First pin position calibration
2. Cylinder angle position calibration

CHuE302: Pin holder unit rotation position calibration

The message indicates the need to repeat the procedure:
First pin position calibration
In particular:
Vertical pin alignment.

CHuE301: First pin posn. calibration

The message indicates the need to repeat the procedure:
First pin position calibration
In particular:
Needle and first pin alignment.

CHuE339: Calibrate lever out posn. of pin holder unit rotation

The message indicates the need to repeat the procedure:
First pin position calibration
In particular:
The lever disengages from the unit rotation pin.

CHuE337: Calibrate angle pickup arm Onboard mach.pos.

The message indicates the need to repeat the procedure:
First pin position calibration
In particular:
Angle pickup arm correction

CHuE338: Cylinder angle position calibration

The message indicates the need to repeat the procedure:
Cylinder angle position calibration

Reference

For further information, refer to the brochure:
Software parameter re-acquisition

Seaming Device dedicated messages

Seaming device

The device is also informally called:
Seaming robot
The following messages are only visible in the dedicated window.
Robot malfunction is shwon in the Main Window by means of a red flag below the machine name.
- ¤ -
Is the device defect causes malfunctioning of the machine, the display first shows the latter malfunction.
It is always advisable try to cancel the error visualized on the Display by pressing the [F8] key, so testing if it's still active.
If the message refers to the device, the control will lead directly to the dedicated menu.
Therefore:
In the window, press:
[Fn] + [F8].

Input sensors detect that the operation progresses stage by stage correctly and safely for the operator.
Each movement is generated by an actuator
The actuator can be pneumatic (solenoid valve) or electric (motor).
The solenoid valves are controlled via the "Serial Line".
The motors are controlled via the "CAN Line".
When the motor returns to the paired position, it goes out of tolerance compared to point zero (sensor).
Some movements are fundamental for machine integrity.
For the most important movements, the actuator is controlled by two sensors.
A sensor detects the final position and another one the initial position.
In this way, the possibility for the moving part to occupy intermediate positions and a faulty sensor to cause damages are excluded.

A fault-solving method is detailed further on.
Refer to item:
Explanation

Serial Line messages

05: Cylinder locking piston not in position Not engaged

06: Cylinder locking piston not in position Not disengaged

Reference

For the position of the input and corresponding output, refer to the instructions given in the message:
CHuE300

07: Cylinder knit pusher not in position. Not down

08: Cylinder knit pusher not in position. Not up

Check whether:
The bushes of the last courses are too narrow and the tensioned knit is prevented from descending.
The solution is correct the programming (GRAPHITRON), thus eliminating the problem.

Reference

For the position of the input and corresponding output, refer to the instructions given in the message:
CHuE303
CHuE304

09: Pickup piston not in position. Not out

10: Pickup piston not in position. Not in

Check whether:
The pick-up device can advance on the needle stem.
If the moving forward pickup devices cause the needles to bend laterally, it means that the adjustment is not accurate enough.
Under this condition, the device cannot go to the end of stroke.
Specific calibration must be redone.
To this end, please refer to:
-CYLINDER ANGLE POSITION CALIBRATION

Reference

For the position of the input and corresponding output, refer to the instructions given in the message:
CHuE305
CHuE306

11: Internal knit raising tube not in position. Not up

12: Internal knit raising tube not in position. Not down

Reference

For the position of the input and corresponding output, refer to the instructions given in the message:
CHuE320

13: Knit transfer piston not in position Not up

14: Knit transfer piston not in position Not down

Reference

For the position of the input and corresponding output, refer to the instructions given in the message:
CHuE316
CHuE317

15: Pin hold knit pusher not in position Not down

16: Pin hold knit pusher not in position Not up

Reference

For the position of the input and corresponding output, refer to the instructions given in the message:

CHuE307

17: Pin holder unit rot. lever not in position Not forward

18: Pin holder unit rot. lever not in position Not reversed

Reference

For the position of the input and corresponding output, refer to the instructions given in the message:
CHuE311

19: Sewing device roller not in position Not forward

20: Sewing device roller not in position Not reversed

Reference

For the position of the input and corresponding output, refer to the instructions given in the message:
CHuE308
CHuE309

21: Sewing device cutter not in position Not closed

22: Sewing device cutter not in position Not open

Reference

For the position of the input and corresponding output, refer to the instructions given in the message:
CHuE327

23: Up turning dev.piston not in position Not down

24: Up turning dev.piston not in position Not up

Reference

For the position of the input and corresponding output, refer to the instructions given in the message:
CHuE329
CHuE330

25: Up turning device tube locking cam not in position.Does NotRelease

26: Up turning device tube locking cam not in position. Does not block

Reference

For the position of the input and corresponding output, refer to the instructions given in the message:
CHuE318
CHuE319

27: Down turning device locking piston not in position. Does NotRelease

28: Down turning device locking piston not in position. Does not block

Reference

For the position of the input and corresponding output, refer to the instructions given in the message:
CHuE314

29: Sock stretching sect. not in position. Not closed

30: Sock stretching sect. not in position. Not open

Reference

For the position of the input and corresponding output, refer to the instructions given in the message:
CHuE334
CHuE335

44: Sock present control rod onboard machine

45: Sock present control rod onboard machine not at zero

Reference

For the position of the input and corresponding output, refer to the instructions given in the message:
CHuE322
CHuE331

Is the device defect causes malfunctioning of the machine, the display first shows the latter malfunction.
The device is also informally called:
Seaming robot
It is always advisable try to cancel the error visualized on the Display by pressing the [F8] key, so testing if it's still active.
If the message refers to the device, the control will lead directly to the dedicated menu.
Therefore:
In the window, press:
[Fn] + [F8].

Error control

At this point we will have two possibilities:

1. The error is cancelled and the machine resumes its functioning.
2. The error is not cancelled, and the machine is blocked with the error displayed.

1st case: the error resets when the button is pressed.

This type of error not persistent must not be understimated, as it indicates an anomalous movement of the mechanical device (too delayed).
The error is displayed because the mechanical device, altough it's in the right position, carried out the movement in too much time.
Proceed as follows to solve the problem:

- Check that the movement of the device is not slowed down or blocked by mechanical obstacoles.
- Check that the internal compressed air ducts of the mechanical device are not blocked and/or clogged.
- Check that the external compressed air ducts (tubes) are not blocked and/or clogged.
- Check that the pneumatic part of the Solenoid valves is no blocked and/or clogged, or mechanically damaged.

2nd case: the error DOES NOT reset when pressing the button.

Should the error not be cancelled, means that the mechanical part concerned shall not be in the right position, or the sensor or the electronic boards has not detected correctly the new position of mechanical part.
Proceed as follows to solve the problem:
Visually check the position taken by the mechanical part concerned the movement.

A. If the mechanical part is not in the right position proceed with the point:
Mechanical device out of position
Should the mechanical device actually be out of position, there are two possible types of problems:
1. Mechanical problem
The mechanical device's movement is blocked, or the Solenoid valve, even though it's properly activated, does not allow the passage of the compressed air toward the exit.
- *Check that the movement of the mechanical part can be carried out without problems.*
Therefore, if necessary, replace the Solenoid valve concerned.

2. *Electric or electronic problem*

The failed movement is due to lack of compressed air from the Solenoid valve.

- *Replace the Solenoid valve concerned.*
- *Replace the Output board corresponding to the command.*

B. If the mechanical part is in the right position proceed with the point:

Mechanical device in right position

If the mechanical part concerned is in the right position, the control sequence was carried out correctly.

Therefore, also the corresponding Solenoid valve functions properly.

The problem may be caused by position sensor that has not found the new position.

- *Check the correct adjustment of the position sensor, and possibly replace it.*
- *Check the connecting cables between the sensor and the inputs board.*
- *Replace the Input board.*

CAN Line messages

32: Mobile pin unit not in position. Not closed

33: Mobile pin unit not in position. Not open

Reference

For the position of the input and corresponding output, refer to the instructions given in the message:
CHuE313

56: Vertical pickup arm position

Reference

For the position of the input and corresponding output, refer to the instructions given in the message:
CHuE340

35: Up turning dev.motor not in end-of-stoke position

Reference

For the position of the input and corresponding output, refer to the instructions given in the message:
CHuE315

38: Pin holder unit rotation motor has not rotated correctly

Reference

For the position of the input and corresponding output, refer to the instructions given in the message:
CHuE312
CHuE313

36: Up turning dev.motor not reached proximity zero

Reference

Refer to item:
MPuE19

39: Pin holder unit rotation motor not in zero position

Reference

Refer to item:
MPuE23

40: Shutter valve motor not in zero position

Reference

Refer to item:
MPuE01

41: External CT shutter valve motor not to zero

Reference

Refer to item:
MPuE24

47: Down turning device inclin. motor not to zero

Reference

Refer to item:
MPuE18

37: Down turning device inclination motor movement not executed

Reference

Refer to item:
GFuE400

Is the device defect causes malfunctioning of the machine, the display first shows the latter malfunction.
The device is also informally called:
Seaming robot
It is always advisable try to cancel the error visualized on the Display by pressing the [F8] key, so testing if it's still active.
If the message refers to the device, the control will lead directly to the dedicated menu.
Therefore:
In the window, press:
[Fn] + [F8].

Error control

At this point we will have two possibilities:

1. The error is cancelled and the machine resumes its functioning.
2. The error is not cancelled, and the machine is blocked with the error displayed.

1st case: the error resets when the button is pressed.

In the window, press:
[Fn] + [F8].
This type of error not persistent must not be understimated, as it indicates an anomalous movement of the mechanical device (too delayed).
The error is displayed because the mechanical device, altough it's in the right position, carried out the movement in too much time.
Proceed as follows to solve the problem:

- Check that the movement of the device is not slowed down or blocked by mechanical obstacoles.
- Check that the internal compressed air ducts of the mechanical device are not blocked and/or clogged.
- Check that the external compressed air ducts (tubes) are not blocked and/or clogged.
- Check that the pneumatic part of the Solenoid valves is no blocked and/or clogged, or mechanically damaged.

2nd case: the error DOES NOT reset when pressing the button.

In the window, press:
[Fn] + [F8].
Should the error not be cancelled, means that the mechanical part concerned shall not be in the right position, or the sensor or the electronic boards has not detected correctly the new position of mechanical part.
Proceed as follows to solve the problem:
Visually check the position taken by the mechanical part concerned the movement.

A. If the mechanical part is not in the right position proceed with the point:
Mechanical device out of position
Should the mechanical device actually be out of position, there are two possible types of problems:
1. *Mechanical problem*
The mechanical device is blocked in its movement.
   - *Check that the movement of the mechanical part can be carried out without problems.*
   - *Check the mechanical functionality of the components linked to the motor movement.*
2. *Electric or electronic problem*
Incorrect or no movement is due to the motor.
   - *Check the wiring that connect the sensor and the motor to the command board (in general the Pcb_3836 board).*
   - *Replace the stepping motor indicated in the message.*
   - *Replace the CAN module (board Pcb_3836) associated with the motor indicated in the message.*

B. If the mechanical part is in the right position proceed with the point:
Mechanical device in right position
If the mechanical part concerned is in the right position, the control sequence was carried out correctly.
The problem may be caused by position sensor that has not found the new position.
   - *Check the correct adjustment of the position sensor, and possibly replace it.*
   - *Check the connecting cables between the sensor and the inputs board.*
   - *Replace the Input board.*

31: Angle pickup arm motor has lost steps. Encoder offset [Fn+G]

PC board	Motor	
Pcb_4752.	Angle arm	

Reference

Refer to item:

57: angle pick-up device arm position [Fn+F0]

PC board	Motor	
Pcb_4752.	Angle arm	

Reference

GFuE423
This message appears when the motor cannot be realigned with the encoder in the work sequence.
The only operation possible is that indicated.
The control resets the device.
The user must continue to Reset the Seaming Device.
Resetting the device means stopping current operation and move it to the home position.

42: Down turning device motor has lost steps. Encoder offset [Fn+B]

42a: Turning device motor down has lost steps. [Fn+R]Repeat[Fn+B]Rest.

PC board	Motor	
Pcb_4752.	Turn. mot. Down	

Reference

GFuE422

49: Vertical pickup arm motor has lost steps. Encoder offset [Fn+V]

PC board	Motor	
Pcb_4752.	Vert. arm	

Reference

GFuE414

Messages on various Management and Operations - S by S

34: Up turning dev.motor has exceeded number of stretching movements

To solve the problem, refer to the instructions given in the message:
► CHuE323

54: Sock seaming phase time too long

To solve the problem, refer to the instructions given in the message:
► CHuE336

Seaming Device dedicated messages

Messages on the manual commands

02: SEWING DEVICE RESET ACTIVATED

A message informs that:
The machine has accepted Resetting of the device.
The function will be activated at the first useful step.
Resetting the device means stopping current operation and move it to the home position.
Only during extraction, when both the machine and robot are synchronised, resetting of a component extends to another.
If a defect occurs in a situation in which it is impossible to complete the next phases, the only solution is to run a Reset cycle.

03: Manually lower the yarn finger plate

This message appears on completion of calibrations.
Furthermore:
The message may be displayed following Resetting.

Problem-solving

Press the operating command:
[Fn] + [Plate Lower]

04: Machine ready Take away phase stop Run de machine

The message appears because the Robot operates by inching.
On this operating mode, each phase is followed by a stop (station).
The machine awaits the specific command to move the device forward.

Problem-solving

Press the operating command:
[Fn] + [*]

60: Press the machine run button to continue

The message indicates the next operation.

Problem-solving

Press the operating command:
(I) Machine Start Button

61: Press the sewing start button to continue

The message indicates the next operation.

Problem-solving

Press the operating command:
c) Seaming device start button
For further information, refer to the brochure:
Software parameter re-acquisition
In particular:
See figure ...
A2.P

62: Seaming device STOP button pressed

The machine has stopped because the button specified was pressed.
b) Linker stop button

For further information, refer to the brochure:
Software parameter re-acquisition
In particular:
See figure ...
A2.P
For the position of the input and corresponding output, refer to the instructions given in the message:

► CHuE325

Problem-solving

The Robot was probably not switched on.
If everything is in order, you can restart the machine.

Restarting the machine

Press the operating command:
c) Seaming device start button
After which:
Follow the sequence displayed.
By Restart the machine it will continue the production of the current Sock.

Manual operation messages

52: Manually remove sock from pickup units

The message may be displayed following Resetting.
The item could not be discharged due to robot stage.
Raise the sock manually to release the knit.

Problem-solving

Raise the sock manually to release the knit.

53: Manually cut seaming fabric

The message may be displayed following Resetting.
Lower the seamer needle using the side knob.
Cut the seaming yarn until the sewing machine retracts without causing any damage.

For further information, refer to the brochure:
Software parameter re-acquisition
In particular:
See figure ...
A2.P

55: Sock presence photocell. Manually adjusts sock

The sock is compressed at the base of the tube via repeated movements of the hands, until when the photocell is uncovered.
A message informs that:
Since the fabric is elastic, the sock covers the phtocell again after compression.
On the first occurrence, the pincers are moved further in depth.
This message appears if, despite this measure, the sock obscures the photocell again.
Lower the sock manually until the photocell is visible.

For further information, refer to the brochure:
Software parameter re-acquisition
In particular:
See figure ...
A2.P

Related messages

For further information see also:
► CHuE323

58: Reverser tube not in correct position Unhook it manually

Reverser tube up

The defect may appear under the following circumstance:
At the end of cycle, the tube must be recovered from the Lower Turning device, which raises and accommodate it, while the Upper Turning Device releases and moves upwards.
The tube adheres by friction to the upper unit, which raises it while it retracts.
In practice:
When the Lower Turning Device descends, the photocell no longer needs to read the tube reflector.

Intervention

Remove the tube from the upper unit and insert it in the lower unit until the clip clicks into place.

The tube tip can be oriented towards the cam or to the right. Orientate it
The tube has this possibility to prevent the toe from entering into the pouches (toe areas).
The tube at the top has two 90° offset side holes.

Orientate the left hole to the cam. The other hole will be on the right.
Or:
Orientate the right hole towards the cam. The other hole will be on the left.

For the position of the input and corresponding output, refer to the instructions given in the message:
► CHuE321

Seaming Device dedicated messages

Safety guard messages

Safety barriers are enabled from item pick up to its expulsion.

63: Angle pickup arm motorvv movement obstructed

The arm disc is surrounded by a metal strip that goes in contact with the housing when it is hurt.
A message informs that:
The arm has encountered an obstacle during its movement.
The obstacle is probably due to a latch that has not released the yarn.

For the position of the input and corresponding output, refer to the instructions given in the message:
► CHuE328

65: Up turning device guards open

Turning device unit Up (top)

A message informs that:
The unit guard has remained open.
Check that the two doors are secured using the locking clip.

For the position of the input and corresponding output, refer to the instructions given in the message:
► CHuE332

66: Barrier obstructed

A message informs that:
The machine or robot work area has been occupied.

Special case

The device operating mode is:
Phase stop
The barriers are only enabled when executing the phase (moving parts) and return in suspension during hold time

For the position of the input and corresponding output, refer to the instructions given in the message:

► CHuE342

Reference

This input can be disabled.
To this end, refer to the menu:
-SETUP TASK CHAIN
In particular:
■ Barrier stop

Notice

- DANGER -

The machine does not display any signal showing that the input has been disabled by the user.
Restore the safey conditions as soon as possible.

Feed messages

64: Sewing yarn broken

A message informs that:
At least one of the Sewing Machine yarns is missing.
The yarn has broken or end of reel.

For the position of the input and corresponding output, refer to the instructions given in the message:
► CHuE310

Messages on various Management and Operations - S by S

48: Yarn finger plate not in position

To solve the problem, refer to the instructions given in the message:
► CHuE167

50: Generic error on motors

To solve the problem, refer to the instructions given in the message:
► CHuE343
► GFuE02

51: Sock ejection failed

To solve the problem, refer to the instructions given in the message:
► CHuE01

59: No phase

To solve the problem, refer to the instructions given in the message:
► CHuE02

Position errors: Moveable device (Moveable Cam)

In the Circular machines many Cams and many mechanical Device controlled by Solenoid valves are equipped with position sensors controlling their movement.

These position sensors are currently of these type:

- CONTACTS:
  They are sensors equipped with a fixed or snap-action contact, which is a integral part of the mechanical device to which they are connected, they operate as an open or closed contact, according to their position.
  The rest position of these sensors, according to the type, may be normally closed (NC) or normally open (NO).
- PROXIMITY:
  They are sensors of proximity, they are supplied with the 24 Vdc tension, with a wire of return for the proximity signal.
  The rest position of these sensors, according to the type, may be normally closed (NC) or normally open (NO).

The Cams and the mechanical device are activated by the corresponding Solenoid valves, which in turn are controlled by the various electronic Outputs of the machine.
The types of solenoid valves are 2: “Normally closed” (N.C.) or “Bistable”.
The command provided to these solenoid valves is initially a “Speed up” voltage (24 Vdc) and subsequently the voltage on their poles is stabilized at a value considerably lower.

- In the first case (NC) air is present at the exit of the Solenoid valve when command is active on its poles.
- In the second case (Bistable) the Solenoid valve switches its output (Closed/Open) only when arrives the specific command.
  This output remains stable even when the machine is turned off, it switches only only when arrives the specific command.

The control sequences of the electronic outputs, and therefore of solenoid valves, are imposed by the active Sock program.
Once the otput has been activated, the corresponding Solenoid valve is excited to allow the movement of mechanical parts.
The mechanical movement is controlled by the corresponding position sensor that sends the information to the inputs board, so that the software can verify the correct position.
Clearly, if only one of the elements of this sequence does not work correctly, a Cam position and/or Mechanical part error message will be activated.
The error message indicates that the concerned mechanical part is not in the right position by the software.

The outputs and inputs boards are part of a “I/O Serial Line” that connects them to a main board to which is left their management.
These olenoid valves are placed on “Bars” (board that perform a command and support function).
These “Bars”, integral part of the “I/O Serial Line”, are placed in a proper box.
Others Solenoid valves can be placed dierctly on the various mechanical devices.
The commands for these Solenoid valves generally come from a board placed on the board Pcb_3759 (I/O Interface), it too placed in a proper box.
Some commands may come also from the Pcb_2008 board.
Some machine models are equipped with mechanical device on which is mounted a serial board, logical equivalent of “Bar”, they too are an integral part of “I/O Serial Line”.
The cable that connects these boards is part of serial connection on the “I/O Serial Line”.

The tubes in exit from solenoid valves reach then mechanical devices (for example the Cams).
On the mechanical device are then assembled the sensors of control, which are connected to the inputs boards.
Main inputs board is the Pcb_3759, which is the main external branch point of the “I/O Serial Line”.
From it the “I/O Serial Line” reaches all the various Inputs and Ouputs boards placed outside the Electronic Cabin.

Error control

It is always advisable try to cancel the error visualized on the Display by pressing the [F8] key, so testing if it’s still active.
At this point we will have two possibilities:

1. The error is cancelled and the machine resumes its functioning.
2. The error is not cancelled, and the machine is blocked with the error displayed.

1st case: the error is cancelled with the [F8] key

This type of error not persistent must not be understimated, as it indicates an anomalous movement of the mechanical device (too delayed).

The error is displayed because the mechanical device, altough it's in the right position, carried out the movement in too much time.
Proceed as follows to solve the problem:

- Check that the movement of the device is not slowed down or blocked by mechanical obstacoles.
- Check that the internal compressed air ducts of the mechanical device are not blocked and/or clogged.
- Check that the external compressed air ducts (tubes) are not blocked and/or clogged.
- Check that the pneumatic part of the Solenoid valves is no blocked and/or clogged, or mechanically damaged.

2nd case: the error is not cancelled with the [F8] key

Should the error not be cancelled, means that the mechanical part concerned shall not be in the right position, or the sensor or the electronic boards has not detected correctly the new position of mechanical part.
Proceed as follows to solve the problem:
Visually check the position taken by the mechanical part concerned the movement.

A. If the mechanical part is not in the right position proceed with the point:
Mechanical device out of position
Should the mechanical device actually be out of position, there are two possible types of problems:
1. *Mechanical problem*
The mechanical device's movement is blocked, or the Solenoid valve, even though it's properly activated, does not allow the passage of the compressed air toward the exit.
   - *Check that the movement of the mechanical part can be carried out without problems.*
   Therefore, if necessary, replace the Solenoid valve concerned.
2. *Electric or electronic problem*
The failed movement is due to lack of compressed air from the Solenoid valve.
   - *Replace the Solenoid valve concerned.*
   - *Replace the Output board corresponding to the command.*

B. If the mechanical part is in the right position proceed with the point:
Mechanical device in right position
If the mechanical part concerned is in the right position, the control sequence was carried out correctly.
Therefore, also the corresponding Solenoid valve functions properly.
The problem may be caused by position sensor th not found the new position.
   - *Check the correct adjustment of the position sensor, and possibly replace it.*
   - *Check the connecting cables between the sensor and the inputs board.*
   - *Replace the Input board.*

Notice

Note

Water vapor inside the compressed air system can damage the pneumatic part of the Solenoid valves.
The compressed air supplied to the machine, besides having the right pressure, must be dry.
If necessary, mount dehumidifiers on the centralized air system or, eventually, bell water vapor condensers at the entry point of each machine.

CONSOLE

```
Co1: Selected language is NOT existing
Co2: Save change or reset original value
COuE01: Motor number already associated
COuE02: Card number already used
COuE03: Motor YOYO number already associated
```

Messages on various Management and Operations

Co1: Selected language is NOT existing

This error appears when Turning on the machine, if previously has been set in the Setup, a language not present in the software installed (“eprom custom”).
This is because in the machine software (“custom”) are available a limited number of languages (2 or 3).
In general in a single “eprom custom” is present a basic language (Italian or English) and other 1 or 2 Languages.
So, there are many “eprom custom” as the whole of the available Languages.
In the choice window (Setup) there are all the various language options, in addition to those actually present in the “eprom custom” installed.
In case the user choose a language not present, the next time you turn on the machine will show this error.
By removing the error automatically the machine sets on the basic language, which is usually Italian or English (the basic language depends in any case by the type of “eprom custom”).
However the machine is perfectly functioning.

If the error occurs to every turning on, must access the Setup and choose a language present on that specific “eprom custom”, then confirm and save.
Otherwise require the Lonati or seek in the “Web” a software that contains the language.
For the request or research indicate the machine model and the version of the software installed in the machine.

Reference

Furthers informations are available in :
GUIDE OF USER INTERFACE
1 Language to use

Co2: Save change or reset original value

This error informs the user that in exit from the modify window of the “Dial” motor values should make a choice.
Save the values modified, or restore the original.
In line with their needs the user should make a choice, only in this case the error can be deleted.

CAN messages on erros of Association/Numbering

COuE01: Motor number already associated

This error can appear during the phase of “Association motors to CAN modules”, if for an error, is associated to a CAN module a motor already previously associated with another CAN module.
- You only need to repeat the Association procedure in the correct order.

Reference

Furthers informations are available in :
GUIDE OF USER INTERFACE
1. Numeration motor CAN

COuE02: Card number already used

This error may appear during “CAN board numbering” when a number already associated with another CAN board is attributed to the board to be numbered.
- You only need to repeat the Numbering procedure in the correct order.

Reference

Furthers informations are available in :
GUIDE OF USER INTERFACE
1. Numeration motor CAN

COuE03: Motor YOYO number already associated

This error may appear during “YOYO motors numbering” when a number already associated with another YOYO motor is attributed to the motor be numbered.

- You only need to repeat the Numbering procedure in the correct order.

Reference

Furthers informations are available in :
GUIDE OF USER INTERFACE

1. YOYO motors numbering

DRUM

Dr1: Error of drums configuration

Messages on Configuration problems

Dr1: Error of drums configuration

This is an internal software error.
It indicates an error of internal configuration on the electronic Pattern Drum management.
This problem is probably due to a software failure, and it is supposed it will never be displayed to the user.

Notice

Attention

In case of the occurrence of this message contact the Lonati technical staff.

GFILE

Gf1: Selected program not existing
GFuE01: External CAN device not numbered
GFuE437: Phase displacement encoder sinker cap posit. motor
GFuE423: Angle pickup device arm motor encoder [Fn+G]
GFuE414: Vertical pickup device arm motor encoder [Fn+V]
GFuE422: Turning device down motor encoder [Fn+B]
GFuE415: Pin feed motor encoder
GFuE419: No 3ENC board mounted
GFuE420: 3ENC CAN module communication "x"
GFuE418: Sewing device needle and ratch.wheel pin not synchronized
GFuE424: Sewing device motor position not correct
Gf2: Selected. subprogram not existing
Gf13: Timeout Comunication CAN "x"
GFuE02: Can generic error
Gf3: Programs memory empty. Reload programs
Gf14: RAM memory partially damaged
Gf4: D.C.N.01 Net outcounter
Gf5: D.C.N.02 Article not compatible with order
Gf6: D.C.N.03 Automatic activation procedure
Gf7: D.C.N.04 Basket outcounter
Gf8: D.C.N.05 Local outcounter
Gf11: D.C.N.08 Forced machine stop
Gf12: PCB2008 software updating failed
GFuE03: Software not for update board
GFuE17: Transmission sizing motor
GFuE18: Send stepping vacuum valve
GFuE19: Send sinker cap motors
GFuE20: Send elastic 1
GFuE21: Send sinker cap position motor
GFuE22: Send saw blade device
GFuE23: Send elastic 2
GFuE24: Send elastic feed 1
GFuE25: Send straighten welt
GFuE26: Send dial motor
GFuE137: Send motor PYF 1
GFuE138: Send motor PYF 2
GFuE139: Send motor PYF 3
GFuE140: Send motor PYF 4
GFuE244: Transmission turning device valve
GFuE256: Transmission stitch cam motor feed 1
GFuE268: Transmission stitch cam motor feed 2
GFuE280: Transmission stitch cam motor feed 3
GFuE292: Transmission stitch cam motor feed 4
GFuE304: Back heel stitch cam motor transmission
GFuE316: Vertical pickup arm motor transmission
GFuE328: Angle pickup arm motor transmission
GFuE340: Turning device down motor transmission
GFuE352: Turning device up motor transmission
GFuE364: Pin feed motor transmission
GFuE376: TX CAN linker motor
GFuE388: Turning device incl. motor transmission
GFuE401: Pin holder unit rotation motor transmission
GFuE425: External CT shutter valve transmission
GFuE27: Reception sizing motor
GFuE28: Reception stepping vacuum valve
GFuE29: Reception sinker cap motors
GFuE30: Reception elastic 1
GFuE31: Rec. sinker cap position motor

GFuE32: Reception saw blade device
GFuE33: Reception elastic 2
GFuE34: Reception elastic feed 1
GFuE35: Reception straighten welt
GFuE36: Reception dial motor
GFuE141: Reception motor PYF 1
GFuE142: Reception motor PYF 2
GFuE143: Reception motor PYF 3
GFuE144: Reception motor PYF 4
GFuE245: Reception turning device valve
GFuE257: Reception stitch cam motor feed 1
GFuE269: Reception stitch cam motor feed 2
GFuE281: Reception stitch cam motor feed 3
GFuE293: Reception stitch cam motor feed 4
GFuE305: Reception stitch cam heel motor
GFuE317: Vertical pickup arm motor reception
GFuE329: Angle pickup arm motor reception
GFuE341: Turning device down motor reception
GFuE353: Turning device up motor reception
GFuE365: Pin feed motor reception
GFuE377: RX CAN linker motor
GFuE389: Turning device incl. motor reception
GFuE402: Pin holder unit rotation motor reception
GFuE426: External CT shutter valve reception
GFuE77: Overrun loss dates sizing motor
GFuE78: Overrun loss dates vacuum valve
GFuE79: Overrun loss dates sinker cap motors
GFuE80: Overrun loss dates elastic 1
GFuE81: Overrun loss dates sinker cap pos.
GFuE82: Overrun loss dates saw blade device
GFuE83: Overrun loss dates elastic 2
GFuE84: Overrun loss dates elastic feed 1
GFuE85: Overrun loss dates straighten welt
GFuE86: Overrun loss dates dial motor
GFuE161: Overrun loss dates motor PYF 1
GFuE162: Overrun loss dates motor PYF 2
GFuE163: Overrun loss dates motor PYF 3
GFuE164: Overrun loss dates motor PYF 4
GFuE249: Overrun data loss turn.device valve
GFuE262: Overrun stitch cam motor feed 1
GFuE274: Overrun stitch cam motor feed 2
GFuE286: Overrun stitch cam motor feed 3
GFuE298: Overrun stitch cam motor feed 4
GFuE310: Overrun stitch cam motor back heel
GFuE369: Pin feed data loss overrun
GFuE333: Angle arm data loss overrun
GFuE321: Vertical arm data loss overrun
GFuE381: overrun linker motor
GFuE357: Turning device up data loss overrun
GFuE345: Turning dev. down data loss overrun
GFuE393: Turn.dev. incl. data loss overrun
GFuE406: Pin hold. rotation motor data loss overrun
GFuE430: External CT shutter valve data loss overrun
GFuE37: Sizing motor disabled!
GFuE38: Stepping vacuum motor valve disabled!
GFuE39: Sinker cap motors disabled!
GFuE40: Elastic motor 1 disabled!
GFuE41: Sinker cap position motor disabled!
GFuE42: Saw blade device motor disabled!
GFuE43: Elastic motor 2 disabled!
GFuE44: Elastic motor feed 1 disabled!
GFuE45: Straighten welt motor disabled!
GFuE46: Dial motor disabled!

GFuE149: Motor PYF 1 disabled
GFuE150: Motor PYF 2 disabled
GFuE151: Motor PYF 3 disabled
GFuE152: Motor PYF 4 disabled
GFuE246: Turning device valve motor disabled!
GFuE258: Disabled Stitch Cam Motor Feed 1
GFuE270: Disabled Stitch Cam Motor Feed 2
GFuE282: Disabled Stitch Cam Motor Feed 3
GFuE294: Disabled Stitch Cam Motor Feed 4
GFuE306: Disabled Heel Return Stitch Cam Motor
GFuE318: Vertical pickup arm motor disabled!
GFuE330: Angle pickup arm motor disabled!
GFuE342: Turning device down motor disabled!
GFuE354: Turning device up motor disabled!
GFuE366: Pin feed motor disabled
GFuE378: DISABLED linker motor
GFuE390: Turning device incl. motor disabled!
GFuE403: Motor pin holder unit rotation motor disabled!
GFuE427: External CT shutter valve motor disabled!
GFuE47: Sizing motor busy!
GFuE48: Stepping vacuum valve motor busy!
GFuE49: Sinker cap motor busy!
GFuE50: Elastic motor 1 busy!
GFuE51: Sinker cap position motor busy!
GFuE52: Saw blade device motor busy!
GFuE53: Elastic motor 2 busy!
GFuE54: Elastic motor feed 1 busy!
GFuE55: Straighten welt motor busy!
GFuE56: Dial motor busy!
GFuE145: Motor PYF 1 BUSY
GFuE146: Motor PYF 2 BUSY
GFuE147: Motor PYF 3 BUSY
GFuE148: Motor PYF 4 BUSY
GFuE247: Turning device valve motor busy!
GFuE259: Busy Stitch Cam Motor Feed 1
GFuE271: Busy Stitch Cam Motor Feed 2
GFuE283: Busy Stitch Cam Motor Feed 3
GFuE295: Busy Stitch Cam Motor Feed 4
GFuE307: Busy Heel Return Stitch Cam Motor
GFuE319: Vertical pickup arm motor busy!
GFuE331: Angle pickup arm motor busy!
GFuE343: Turning device down motor busy!
GFuE355: Turning device up motor busy!
GFuE367: Pin feed motor busy!
GFuE379: linker motor busy!
GFuE391: Turning device incl. motor busy!
GFuE404: Motor pin holder unit rotation motor busy
GFuE428: External CT shutter valve motor busy!
GFuE57: Reset impossible Sizing Motor
GFuE59: Set-over impossible sinker cap motors
GFuE61: Reset impossible Angular Motor
GFuE260: Reset impossible Stitch Cam Motor Feed 1
GFuE272: Reset impossible Stitch Cam Motor Feed 2
GFuE284: Reset impossible Stitch Cam Motor Feed 3
GFuE296: Reset impossible Stitch Cam Motor Feed 4
GFuE327: Vertical arm resetting impossible
GFuE339: Angle arm resetting impossible
GFuE351: Turning dev. down resetting impossible
GFuE363: Turning device up reset impossible
GFuE375: Pin feed resetting impossible
GFuE387: reset impossible linker motor
GFuE399: Turn.dev. incl. resetting impossible
GFuE412: Pin hold.rotation motor resetting impossible

GFuE436: External CT shutter valve resetting impossible
GFuE308: Reset impossible heel Return S.C. Motor
GFuE67: Impossible approach to 0 sizing motor
GFuE69: Impossible approach to 0 sinker cap motors
GFuE71: Impossible approach to 0 sin.cap position
GFuE261: Lost Steps Stitch Cam Motor Feed 1
GFuE273: Lost Steps Stitch Cam Motor Feed 2
GFuE285: Lost Steps Stitch Cam Motor Feed 3
GFuE297: Lost Steps Stitch Cam Motor Feed 4
GFuE320: Impossible approaching vert.arm to zero
GFuE332: Angle arm approaching to zero impossible
GFuE344: Turning dev. down approaching to zero impossible
GFuE356: Turning device up approach to zero impossible
GFuE368: Pin feed approach to zero impossible
GFuE380: lost steps linker motor
GFuE392: Turn.dev. incl. approach to zero impossible
GFuE405: Pin hold.rot.mot. approach to zero impossible
GFuE429: External CT shutter valve approach to zero impossible
GFuE309: Lost Steps Heel Return Stitch Cam Motor
GFuE400: Turn.dev. incl. movement impossible
GFuE413: Pin hold.rotation motor movement impossible
GFuE416: Pin feed motor movement impossible
GFuE417: Sewing device motor movement impossible
GFuE87: Checksum in update sizing motor
GFuE88: Checksum in update vacuum valve
GFuE89: Checksum in update sinker cap motors
GFuE90: Checksum in update elastic 1
GFuE91: Checksum in update sinker cap pos.
GFuE92: Checksum in update saw blade device
GFuE93: Checksum in update elastic 2
GFuE94: Checksum in update elastic feed 1
GFuE95: Checksum in update straighten welt
GFuE96: Checksum in update dial motor
GFuE165: Checksum in update motor PYF 1
GFuE166: Checksum in update motor PYF 2
GFuE167: Checksum in update motor PYF 3
GFuE168: Checksum in update motor PYF 4
GFuE250: Checksum in update turn.device valve
GFuE263: Checksum Stitch Cam Motor Feed 1
GFuE275: Checksum Stitch Cam Motor Feed 2
GFuE287: Checksum Stitch Cam Motor Feed 3
GFuE299: Checksum Stitch Cam Motor Feed 4
GFuE322: Vertical arm checksum being updated
GFuE334: Angle arm checksum being updated
GFuE346: Turning dev. down checksum being updated
GFuE358: Turning device up checksum being updated
GFuE370: Pin feed checksum being updated
GFuE382: checksum linker motor
GFuE394: Turn.dev. incl. checksum being updated
GFuE407: Pin hold.rot.mot. checksum being updated
GFuE431: External CT shutter valve checksum being updated
GFuE311: Checksum Heel Return Stitch Cam Motor
GFuE97: Length update page sizing motor
GFuE98: Length update page vacuum valve
GFuE99: Length update page sinker cap motors
GFuE100: Length update page elastic 1
GFuE101: Length update page sinker cap motor
GFuE102: Length update page saw blade device
GFuE103: Length update page elastic 2
GFuE104: Length update page elastic feed 1
GFuE105: Length update page straighten welt
GFuE106: Length update page dial motor
GFuE169: Length update page motor PYF 1

GFuE170: Length update page motor PYF 2
GFuE171: Length update page motor PYF 3
GFuE172: Length update page motor PYF 4
GFuE251: Page length in update turn.device valve
GFuE264: Leng.page Stitch Cam Motor Feed 1
GFuE276: Leng.page Stitch Cam Motor Feed 2
GFuE288: Leng.page Stitch Cam Motor Feed 3
GFuE300: Leng.page Stitch Cam Motor Feed 4
GFuE323: Vertical arm page length being updated
GFuE335: Angle arm page length being updated
GFuE347: Turning dev. down page length being updated
GFuE359: Turning device up page length being updated
GFuE371: Pin feed page length being updated
GFuE383: leng.page linker motor
GFuE395: Turn.dev. incl. page length being updated
GFuE408: Pin hold.rot.mot. page length being updated
GFuE432: External CT shutter valve page length being updated
GFuE312: Leng.page Heel Return Stitch Cam Motor
GFuE107: Writing FLASH update sizing motor
GFuE108: Writing FLASH update vacuum valve
GFuE109: Writing FLASH update sinker cap motors
GFuE110: Writing FLASH update elastic 1
GFuE111: Writing FLASH update sinker cap motor
GFuE112: Writing FLASH update saw blade device
GFuE113: Writing FLASH update elastic 2
GFuE114: Writing FLASH update elastic feed 1
GFuE115: Writing FLASH update straighten welt
GFuE116: Writing FLASH update dial motor
GFuE173: Writing FLASH update motor PYF 1
GFuE174: Writing FLASH update motor PYF 2
GFuE175: Writing FLASH update motor PYF 3
GFuE176: Writing FLASH update motor PYF 4
GFuE252: FLASH write in update turn.device valve
GFuE265: Flash Stitch Cam Motor Feed 1
GFuE277: Flash Stitch Cam Motor Feed 2
GFuE289: Flash Stitch Cam Motor Feed 3
GFuE301: Flash Stitch Cam Motor Feed 4
GFuE324: Vertical arm FLASH write being updated
GFuE336: Angle arm FLASH write being updated
GFuE348: Turning dev. down FLASH write being updated
GFuE360: Turning device up FLASH write being updated
GFuE372: Pin feed FLASH write being updated
GFuE384: flash linker motor
GFuE396: Turn.dev. incl. FLASH write being updated
GFuE409: Pin hold.rot.mot. FLASH write being updated
GFuE433: External CT shutter valve FLASH write being updated
GFuE313: Flash Heel Return Stitch Cam Motor
GFuE117: Number page in updating sizing motor
GFuE118: Number page in updating vacuum valve
GFuE119: Number page in updating sinker cap motors
GFuE120: Number page in updating elastic 1
GFuE121: Number page in updating sinker cap pos.
GFuE122: Number page in updating saw blade device
GFuE123: Number page in updating elastic 2
GFuE124: Number page in updating elastic feed 1
GFuE125: Number page in updating straighten welt
GFuE126: Number page in updating dial motor
GFuE177: Number page in updating motor PYF 1
GFuE178: Number page in updating motor PYF 2
GFuE179: Number page in updating motor PYF 3
GFuE180: Number page in updating motor PYF 4
GFuE253: Page number in update turn.device valve
GFuE266: Number page Stitch Cam Motor Feed 1

GFuE278: Number page Stitch Cam Motor Feed 2
GFuE290: Number page Stitch Cam Motor Feed 3
GFuE302: Number page Stitch Cam Motor Feed 4
GFuE325: Vertical arm page number being updated
GFuE337: Angle arm page number being updated
GFuE349: Turning dev. down page number being updated
GFuE361: Turning device up page number being updated
GFuE373: Pin feed page number being updated
GFuE385: num.page linker motor
GFuE397: Turn.dev. incl. page number being updated
GFuE410: Pin hold.rot.mot. page number being updated
GFuE434: External CT shutter valve page number being updated
GFuE314: Number page Heel Return Stitch Cam Motor
GFuE127: Tension low feeding sizing motor
GFuE128: Tension low feeding vacuum valve
GFuE129: Tension low feeding sinker cap motors
GFuE130: Tension low feeding elastic 1
GFuE131: Tension low feeding sinker cap pos.
GFuE132: Tension low feeding saw blade device
GFuE133: Tension low feeding elastic 2
GFuE134: Tension low feeding elastic feed 1
GFuE135: Tension low feeding straighten welt
GFuE136: Tension low feeding dial motor
GFuE181: Tension low feeding motor PYF 1
GFuE182: Tension low feeding motor PYF 2
GFuE183: Tension low feeding motor PYF 3
GFuE184: Tension low feeding motor PYF 4
GFuE254: Supply voltage low turn.device valve
GFuE267: Tension Stitch Cam Motor Feed 1
GFuE279: Tension Stitch Cam Motor Feed 2
GFuE291: Tension Stitch Cam Motor Feed 3
GFuE303: Tension Stitch Cam Motor Feed 4
GFuE326: Vertical arm power supply too low
GFuE338: Angle arm power supply too low
GFuE350: Turning dev. down power supply too low
GFuE362: Turning device up power supply too low
GFuE374: Pin feed power supply too low
GFuE386: tension linker motor
GFuE398: Turn.dev. incl. supply voltage too low
GFuE411: Pin hold.rot.mot. Power supply too low
GFuE435: External CT shutter valve power supply too low
GFuE315: Tension Heel Return Stitch Cam Motor
GFuE185: Bobbin End motor PYF 1
GFuE186: Bobbin End motor PYF 2
GFuE187: Bobbin End motor PYF 3
GFuE188: Bobbin End motor PYF 4
GFuE189: ECODD: Generic
GFuE190: ECODD: 310 Volt KO
GFuE191: ECODD: Motor thermal relay
GFuE192: ECODD: Dissipator thermal relay
GFuE193: ECODD: Motor energy I2T
GFuE194: ECODD: TX CAN
GFuE195: ECODD: RX CAN
GFuE196: ECODD: Commands overlap
GFuE197: ECODD: FLASH write
GFuE198: ECODD: Set of parameters
GFuE199: ECODD: Parameters RDC
GFuE200: ECODD: WATCH DOG Actuation
GFuE201: ECODD: Actuation not configured
GFuE202: ECODD: OFFSET execution reference
GFuE218: Generic CAN YOYO
GFuE219: YOYO Not numerated
GFuE220: Transmission YOYO “x”

GFuE221: Reception YOYO "x"
GFuE222: Broken Yarn YOYO "x"
GFuE224: Sensor of Hall YOYO "x"
GFuE228: Overrun YOYO "x"
GFuE229: Checksum YOYO "x"
GFuE230: Length page YOYO "x"
GFuE231: Writing on FLASH YOYO "x"
GFuE232: Page number YOYO "x"

Messages on various Management and Operations

Gf1: Selected program not existing

This message alerts the user that the selected file in RAM memory of the Pcb_2007 board does not exist (wrong choice or files damaged).
The type of file selected is "Sock Program" or " Link Program" and the operation type is Activation.
However it should never appear if not in case of damages of the files in RAM memory or in case of "Link program" composed of "Sock programs" no longer present in memory (for example, because deleted).

- If appropriate proceed to activation of a program available in memory.

GFuE01: External CAN device not numbered

This message refers to a generic external device connected to the CAN module.
This error is generated when, during external device Numbering, an identification number for a motor not enabled in Setup is used by mistake.

Notice

Note

Currently on the machines are not provided external devices in CAN.
This message then should not appear.

GFuE437: Phase displacement encoder sinker cap posit. motor

This message may appear in machines in which the "Sinker Cap Position" is arranged with an Encoder for the position control.
If, after a command, the position reached by the Cap motor, controlled by the Encoder, is not within a certain tolerance, appears this error.
From this error window the user can restore the correct position by pressing the keys:
[Ctrl]+[X]

Messages on various Management and Operations - S by S

GFuE423: Angle pickup device arm motor encoder [Fn+G]

Angle pickup arm motor

The motor position is controlled by an encoder.
If the motor position differs from the software instruction, an error is displayed.
From this error window the user can restore the correct position by pressing the keys:
[Fn]+[G]

The encoder signals associated with this motor are then sent to the board:
Pcb_4752.

GFuE414: Vertical pickup device arm motor encoder [Fn+V]

Vertical pickup arm motor

The motor position is controlled by an encoder.
If the motor position differs from the software instruction, an error is displayed.
From this error window the user can restore the correct position by pressing the keys:
[Fn]+[V]

The encoder signals associated with this motor are then sent to the board:
Pcb_4752.

GFuE422: Turning device down motor encoder [Fn+B]

Turning motor down

The motor position is controlled by an encoder.
If the motor position differs from the software instruction, an error is displayed.
From this error window the user can restore the correct position by pressing the keys:
[Fn]+[B]

The encoder signals associated with this motor are then sent to the board:
Pcb_4752.

GFuE415: Pin feed motor encoder

Pin frwd. Motor

The motor position is controlled by an encoder.
If the motor position differs from the software instruction, an error is displayed.
The user must continue to Reset the Seaming Device.
Press the button:
[Fn] + [F0]

This message highlights a problem caused by an error in the Software management.
For this reason it should never appear to the customer.

Notice

Attention

Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

The encoder signals associated with this motor are then sent to the board:

PC board	Connector	
Pcb_3836 Nr. 2	J12	

GFuE419: No 3ENC board mounted

This message is displayed when you wish to update the component with the specific Up file, but it is still not present.

The message refers to the board:
Pcb_4752.
This board is detected automatically and does not require any intervention on jumpers, dip-switches or the Setup menu.
The Pcb_4752 board is a module used to handle the signals of three encoders and integrate them in the CAN line.

The board requires its own software.
The specific component software is an “.up” file.
The file name is:
3ENCxxxx.up

xxxx represents the version identification number.
To this end, refer to the menu:
Expansion versions of 3ENC

The board is reported as absent when all the CAN motors requesting it have been disabled by the user.

Problem-solving

Check that the specified Setup item has been enabled.
Check that at least one CAN motor requiring the board is enabled

Stitch-by-stitch models.

The motors using the board are the following:
25 - Vertical pickup arm motor
26 - Angle pickup arm motor
27 - Turning motor down
All the CAN motors of the Seaming Device are disabled by deactivating the following Setup item:
■ Sock extraction and seaming

The number of boards currently present is:
1.

GFuE420: 3ENC CAN module communication "x"

On machine start up, this error informs the user that a board does not answer to software queries.
This generally occurs when the board is faulty or disconnected.

The message refers to the board:
Pcb_4752.
This board is detected automatically and does not require any intervention on jumpers, dip-switches or the Setup menu.
The board is detected if at least one CAN motor requiring it is enabled.
The message appears if the board is faulty, or it is wrongly connected: check the connectors, and replace the board, if necessary.
This board is linked to the board:
Pcb_4706/2.

- Check the connections and replace the board, if necessary.

Sometimes the error is generated when there are communication interference between board Pcb_3836 and board Pcb_4752.
If the episode is random and not repeated in the time, cancel the error and continue the production.

If the error shows up more than once, the user must find the reason.
Proceed as follows to solve the problem:
- Check the presence of electrical noise on power Three-Phase Line of the machine.
- Check the functionality of the Earth installation of the machine and the correct connection to Ground of the yarn Creel.
- Check the presence of disturbances on the Ground of the machine (0 Vdc).

Reference

For further information see also:
GFuE419

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

GFuE418: Sewing device needle and ratch.wheel pin not synchronized

During sock seaming, the vertical reciprocating movement of the needle must be synchronised with feed (rotation) of the pin holder dome unit.
A message appears when these mechanical parts are no longer synchronised.
Synchronism can be verified on the Sewing Machine Motor Zero signal (needle down) and the Pin Feed motor encoder signal.
Regular advance of a pin may occur between a seaming point and the next.
The step between pins depends on the number of machine needles.
Proceed as follows to solve the problem:
The user must continue to Reset the Seaming Device.
Press the operating command:
[Fn] + [F0]
If the problem persists:
Check the sensor changes its status when the needle leaves the low-needle position.
Check that the wheel the sensor detects is integral with the pivot.
In generating this signal, the following components are involved:

- Sewing machine zero sensor
- Encoder of the Pin Feed motor

The signals are then sent to the board:
Pcb_3836 Nr. 2

GFuE424: Sewing device motor position not correct

Messages on problems in the Software Management

Gf2: Selected. subprogram not existing

This alarm indicates incompatibility between the programming software (GRAPHITRON) and the machine software (Eproms).

- The solution, depending on the case, is to update the machine software (Eproms) or the GRAPHITRON software.

Other causes for this problem may be the machine software or programming software not valid because damaged or containing a mistake.

- Also in this case, the solution is to run the software update with a valid and compatible version.

Notice

Attention

Contact Lonati technical staff for further information and for an eventual Software update.

Gf13: Timeout Comunication CAN "x"

This is a system error, it means that in the maximum time for the operation on the CAN line, the system has not been answered (logic timeout).
This problem is probably due to a software failure, and it is supposed it will never be displayed to the user.
However, can exist situations or hardware broken that could cause the appearance of this error.

In case of the occurrence of this error after a Software Update.

- *Run again the Updating procedure, is possible that the copy operation of Software in FLASH memory is not carried out correctly.*

Even if not specific with respect to the real problem, this error may appear in the event of an hardware problem (a fault):

- *To any CAN module.*

- *To the board Pcb_2008.*
- *To the wirings between these boards.*

- A problem in the software writing, an hardware problem on the CAN boards, a disorder on the CAN transmission:
  All these conditions may cause CAN Errors/Alarms not related to the real failure, but General of the CAN system.

Therefore in general, for all the CAN Errors/Alarms, after having evaluated the specific problem indicated by error, also to assess as a possible cause a general problem of the CAN system (software and hardware).

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

GFuE02: Can generic error

This error indicates that the software has been a problem on the CAN logic, but failed to define the type of problem.
This problem is probably due to a software failure, and it is supposed it will never be displayed to the user.

- A problem in the software writing, an hardware problem on the CAN boards, a disorder on the CAN transmission:
  All these conditions may cause CAN Errors/Alarms not related to the real failure, but General of the CAN system.

Therefore in general, for all the CAN Errors/Alarms, after having evaluated the specific problem indicated by error, also to assess as a possible cause a general problem of the CAN system (software and hardware).

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Messages on operations in RAM

Gf3: Programs memory empty. Reload programs

This error appears on Switching on, when the RAM memory of the Pcb_2007 board is completely empty.
Generally this happens when the the buffer battery for the RAM memory of the Pcb_2007 board is exhausted, disconnected because open the proper jumper, or as a result of a Reset of the RAM.
Obviously also the installation of a new Pcb_2007 board may cause this error.
In the new Pcb_2007 boards, when they are new or sent by Lonati, the activation Jumper of the buffer battery is always open, and therefore is necessary to shut it when the board is mounted on the machine.
The appearance of this error is correct when performing certain specific operations (some cases of updating software and during procedures for the resolution of malfunctions that require the cancellation of RAM memory).

- The solution is the cancellation of the error, and, for example the loading of a Sock Program in the machine.
- If previously no operation was performed,, check the Jumper position and the status of the buffer battery BT1 (3, 2 V), eventually replace it.

Gf14: RAM memory partially damaged

This message informs the user that following the operation of machine software Updating the programs memory (RAM) has been partially damaged.
The consequence of this is the loss of some Sock programs previously available in RAM memory.
This message informs the user that the operation on the software has caused the loss of part of the RAM memory contents.

Messages on the DCN device

Gf4: D.C.N.01 Net outcounter

This error, communicated by the DCN system (production control), stops the machine warning the user that is finished the socks production set by using DCN system (production Target).

Notice

Attention

For details of the Dinema DCN network, contact Dinema S.r.l.

Gf5: D.C.N.02 Article not compatible with order

This error, communicated by the DCN system (production control), alerts the user that the Program activated on the machine is not compatible with the one set by the DCN system; this is true only for the special article.

Notice

Attention

For details of the Dinema DCN network, contact Dinema S.r.l.

Gf6: D.C.N.03 Automatic activation procedure

This error, communicated by the DCN system (production control), informs the user that the Program activation was made by the DCN System, and therefore that the next production will be relate to a new article.

Notice

Attention

For details of the Dinema DCN network, contact Dinema S.r.l.

Gf7: D.C.N.04 Basket outcounter

This error, communicated by the DCN system (production control), stops the machine warning the user that is finished the socks production set by the Basket Outcounter (bag) of the DCN system; is possible now change the bag containing the socks with an empty.

Notice

Attention

For details of the Dinema DCN network, contact Dinema S.r.l.

Gf8: D.C.N.05 Local outcounter

This error, communicated by the DCN system (production control), stops the machine warning the user that is finished the socks production set by the local Outcounter (i.e. not tied to any order, but proper of the DCN system).

Notice

Attention

For details of the Dinema DCN network, contact Dinema S.r.l.

Gf11: D.C.N.08 Forced machine stop

This error, communicated by the DCN system (production control), alerts the user that the machine has been stopped at the End of Cyle forcing the appropriate key through the DCN system.

Notice

Attention

For details of the Dinema DCN network, contact Dinema S.r.l.

Messages on operations in FLASH

Gf12: PCB2008 software updating failed

This error informs the user that the attempt to update the Pcb_2008 board with its specific software has failed.
The file ".up" is not copied in the FLASH memory of the Board or module.
The failure of this operation is rare, usually can happen if the file in activation is damaged or if happen a traumatic end of the operation (for example turn off the machine during the copy).
Proceed as follows to solve the problem:

- Repeat the procedure of loading and activation of the software.
- Replace the board or module concerned the software upgrade.

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Reference

For the information concerning the procedures mentioned in previous explanations make reference to the section:
Operations on the Software machine

GFuE03: Software not for update board

This error appears when trying to run the software update of a CAN module with a software not compatible for that specific module (CAN board).

An introduction, in the Lonati machines are available various type of CAN modules (different type of Boards), the one always present is the Pcb_3836.
Others possible modules are the Pcb_3825 board, the Pcb_3862 board for the PYF brushless control, and more.
In addition each individual machine can be provided with more boards of the same type (e.g. 2, 3 or 4 Pcb_3836 boards).
Usually the software Update (for example the activation of a file ".up") provides the contemporary updating of all the boards of the same type available in the machine.
Through the appropriate Utility is possible update a single module (CAN board) and not the other.
These Utilities allow us to combine the software (file ".up") to a certain module (through its identification number) and proceed to only its Update.
If however the file ".up" (software) is not related to that type of CAN module (for example with a file ".up" specific for the Pcb_3836 board you should update a board type Pcb_3825) this must not be possible.

This update operation is therefore blocked and the user is warned with an error.
The file used is not valid to update the board indicated.

CAN messages: Communication Management

GFuE17: Transmission sizing motor

GFuE18: Send stepping vacuum valve

GFuE19: Send sinker cap motors

GFuE20: Send elastic 1

GFuE21: Send sinker cap position motor

GFuE22: Send saw blade device

GFuE23: Send elastic 2

GFuE24: Send elastic feed 1

GFuE25: Send straighten welt

GFuE26: Send dial motor

GFuE137: Send motor PYF 1

GFuE138: Send motor PYF 2

GFuE139: Send motor PYF 3

GFuE140: Send motor PYF 4

GFuE244: Transmission turning device valve

GFuE256: Transmission stitch cam motor feed 1

GFuE268: Transmission stitch cam motor feed 2

GFuE280: Transmission stitch cam motor feed 3

GFuE292: Transmission stitch cam motor feed 4

GFuE304: Back heel stitch cam motor transmission

GFuE316: Vertical pickup arm motor transmission

GFuE328: Angle pickup arm motor transmission

GFuE340: Turning device down motor transmission

GFuE352: Turning device up motor transmission

GFuE364: Pin feed motor transmission

GFuE376: TX CAN linker motor

GFuE388: Turning device incl. motor transmission

GFuE401: Pin holder unit rotation motor transmission

GFuE425: External CT shutter valve transmission

This message warns the user that there is transmission error on the CAN line between board Pcb_2008 and the CAN module associated with the motor indicated in the error.
The problem may be caused by a transmission defect, and then by a malfunction of hardware concerned.
Proceed as follows to solve the problem:

- Check the wiring that connect the Pcb_2008 board to the CAN module (Pcb_3836 board) relative the motor indicated in the message.
- Replace the CAN module (board Pcb_3836) associated with the motor indicated in the message.
- Replace the board Pcb_2008.

Also assess the frequency of occurrence of the error and if it determines malfunctions of the concerned motor or of other

CAN devices.

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

GFuE27: Reception sizing motor

GFuE28: Reception stepping vacuum valve

GFuE29: Reception sinker cap motors

GFuE30: Reception elastic 1

GFuE31: Rec. sinker cap position motor

GFuE32: Reception saw blade device

GFuE33: Reception elastic 2

GFuE34: Reception elastic feed 1

GFuE35: Reception straighten welt

GFuE36: Reception dial motor

GFuE141: Reception motor PYF 1

GFuE142: Reception motor PYF 2

GFuE143: Reception motor PYF 3

GFuE144: Reception motor PYF 4

GFuE245: Reception turning device valve

GFuE257: Reception stitch cam motor feed 1

GFuE269: Reception stitch cam motor feed 2

GFuE281: Reception stitch cam motor feed 3

GFuE293: Reception stitch cam motor feed 4

GFuE305: Reception stitch cam heel motor

GFuE317: Vertical pickup arm motor reception

GFuE329: Angle pickup arm motor reception

GFuE341: Turning device down motor reception

GFuE353: Turning device up motor reception

GFuE365: Pin feed motor reception

GFuE377: RX CAN linker motor

GFuE389: Turning device incl. motor reception

GFuE402: Pin holder unit rotation motor reception

GFuE426: External CT shutter valve reception

This message warns the user that there is transmission error on the CAN line between board Pcb_2008 and the CAN module associated with the motor indicated in the error.
The problem may be caused by a transmission defect, and then by a malfunction of hardware concerned.
Proceed as follows to solve the problem:

- Check the wiring that connect the Pcb_2008 board to the CAN module (Pcb_3836 board) relative the motor indicated in the message.
- Replace the CAN module (board Pcb_3836) associated with the motor indicated in the message.
- Replace the board Pcb_2008.

Also assess the frequency of occurrence of the error and if it determines malfunctions of the concerned motor or of other CAN devices.

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

GFuE77: Overrun loss dates sizing motor

GFuE78: Overrun loss dates vacuum valve

GFuE79: Overrun loss dates sinker cap motors

GFuE80: Overrun loss dates elastic 1

GFuE81: Overrun loss dates sinker cap pos.

GFuE82: Overrun loss dates saw blade device

GFuE83: Overrun loss dates elastic 2

GFuE84: Overrun loss dates elastic feed 1

GFuE85: Overrun loss dates straighten welt

GFuE86: Overrun loss dates dial motor

GFuE161: Overrun loss dates motor PYF 1

GFuE162: Overrun loss dates motor PYF 2

GFuE163: Overrun loss dates motor PYF 3

GFuE164: Overrun loss dates motor PYF 4

GFuE249: Overrun data loss turn.device valve

GFuE262: Overrun stitch cam motor feed 1

GFuE274: Overrun stitch cam motor feed 2

GFuE286: Overrun stitch cam motor feed 3

GFuE298: Overrun stitch cam motor feed 4

GFuE310: Overrun stitch cam motor back heel

GFuE369: Pin feed data loss overrun

GFuE333: Angle arm data loss overrun

GFuE321: Vertical arm data loss overrun

GFuE381: overrun linker motor

GFuE357: Turning device up data loss overrun

GFuE345: Turning dev. down data loss overrun

GFuE393: Turn.dev. incl. data loss overrun

GFuE406: Pin hold. rotation motor data loss overrun

GFuE430: External CT shutter valve data loss overrun

This message warns the user that there is transmission error on the CAN line between board Pcb_2008 and the CAN module associated with the motor indicated in the error.
The transmission line concerned the module indicated in the error is congested.
The problem may be caused by a transmission defect, and then by a malfunction of hardware concerned.
Proceed as follows to solve the problem:

- Check the wiring that connect the Pcb_2008 board to the CAN module (Pcb_3836 board) relative the motor indicated in the message.
- Replace the CAN module (board Pcb_3836) associated with the motor indicated in the message.
- Replace the board Pcb_2008.

Also assess the frequency of occurrence of the error and if it determines malfunctions of the concerned motor or of other CAN devices.

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

CAN messages: Motor Disabled

GFuE37: Sizing motor disabled!

GFuE38: Stepping vacuum motor valve disabled!

GFuE39: Sinker cap motors disabled!

GFuE40: Elastic motor 1 disabled!

GFuE41: Sinker cap position motor disabled!

GFuE42: Saw blade device motor disabled!

GFuE43: Elastic motor 2 disabled!

GFuE44: Elastic motor feed 1 disabled!

GFuE45: Straighten welt motor disabled!

GFuE46: Dial motor disabled!

GFuE149: Motor PYF 1 disabled

GFuE150: Motor PYF 2 disabled

GFuE151: Motor PYF 3 disabled

GFuE152: Motor PYF 4 disabled

GFuE246: Turning device valve motor disabled!

GFuE258: Disabled Stitch Cam Motor Feed 1

GFuE270: Disabled Stitch Cam Motor Feed 2

GFuE282: Disabled Stitch Cam Motor Feed 3

GFuE294: Disabled Stitch Cam Motor Feed 4

GFuE306: Disabled Heel Return Stitch Cam Motor

GFuE318: Vertical pickup arm motor disabled!

GFuE330: Angle pickup arm motor disabled!

GFuE342: Turning device down motor disabled!

GFuE354: Turning device up motor disabled!

GFuE366: Pin feed motor disabled

GFuE378: DISABLED linker motor

GFuE390: Turning device incl. motor disabled!

GFuE403: Motor pin holder unit rotation motor disabled!

GFuE427: External CT shutter valve motor disabled!

Any CAN motor, if provided in the software (in the “eprom custom”), may be disabled from “Setup”.
This error appears if in the Sock Program is commanded a disabled motor.

- The solution is access to the Setup and enable the motor, or is eliminate the command in the Sock Program (GRAPHITRON).

Notice

Note

According to the machine model, could not be possible the disabling of some specific motor by Setup.
This is because they are always mounted in the machine and are essential for its operation.

CAN messages: Zeroing and Busy management

GFuE47: Sizing motor busy!

GFuE48: Stepping vacuum valve motor busy!

GFuE49: Sinker cap motor busy!

GFuE50: Elastic motor 1 busy!

GFuE51: Sinker cap position motor busy!

GFuE52: Saw blade device motor busy!

GFuE53: Elastic motor 2 busy!

GFuE54: Elastic motor feed 1 busy!

GFuE55: Straighten welt motor busy!

GFuE56: Dial motor busy!

GFuE145: Motor PYF 1 BUSY

GFuE146: Motor PYF 2 BUSY

GFuE147: Motor PYF 3 BUSY

GFuE148: Motor PYF 4 BUSY

GFuE247: Turning device valve motor busy!

GFuE259: Busy Stitch Cam Motor Feed 1

GFuE271: Busy Stitch Cam Motor Feed 2

GFuE283: Busy Stitch Cam Motor Feed 3

GFuE295: Busy Stitch Cam Motor Feed 4

GFuE307: Busy Heel Return Stitch Cam Motor

GFuE319: Vertical pickup arm motor busy!

GFuE331: Angle pickup arm motor busy!

GFuE343: Turning device down motor busy!

GFuE355: Turning device up motor busy!

GFuE367: Pin feed motor busy!

GFuE379: linker motor busy!

GFuE391: Turning device incl. motor busy!

GFuE404: Motor pin holder unit rotation motor busy

GFuE428: External CT shutter valve motor busy!

This error happens when to a particular stepping motor comes a command of movement without the previous has been fully executed.
A typical example of this error is when in the Sock Program on 2 consecutive steps are programmed Commands for the same motor, and at the time of the second command the first is still in implementation (the motor is still in motion).
By cancelling the error the Sock Cycle can continue, but the sock produced probably will be defective.
This is because during the sock cycle were lost some “steps” motor (e.g. the second movement of the motor was not executed).
At the end of the sock, in the moment of control of the Zero motor position, the loss of “steps” determined by the “Motor busy...” error probably will determine the appearance of the “Lost steps...” (Impossible 0 approach) error.

When appears this error is therefore advised to reset the sock, or in any case with the sock cylcle reach the step zero (the sock is however defective).

- The solution is to correct the Sock Program, for example away more among them the 2 commands relating to the same stepping motor.

Other type of causes for this error are unlikely.
Hardware malfunctions of the components concerned these movements should determine also other problems with appearance of other errors or alarms.

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Reference

See the control procedure described about the error:
GFuE67

GFuE57: Reset impossible Sizing Motor

Input board for the sensor:	Pcb_3836 N° 1	
Nr. Led of zero sensor:	Pcb_3836 DS15	
Led status with motor in zero position	ON	

GFuE59: Set-over impossible sinker cap motors

Input board for the sensor:	Pcb_3836 N° 1	
Nr. Led of zero sensor:	Pcb_3836 DS06	
Led status with motor in zero position	ON	

GFuE61: Reset impossible Angular Motor

Input board for the sensor:	Pcb_3836 Nr. X	
Nr. Led of zero sensor:	Pcb_3836 DS__	
Led status with motor in zero position	ON	

The board number (N° X) and the Led number (DS__) depend on model and optionals with which is arranged the machine.
The configuration is always: [Mot.1 = Ds15] - [Mot.2 = Ds14] - [Mot.3 = Ds6] - [Mot.4 = Ds16].

GFuE260: Reset impossible Stitch Cam Motor Feed 1

Input board for the sensor:	Pcb_3836 Nr. X	
Nr. Led of zero sensor:	Pcb_3836 DS__	
Led status with motor in zero position	ON	

The board number (N° X) and the Led number (DS__) depend on model and optionals with which is arranged the machine.
The configuration is always: [Mot.1 = Ds15] - [Mot.2 = Ds14] - [Mot.3 = Ds6] - [Mot.4 = Ds16].

GFuE272: Reset impossible Stitch Cam Motor Feed 2

Input board for the sensor:	Pcb_3836 Nr. X	
Nr. Led of zero sensor:	Pcb_3836 DS__	
Led status with motor in zero position	ON	

The board number (N° X) and the Led number (DS__) depend on model and optionals with which is arranged the machine.
The configuration is always: [Mot.1 = Ds15] - [Mot.2 = Ds14] - [Mot.3 = Ds6] - [Mot.4 = Ds16].

GFuE284: Reset impossible Stitch Cam Motor Feed 3

Input board for the sensor:	Pcb_3836 Nr. X	
Nr. Led of zero sensor:	Pcb_3836 DS__	
Led status with motor in zero position	ON	

The board number (N° X) and the Led number (DS__) depend on model and optionals with which is arranged the machine.
The configuration is always: [Mot.1 = Ds15] - [Mot.2 = Ds14] - [Mot.3 = Ds6] - [Mot.4 = Ds16].

GFuE296: Reset impossible Stitch Cam Motor Feed 4

Input board for the sensor:	Pcb_3836 Nr. X	
Nr. Led of zero sensor:	Pcb_3836 DS__	
Led status with motor in zero position	ON	

The board number (N° X) and the Led number (DS__) depend on model and optionals with which is arranged the machine.
The configuration is always: [Mot.1 = Ds15] - [Mot.2 = Ds14] - [Mot.3 = Ds6] - [Mot.4 = Ds16].

GFuE327: Vertical arm resetting impossible

Input board for the sensor:	Pcb_3836 Nr. X	
Nr. Led of zero sensor:	Pcb_3836 DS__	
Led status with motor in zero position	ON	

The board number (N° X) and the Led number (DS__) depend on model and optionals with which is arranged the machine.
The configuration is always: [Mot.1 = Ds15] - [Mot.2 = Ds14] - [Mot.3 = Ds6] - [Mot.4 = Ds16].

GFuE339: Angle arm resetting impossible

Input board for the sensor:	Pcb_3836 Nr. X	
Nr. Led of zero sensor:	Pcb_3836 DS__	
Led status with motor in zero position	ON	

The board number (N° X) and the Led number (DS__) depend on model and optionals with which is arranged the machine.
The configuration is always: [Mot.1 = Ds15] - [Mot.2 = Ds14] - [Mot.3 = Ds6] - [Mot.4 = Ds16].

GFuE351: Turning dev. down resetting impossible

Input board for the sensor:	Pcb_3836 Nr. X	
Nr. Led of zero sensor:	Pcb_3836 DS__	
Led status with motor in zero position	ON	

The board number (N° X) and the Led number (DS__) depend on model and optionals with which is arranged the machine.
The configuration is always: [Mot.1 = Ds15] - [Mot.2 = Ds14] - [Mot.3 = Ds6] - [Mot.4 = Ds16].

GFuE363: Turning device up reset impossible

Input board for the sensor:	Pcb_3836 Nr. X	
Nr. Led of zero sensor:	Pcb_3836 DS__	
Led status with motor in zero position	ON	

The board number (N° X) and the Led number (DS__) depend on model and optionals with which is arranged the machine.
The configuration is always: [Mot.1 = Ds15] - [Mot.2 = Ds14] - [Mot.3 = Ds6] - [Mot.4 = Ds16].

GFuE375: Pin feed resetting impossible

Input board for the sensor:	Pcb_3836 Nr. X	
Nr. Led of zero sensor:	Pcb_3836 DS__	
Led status with motor in zero position	ON	

The board number (N° X) and the Led number (DS__) depend on model and optionals with which is arranged the machine.
The configuration is always: [Mot.1 = Ds15] - [Mot.2 = Ds14] - [Mot.3 = Ds6] - [Mot.4 = Ds16].

GFuE387: reset impossible linker motor

Input board for the sensor:	Pcb_3836 Nr. X	
Nr. Led of zero sensor:	Pcb_3836 DS__	
Led status with motor in zero position	ON	

The board number (N° X) and the Led number (DS__) depend on model and optionals with which is arranged the machine.
The configuration is always: [Mot.1 = Ds15] - [Mot.2 = Ds14] - [Mot.3 = Ds6] - [Mot.4 = Ds16].

GFuE399: Turn.dev. incl. resetting impossible

Input board for the sensor:	Pcb_3836 Nr. X	
Nr. Led of zero sensor:	Pcb_3836 DS__	
Led status with motor in zero position	ON	

The board number (N° X) and the Led number (DS__) depend on model and optionals with which is arranged the machine.
The configuration is always: [Mot.1 = Ds15] - [Mot.2 = Ds14] - [Mot.3 = Ds6] - [Mot.4 = Ds16].

GFuE412: Pin hold.rotation motor resetting impossible

Input board for the sensor:	Pcb_3836 Nr. X	
Nr. Led of zero sensor:	Pcb_3836 DS__	
Led status with motor in zero position	ON	

The board number (N° X) and the Led number (DS__) depend on model and optionals with which is arranged the machine.

The configuration is always: [Mot.1 = Ds15] - [Mot.2 = Ds14] - [Mot.3 = Ds6] - [Mot.4 = Ds16].

GFuE436: External CT shutter valve resetting impossible

Input board for the sensor:	Pcb_3836 Nr. X	
Nr. Led of zero sensor:	Pcb_3836 DS__	
Led status with motor in zero position	ON	

The board number (N° X) and the Led number (DS__) depend on model and optionals with which is arranged the machine.
The configuration is always: [Mot.1 = Ds15] - [Mot.2 = Ds14] - [Mot.3 = Ds6] - [Mot.4 = Ds16].

GFuE308: Reset impossible heel Return S.C. Motor

Input board for the sensor:	Pcb_3836 Nr. X	
Nr. Led of zero sensor:	Pcb_3836 DS__	
Led status with motor in zero position	ON	

The board number (N° X) and the Led number (DS__) depend on model and optionals with which is arranged the machine.
The configuration is always: [Mot.1 = Ds15] - [Mot.2 = Ds14] - [Mot.3 = Ds6] - [Mot.4 = Ds16].

This error appears if the software detects anomalies in the behaviour of stepping motors in 2 specific conditions, during the procedure of “Zeroing” and in phase of “Working enter”.
In these situations, after an appropriate zeroing command sent to the motor, is executed a control of the Zero motor position through the Zero sensor.
In practice the motors are “pushed” towards Zero until the reading of the sensor, then turn away a little, then perform a slow precision approach.
When the sensor is obscured or pressed the Zero condition is found, the motor is blocked and it is in the correct Zero position.
If the sensor initially was already in Reading (the motor at zero), during this phase before turn away of a specific number of “steps” and then it executes the precision approach.

The error appears in these conditions:
- The motor does not receive the command or the board not controls the motor.
  There is a time limit within which the command must be executed, if the status of the sensor does not change in the manner provided by the software, the command exits.
- With right command, the Zero sensor does not change the reading status in the manner provided by the software.
  For reasons linked to the sensor itself or to the mechanic component of the movement device.

Proceed as follows to solve the problem:
- Check the mechanical functionality of the components linked to the motor movement.
- Check the wiring that connect the sensor and the motor to the command board (in general the Pcb_3836 board).
- Check the proper functioning of the Zero sensor.
  Proceed to its adjustment and eventually replace it.
- Replace the stepping motor indicated in the message.
- Replace the CAN module (board Pcb_3836) associated with the motor indicated in the message.

Reference

See the control procedure described about the error:
GFuE67

GFuE67: Impossible approach to 0 sizing motor

Input board for the sensor:	Pcb_3836 N° 1	
Nr. Led of zero sensor:	Pcb_3836 DS15	
Led status with motor in zero position	ON	

GFuE69: Impossible approach to 0 sinker cap motors

Input board for the sensor:	Pcb_3836 N° 1	
Nr. Led of zero sensor:	Pcb_3836 DS06	
Led status with motor in zero position	ON	

GFuE71: Impossible approach to 0 sin.cap position

Input board for the sensor:	Pcb_3836 Nr. X	
Nr. Led of zero sensor:	Pcb_3836 DS__	
Led status with motor in zero position	ON	

The board number (N° X) and the Led number (DS__) depend on model and optionals with which is arranged the machine.
The configuration is always: [Mot.1 = Ds15] - [Mot.2 = Ds14] - [Mot.3 = Ds6] - [Mot.4 = Ds16].

GFuE261: Lost Steps Stitch Cam Motor Feed 1

Input board for the sensor:	Pcb_3836 Nr. X	
Nr. Led of zero sensor:	Pcb_3836 DS__	
Led status with motor in zero position	ON	

The board number (N° X) and the Led number (DS__) depend on model and optionals with which is arranged the machine.
The configuration is always: [Mot.1 = Ds15] - [Mot.2 = Ds14] - [Mot.3 = Ds6] - [Mot.4 = Ds16].

GFuE273: Lost Steps Stitch Cam Motor Feed 2

Input board for the sensor:	Pcb_3836 Nr. X	
Nr. Led of zero sensor:	Pcb_3836 DS__	
Led status with motor in zero position	ON	

The board number (N° X) and the Led number (DS__) depend on model and optionals with which is arranged the machine.
The configuration is always: [Mot.1 = Ds15] - [Mot.2 = Ds14] - [Mot.3 = Ds6] - [Mot.4 = Ds16].

GFuE285: Lost Steps Stitch Cam Motor Feed 3

Input board for the sensor:	Pcb_3836 Nr. X	
Nr. Led of zero sensor:	Pcb_3836 DS__	
Led status with motor in zero position	ON	

The board number (N° X) and the Led number (DS__) depend on model and optionals with which is arranged the machine.
The configuration is always: [Mot.1 = Ds15] - [Mot.2 = Ds14] - [Mot.3 = Ds6] - [Mot.4 = Ds16].

GFuE297: Lost Steps Stitch Cam Motor Feed 4

Input board for the sensor:	Pcb_3836 Nr. X	
Nr. Led of zero sensor:	Pcb_3836 DS__	
Led status with motor in zero position	ON	

The board number (N° X) and the Led number (DS__) depend on model and optionals with which is arranged the machine.
The configuration is always: [Mot.1 = Ds15] - [Mot.2 = Ds14] - [Mot.3 = Ds6] - [Mot.4 = Ds16].

GFuE320: Impossible approaching vert.arm to zero

Input board for the sensor:	Pcb_3836 Nr. X	
Nr. Led of zero sensor:	Pcb_3836 DS__	
Led status with motor in zero position	ON	

The board number (N° X) and the Led number (DS__) depend on model and optionals with which is arranged the machine.
The configuration is always: [Mot.1 = Ds15] - [Mot.2 = Ds14] - [Mot.3 = Ds6] - [Mot.4 = Ds16].

GFuE332: Angle arm approaching to zero impossible

Input board for the sensor:	Pcb_3836 Nr. X	
Nr. Led of zero sensor:	Pcb_3836 DS__	
Led status with motor in zero position	ON	

The board number (N° X) and the Led number (DS__) depend on model and optionals with which is arranged the machine.
The configuration is always: [Mot.1 = Ds15] - [Mot.2 = Ds14] - [Mot.3 = Ds6] - [Mot.4 = Ds16].

GFuE344: Turning dev. down approaching to zero impossible

Input board for the sensor:	Pcb_3836 Nr. X	
Nr. Led of zero sensor:	Pcb_3836 DS__	
Led status with motor in zero position	ON	

The board number (N° X) and the Led number (DS__) depend on model and optionals with which is arranged the machine.
The configuration is always: [Mot.1 = Ds15] - [Mot.2 = Ds14] - [Mot.3 = Ds6] - [Mot.4 = Ds16].

GFuE356: Turning device up approach to zero impossible

Input board for the sensor:	Pcb_3836 Nr. X	
Nr. Led of zero sensor:	Pcb_3836 DS__	
Led status with motor in zero position	ON	

The board number (N° X) and the Led number (DS__) depend on model and optionals with which is arranged the machine.
The configuration is always: [Mot.1 = Ds15] - [Mot.2 = Ds14] - [Mot.3 = Ds6] - [Mot.4 = Ds16].

GFuE368: Pin feed approach to zero impossible

Input board for the sensor:	Pcb_3836 Nr. X	
Nr. Led of zero sensor:	Pcb_3836 DS__	
Led status with motor in zero position	ON	

The board number (N° X) and the Led number (DS__) depend on model and optionals with which is arranged the machine.
The configuration is always: [Mot.1 = Ds15] - [Mot.2 = Ds14] - [Mot.3 = Ds6] - [Mot.4 = Ds16].

GFuE380: lost steps linker motor

Input board for the sensor:	Pcb_3836 Nr. X	
Nr. Led of zero sensor:	Pcb_3836 DS__	
Led status with motor in zero position	ON	

The board number (N° X) and the Led number (DS__) depend on model and optionals with which is arranged the machine.
The configuration is always: [Mot.1 = Ds15] - [Mot.2 = Ds14] - [Mot.3 = Ds6] - [Mot.4 = Ds16].

GFuE392: Turn.dev. incl. approach to zero impossible

Input board for the sensor:	Pcb_3836 Nr. X	
Nr. Led of zero sensor:	Pcb_3836 DS__	
Led status with motor in zero position	ON	

The board number (N° X) and the Led number (DS__) depend on model and optionals with which is arranged the machine.
The configuration is always: [Mot.1 = Ds15] - [Mot.2 = Ds14] - [Mot.3 = Ds6] - [Mot.4 = Ds16].

GFuE405: Pin hold.rot.mot. approach to zero impossible

Input board for the sensor:	Pcb_3836 Nr. X	
Nr. Led of zero sensor:	Pcb_3836 DS__	
Led status with motor in zero position	ON	

The board number (N° X) and the Led number (DS__) depend on model and optionals with which is arranged the machine.
The configuration is always: [Mot.1 = Ds15] - [Mot.2 = Ds14] - [Mot.3 = Ds6] - [Mot.4 = Ds16].

GFuE429: External CT shutter valve approach to zero impossible

Input board for the sensor:	Pcb_3836 Nr. X	
Nr. Led of zero sensor:	Pcb_3836 DS__	
Led status with motor in zero position	ON	

The board number (N° X) and the Led number (DS__) depend on model and optionals with which is arranged the machine.
The configuration is always: [Mot.1 = Ds15] - [Mot.2 = Ds14] - [Mot.3 = Ds6] - [Mot.4 = Ds16].

GFuE309: Lost Steps Heel Return Stitch Cam Motor

Input board for the sensor:	Pcb_3836 Nr. X	

Nr. Led of zero sensor:	Pcb_3836 DS__	
Led status with motor in zero position	ON	

The board number (N° X) and the Led number (DS__) depend on model and optionals with which is arranged the machine.
The configuration is always: [Mot.1 = Ds15] - [Mot.2 = Ds14] - [Mot.3 = Ds6] - [Mot.4 = Ds16].

During the normal Sock cycle, in the transition for the step zero, the Stich motor receive the Command to go to the share of Zero (rest).
This command is part of the normal programming for each Stich motor (GRAPHITRON).
This Zero position is the point of start of the motor at the begin of each Sock Cycle.
For this machines model the Zero condition corresponds to the programming of the share:
"0"
After this Zeroing command and before start a new Sock Cycle, the software will run a control on achieving this share of Zero.
The control follows a special procedure determined by particular procedure with which the motor reaches the share of zero.

1. When the motor receives the Command to go to zero, not all of the "steps" necessary are carried out consecutively; 10 "steps" are not executed.
2. At this point the software controls that the Zero motor sensor is not closed, since this would mean that the motor has reached the Zero position before it should have.

This can happen only if during the Sock Cycle, in the various movements, the motor has lost "steps" in a direction.
The direction in leaving from the Zero position.
In the first stage, the software checks that the Zero sensor is open at this point of the procedure.
Otherwise is displayed this error of:

"Impossible 0 approach"

If this first phase of the procedure is correct, so the Zero sensor is still open, the procedure continues.

1. The subsequently sequence of movement of the motor provides that "step by step" the motor run the last "10 steps" missing to reach the Zero position.
   In practice runs a precision approach.
2. At this point the software controls that the Zero motor sensor is not open, since this would mean that the motor has not reached the Zero position.

This can happen only if during the Sock Cycle, in the various movements, the motor has lost "steps" in a direction.
The direction in approaching to the Zero position.
In the second stage, the software checks that the Zero sensor is closed at this point of the procedure.
Otherwise is displayed this error of:

"Impossible 0 approach"

All of these operations are carried out before the arrival to step zero, n the steps following the one where is planned the share of zero (last share of the motor present in the Sock Cycle).
Between the step where is programmed the share Zero and the Step Zero must be provided a sufficient number of steps to enable the motor to run the entire Approaching/Zeroing procedure.
Otherwise is displayed another type of error: "Motor ... not at zero"
This error is a particular case of more general error of:

"Impossible 0 approach"

The most common causes that determine this problem are:

- Loss of "steps" due to mechanical factors (Obstructed movement).
- Loss of "steps" due to electrical factors (motor faulty or electrical control not coherent).
- Bad adjustment or malfunction of the sensor of Zero phase.

Depending on whether the error is present in the first phase (at -10 step from Zero), or in the second phase (at Zero), the assessments may be different.
This is because in the 2 cases the right status of the Zero sensor is one opposite to the other.

In general however perform some standard checks.

- Check if the Zero sensor is in the correct status for the point of the procedure in which the error appeared.
  In reference to this, check the status of the LED of zero on the Pcb_3836 board.
- Replace the CAN module (board Pcb_3836) associated with the motor indicated in the message.

With the mechanical position of the motor correct.

Check if the Zero sensor is in the correct status for the point of the procedure in which the error appeared.
In reference to this, check the status of the LED of zero on the Pcb_3836 board.

- Check the proper functioning of the Zero sensor.
  Proceed to its adjustment and eventually replace it.
- Check the wiring that connect the sensor and the motor to the command board (in general the Pcb_3836 board).
- Replace the CAN module (board Pcb_3836) associated with the motor indicated in the message.

With the mechanical position of the motor not correct.

The sensor therefore reads correctly a position that is wrong.

- Check if the motor movement has found mechanical obstacles or a very high resistance.
- Check the wiring that connect the sensor and the motor to the command board (in general the Pcb_3836 board).
- Replace the stepping motor indicated in the message.
- Replace the CAN module (board Pcb_3836) associated with the motor indicated in the message.

Notice

Attention

This type of error is recursive.
It is not cancel simply by pressing the key [F8].
The best solution is to run a Zeroing ([F0]) to arrive at the End of Sock.
The machine can then return to its normal operation.
A turn off and turn on of the machine keeps the machine in the same point (if available, starts the black-out procedure).
A hardware Reset brings the machine to End of Cycle, but could cause subsequent mechanical damage.
If the problem is not resolved it will recur in the same point of the subsequent sock.

Reference

See the control procedure described about the error:
REuE02

GFuE400: Turn.dev. incl. movement impossible

GFuE413: Pin hold.rotation motor movement impossible

GFuE416: Pin feed motor movement impossible

GFuE417: Sewing device motor movement impossible

Input board for the sensor:	Pcb_3836 Nr. X	
Nr. Led of zero sensor:	Pcb_3836 DS__	
Led status with motor in zero position	ON	

The board number (N° X) and the Led number (DS__) depend on model and optionals with which is arranged the machine.
The configuration is always: [Mot.1 = Ds15] - [Mot.2 = Ds14] - [Mot.3 = Ds6] - [Mot.4 = Ds16].

If the motor receives a command of displacement from the zero point, the software checks that after a set time the motor zero sensor has switched on or off.
Otherwise a message is displayed.

The error appears in these conditions:

- The motor does not receive the command or the board not controls the motor.
  There is a time limit within which the command must be executed, if the status of the sensor does not change in the manner provided by the software, the command exits.
- With right command, the Zero sensor does not change the reading status in the manner provided by the software.
  For reasons linked to the sensor itself or to the mechanic component of the movement device.

Proceed as follows to solve the problem:
- Check the mechanical functionality of the components linked to the motor movement.
- Check the wiring that connect the sensor and the motor to the command board (in general the Pcb_3836 board).
- Check the proper functioning of the Zero sensor.
  Proceed to its adjustment and eventually replace it.
- Replace the stepping motor indicated in the message.
- Replace the CAN module (board Pcb_3836) associated with the motor indicated in the message.

Reference

See the control procedure described about the error:
GFuE67

CAN messages: Management of the operation in FLASH

GFuE87: Checksum in update sizing motor

GFuE88: Checksum in update vacuum valve

GFuE89: Checksum in update sinker cap motors

GFuE90: Checksum in update elastic 1

GFuE91: Checksum in update sinker cap pos.

GFuE92: Checksum in update saw blade device

GFuE93: Checksum in update elastic 2

GFuE94: Checksum in update elastic feed 1

GFuE95: Checksum in update straighten welt

GFuE96: Checksum in update dial motor

GFuE165: Checksum in update motor PYF 1

GFuE166: Checksum in update motor PYF 2

GFuE167: Checksum in update motor PYF 3

GFuE168: Checksum in update motor PYF 4

GFuE250: Checksum in update turn.device valve

GFuE263: Checksum Stitch Cam Motor Feed 1

GFuE275: Checksum Stitch Cam Motor Feed 2

GFuE287: Checksum Stitch Cam Motor Feed 3

GFuE299: Checksum Stitch Cam Motor Feed 4

GFuE322: Vertical arm checksum being updated

GFuE334: Angle arm checksum being updated

GFuE346: Turning dev. down checksum being updated

GFuE358: Turning device up checksum being updated

GFuE370: Pin feed checksum being updated

GFuE382: checksum linker motor

GFuE394: Turn.dev. incl. checksum being updated

GFuE407: Pin hold.rot.mot. checksum being updated

GFuE431: External CT shutter valve checksum being updated

GFuE311: Checksum Heel Return Stitch Cam Motor

This error occurs during Updating of the CAN module associated with the motor indicated in the error.

- Repeat the Update operation, loading again the file “up” (software) in the FLASH memory and activate it.

If the problem persists:

- Replace the CAN module (board Pcb_3836) associated with the motor indicated in the message.

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

GFuE97: Length update page sizing motor

GFuE98: Length update page vacuum valve

GFuE99: Length update page sinker cap motors

GFuE100: Length update page elastic 1

GFuE101: Length update page sinker cap motor

GFuE102: Length update page saw blade device

GFuE103: Length update page elastic 2

GFuE104: Length update page elastic feed 1

GFuE105: Length update page straighten welt

GFuE106: Length update page dial motor

GFuE169: Length update page motor PYF 1

GFuE170: Length update page motor PYF 2

GFuE171: Length update page motor PYF 3

GFuE172: Length update page motor PYF 4

GFuE251: Page length in update turn.device valve

GFuE264: Leng.page Stitch Cam Motor Feed 1

GFuE276: Leng.page Stitch Cam Motor Feed 2

GFuE288: Leng.page Stitch Cam Motor Feed 3

GFuE300: Leng.page Stitch Cam Motor Feed 4

GFuE323: Vertical arm page length being updated

GFuE335: Angle arm page length being updated

GFuE347: Turning dev. down page length being updated

GFuE359: Turning device up page length being updated

GFuE371: Pin feed page length being updated

GFuE383: leng.page linker motor

GFuE395: Turn.dev. incl. page length being updated

GFuE408: Pin hold.rot.mot. page length being updated

GFuE432: External CT shutter valve page length being updated

GFuE312: Leng.page Heel Return Stitch Cam Motor

This error occurs during Updating of the CAN module associated with the motor indicated in the error.

- Repeat the Update operation, loading again the file “up” (software) in the FLASH memory and activate it.

If the problem persists:

- Replace the CAN module (board Pcb_3836) associated with the motor indicated in the message.

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

GFuE107: Writing FLASH update sizing motor

GFuE108: Writing FLASH update vacuum valve

GFuE109: Writing FLASH update sinker cap motors

GFuE110: Writing FLASH update elastic 1

GFuE111: Writing FLASH update sinker cap motor

GFuE112: Writing FLASH update saw blade device

GFuE113: Writing FLASH update elastic 2

GFuE114: Writing FLASH update elastic feed 1

GFuE115: Writing FLASH update straighten welt

GFuE116: Writing FLASH update dial motor

GFuE173: Writing FLASH update motor PYF 1

GFuE174: Writing FLASH update motor PYF 2

GFuE175: Writing FLASH update motor PYF 3

GFuE176: Writing FLASH update motor PYF 4

GFuE252: FLASH write in update turn.device valve

GFuE265: Flash Stitch Cam Motor Feed 1

GFuE277: Flash Stitch Cam Motor Feed 2

GFuE289: Flash Stitch Cam Motor Feed 3

GFuE301: Flash Stitch Cam Motor Feed 4

GFuE324: Vertical arm FLASH write being updated

GFuE336: Angle arm FLASH write being updated

GFuE348: Turning dev. down FLASH write being updated

GFuE360: Turning device up FLASH write being updated

GFuE372: Pin feed FLASH write being updated

GFuE384: flash linker motor

GFuE396: Turn.dev. incl. FLASH write being updated

GFuE409: Pin hold.rot.mot. FLASH write being updated

GFuE433: External CT shutter valve FLASH write being updated

GFuE313: Flash Heel Return Stitch Cam Motor

This error occurs during Updating of the CAN module associated with the motor indicated in the error.

- Repeat the Update operation, loading again the file “up” (software) in the FLASH memory and activate it.

If the problem persists:

- Replace the CAN module (board Pcb_3836) associated with the motor indicated in the message.

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

GFuE117: Number page in updating sizing motor

GFuE118: Number page in updating vacuum valve

GFuE119: Number page in updating sinker cap motors

GFuE120: Number page in updating elastic 1

GFuE121: Number page in updating sinker cap pos.

GFuE122: Number page in updating saw blade device

GFuE123: Number page in updating elastic 2

GFuE124: Number page in updating elastic feed 1

GFuE125: Number page in updating straighten welt

GFuE126: Number page in updating dial motor

GFuE177: Number page in updating motor PYF 1

GFuE178: Number page in updating motor PYF 2

GFuE179: Number page in updating motor PYF 3

GFuE180: Number page in updating motor PYF 4

GFuE253: Page number in update turn.device valve

GFuE266: Number page Stitch Cam Motor Feed 1

GFuE278: Number page Stitch Cam Motor Feed 2

GFuE290: Number page Stitch Cam Motor Feed 3

GFuE302: Number page Stitch Cam Motor Feed 4

GFuE325: Vertical arm page number being updated

GFuE337: Angle arm page number being updated

GFuE349: Turning dev. down page number being updated

GFuE361: Turning device up page number being updated

GFuE373: Pin feed page number being updated

GFuE385: num.page linker motor

GFuE397: Turn.dev. incl. page number being updated

GFuE410: Pin hold.rot.mot. page number being updated

GFuE434: External CT shutter valve page number being updated

GFuE314: Number page Heel Return Stitch Cam Motor

This error occurs during Updating of the CAN module associated with the motor indicated in the error.

- Repeat the Update operation, loading again the file “up” (software) in the FLASH memory and activate it.

If the problem persists:

- Replace the CAN module (board Pcb_3836) associated with the motor indicated in the message.

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

CAN messages: Hardware faulty

GFuE127: Tension low feeding sizing motor

GFuE128: Tension low feeding vacuum valve

GFuE129: Tension low feeding sinker cap motors

GFuE130: Tension low feeding elastic 1

GFuE131: Tension low feeding sinker cap pos.

GFuE132: Tension low feeding saw blade device

GFuE133: Tension low feeding elastic 2

GFuE134: Tension low feeding elastic feed 1

GFuE135: Tension low feeding straighten welt

GFuE136: Tension low feeding dial motor

GFuE181: Tension low feeding motor PYF 1

GFuE182: Tension low feeding motor PYF 2

GFuE183: Tension low feeding motor PYF 3

GFuE184: Tension low feeding motor PYF 4

GFuE254: Supply voltage low turn.device valve

GFuE267: Tension Stitch Cam Motor Feed 1

GFuE279: Tension Stitch Cam Motor Feed 2

GFuE291: Tension Stitch Cam Motor Feed 3

GFuE303: Tension Stitch Cam Motor Feed 4

GFuE326: Vertical arm power supply too low

GFuE338: Angle arm power supply too low

GFuE350: Turning dev. down power supply too low

GFuE362: Turning device up power supply too low

GFuE374: Pin feed power supply too low

GFuE386: tension linker motor

GFuE398: Turn.dev. incl. supply voltage too low

GFuE411: Pin hold.rot.mot. Power supply too low

GFuE435: External CT shutter valve power supply too low

GFuE315: Tension Heel Return Stitch Cam Motor

This message indicates that the CAN module associated with the motor is powered at a lower voltage than allowed.
The software recognizes through the Hardware of the module that this value is not within the margins established.
Then is displayed a specific alarm.
Proceed as follows to solve the problem:

- Check the power supply (voltage) of the CAN board (for example a Pcb_3836 relative the motor indicated in the message.
- Replace the CAN module (board Pcb_3836) associated with the motor indicated in the message.
- A problem in the software writing, an hardware problem on the CAN boards, a disorder on the CAN transmission:
  All these conditions may cause CAN Errors/Alarms not related to the real failure, but General of the CAN system.

Therefore in general, for all the CAN Errors/Alarms, after having evaluated the specific problem indicated by error, also to assess as a possible cause a general problem of the CAN system (software and hardware).

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

CAN messages on PYF end of yarn bobbin

GFuE185: Bobbin End motor PYF 1

GFuE186: Bobbin End motor PYF 2

GFuE187: Bobbin End motor PYF 3

GFuE188: Bobbin End motor PYF 4

This error is relative the Normal PYF or PYF-2000 device indicated in the message.
Each PYF device is prepared with a mechanism to control the quantity of yarn available on the same device (contact of error).
The user adjusts the device to control so that the contact is close when the yarn remaining above the device descends below a certain level.
The cable for the motor command (from the command board to the PYF device) includes a wire used for the return of this “End of Bobbin” contact.
The correct condition (stop not active) is:
”contact open”
The command board is:
Pcb_3836 board for Normal PYF.
Pcb_3862 board for PYF 2000.

In case of error first check if has been intervened the control device (real error).
- Solve the real problem that has caused the error.

If the control device has not intervened, check the regulation and setting and then proceed as follows.
To facilitate the failure search, disconnect the control wire from the device.
If the error is cancelled by pressing the [F8] key the device is defective.
- *Then proceed to the repair or replacement of the device.*

If the error remains.
- *Check that the wire in its path between the device and the inputs board is not to ground.*
  In the case, operate the repair or replacement of the wire.
- *Replace the Input board of the signal control.*
  In this case replace the board Pcb_3836 (PYF normal) or Pcb_3862 (PYF 2000).

Notice

Note

If the wire that connects the inputs board to the control device was rough or however interrupted, the error would never appear, then the machine would work without this control.

CAN messages on the ECODD Drive motor board

GFuE189: ECODD: Generic

This error indicates that the software has been a problem on the CAN logic, but failed to define the type of problem.
In this case, the software has however established that the problem is on the management of the ECODD15 Motor Drive board in CAN.
This problem is probably due to a software failure, and it is supposed it will never be displayed to the user.

- A problem in the software writing, an hardware problem on the CAN boards, a disorder on the CAN transmission:
  All these conditions may cause CAN Errors/Alarms not related to the real failure, but General of the CAN system.

Therefore in general, for all the CAN Errors/Alarms, after having evaluated the specific problem indicated by error, also to assess as a possible cause a general problem of the CAN system (software and hardware).

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

GFuE190: ECODD: 310 Volt KO

This message indicates that the Motor drive board has detected an error probably due to the power supply too low.

Check the presence of the tension 220 Vac entering the ECODD Motor Drive board.

If the voltage is incorrect:

- Re-establish the correct power supply in input (220 Vac).

If the voltage is correct:

- Replace the Motor Drive board.

GFuE191: ECODD: Motor thermal relay

This message indicates that the Motor Drive board has detected an error by the Thermal relay of the motor (motor too hot).
A motor too hot is a symptom of an excessive friction or abnormal operation.

- Check that there are no mechanical factors (frictions, assembling defective, mechanical damages) that cause an excessive effort and therefore a high power absorption by the motor.

Only after excluding any mechanical problems proceed to the search for other causes.

Proceed as follows to solve the problem:

- Check the wiring between the Pcb_2008 board and the Motor Drive board.
- Check the wiring between the Motor Resolver and the Motor Drive board.
- Replace the Motor Drive board.
- Replace the motor.

GFuE192: ECODD: Dissipator thermal relay

This message indicates that the Motor Drive board has detected an error due to the Dissipator thermal relay place on the board.
A Motor Drive board that dispels energy over the limit is a symptom of an excessive friction or abnormal operation.

- Check that there are no mechanical factors (frictions, assembling defective, mechanical damages) that cause an excessive effort and therefore a high power absorption by the motor.

Only after excluding any mechanical problems proceed to the search for other causes.

Proceed as follows to solve the problem:

- Check the wiring between the Pcb_2008 board and the Motor Drive board.
- Check the wiring between the Motor Resolver and the Motor Drive board.
- Replace the Motor Drive board.

- Replace the motor.

GFuE193: ECODD: Motor energy I2T

This message indicates that the Motor Drive board has detected an error due to the intervention of the protection of maximum current.
A Motor Drive board that provides the motor current beyond the limit is a symptom of an excessive friction or abnormal operation.

- Check that there are no mechanical factors (frictions, assembling defective, mechanical damages) that cause an excessive effort and therefore a high power absorption by the motor.

Only after excluding any mechanical problems proceed to the search for other causes.

Proceed as follows to solve the problem:

- Check the wiring between the Pcb_2008 board and the Motor Drive board.
- Check the wiring between the Motor Resolver and the Motor Drive board.
- Replace the Motor Drive board.
- Replace the motor.

GFuE194: ECODD: TX CAN

This message warns the user that there is transmission error on the CAN line between board Pcb_2008 and the Motor Drive board.
The problem may be caused by a transmission defect, and then by a malfunction of hardware concerned.
Proceed as follows to solve the problem:

- Check the wiring between the Pcb_2008 board and the Motor Drive board.
- Replace the Motor Drive board.
- Replace the board Pcb_2008.

Also assess the frequency of occurrence of the error and if it determines malfunctions of the concerned motor or of other CAN devices.

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

GFuE195: ECODD: RX CAN

This message warns the user that there is transmission error on the CAN line between board Pcb_2008 and the Motor Drive board.
The problem may be caused by a transmission defect, and then by a malfunction of hardware concerned.
Proceed as follows to solve the problem:

- Check the wiring between the Pcb_2008 board and the Motor Drive board.
- Replace the Motor Drive board.
- Replace the board Pcb_2008.

Also assess the frequency of occurrence of the error and if it determines malfunctions of the concerned motor or of other CAN devices.

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

GFuE196: ECODD: Commands overlap

This message informs the user that was detected an error due to the slowdown in software management internal the Motor Drive board.
This alarm appears when the software in the time given is not able to carry out all the operations expected by the software.

This problem is probably due to a software failure, and it is supposed it will never be displayed to the user.
However, can exist situations or hardware broken that could cause the appearance of this error.

Proceed as follows to solve the problem:
- Perform an software Update of the Motor Drive board.
- Replace the Motor Drive board.

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

GFuE197: ECODD: FLASH write

This error occurs during Updating of the Motor Drive board.
- Repeat the Update operation, loading again the file “up” (software) in the FLASH memory and activate it.

If the problem persists:
- Replace the Motor Drive board.

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

GFuE198: ECODD: Set of parameters

This message informs the user that whne the machine is turned on is detected a coherence error in the parameters sent by the machine (Pcb_2007 to the Motor Drive board.
This coherence control is the first evaluation, check that the parameters sent are not clearly erroneous.
This problem is probably due to a software failure, and it is supposed it will never be displayed to the user.
However, can exist situations or hardware broken that could cause the appearance of this error.

Proceed as follows to solve the problem:
- Check the coherence of the machine software version.
  Perform a software update.
- Perform an software Update of the Motor Drive board.
- Replace the Motor Drive board.

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

GFuE199: ECODD: Parameters RDC

This message informs the user that whne the machine is turned on is detected a coherence error in the parameters sent by the machine (Pcb_2007 to the Motor Drive board.
This coherence control is the first evaluation, check that the parameters sent are not clearly erroneous.
This problem is probably due to a software failure, and it is supposed it will never be displayed to the user.
However, can exist situations or hardware broken that could cause the appearance of this error.

Proceed as follows to solve the problem:
- Check the coherence of the machine software version.
  Perform a software update.
- Perform an software Update of the Motor Drive board.
- Replace the Motor Drive board.

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

GFuE200: ECODD: WATCH DOG Actuation

This message informs the user that has been detected an error on the communication with the board Pcb_2008 that generate a general malfunction of the Motor Drive board.
The appearance of this error presupposes that subsequently the communication on the CAN line be restored and has allowed the sending of this message.
Normally in the event of this type of malfunctions this message is overwritten by other error or alarm messages more specific and priority.

Proceed as follows to solve the problem:
- Check the wiring between the Pcb_2008 board and the Motor Drive board.
- Replace the Motor Drive board.
- Replace the board Pcb_2008.

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

GFuE201: ECODD: Actuation not configured

This message informs the user that has been detected an error because the Motor Drive board has received an enabling command without which the board had been previously configured.
In practice does not have been sent to the Motor Drive board the operating parameters, which should happen when the machine is turned on.
This problem is probably due to a software failure, and it is supposed it will never be displayed to the user.
However, can exist situations or hardware broken that could cause the appearance of this error.

Proceed as follows to solve the problem:
- Check the coherence of the machine software version.
  Perform a software update.
- Perform an software Update of the Motor Drive board.
- Replace the Motor Drive board.

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

GFuE202: ECODD: OFFSET execution reference

This message informs the user that has been detected an error in the OFFSET procedure that happens on the Motor Drive board when the machine is turned on.
This problem is probably due to a software failure, and it is supposed it will never be displayed to the user.
However, can exist situations or hardware broken that could cause the appearance of this error.

Proceed as follows to solve the problem:
- Check the coherence of the machine software version.
  Perform a software update.
- Perform an software Update of the Motor Drive board.
- Replace the Motor Drive board.

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

CAN messages on the YOYO device

GFuE218: Generic CAN YOYO

This error indicates that the software has been a problem on the CAN logic, but failed to define the type of problem.
In particular, the problem is detected on the CAN line related to the YOYO motors.
This problem is probably due to a software failure, and it is supposed it will never be displayed to the user.

- A problem in the software writing, an hardware problem on the CAN boards, a disorder on the CAN transmission:
  All these conditions may cause CAN Errors/Alarms not related to the real failure, but General of the CAN system.

Therefore in general, for all the CAN Errors/Alarms, after having evaluated the specific problem indicated by error, also to assess as a possible cause a general problem of the CAN system (software and hardware).

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

GFuE219: YOYO Not numerated

Each stepping motor enabled by software or Setup must be associated with a CAN module (CAN board for the motors control).
In practice, for each enabled motor, its identification number must be associated with a CAN module.
If this not happens, when turn on the machine the software displays an alarm of: “Motor not numbered (associated)”, generic of the “Tasks” to which belongs the motor not associated.
This message refers to the YOYO motors connected to the CAN module.
Each YOYO motor is composed by the motor itself and by the CAN module for the command.
Each motor (to be Associated) corresponds to a CAN module which also corresponds to a single CAN board (to be Numbered).
For which the Numbering procedure automatically also executes the Association.

- The solution is access to the CAN YOYO Setup and proceed to the Numbering of the motors.

This error is generated when, during YOYO Numbering, an identification number for a motor not enabled in Setup is used by mistake.
For example, in the Setup are enabled the motors 1, 2, 3, 4; in the numbering is wrongly written 1, 2, 3, 5, where “5” is a number different from those expected.
The software in this case, for priorities, displays this generic message relative the wrong identification number, rather than the specific message of the motor that was not numbered.

Reference

All information relating to the CAN management procedures, (Association, Numbering, etc.) are available in:
GUIDE OF USER INTERFACE

1. Setup YOYO in CAN
2. YOYO motors numbering

GFuE220: Transmission YOYO “x”

This message warns the user that there is transmission error on the CAN line between board Pcb_2008 and the CAN module associated with the motor indicated in the error.
The problem may be caused by a transmission defect, and then by a malfunction of hardware concerned.

Proceed as follows to solve the problem:
- Check the wiring that connect the Pcb_2008 board to the CAN module (YOYO motor indicated in the message).
- Replace the CAN module (YOYO motor indicated in the message).
- Replace the board Pcb_2008.

Also assess the frequency of occurrence of the error and if it determines malfunctions of the concerned motor or of other CAN devices.

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

GFuE221: Reception YOYO "x"

This message warns the user that there is transmission error on the CAN line between board Pcb_2008 and the CAN module associated with the motor indicated in the error.
The problem may be caused by a transmission defect, and then by a malfunction of hardware concerned.

Proceed as follows to solve the problem:
- Check the wiring that connect the Pcb_2008 board to the CAN module (YOYO motor indicated in the message).
- Replace the CAN module (YOYO motor indicated in the message).
- Replace the board Pcb_2008.

Also assess the frequency of occurrence of the error and if it determines malfunctions of the concerned motor or of other CAN devices.

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

GFuE222: Broken Yarn YOYO "x"

This message informs the user that the "Loading Cell" finds no yarn.
In practice the yarn relative the YOYO motor indicated in the message is broken.
- Restore the correct transition of the yarn and eliminate the error.

Notice

Note

This "Yarn broken" control may be disabled through the GRAPHITRON programming.
This control is disabled in the cases are present other devices for the control of the yarn rupture.
If the control is enabled, aboard the machine is possible to disable for a certain number of socks the control management.
Completed the number of socks set, automatically the control will be rehabilitated.
This exclusion function is useful to the user, in the case of tests or sock adjustment.

Reference

All information relating to the CAN management procedures, (Association, Numbering, etc.) are available in:
GUIDE OF USER INTERFACE
1. Disable error broken yarn

GFuE224: Sensor of Hall YOYO "x"

This message informs the user that at least a "Hall sensor" of the YOYO motor indicated in the error is defective.

The control of the YOYO motor use the “Hall sensors” present to its inside as feedback.
The “Hall sensors” must be between their synchronized.
If the YOYO software notes an erroneous synchronization of the sensors signals is displayed this message.
The problem is therefore internal to the YOYO motor.

- Replace the CAN module (YOYO motor indicated in the message).

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

GFuE228: Overrun YOYO “x”

This message warns the user that there is transmission error on the CAN line between board Pcb_2008 and the CAN module associated with the motor indicated in the error.
The transmission line concerned the module indicated in the error is congested.
The problem may be caused by a transmission defect, and then by a malfunction of hardware concerned.

Proceed as follows to solve the problem:

- Check the wiring that connect the Pcb_2008 board to the CAN module (YOYO motor indicated in the message).
- Replace the CAN module (YOYO motor indicated in the message).
- Replace the board Pcb_2008.

Also assess the frequency of occurrence of the error and if it determines malfunctions of the concerned motor or of other CAN devices.

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

GFuE229: Checksum YOYO “x”

This error occurs during Updating of the CAN module associated with the motor indicated in the error.

- Repeat the Update operation, loading again the file “up” (software) in the FLASH memory and activate it.

If the problem persists:

- Replace the CAN module (YOYO motor indicated in the message).

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

GFuE230: Length page YOYO “x”

This error occurs during Updating of the CAN module associated with the motor indicated in the error.

- Repeat the Update operation, loading again the file “up” (software) in the FLASH memory and activate it.

If the problem persists:

- Replace the CAN module (YOYO motor indicated in the message).

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

GFuE231: Writing on FLASH YOYO “x”

This error occurs during Updating of the CAN module associated with the motor indicated in the error.

- Repeat the Update operation, loading again the file “up” (software) in the FLASH memory and activate it.

If the problem persists:

- Replace the CAN module (YOYO motor indicated in the message).

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

GFuE232: Page number YOYO “x”

This error occurs during Updating of the CAN module associated with the motor indicated in the error.

- Repeat the Update operation, loading again the file “up” (software) in the FLASH memory and activate it.

If the problem persists:

- Replace the CAN module (YOYO motor indicated in the message).

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

MAIN

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Ma1: Setup data lost. Run SETUP
MAuE01: Too much time in state of WAIT
MAuE02: Machine stopped for F1
Ma4: Encoder not connected
Ma5: Timer in overflow
MAuE03: Valid 0: FN+A] 0 on Sk2007 FN+Z] 0 on ECODD
MAuE04: The valid zero is into ECODD, FN+Z to accept it
MAuE05: The valid zero is into SETUP, FN+A to accept it
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Messages on various Management and Operations

Ma1: Setup data lost. Run SETUP

This message appears when turned on the machine, in case the Setup data contained in the FLASH memory of the Pcb_2007 board are not considered valid by the software.
This happens when the Pcb_2007 board is new, when the data are being erased by the appropriate Reset, and in any case they are not estimated valid by the software.
When the machine is turned on the user is warned through this error that the Setup is not valid.
The error is erasable with the [F8] key, this allows the user to access the functionality to execute a valid Setup, essential for the machine operation.
Without valid setup the machine cannot work properly, the data in the DEFAULT setup (eprom custom), must always be corrections due to differences between the machines, and due to the optionals devices mounted.

Reference

Furthers informations are available in :
GUIDE OF USER INTERFACE
1. Machine Setup

MAuE01: Too much time in state of WAIT

This error informs the user that in the passage for the step zero of the Sock Cycle, after having intervened the “wait status” (pending) for the execution of an operation required by the user or by automatic procedures of control, this “wait” status was not disabled after the operation.
These operations, for example, are a Size modify made in the previous cycle by the user, or automatically by the Sock lenght control.
The machine stays therefore at the End of Cycle, in rotation, without counting degrees active.
After a few seconds intervenes this error, the user is so warned of the problem.
This error avoids that the machine stays indefinitely in rotation at the step zero without the user is warned.
The solution is simply “turn off the machine”, there are no problems because the machine is positioned at the step zero; when the machine is turned on, it can run again without problems.
In case the [F8] key is pressed (error cancelled) and starts again the machine, after a few seconds the machine will stop again with this error, and this until the machine will be turned off.

Notice

Attention

This error is a symptom of another problem, in normal conditions should not appear.
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

MAuE02: Machine stopped for F1

Outside the step Zero, if is activated the [F1] key to block the step chain progress is also active a control for the correct use of this key.

After a certain period of time (about 30 seconds) with machine in motion and key acive, the machine stops with this error.
This message informs the user that the machine, outside the step Zero, is running with the [F1] key active.
This is considered an anomalous functioning, and therefore the machine has been stop.
If the error is erased and the machine is put in motion without deactivate the [F1] key, after the same time it will stop again.
The activation of the [F1] key outside the step Zero logically, is used only for maintenance or tests.

Messages on the management of the Encoder counting

Ma4: Encoder not connected

This error appears when the machine counting is not synchronized, i.e. not yet been received a signal of valid Zero that allows the start of the counting.
This error appears when, with machine synchronized (the machine has already reached the first zero to start the counting), the impulse of the Encoder (Resolver) just arrived is equal to the previous one.
Practically it checks that, with machine in rotation, 2 impulses of counting subsequent between them are not equal.
This could be a symptom of Encoder (Resolver) not connected, check the wiring between the Resolver and the Motor Drive board, between the Motor Drive board and the Pcb_2008 board.
The devices concerned to the problem are:

- The Resolver
- The motor.
- The Motor Drive board.
- The board Pcb_2008.

Notice

Attention

Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Ma5: Timer in overflow

A problem of this type is due to delays in the operation time of the software.
It should not appear to the user as the problem may be only software or hardware of the Pcb_2007 board.

Notice

Attention

Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Messages on Zero cylinder management

MAuE03: Valid 0: FN+A] 0 on Sk2007 FN+Z] 0 on ECODD

This error appears on many occasions and warns the user that is useful to check the position of the mechanical Zero before the start of the Sock Cycle.
However we must distinguish 2 different situations due to the machine arrangement.

A. Machine equipped with the “Motor drive control” board of the type RUNNER
B. Machine equipped with the “Motor drive control” board of the type ECODD15

Machine equipped with the “Motor drive control” board of the type RUNNER

With this preparation this error can never appear.
In these conditions the mechanical Zero is executed and stored directly on the RUNNER Motor Drive board, no data is present on the Pcb_2007 board.

Motor Drive board type RUNNER: Mechanical Zero management

This Mechanical Zero is a configuration contained into the Motor Drive itself, in case of its replacement or inversion with other machine the user should run a new acquisition of this Zero.

Machine equipped with the “Motor drive control” board of the type ECODD15

In the second case is succeeded a completely new management.
This ECODD Motor Drive board is connected through a CAN protocol to the Pcb_2008 board.
All of the operating parameters of the Motor Drive board are contained in the software of personalization of the machine (“eprom custom”).
When the machine is turned on they are being sent to the ECODD Motor Drive board, which will be adapted to the machine model.
The machine (software) recognised in automatic the type of Motor Drive board that is mounted.
If is present and active on the CAN line, assumes that the machine is equipped with the Motor Drive board of type ECODD and performs accordingly.
The operation data will be sent to the Motor Drive board, also will use a “set” of “Heel parameters” specific for this type of Motor Drive board.
Otherwise it is ready for operation with a Motor Drive board of type RUNNER.

In case of ECODD Motor Drive board, the “Mechanical Zero”, besides that be stored in the FLASH memory of the Pcb_2007 board (machine Setup), is also stored in the FLASH memory of the Motor Drive board.
In this way the same data (“Mechanical Zero”) is stored in 2 places physical different, on the Pcb_2007 board and on ECODD Motor Drive board.
This dual system of storage of the “Mechanical Zero” allows the software to run to each turning on the machine a check of coherence of the 2 data.
This fact was not possible with the previous RUNNER Motor Drive board, as there was no CAN link between it and the logic board of the machine.

In conclusion, this error appears to the user when the “Mechanical Zero” content in the machine Setup (board Pcb_2007) is different from that in the ECODD Motor Drive board.
Therefore in case of replacement of one of the 2 boards containing the “Mechanical Zero” (board Pcb_2007 and ECODD Motor Drive board) is possible always recover this data; obviously these cards should not be replaced at the same time.

The user at this point will have3 possibilities.

1. First possibility
   Acquire and regarded as valid the “Mechanical Zero” present in the Pcb_2007 board.
   Therefore press the [FN] + [A] keys.
   The “Mechanical Zero” will be automatically copied even in the Motor Drive board and will be used in the machine functioning.
   Of course, for a correct choice the user must have assessed that previously had been replaced the Motor Drive board and therefore that the valid Zero of the machine is the one available on the Pcb_2007 board.
2. Second possibility
   Acquire and regarded as valid the “Mechanical Zero” present in the Motor Drive board.
   Therefore press the [FN] + [Z] keys.
   The “Mechanical Zero” will be automatically copied even in the Pcb_2007 board and will be used in the machine functioning.
   Of course, for a correct choice the user must have assessed that previously had been replaced the Pcb_2007 board and therefore that the valid Zero of the machine is the one available on the ECODD Motor Drive board.
3. Third possibility
   The user has not certainty about the valid Zero, and therefore to prevent risks decides to carry out a new Zero acquisition, so will enter in the Setup and will perform the procedure.
   In order to proceed the user must: put the key in “Programming” position, cancel the error with [F8], enter the Setup, activate the procedure and acquire the Zero.

The machine software, in 2 particular situations, address the user to the conduct which it considers the most likely.
In these cases, however not appears this error, but instead an error appear where are clearly indicated the keys to press, already assuming the valid Zero.

1. First particular situation
   ”Zero” will thus be entered in the memory location associated with “Mechanical zero” of the machine Setup (board Pcb_2007).
   This may be, for example after a software update of the machine, or in the case of Setup Reset or replacement of the Pcb_2007 board with a new one.
   In this case, if there is a valid Zero in the ECODD Motor Drive board, an error message will advise the user to press the [FN] + [Z] keys to copy this value also in the machine Setup (Pcb_2007 board), and therefore consider it valid and acquired.
2. Second particular situation
   ”Zero” will thus be entered in the memory location associated with “Mechanical zero” of the Drive motor board ECODD.
   This may be, for example when the Motor Drive board is new, or after a software update of the Motor Drive board itself.
   In this case, if there is a valid Zero in the machine Setup (Pcb_2007 board), an error message will advise the user to press the [FN] + [A] keys to copy this value also in the ECODD Motor Drive board, and therefore consider it valid and acquired.

Advice for the user.

In all these situations in which is acquired a Mechanical Zero (particularly when was confirmed a Zero with [FN] + [A] or [FN] + [Z]) is recommended that the user checks that if the acquired Zero corresponds to the Mechanical Zero.
Therefore with [F1] (stop chain) active and machine at the step Zero, to start the machine and ensure that the Zero degree on the machine Display corresponds with the actual Zero actual of the cylinder.
This actual Mechanical Zero depends by the various machine models (first long-butt needle or first short-butt needle), but generally the marked canal (with the electric pen) of the cylinder must be in correspondence to a fixed point of the cylinder support (hole of Zero, stitch cam, etc.).

Notice

Note

In the case of ECODD Motor Drive board the functioning data specific for the macchine model are present in the machine software (eprom custom).
When the machine is turned on they are being sent to the ECODD Motor Drive board, which will be adapted to the machine model.
The ECODD Motor Drive Boards are therefore equal for all the models of Lonati machine.
In addition to these operation data used directly by Motor Drive board there are also the “Heel parameters” used by the machine software.
Between the 2 types of Motor Drive board, RUNNER and ECODD, these parameters are different.
These 2 “Set” of parameters are both available in the machine software, which recognizes the type of Motor Drive board mounted and automatically use the correct “Set”.

Reference

For information on the “Mechanical zero acquisition” procedure see the section :
Procedure of “Mechanical zero acquisition” for:
Machines GOAL / PANTYHOSE

Furthers informations are available in :
GUIDE OF USER INTERFACE
1. Motor setup

MAuE04: The valid zero is into ECODD, FN+Z to accept it

This error is relative a specific situation of the more general error of: “Mechanical Zero not coherent”.
It appears when the software has found this particular condition.
”Zero” will thus be entered in the memory location associated with “Mechanical zero” of the machine Setup (board Pcb_2007).
This may be, for example after a software update of the machine, or in the case of Setup Reset or replacement of the Pcb_2007 board with a new one.

In this case, if there is a valid Zero in the ECODD Motor Drive board, an error message will advise the user to press the [FN] + [Z] keys to copy this value also in the machine Setup (Pcb_2007 board), and therefore consider it valid and acquired.
The error message is precisely this just described.

Example

Lets suppose that was executed a Reset of the machine Setup, for which it is no longer valid.

- ”Zero” will thus be entered in the memory location associated with “Mechanical zero”.
- The next turning on the machine an error shall advise the user that the Setup is not valid.
- After the setting of all the other Setup data and after their saving, when is turned on the machine, placing it in working status, will appear this error.
- At this point press [FN] + [Z], the “Mechanical Zero” data avilable on the ECODD Motor Drive board will be copied in the Pcb_2007 board, becoming an integral part of the machine Setup.

In this way was avoided to run a new procedure for the “Mechanical Zero” acquisition.

Reference

For further information, please refer to the description detailing the error:
MAuE03

For information on the “Mechanical zero acquisition” procedure see the section :
Procedure of “Mechanical zero acquisition” for:
Machines GOAL / PANTYHOSE

Furthers informations are available in :
GUIDE OF USER INTERFACE
1. Motor setup

MAuE05: The valid zero is into SETUP, FN+A to accept it

This error is relative a specific situation of the more general error of: “Mechanical Zero not coherent”.
It appears when the software has found this particular condition.
”Zero” will thus be entered in the memory location associated with “Mechanical zero” of the Drive motor board ECODD.
This may be, for example when the Motor Drive board is new, or after a software update of the Motor Drive board itself.
In this case, if there is a valid Zero in the machine Setup (Pcb_2007 board), an error message will advise the user to press the [FN] + [A] keys to copy this value also in the ECODD Motor Drive board, and therefore consider it valid and acquired.
The error message is precisely this just described.

Example

Lets suppose that was executed a software update of the ECODD Motor Drive board, for which the Zero previously in it has been lost.

- ”Zero” will thus be entered in the memory location associated with “Mechanical zero”.
- The next turning on the machine an error shall advise the user that the Setup is not valid.
- At this point press [FN] + [A], the “Mechanical Zero” data avilable in the machine Setup (Pcb_2007 board) will be copied in the ECODD Motor Drive board, the 2 data will be so equal, and therefore be valid.

In this way was avoided to run a new procedure for the “Mechanical Zero” acquisition.

Reference

For further information, please refer to the description detailing the error:
MAuE03

For information on the “Mechanical zero acquisition” procedure see the section :
Procedure of “Mechanical zero acquisition” for:
Machines GOAL / PANTYHOSE

Furthers informations are available in :
GUIDE OF USER INTERFACE
1. Motor setup

MOTO

Mo1: Obstructed motion

Messages on Hw/Sw faulty

Mo1: Obstructed motion

This error informs the user something has obstructed the machine motion.
In particular the speed reference has been for more than 20 Ms at the maximum speed (+/-10 Vdc) without the machine has moved (the software has not seen the correct signals from the Resolver motor).
Generally the problem is due to the fact that the Cylinder movement found a resistance to prevent the rotation (friction very strong), and in particular this happens in departures when the machine is stopped.
If the error is caused by this reason, it usually occurs when the machine is being Run-in, or after the replacement of particular regarding the rotation and that therefore since they are new they produce friction higher than normal.
Another possible situation is the mechanical rupture, for example on the cylinder, that compromise the rotation, causing its blocking.

- In all these cases, is necessary to intervene on the mechanical causes by oiling the parts with friction and Run-in the mechanical parts.

Another cause of error is due to the main motor and its transmission organs.
Proceed as follows to solve the problem:

- Check the gears and the drive belt.
- Replace the motor.
- Replace the resolver.
  The Resolver determines the proper functioning of the motor.
  The Resolver malfunction is the main cause of motor malfunction.

Other causes of this problem may be due to the complex of boards and wiring that determine the motor movement.
The speed reference exits from the Pcb_2008 board and reaches the Motor drive board.
The Resolver phases, from the motor reaches the Motor drive board, which uses in 2 ways.

1. They are used for the motor control.
2. They are processed, transforming them into an encoder for degrees/needles counting, and then they are sended to the Pcb_2008.

In case of ECODD15 Motor drive board there is also a wiring for the connection between the CAN board Pcb_2008 and the Motor drive board.
The power phases for the motor command exit from the Motor drive board, reach the Motor Contactor which is controlled by the Pcb_2008 board (Start/Stop management), pass for the interface D4840496 and finally reach the motor.

Proceed as follows to solve the problem:

- Check the wiring between the Pcb_2008 board and the Motor Drive board.
- Check the wiring between the Motor Resolver and the Motor Drive board.
- Replace the Motor Drive board.
- Replace the motor Contactor TL1.
- Replace the board Pcb_2008.

Notice

Note

This is an error with a particular management, when it appears is not erasable with key [F8].
For the restoration of functionality must Turn off and then Turn on the machine.
Of course must work the “Black-out” batteries, otherwise the machine executes a Reset and goes to the End of Cycle step.
At this point erase the error with [F8] and start the machine.
If the reason of the error is still active it will appear again, otherwise the machine will resume the proper operation.
This management permits in most cases the saving of socks, and the possibility of leaving the error without the appe-

arance of mechanical problems due to machine Reset.

MPP

```
MPuE01: Air vacuum valve not at zero
MPuE02: Raising dial motor not at zero
MPuE03: Overturn welt motor not at zero
MPuE04: Turning device vacuum valve motor not at zero
MPuE16: Vertical pickup arm motor not at zero
MPuE17: Angle pickup arm motor not at zero
MPuE18: Down turning device motor not at zero
MPuE19: Top turning device motor not at zero
MPuE20: Pin forward motor not at zero
MPuE21: Linker motor not at zero
MPuE22: Turning roller inclination motor not at zero
MPuE23: Pin unit reversing motor not at zero
MPuE24: External CT shutter valve motor not at zero
MPuE06: Raising dial motor wrong position
MPuE07: Dial encoder wrong position
MPuE08: Dial in right position. Busy error
MPuE09: Dial not at zero!! Manual. reset obliged
MPuE10: Dial manual movement Not completed
MPuE12: Carry out recovery borde manual
MPuE13: ATTENTION! Dial lock piston inserted
MPuE14: Welt position changed Modif. lost
```

CAN messages on the motors position

MPuE01: Air vacuum valve not at zero

Input board for the sensor:	Pcb_3836 N° 1	
Nr. Led of zero sensor:	Pcb_3836 DS14	
Led status with motor in zero position	ON	

MPuE02: Raising dial motor not at zero

Input board for the sensor:	Pcb_3836 Nr. X	
Nr. Led of zero sensor:	Pcb_3836 DS__	
Led status with motor in zero position	OFF	

The board number (N° X) and the Led number (DS__) depend on model and optionals with which is arranged the machine.
The configuration is always: [Mot.1 = Ds15] - [Mot.2 = Ds14] - [Mot.3 = Ds6] - [Mot.4 = Ds16].

MPuE03: Overturn welt motor not at zero

Input board for the sensor:	Pcb_3836 Nr. X	
Nr. Led of zero sensor:	Pcb_3836 DS__	
Led status with motor in zero position	OFF	

The board number (N° X) and the Led number (DS__) depend on model and optionals with which is arranged the machine.
The configuration is always: [Mot.1 = Ds15] - [Mot.2 = Ds14] - [Mot.3 = Ds6] - [Mot.4 = Ds16].

MPuE04: Turning device vacuum valve motor not at zero

Input board for the sensor:	Pcb_3836 Nr. X	
Nr. Led of zero sensor:	Pcb_3836 DS__	
Led status with motor in zero position	ON	

The board number (N° X) and the Led number (DS__) depend on model and optionals with which is arranged the machine.
The configuration is always: [Mot.1 = Ds15] - [Mot.2 = Ds14] - [Mot.3 = Ds6] - [Mot.4 = Ds16].

MPuE16: Vertical pickup arm motor not at zero

MPuE17: Angle pickup arm motor not at zero

MPuE18: Down turning device motor not at zero

MPuE19: Top turning device motor not at zero

MPuE20: Pin forward motor not at zero

MPuE21: Linker motor not at zero

MPuE22: Turning roller inclination motor not at zero

MPuE23: Pin unit reversing motor not at zero

MPuE24: External CT shutter valve motor not at zero

Input board for the sensor:	Pcb_3836 Nr. X	
Nr. Led of zero sensor:	Pcb_3836 DS__	

The board number (N° X) and the Led number (DS__) depend on model and optionals with which is arranged the machine.
The configuration is always: [Mot.1 = Ds15] - [Mot.2 = Ds14] - [Mot.3 = Ds6] - [Mot.4 = Ds16].

Remember that:

There are two types of proximity sensors detecting the presence of material.
Some proximity switches emit a signal when the material is visible, others when it is not.
The proximity switches are devices that open up or close depending on the external situation.

If the sensor does not switches on/off (always open or closed), it means it is broken.
Check that the sensor switches from 0 to 1 or vice versa at point zero.
Check on the board that the LED associated with the sensor signal switches on or off in the presence of zero.

This error is a particular case of more general error of:
”Impossible 0 approach”
It is on every single stepping motor with a control of the Zero position during the passage for the step Zero of the Sock Cycle (for example is true for all Stitch motors).
This error happens when the stepping motor indicated in the error, during the Sock cycle, to the achievement of the step zero not found then motor itself in the Zero condition.
The phase sensor at the step Zero would have had to be in a reading status, and this has not happened.
Since the movement of this asynchronous motor compared to the machine cylinder rotation, typically this error can occur if the Sock Program occur some special conditions.

These condition are:
- The step which is programmed the zeroing quota is very near the step Zero.
- The speed of the cylinder is too high.

- The “steps” to run to reach the Zero are many (you are coming from a “steps” quota very distant from Zero).

In all these cases, or combination of them, may occur the situation that determines the error (Sock cycle at step Zero with sensor not a Zero).
In these cases, the solution involves an appropriate modify of the Sock program.
Other types of problems (boards or sensors rupture) that can cause this error is unlikely, would have priority in these cases the error of:
”Impossible 0 approach”

Notice

Attention

This type of error is recursive.
It is not cancel simply by pressing the key [F8].
The best solution is to run a Zeroing ([F0]) to arrive at the End of Sock.
The machine can then return to its normal operation.
If the problem is not resolved it will recur in the same point of the subsequent sock.
A turn off and turn on of the machine keeps the machine in the same point (if available, starts the black-out procedure).
A hardware Reset brings the machine to End of Cycle, but could cause subsequent mechanical damage.

Reference

See the control procedure described about the error:
GFuE67

Angle pickup arm motor

Angle pickup arm: zero proximity switch

Improvements have been made to the mechanical unit.
The updated machine software is compatible with the new layout and the previous one.
The actual outfit must be specified from the dedicated menu.
To this end, refer to the menu:
-ANGLE PICK-UP ARM CONTROL

Messages on the Dial management

MPuE06: Raising dial motor wrong position

This message informs the user that the “Dial” is not in the appropriate position.
This followed a manual command of [Dial Raiser] or [Dial Lower].
Through the encoder connected to the “Dial” is always controlled the device position.
If the position is different from the real one for at least one “Step” is displayed this message.
The user must complete the movement of the “Dial” using the same manual commands ([Dial Raiser] and [Dial Lower]).

MPuE07: Dial encoder wrong position

This message informs the user that the “Dial” is not in the appropriate position.
This as a result of the various movements provided by the Sock Cycle.
Through the encoder connected to the “Dial” is always controlled the device position.
If the position in the Sock Programme is outside tolerance (3 “Steps”) is displayed this message.
The user must restore the proper position using the appropriate keys.
This happens through the pressure of the [CTRL] + [C] keys directly in the Error Window.
Then delete the error with the key [F8].

MPuE08: Dial in right position. Busy error

This message informs the user that the manual command [Dial Raiser] or [Dial Lower] just executed has carried the Dial

in a not coherent position (out of tolerance) than expected by the software.
This warning indicates a problem.
This message informs the user that the “Dial” is not in the appropriate position.
This followed a manual command of [Dial Raiser] or [Dial Lower].
Through the encoder connected to the “Dial” is always controlled the device position.
If the position is different from the real one for at least one “Step” is displayed this message.
The user must complete the movement of the “Dial” using the same manual commands ([Dial Raiser] and [Dial Lower]).
This particular message is a symptom of a Hardware or Software problem.

Notice

Attention

Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

MPuE09: Dial not at zero!! Manual. reset obliged

This message appears in Working Enter.
This message informs the user that is forced to perform a manual Zeroing of the “Dial”.
Only after this operation the machine can be the running.

MPuE10: Dial manual movement Not completed

This message informs the user that the machine cannot be Run.
This movement is not possible as it is disabled from the software control associated with a Manual Command.
In this case the origin of the problem is the manual command [Dial Raiser] which has not been completed.
The “Dial” is not in the correct position.

MPuE12: Carry out recovery borde manual

This message appears in response to the restoration (recovery) after a “Black-out”.
The user, during the restoration, through a manual command must restore the “Dial” position.
This message is displayed when the software detects the attempt to put in motion the machine (pressure of the Start key or [Handle] keys), or notes an Encoder movement due to the use of the [Mechanical Handle].
The user must restore the proper position using the appropriate keys.

MPuE13: ATTENTION! Dial lock piston inserted

Sensor input:
Pcb_3759 J14 p11
Command output:
G44J: в1 e8 — G54JCT: в1 e8 — G54JOT: в1 e8 — G615: в16 e5 — G615D: в1 e8 — G616: в16 e2 — G616D: в16 e2 — G61Q: в16 e1 — G624: в1 e8 — G626: в16 e1

This message may appear only in the case of Motorized Dial.
The “Dial locking piston” is a device that is activated to block the Dial when it’s in the Up position (End of Run higher), preventing all its vertical movement.

When the device is not commanded (Solenoid valve de-energized) it is active (inserted); the Dial is blocked in the specified position.
In this condition the control contact is open on the Ground.
The inputs Autotest therefore displays the value “1”.

When the device is commanded (Solenoid valve energized) it is not active (not inserted); the Dial may be moved by the motor.
In this condition the control contact is closed on the Ground.
The inputs Autotest therefore displays the value “0”.

This message appears when, with Dial in Up position (End of Run higher), the software notes that the input status is not coherent with what is expected.
At this phase the right status of the control must be: “Piston” inserted and Autotest = “0”.

Otherwise appears this error.

Error control

It is always advisable try to cancel the error visualized on the Display by pressing the [F8] key, so testing if it's still active.
At this point we will have two possibilities:

1. The error is cancelled and the machine resumes its functioning.
2. The error is not cancelled, and the machine is blocked with the error displayed.

1st case: the error is cancelled with the [F8] key

Generally this message appears when the machine is turned on after a Black-Out procedure.
Normally this is due to the timing on the real movement of the Piston and therefore is possible to delete this message , and the machine can be running.

2nd case: the error is not cancelled with the [F8] key

Should the error not be cancelled, means that the mechanical part concerned shall not be in the right position, or the sensor or the electronic boards has not detected correctly the new position of mechanical part.
Proceed as follows to solve the problem:
Visually check the position taken by the mechanical part concerned the movement.

1. If the mechanical part is not in the right position proceed with the point:
   Mechanical device out of position
   Should the mechanical device actually be out of position, there are two possible types of problems:
   Mechanical problem
   - *Check that the movement of the mechanical part can be carried out without problems.*

   Electric or electronic problem
   - *Replace the Solenoid valve concerned.*
   - *Replace the Output board corresponding to the command.*

2 If the mechanical part is in the right position proceed with the point:
   Mechanical device in right position
   If the mechanical part concerned is in the right position, the control sequence was carried out correctly. Therefore, also the corresponding Solenoid valve functions properly.
   The problem may be caused by position sensor that has not found the new position.
   - *Check the correct adjustment of the position sensor, and possibly replace it.*
   - *Check the connecting cables between the sensor and the inputs board.*
   - *Replace the Input board.*

MPuE14: Welt position changed Modif. lost

The User may modify the Dial quota aboard the machine.
This modify is immediately active, but because it is regularly stored must be properly saved.
If the modify has not been saved, and during the Sock Cycle by programming arrives a new Dial quota, the previous manual modify will be lost.
This message informs the user that the manual modify is not more active.

REST

```
Re1: Modify possible in working only
REuE19: Timeout CAN encoder sinker cap posit. motor
REuE23: Type of cam not found
REuE02: Sizing motor not at zero
REuE03: Sinker cap motor not at zero
REuE04: Sinker cap angular motor not at zero
REuE24: Heel Return S.C. Motor not at zero
REuE26: Stitch Cam Motor Feed 1 not at zero
REuE28: Stitch Cam Motor Feed 2 not at zero
REuE30: Stitch Cam Motor Feed 3 not at zero
REuE32: Stitch Cam Motor Feed 4 not at zero
REuE20: Stitch cam calibration data in FLASH, lost
REuE21: Number of stitch cam position too high
REuE22: Number of stitch cams motors is wrong
```

Messages on various Management and Operations

Re1: Modify possible in working only

This message informs the user that the attempted operation is only possible with the key selector in position of:
- RUN -
In this case the operation tempted is on the modify of certain data.
Press the [F8] key to cancel the error.
Perform the operation with the Key in the correct position.

REuE19: Timeout CAN encoder sinker cap posit. motor

This message may appear in machines in which the “Sinker Cap Position” is arranged with an Encoder for the position control.
After a command, if the software via CAN not receive the communication about the position reached by the Encoder is activated a “Timeout” (waiting) and appears this error.
This problem is probably due to a software failure, and it is supposed it will never be displayed to the user.
However, can exist situations or hardware broken that could cause the appearance of this error.

In case of the occurrence of this error after a Software Update.

- *Run again the Updating procedure, is possible that the copy operation of Software in FLASH memory is not carried out correctly.*

Even if not specific with respect to the real problem, this error may appear in the event of an hardware problem (a fault):

- *To any CAN module.*
- *To the board Pcb_2008.*
- *To the wirings between these boards.*

- A problem in the software writing, an hardware problem on the CAN boards, a disorder on the CAN transmission:
  All these conditions may cause CAN Errors/Alarms not related to the real failure, but General of the CAN system.

Therefore in general, for all the CAN Errors/Alarms, after having evaluated the specific problem indicated by error, also to assess as a possible cause a general problem of the CAN system (software and hardware).

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

REuE23: Type of cam not found

This alarm indicates incompatibility between the programming software (GRAPHITRON) and the machine software (Eproms).
In particular the type of “Stitch cams” codified in the Sock Program is not available in the machine software (“eprom custom”).

- The solution, depending on the case, is to update the machine software (Eproms) or the GRAPHITRON software.

Other causes for this problem may be the machine software or programming software not valid because damaged or containing a mistake.

- Also in this case, the solution is to run the software update with a valid and compatible version.

Notice

Attention

Contact Lonati technical staff for further information and for an eventual Software update.

CAN messages on the motors position

REuE02: Sizing motor not at zero

Input board for the sensor:	Pcb_3836 N° 1	
Nr. Led of zero sensor:	Pcb_3836 DS15	
Led status with motor in zero position	ON	

REuE03: Sinker cap motor not at zero

Input board for the sensor:	Pcb_3836 N° 1	
Nr. Led of zero sensor:	Pcb_3836 DS06	
Led status with motor in zero position	ON	

REuE04: Sinker cap angular motor not at zero

Input board for the sensor:	Pcb_3836 Nr. X	
Nr. Led of zero sensor:	Pcb_3836 DS__	
Led status with motor in zero position	ON	

The board number (N° X) and the Led number (DS__) depend on model and optionals with which is arranged the machine.
The configuration is always: [Mot.1 = Ds15] - [Mot.2 = Ds14] - [Mot.3 = Ds6] - [Mot.4 = Ds16].

REuE24: Heel Return S.C. Motor not at zero

Input board for the sensor:	Pcb_3836 Nr. X	
Nr. Led of zero sensor:	Pcb_3836 DS__	
Led status with motor in zero position	ON	

The board number (N° X) and the Led number (DS__) depend on model and optionals with which is arranged the machine.
The configuration is always: [Mot.1 = Ds15] - [Mot.2 = Ds14] - [Mot.3 = Ds6] - [Mot.4 = Ds16].

REuE26: Stitch Cam Motor Feed 1 not at zero

Input board for the sensor:	Pcb_3836 Nr. X	
Nr. Led of zero sensor:	Pcb_3836 DS__	
Led status with motor in zero position	ON	

The board number (N° X) and the Led number (DS__) depend on model and optionals with which is arranged the machine.
The configuration is always: [Mot.1 = Ds15] - [Mot.2 = Ds14] - [Mot.3 = Ds6] - [Mot.4 = Ds16].

REuE28: Stitch Cam Motor Feed 2 not at zero

Input board for the sensor:	Pcb_3836 Nr. X	
Nr. Led of zero sensor:	Pcb_3836 DS__	
Led status with motor in zero position	ON	

The board number (N° X) and the Led number (DS__) depend on model and optionals with which is arranged the machine.
The configuration is always: [Mot.1 = Ds15] - [Mot.2 = Ds14] - [Mot.3 = Ds6] - [Mot.4 = Ds16].

REuE30: Stitch Cam Motor Feed 3 not at zero

Input board for the sensor:	Pcb_3836 Nr. X	
Nr. Led of zero sensor:	Pcb_3836 DS__	
Led status with motor in zero position	ON	

The board number (N° X) and the Led number (DS__) depend on model and optionals with which is arranged the machine.
The configuration is always: [Mot.1 = Ds15] - [Mot.2 = Ds14] - [Mot.3 = Ds6] - [Mot.4 = Ds16].

REuE32: Stitch Cam Motor Feed 4 not at zero

Input board for the sensor:	Pcb_3836 Nr. X	
Nr. Led of zero sensor:	Pcb_3836 DS__	
Led status with motor in zero position	ON	

The board number (N° X) and the Led number (DS__) depend on model and optionals with which is arranged the machine.
The configuration is always: [Mot.1 = Ds15] - [Mot.2 = Ds14] - [Mot.3 = Ds6] - [Mot.4 = Ds16].

This error is a particular case of more general error of:
”Impossible 0 approach”
It is on every single stepping motor with a control of the Zero position during the passage for the step Zero of the Sock Cycle (for example is true for all Stitch motors).
This error happens when the stepping motor indicated in the error, during the Sock cycle, to the achievement of the step zero not found then motor itself in the Zero condition.
The phase sensor at the step Zero would have had to be in a reading status, and this has not happened.
Since the movement of this asynchronous motor compared to the machine cylinder rotation, typically this error can occur if the Sock Program occur some special conditions.

These condition are:
- The step which is programmed the zeroing quota is very near the step Zero.

- The speed of the cylinder is too high.
- The “steps” to run to reach the Zero are many (you are coming from a “steps” quota very distant from Zero).

In all these cases, or combination of them, may occur the situation that determines the error (Sock cycle at step Zero with sensor not a Zero).
In these cases, the solution involves an appropriate modify of the Sock program.
Other types of problems (boards or sensors rupture) that can cause this error is unlikely, would have priority in these cases the error of:

”Impossible 0 approach”

Notice

Attention

This type of error is recursive.
It is not cancel simply by pressing the key [F8].
The best solution is to run a Zeroing ([F0]) to arrive at the End of Sock.
The machine can then return to its normal operation.
If the problem is not resolved it will recur in the same point of the subsequent sock.
A turn off and turn on of the machine keeps the machine in the same point (if available, starts the black-out procedure).
A hardware Reset brings the machine to End of Cycle, but could cause subsequent mechanical damage.

Reference

See the control procedure described about the error:
GFuE67

Messages on software problems in the Stitch Cams management

REuE20: Stitch cam calibration data in FLASH, lost

This message appears when in the part of the machine Setup dedicated to the saving of the “Stitch cams self-calibration” data are not present valid data.
This happens when the Pcb_2007 board is new, when the data are being erased by the appropriate Reset, and in any case they are not estimated valid by the software.
The next “Turning on” the machine a message warns the user that the “Self-calibration” is missing, is necessary to run an access to the “Self-calibration” procedure and perform at least a data saving.
The error is erasable with the [F8] key, this allows the user to access the functionality to execute a valid Setup, essential for the machine operation.

Reference

Furthers informations are available in :
GUIDE OF USER INTERFACE
1. Stitch cams self-calibration

REuE21: Number of stitch cam position too high

REuE22: Number of stitch cams motors is wrong

This alarm indicates incompatibility between the programming software (GRAPHITRON) and the machine software (Eproms).
In particular the problem is related to the “Stitch cams” management (Motors number and Positions number) codified in the Sock Program than expected in the machine software (“eprom custom”).

- The solution, depending on the case, is to update the machine software (Eproms) or the GRAPHITRON software.

Other causes for this problem may be the machine software or programming software not valid because damaged or containing a mistake.

- Also in this case, the solution is to run the software update with a valid and compatible version.

Notice

Attention

Contact Lonati technical staff for further information and for an eventual Software update.

SCORE

Sc1: Reading table complete, learning failed
Sc4: Wrong encoder data
Sc10: Command for serial sensors not recognized
Sc16: Yarn sliding events queue full
Sc5: Yarn not cut H sensor N. "x"
Sc21: Yarn not cut L sensor N. "x"
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Sc22: Broken yarn L Sensor N. "x"
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Sc7: None signal from sensors
Sc11: Serial sensors wrong communications
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Sc14: Serial sensors too slow
Sc17: Too many irq on reception
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Sc15: Configuration wrong, serial sensor N. "x"
Sc25: Parameters out of range sensor N. "x"
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Sc18: Transistor of stop broken, sensor N. "x"
Sc19: Optical blinded sensor N. "x"
Sc20: Optical dirty sensor N. "x"

Messages on software problems in the Yarn Sliding

Sc1: Reading table complete, learning failed

This error alerts the user that during the Yarn sliding Learning procedure of a sock, many readings have been made in order to fill out the table prepared in RAM memory.
Since the writing in the table is dynamic and if is necessary the old "Learnings" are cancelled for the new one, this error could appear even if a single "Learning" fill this table.
This error should never appear because the software has dimensioned a memory table sufficient enough for any type of reading (sock).
In case the error appears perform a Reset of the RAM memory through the function aboard the machine, or disconnect the buffer battery BT1 of the Pcb_2007 board with the machine turned off.
Result of this operation is the complete cancellation of RAM memory, and then reload the Sock Program and execute a new "Learning".

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Sc4: Wrong encoder data

This error alerts the user that the software was not able to elaborate a sample, because "interrupt software" with major priority didn't allow.
As a result the "Yarn sliding" will be suspended.
The possibility of this error is directly proportional to the number of sensors read and to the frequency of reading; as these numbers are high, as is more high the probability of occurrence of the error.
In case the error appears, delete it, finish the sock, turn off and on the machine; carry out a new "Learning" and restart the production.

If the error shows up more than once, the user must find the reason.

Proceed as follows to solve the problem:

- Check the presence of electrical noise on power Three-Phase Line of the machine.
- Check the functionality of the Earth installation of the machine and the correct connection to Ground of the yarn Creel.
- Check the presence of disturbances on the Ground of the machine (0 Vdc).
- Check the functionality of the Yarn sliding sensors and their correct connection.
  The malfunction of a sensor can cause this error.
- Check the wiring that connect the Pcb_2008 board to the sensors (shielded cable with 0 Vdc and shield to Ground).

On the Lonati machines, the working condition more critical of the “Yarn Sliding” is the following.
Reading Frequency of 4 per revolution, with a maximum of 20 sensors mounted.
With these parameters the software should not have problems in the readings processing.

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Sc10: Command for serial sensors not recognized

This error alerts the user that the command requested is unknown.
This problem is probably due to a software failure, and it is supposed it will never be displayed to the user.

Notice

Attention

In case of the occurrence of this message contact the Lonati technical staff.

Sc16: Yarn sliding events queue full

This error alerts the user that the circular queue for the events storage inside the software is full.
This problem is probably due to a software failure, and it is supposed it will never be displayed to the user.

Notice

Attention

In case of the occurrence of this message contact the Lonati technical staff.

Messages on the functioning of the Yarn Sliding

Sc5: Yarn not cut H sensor N. “x”

Sc21: Yarn not cut L sensor N. “x”

Machine stop for yarn not cut.

This couple of errors alert the user that the yarn matched to the sensor “Nr. xx” has not been cut, or it is still sliding when it should be stationary.
The software performs these checks by comparing the previous Learning with the Read values during the control phase, comparing on each reading the yarn condition.

The status of the yarn also depended on sensor internal parameter, set in the configuration window of the sensors parameters.
The standard values (DEFAULT) provided in the software allow, in most cases, a good management of Yarn Sliding.
Any change of these parameters, the software automatically requires the execution of a new Learning.

The management of the control depends also by the sensor Filters, set in the configuration window of the sensors Filter.
The standard values (DEFAULT) provided in the software allow, in most cases, a good management of Yarn Sliding.
The change of these values not implies automatic execution of a new Learning (does not change the values previously learnt).

The first evaluation to do about this error is to check that it is due to a real fact.
In this case, a yarn found in movement when this was not foreseen in Learning.
For example when the yarn-finger exits knitting and the yarn was not cut, for which it continues to flow because knitted from the needles in rotation.

- In this case solve the textile problem.

If this stop occurs while the yarn is stationary, it is clearly a false error.
Proceed with the following operations:

- Check that the sensor does not consider the yarn in sliding (Green Led on sensor lit) even if it is stationary. Eventually lower the sensibility of the sensor (Sensors parameters configuration).
- Replace the sensor that has found the error. Perform a new sensors identification and a new Learning of the sock.

We must always analyze the type of error to adapt the intervention, both on the mechanic-textiles conditions that on the parameters of configuration.
For example, if an error of “yarn not cut” appears always when the yarn-finger exits knitting.
This may mean an excessive sensibility of the sensor (read the yarn in sliding even when it almost stopped), or excessive yarn mobility (little tension) that keeps the yarn free to fluctuate too much in the phase of stop.
After the evaluation is made act as a consequence, by lowering the sensibility or tensioning the yarn.

There are many possible situations, knowing the functioning, the meaning of the parameters, the textile problems, the yarn movement, you can always optimize and ajust the functioning of the system, even by personalizing a single sensor.
This in order to obtain the less number of stops unnecessary and the maximum control (less time of intervention and certainty of stop).

Notice

Attention

In the machine software are available 2 operations for the Yarns Sliding.
A “Lonati Management” and a “Special Management”.
A function in the Yarn Sliding Setup allows to enable the “Special Management”.
Currently, with the Yarn sliding sensors of BTSR type is used the “Special Management”.
With the “Lonati Management” enabled the algorithm of control of this error is different.

Reference

Many information about the meaning and the detailed rules for the modify of the various configuration parameters relating to the yarn Sliding management are available in:
GUIDE OF USER INTERFACE

1. Yarns sliding
2. Sensors filters configuration
3. Sensors parameters configuration
4. Identification of sensors
5. Management sw sliding

Sc6: Broken yarn H sensor N. “x”

Sc22: Broken yarn L Sensor N. “x”

Machine stop for yarn broken

This error alerts the user that the yarn matched to the sensor “Nr. xx” is broken, or it is however stationary when it should be in sliding.

The software performs these checks by comparing the previous Learning with the Read values during the control phase, comparing on each reading the yarn condition.

The status of the yarn also depended on sensor internal parameter, set in the configuration window of the sensors parameters.
The standard values (DEFAULT) provided in the software allow, in most cases, a good management of Yarn Sliding.
Any change of these parameters, the software automatically requires the execution of a new Learning.

The management of the control depends also by the sensor Filters, set in the configuration window of the sensors Filter.
The standard values (DEFAULT) provided in the software allow, in most cases, a good management of Yarn Sliding.
The change of these values not implies automatic execution of a new Learning (does not change the values previously learnt).

The first evaluation to do about this error is to check that it is due to a real fact.
In this case, a yarn noted stationary when the “Learning” does not do this.
For example whne ends the yarn on the Bobbin.

- In this case solve the textile problem.

If this stop occurs while the yarn is sliding, it is clearly a false error.
Proceed with the following operations:

- Check that the sensor does not consider the yarn stationary (Red Led on sensor lit) even if it is in sliding.
  Eventually raise the sensibility of the sensor (Sensors parameters configuration).
- Clean the reading window of the sensor.
  Eventually carry out a new Learning.
- Replace the sensor that has found the error.
  Perform a new sensors identification and a new Learning of the sock.

We must always analyze the type of error to adapt the intervention, both on the mechanic-textiles conditions that on the parameters of configuration.
For example, if an error of “broken yarn” appears always when the yarn-finger exits knitting.
This may mean an insufficient sensibility of the sensor (read the yarn stationary even when it is however in motion, even if in phase of stop).
After the evaluation is made act as a consequence, by raising the sensibility.

There are many possible situations, knowing the functioning, the meaning of the parameters, the textile problems, the yarn movement, you can always optimize and ajust the functioning of the system, even by personalizing a single sensor.
This in order to obtain the less number of stops unnecessary and the maximum control (less time of intervention and certainty of stop).

Notice

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A function in the Yarn Sliding Setup allows to enable the “Special Management”.
Currently, with the Yarn sliding sensors of BTSR type is used the “Special Management”.
With the “Lonati Management” enabled the algorithm of control of this error is different.

Reference

Many information about the meaning and the detailed rules for the modify of the various configuration parameters relating to the yarn Sliding management are available in:
GUIDE OF USER INTERFACE

1. Yarns sliding
2. Sensors filters configuration
3. Sensors parameters configuration
4. Identification of sensors
5. Management sw sliding

Sc23: Broken yarn H SPEED sensor N. “x”

Machine stop for yarn broken

This error alerts the user that the yarn matched to the sensor “Nr. xx” is broken, or it is however stationary when it should be in sliding.
The software performs these checks by comparing the previous Learning with the Read values during the control phase, comparing on each reading the yarn condition.

The status of the yarn also depended on sensor internal parameter, set in the configuration window of the sensors parameters.
The standard values (DEFAULT) provided in the software allow, in most cases, a good management of Yarn Sliding.
Any change of these parameters, the software automatically requires the execution of a new Learning.

The management of the control depends also by the sensor Filters, set in the configuration window of the sensors Filter.
The standard values (DEFAULT) provided in the software allow, in most cases, a good management of Yarn Sliding.
The change of these values not implies automatic execution of a new Learning (does not change the values previously learnt).

The first evaluation to do about this error is to check that it is due to a real fact.
In this case, a yarn noted stationary when the “Learning” does not do this.
For example whne ends the yarn on the Bobbin.

- In this case solve the textile problem.

If this stop occurs while the yarn is sliding, it is clearly a false error.
Proceed with the following operations:

- Check that the sensor does not consider the yarn stationary (Red Led on sensor lit) even if it is in sliding.
  Eventually raise the sensibility of the sensor (Sensors parameters configuration).
- Clean the reading window of the sensor.
  Eventually carry out a new Learning.
- Replace the sensor that has found the error.
  Perform a new sensors identification and a new Learning of the sock.

We must always analyze the type of error to adapt the intervention, both on the mechanic-textiles conditions that on the parameters of configuration.
For example, if an error of “broken yarn” appears always when the yarn-finger exits knitting.
This may mean an insufficient sensibility of the sensor (read the yarn stationary even when it is however in motion, even if in phase of stop).
After the evaluation is made act as a consequence, by raising the sensibility.

There are many possible situations, knowing the functioning, the meaning of the parameters, the textile problems, the yarn movement, you can always optimize and ajust the functioning of the system, even by personalizing a single sensor.
This in order to obtain the less number of stops unnecessary and the maximum control (less time of intervention and certainty of stop).

Notice

Note

The principle of operation of the “Highspeed” error is equal to that of “Broken Yarn H”.
The difference is that the “Highspeed” error has its dedicated “Filters” parameters and which only occurs when the software detects the error in a point of the sock where considers the yarn in a durable status of sliding.

Attention

In the machine software are available 2 operations for the Yarns Sliding.
A “Lonati Management” and a “Special Management”.
A function in the Yarn Sliding Setup allows to enable the “Special Management”.
Currently, with the Yarn sliding sensors of BTSR type is used the “Special Management”.
With the “Lonati Management” enabled the algorithm of control of this error is different.

Reference

Many information about the meaning and the detailed rules for the modify of the various configuration parameters rela-

ting to the yarn Sliding management are available in:
GUIDE OF USER INTERFACE

1. Yarns sliding
2. Sensors filters configuration
3. Sensors parameters configuration
4. Identification of sensors
5. Management sw sliding

Sc24: Broken yarn cumulative sensor N. "x"

Machine stop for yarn broken

This error alerts the user that the yarn matched to the sensor "Nr. xx" is broken, or it is however stationary when it should be in sliding.
The software performs these checks by comparing the previous Learning with the Read values during the control phase, comparing on each reading the yarn condition.

The status of the yarn also depended on sensor internal parameter, set in the configuration window of the sensors parameters.
The standard values (DEFAULT) provided in the software allow, in most cases, a good management of Yarn Sliding.
Any change of these parameters, the software automatically requires the execution of a new Learning.

The management of the control depends also by the sensor Filters, set in the configuration window of the sensors Filter.
The standard values (DEFAULT) provided in the software allow, in most cases, a good management of Yarn Sliding.
The change of these values not implies automatic execution of a new Learning (does not change the values previously learnt).

The first evaluation to do about this error is to check that it is due to a real fact.
In this case, a yarn noted stationary when the "Learning" does not do this.
For example whne ends the yarn on the Bobbin.

- In this case solve the textile problem.

If this stop occurs while the yarn is sliding, it is clearly a false error.
Proceed with the following operations:

- Check that the sensor does not consider the yarn stationary (Red Led on sensor lit) even if it is in sliding.
  Eventually raise the sensibility of the sensor (Sensors parameters configuration).
- Clean the reading window of the sensor.
  Eventually carry out a new Learning.
- Replace the sensor that has found the error.
  Perform a new sensors identification and a new Learning of the sock.

We must always analyze the type of error to adapt the intervention, both on the mechanic-textiles conditions that on the parameters of configuration.
For example, if an error of "broken yarn" appears always when the yarn-finger exits knitting.
This may mean an insufficient sensibility of the sensor (read the yarn stationary even when it is however in motion, even if in phase of stop).
After the evaluation is made act as a consequence, by raising the sensibility.

There are many possible situations, knowing the functioning, the meaning of the parameters, the textile problems, the yarn movement, you can always optimize and ajust the functioning of the system, even by personalizing a single sensor.
This in order to obtain the less number of stops unnecessary and the maximum control (less time of intervention and certainty of stop).

Notice

Note

If during a sock cycle a yarn slides for a number of samplings inferior to the value of "Filter broken H" it's impossible to recognize the broken yarn, because the error counters are set at zero at the end of cycle.
The counter of the "Cumulative" error instead is not set at zero at the end of the sock, therefore at a certain point the value or error intervention is reached (placed at : [Filter broken H] + [2]), so the maximum after 2 or 3 sock the machi-

ne is stopped in order to avoid a serious damage to the production.
This fact is very important for the “Single cylinder” machines in case of particular patterns (few needles).
But there is a negative effect, in case of Learning of yarns inserted in the sensor that are not working, it may occur that high sensibility and delay, could cause the reading of yarn that runs for a few samplings, even if the yarn really doesn’t work.
This will cause every few sock to stop with the “Cumulative error”.

Another solution to check the short movements of the yarn is set for individual sensor a value of “Filter broken H” low enough to be able to note the error.

In the BRAVO machines, the textile conditions of work prevent the production of sock with minimum yarn knitting, so this error is disabled by DEFAULT.

Attention

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A function in the Yarn Sliding Setup allows to enable the “Special Management”.
Currently, with the Yarn sliding sensors of BTSR type is used the “Special Management”.

Reference

Many information about the meaning and the detailed rules for the modify of the various configuration parameters relating to the yarn Sliding management are available in:
GUIDE OF USER INTERFACE

1. Yarns sliding
2. Sensors filters configuration
3. Sensors parameters configuration
4. Identification of sensors
5. Management sw sliding

Messages on the seria communication with the Yarn Sl. Sensors

Sc7: None signal from sensors

This error alerts the user that during the Learning phase, the machine has not found signal of change of the sliding status of the sensors.
The error appears at the end of the sock.
Some typical situations in which appears this error are:

- Learning of a sock in which was not programmed any movement of the yarn-fingers.
- Learning of a normal Sock cycle, but without the presence of the yarns.
- Learning of a sock, but without any sensor connected, for example because on the Yarn Creel the Yarn Sliding cable is not connected to the sensors.

In these cases, if you don’t want modify the condition that determines the error, must be uninstall the Yarn Sliding management in the Setup.
Otherwise eliminate the origin of the error, for example by connecting the sensors to the control cable.

Except for the above-mentioned situations, we must look for other cases that might determine the problem.
Proceed as follows to solve the problem:

- Check the functionality of the Yarn sliding sensors and their correct connection.
  The malfunction of a sensor can cause this error.
- Check the wiring that connect the Pcb_2008 board to the sensors (shielded cable with 0 Vdc and shield to Ground).
- Replace the board Pcb_2008.

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Reference

Furthers informations are available in :
GUIDE OF USER INTERFACE
1. Enable yarn sliding

Sc11: Serial sensors wrong communications

When the machine is turned on, this error alerts the user that during the initial communication protocol between the machine and the serial sensors, a difference has been found between the Identification values written in FLASH memory and those sensors themselves.
The stored values not correspond to those sensors connected.
A typical situation is when are disconnected one or more sensors without executing a new Identification.
When the machine is turned on the software notes this difference and communicates it through the error.
- Perform a new sensors Identification.

Sometimes the error appears if there are communication problems between the Pcb_2008 board and the sensors.
If the episode is random and not repeated in the time, cancel the error and continue the production.

If the error shows up more than once, the user must find the reason.
Proceed as follows to solve the problem:
- Check the presence of electrical noise on power Three-Phase Line of the machine.
- Check the functionality of the Earth installation of the machine and the correct connection to Ground of the yarn Creel.
- Check the presence of disturbances on the Ground of the machine (0 Vdc).
- Check the functionality of the Yarn sliding sensors and their correct connection.
  The malfunction of a sensor can cause this error.
- Check the wiring that connect the Pcb_2008 board to the sensors (shielded cable with 0 Vdc and shield to Ground).

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Reference

Furthers informations are available in :
GUIDE OF USER INTERFACE
1. Identification of sensors

Sc12: Sensor N. "x" doesn't answer to communication

When the machine is turned on, this error alerts the user that a certain sensor (Nr. xx) does not respond to the software signals.
This generally occurs when the sensor is defective or not connected.
- Then check the connection and eventually replace the sensor.

Perform a new sensors Identification.

Sometimes the error appears if there are communication problems between the Pcb_2008 board and the sensors.
If the episode is random and not repeated in the time, cancel the error and continue the production.

If the error shows up more than once, the user must find the reason.
Proceed as follows to solve the problem:
- Check the presence of electrical noise on power Three-Phase Line of the machine.
- Check the functionality of the Earth installation of the machine and the correct connection to Ground of the

yarn Creel.
- Check the presence of disturbances on the Ground of the machine (0 Vdc).
- Check the functionality of the Yarn sliding sensors and their correct connection.
  The malfunction of a sensor can cause this error.
- Check the wiring that connect the Pcb_2008 board to the sensors (shielded cable with 0 Vdc and shield to Ground).
- Perform a new sensors identification and a new Learning of the sock.

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Reference

Furthers informations are available in :
GUIDE OF USER INTERFACE
1. Identification of sensors

Sc14: Serial sensors too slow

This error alerts the user that, during the Learning or Control phases, one or more sensors does not respond to the software signals within the time limit.
After this error the software puts the Yarn Sliding system in Suspension status.
By erasing the error the machine can continue the sock production, of course without the Yarn sliding control active.
The next sock the Yarn Sliding system back in the Status above the Suspension.

Sometimes the error appears if there are communication problems between the Pcb_2008 board and the sensors.
If the episode is random and not repeated in the time, cancel the error and continue the production.

If the error shows up more than once, the user must find the reason.
Proceed as follows to solve the problem:
- Check the presence of electrical noise on power Three-Phase Line of the machine.
  They could be induced by motors, fans or other electrical equipment.
- Check the functionality of the Earth installation of the machine and the correct connection to Ground of the yarn Creel.
- Check the presence of disturbances on the Ground of the machine (0 Vdc).
  They could be induced by coupling of a Ground cable with the Motor cable.
- Check the functionality of the Yarn sliding sensors and their correct connection.
  The malfunction of a sensor can cause this error.
  Find the defective sensors and replace them.
  Perform a new sensors identification and a new Learning of the sock.
- Check the wiring that connect the Pcb_2008 board to the sensors (shielded cable with 0 Vdc and shield to Ground).
- Replace the board Pcb_2008.

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Sc17: Too many irq on reception

This error alerts the user that the software has received too many IRQ (interrupt) in communication with the DSP.
This problem is probably due to a software failure, and it is supposed it will never be displayed to the user.
It may appear if for any reason the sensors shall communicate not correct information to the software.
- Perform a Reset of the sensors and then and turn off and on the machine.
  Perform a new sensors identification and a new Learning of the sock.

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Reference

Furthers informations are available in :
GUIDE OF USER INTERFACE
1. Yarn control configuration
2. Identification of sensors

Messages on the configuration/learning of the Yarns sliding

Sc8: Sensors FLASH failure. Do identify

This error alerts the user that the identification data of the Yarn Sliding sensors stored in the FLASH memory (Setup) are not valid.
- Perform a new sensors Identification.

This error appears only when turning on the machine, each time the data in FLASH memory are not valid or don't correspond to the connected sensors.

Reference

Furthers informations are available in :
GUIDE OF USER INTERFACE
1. Identification of sensors

Sc15: Configuration wrong, serial sensor N. "x"

This error alerts the user that the internal configuration of a certain sensor (Nr. xx) is different from the one stored in the FLASH memory during the last configuration.
This can occur for example, if a sensor has been replaced without following the proper Identification procedure.
- Perform a new sensors Identification.

Reference

Furthers informations are available in :
GUIDE OF USER INTERFACE
1. Identification of sensors

Sc25: Parameters out of range sensor N. "x"

This error alerts the user that the configuration present in FLASH memory (Setup) of a certain sensor shows values that are out of the range foreseen by the software, or however not correct.
This occurs when the user, during the the operation of "Filters" and "Parameters" configuration for the Yarn sliding sensors, writes a value beyond the limits set for that.
Also a bad initialize in memory of data relative the Yarn Sliding may cause this problem.
- The solution is to enter the configuration window and set the parameters of the specific sensor to the correct value.

Reference

Many information about the meaning and the detailed rules for the modify of the various configuration parameters relating to the yarn Sliding management are available in:

GUIDE OF USER INTERFACE
1. Yarns sliding
2. Sensors filters configuration
3. Sensors parameters configuration

Sc26: Added sensor not identified

This error alerts the user that was connected a new Yarn Sliding sensor without carrying out the Identification.
If the software is able to recognize that a sensor has been added, this error will appear.
Otherwise a configuration error may appear regarding the specific sensor, it depends on the position where has been inserted the sensor.
In these cases, the software detects an unusual conditions, and therefore could display errors not due to a real cause.
- Perform a new sensors Identification.

Notice

Attention

In the machine software are available 2 operations for the Yarns Sliding.
A “Lonati Management” and a “Special Management”.
A function in the Yarn Sliding Setup allows to enable the “Special Management”.
Currently, with the Yarn sliding sensors of BTSR type is used the “Special Management”.
With the “Lonati Management” enabled the algorithm of control of this error is different.

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GUIDE OF USER INTERFACE
1. Identification of sensors

Messages on faulty of the serial sensors

Sc18: Transistor of stop broken, sensor N. “x”

This error alerts the user that an internal component of the sensor is damaged.
- Replace the sensor shown in the error.
  Perform a new sensors identification and a new Learning of the sock.

Proceed as follows if the error persists:
- Check the wiring that connect the Pcb_2008 board to the sensors (shielded cable with 0 Vdc and shield to Ground).
- Check the functionality of the Yarn sliding sensors and their correct connection.
  The malfunction of a sensor can cause this error.
  Find the defective sensors and replace them.
  Perform a new sensors identification and a new Learning of the sock.
- Perform a Reset of the sensors and then and turn off and on the machine.
  Perform a new sensors identification and a new Learning of the sock.

Notice

Attention

In the machine software are available 2 operations for the Yarns Sliding.
A “Lonati Management” and a “Special Management”.
A function in the Yarn Sliding Setup allows to enable the “Special Management”.
Currently, with the Yarn sliding sensors of BTSR type is used the “Special Management”.
With the “Lonati management” enabled, this error is not managed.

Reference

Furthers informations are available in :
GUIDE OF USER INTERFACE
1. Yarn control configuration
2. Identification of sensors

Sc19: Optical blinded sensor N. "x"

This error alerts the user that the sensor is struck by a strong light that could compromise its eventual reading of the yarn movement.

- Make sure that the light source does not hit the sensor.
- Replace the sensor shown in the error.
  Perform a new sensors identification and a new Learning of the sock.

Proceed as follows if the error persists:

- Check the wiring that connect the Pcb_2008 board to the sensors (shielded cable with 0 Vdc and shield to Ground).
- Check the functionality of the Yarn sliding sensors and their correct connection.
  The malfunction of a sensor can cause this error.
  Find the defective sensors and replace them.
  Perform a new sensors identification and a new Learning of the sock.
- Perform a Reset of the sensors and then and turn off and on the machine.
  Perform a new sensors identification and a new Learning of the sock.

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Attention

In the machine software are available 2 operations for the Yarns Sliding.
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A function in the Yarn Sliding Setup allows to enable the "Special Management".
Currently, with the Yarn sliding sensors of BTSR type is used the "Special Management".
With the "Lonati management" enabled, this error is not managed.

Reference

Furthers informations are available in :
GUIDE OF USER INTERFACE
1. Yarn control configuration
2. Identification of sensors

Sc20: Optical dirty sensor N. "x"

This error alerts the user that the sensor is obscured by dirt that could compromise its eventual reading of the yarn movement.
The sensor communicates to be in the condition of "dirty optical" when it is still able to read the yarn movement, especially if the yarn has a big dimension.
Therefore the software doesn't stop the machine immediately, but it waits 250 consecutive readings with "dirty optical".
This in order to avoid the early appearence of the error, in fact when the reading becomes impossible for the dirt, the machine still will display the "Broken Yarn" error.

- The solution is: clear the sensor.
- Replace the sensor shown in the error.
  Perform a new sensors identification and a new Learning of the sock.

Proceed as follows if the error persists:

- Check the wiring that connect the Pcb_2008 board to the sensors (shielded cable with 0 Vdc and shield to Ground).
- Check the functionality of the Yarn sliding sensors and their correct connection.
  The malfunction of a sensor can cause this error.
  Find the defective sensors and replace them.
  Perform a new sensors identification and a new Learning of the sock.
- Perform a Reset of the sensors and then and turn off and on the machine.

Perform a new sensors identification and a new Learning of the sock.

Notice

Attention

In the machine software are available 2 operations for the Yarns Sliding.
A “Lonati Management” and a “Special Management”.
A function in the Yarn Sliding Setup allows to enable the “Special Management”.
Currently, with the Yarn sliding sensors of BTSR type is used the “Special Management”.
With the “Lonati management” enabled, this error is not managed.

Reference

Furthers informations are available in :
GUIDE OF USER INTERFACE

1. Yarn control configuration
2. Identification of sensors

YARN

```
Ya1: Modify executable with key in prog. pos.
Ya2: None active program
YAuE01: Manual disabling YOYO "x"
```

Messages on various Management and Operations

Ya1: Modify executable with key in prog. pos.

This message informs the user that the attempted operation is only possible with the key selector in position of:
- PROGRAMMING -
In this case the operation tempted is on the modify of certain data.
Press the [F8] key to cancel the error.
Perform the operation with the Key in the correct position.
In this case is neccessary to bring the Sock Cycle to the End of Cycle step.

Ya2: None active program

This message appears in entering working, when no Sock program was previously activated.

- Return in Programming status and activate a valid program.

YAuE01: Manual disabling YOYO "x"

The YOYO motor is equipped with a button to the single YOYO disabling, by pressing the button, the motor is immediately disabled.
In general the user disables the YOYO motor manually when has problems (yarn rupture, etc.), but will however continue the sock up to End of Cycle, and then restore its correct functioning.
If a YOYO motor was disabled, when the machine reaches the End of Cycle is displayed this message.
The user is advised that th indicated has been disabled, and is advisable its manual rehabilitation.
In case the user will eliminate the error without rehabilitate the YOYO, to each End of Cycle the machine will stop with this message.
If the user does not want more use the YOYO motor will use the disabling functions in the menu aboard the machine.

Alarm

CHAIN

Ch11: Setup elements number not correct
Ch6: BIT CONFIGURATION NOT OK
Ch1: LINK FULL
Ch2: End of heel programmed in wrong direction
CHuA08: Function code unknown
CHuA10: Closed toe not possible see the prog.
CHuA11: Wide heel not possible see setup or prog.
CHuA12: Jacquard not possible see setup or prog.
CHuA19: Sock extraction logic and seaming disabled
CHuA20: Data in programme for extr.-seaming incorrect
Ch3: DISPACH FUNCTION NOT ALLOWED
Ch4: DISPACH DIRECT OPERATION WRONG
Ch5: Output EV pneumatic error
Ch7: Wrong logics number
Ch8: CODIFY INCOMPATIBLE WITH SUBPROGRAM CATE
Ch9: Codify not compatible SW Sub-program EFUN
CHuA14: Too many commands per piatto gf
CHuA01: SERIAL OUTPUTS NOT CONFIGURED
CHuA02: General Serial outputs
CHuA03: ERROR MISSING ON SERIAL OUTPUTS
CHuA04: SERIAL BARS SAVED. SWITCH MACH. OFF
CHuA05: SERIAL BARS SAVING ERROR. WRONG WRITING
CHuA07: Missing 24 VDC external serial line
CHuA09: Hook forced motor saw
CHuA15: Cutter engage proximity in an incorrect position

Internal software failure

Ch11: Setup elements number not correct

This alarm refers to internal software management.
This particular alarm is detected by this specific “Task”.
This problem is probably due to a software failure, and it is supposed it will never be displayed to the user.

Notice

Attention

Contact Lonati technical staff for further information and for an eventual Software update.

Ch6: BIT CONFIGURATION NOT OK

This alarm appears when the software notes a situation not expected during a status passage internal to the machine software (incorrect values for registers or data).
This particular alarm is detected by this specific “Task”.
The cause could be an anomaly in the the main microprocessor functioning of the Pcb_2007 board.

Notice

Attention

Before replacing the boards or intervening in any way:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Messages on Programming and Setup

Ch1: LINK FULL

This alarm appears when the software is too slow to empty the “buffer” of “LINK”.
Practically there are too many operations to be made at a certain speed, which is not able to complete them, so the machine is blocked with this alarm.

- The only solution is to decrease the functions implemented in the chain step where appears the alarm (placing them if possible in others step) or lower the speed in that point.

Another cause is the not “UNLINKING” of a function, for a programming error.
A typical example is, in a sock cycle, have programmed the function “Enable sock passsage”, but not have programmed the function “Control sock passage”.
After a certain numbers of Sock this alarm will appear.

In general these situations of incorrect programming are intercepted (alerts or errors) in the program coding by GRAPHITRON and therefore should not happen to the user during the Sock Cycle.

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Ch2: End of heel programmed in wrong direction

This alarm appears, in Working enter, when the software detects a programming error in the “Heel” or “Toe” block (Zona).
This happens when the user has programmed the “Heel” or “Toe” function in a wrong step (step belonging to the back motion).

- The solution is correct the programming (GRAPHITRON), thus eliminating the problem.

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

CHuA08: Function code unknown

This alarm indicates incompatibility between the programming software (GRAPHITRON) and the machine software (Eproms).
The alarm appears during the Sock Cycle, when the “Codified Program” recalls for a function not existing in the machine software.

The following deduction is that the machine software version (“eprom machine”) is previous to the programming software version (GRAPHITRON).
This because the programming software (GRAPHITRON) is in continuos eveolution, for the implementation of new operative functions and new machine devices.
As is possible this software is kept compatible with the machine of the same type but of previous model.
Obviously may not use on these machines the new features included in GRAPHITRON to less than run a software update of the machines.

Sometimes, is not possible to upgrade the machine software, depends on the evolution of the machine model.
For example, one same machine model, in its evolution, may be available with electronic equipment of type very different.
Some new devices or new functionality may not be implemented in machines with electronic and mecahnica equipment very backlog compared to the new model.
However the same programming software (GRAPHITRON) may be used on machines of the same basic model, but with a different equipment, derived by the electronic and mechanical evolution.
The warning is however not to use in the Sock Program functions implemented after the date of “End production” for that particular machine model.

Proceed as follows to solve the problem:

- Find the function used in the Sock Program and not present in the machine software, checking all the functions present in the chain step where the alarm is appeared.
- Remove from the Sock Program the function not existing in the machine software.

Contact the Lonati technical staff and be informed if there is a machine software version (“eprom machine”) more recently that implements the missing function.
Also to report the specific machine model (equipment) so that is possible to assess the possible availability and compatibility of the machine software.
Also evaluate that the machine is mechanically prepared for the function (device) that is to be used.

- If the conditions above are satisfied, an update of the machine software is possible.
  Request an estimate to Lonati and eventually order the necessary material.

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

CHuA10: Closed toe not possible see the prog.

This alarm is displayed when, on Sock Program activation, the software detects a difference between the type of “Article” in the Coded Program and that under machine Setup.
In particular, the “Codified Program” requires the functioning with the “Closed Toe” while the machine is not prepared (Setup).

This type of control is used to avoid mechanical problems, in case of special predispositions of the machine, necessary for the production of a certain “Article” (special type of Sock).
In fact, if these special predispositions prevent the production of a normal sock, we need to prevent the user for the possibility of using a Sock Program not valid for the mechanical condition of the machine.
A machine so modified may not be used for the production of a Normal Sock, and vice versa.
The software controls the compatibility between the value set in the machine Setup and the value inserted in the Sock Program (Codified Program).

The User should check the type of machine “article” set in the Sock Program and compare it with the one set in the machine Setup.

- If it doesn’t corresponds, correct the Sock Program by GRAPHITRON.
- If it corresponds, access to the machine Setup and set the correct value.

A typical situation in which may appear this problem is a result of a Setup Reset or replacement of the Pcb_2007 board.

- In both cases the user is obliged to set again the Setup, with the possibility of oversight or error in the set of this value.

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

CHuA11: Wide heel not possible see setup or prog.

CHuA12: Jacquard not possible see setup or prog.

This alarm is displayed when, on Sock Program activation, the software detects a difference between the type of “Article” in the Coded Program and that under machine Setup.

This type of control is used to avoid mechanical problems, in case of special predispositions of the machine, necessary for the production of a certain “Article” (special type of Sock).
In fact, if these special predispositions prevent the production of a normal sock, we need to prevent the user for the possibility of using a Sock Program not valid for the mechanical condition of the machine.

A machine so modified may not be used for the production of a Normal Sock, and vice versa.
The software controls the compatibility between the value set in the machine Setup and the value inserted in the Sock Program (Codified Program).

The User should check the type of machine “article” set in the Sock Program and compare it with the one set in the machine Setup.

- If it doesn’t corresponds, correct the Sock Program by GRAPHITRON.
- If it corresponds, access to the machine Setup and set the correct value.

A typical situation in which may appear this problem is a result of a Setup Reset or replacement of the Pcb_2007 board.

- In both cases the user is obliged to set again the Setup, with the possibility of oversight or error in the set of this value.

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

CHuA19: Sock extraction logic and seaming disabled

This information only applies to the following models:
External Toe Closed
The message indicates that the following item is not enabled under Setup:
Sock extraction and seaming
To this end, refer to the menu:
-DEDICATED DEVICES

In practice:
The message indicates that you want to activate a Sock Programme containing functions associated with the use of the deactivated device.

The solution is correct the programming (GRAPHITRON), thus eliminating the problem.
Or:
Enable under Setup the device recalled by the Sock Programme.

This alarm is displayed when, on Sock Program activation, the software detects a difference between the type of “Article” in the Coded Program and that under machine Setup.

This type of control is used to avoid mechanical problems, in case of special predispositions of the machine, necessary for the production of a certain “Article” (special type of Sock).
In fact, if these special predispositions prevent the production of a normal sock, we need to prevent the user for the possibility of using a Sock Program not valid for the mechanical condition of the machine.
A machine so modified may not be used for the production of a Normal Sock, and vice versa.
The software controls the compatibility between the value set in the machine Setup and the value inserted in the Sock Program (Codified Program).

The User should check the type of machine “article” set in the Sock Program and compare it with the one set in the machine Setup.

- If it doesn’t corresponds, correct the Sock Program by GRAPHITRON.
- If it corresponds, access to the machine Setup and set the correct value.

A typical situation in which may appear this problem is a result of a Setup Reset or replacement of the Pcb_2007 board.

- In both cases the user is obliged to set again the Setup, with the possibility of oversight or error in the set of this value.

CHuA20: Data in programme for extr.-seaming incorrect

This information only applies to the following models:
External Toe Closed
This problem is probably due to a software failure, and it is supposed it will never be displayed to the user.
The cause of this problem can only be a wrong user programming by GRAPHITRON.

In general these situations of incorrect programming are intercepted (alerts or errors) in the program coding by GRAPHITRON and therefore should not happen to the user during the Sock Cycle.
Therefore:
The solution is to correct the Program.

Messages on problems in the Software Management

Ch3: DISPACH FUNCTION NOT ALLOWED

This alarm refers to internal software management.
This alarm appears when a machine software error (custom) occurs in coding functions of the following type:
[31]
It appears in the step where is programmed the function which determines the Software problem.
This problem is probably due to a software failure, and it is supposed it will never be displayed to the user.

Notice

Attention

Contact Lonati technical staff for further information and for an eventual Software update.

Ch4: DISPACH DIRECT OPERATION WRONG

This alarm refers to internal software management.
This alarm appears when a machine software error (custom) occurs in coding functions of the following type:
[30]
It appears in the step where is programmed the function which determines the Software problem.
This problem is probably due to a software failure, and it is supposed it will never be displayed to the user.

Notice

Attention

Contact Lonati technical staff for further information and for an eventual Software update.

Ch5: Output EV pneumatic error

This alarm refers to internal software management.
This alarm appears when a machine software error (custom) occurs in coding functions of the following type:
[7]
It appears in the step where is programmed the function which determines the Software problem.
This problem is probably due to a software failure, and it is supposed it will never be displayed to the user.

Notice

Attention

Contact Lonati technical staff for further information and for an eventual Software update.

Ch7: Wrong logics number

This alarm refers to internal software management.
This alarm appears when a machine software error (custom) occurs in:
- implementation of the logic of operation.

It appears in the step where is programmed the function which determines the Software problem.
This problem is probably due to a software failure, and it is supposed it will never be displayed to the user.

Notice

Attention

Contact Lonati technical staff for further information and for an eventual Software update.

Ch8: CODIFY INCOMPATIBLE WITH SUBPROGRAM CATE

Ch9: Codify not compatible SW Sub-program EFUN

This alarm indicates incompatibility between the programming software (GRAPHITRON) and the machine software (Eproms).

- The solution, depending on the case, is to update the machine software (Eproms) or the GRAPHITRON software.

Other causes for this problem may be the machine software or programming software not valid because damaged or containing a mistake.

- Also in this case, the solution is to run the software update with a valid and compatible version.

Notice

Attention

Contact Lonati technical staff for further information and for an eventual Software update.

CHuA14: Too many commands per piatto gf

This alarm refers to internal software management.
It appears when, following subsequent commands of [Raiser] and [Lower] the Yarn-fingers Plate carried out by the user, the software is unable to complete correctly the operations.
Practically, this is a control to check if the sequence were lost commands.
This problem is probably due to a software failure, and it is supposed it will never be displayed to the user.

Notice

Attention

Contact Lonati technical staff for further information and for an eventual Software update.

Messages on the I/O Serial Line

CHuA01: SERIAL OUTPUTS NOT CONFIGURED

This message appears in entering working, when the “I/O serial outputs” are not configurated.
This may happens: after the first turning on the machine, after the cancellation of the machine Setup or the replacement of the Pcb_2007 board, after the “I/O serial otputs” Reset.
For the operation of the machine is necessary learning the quantity and the position of outputs with a load connected, operation that is carried out by the “Acquisition I/O serial otputs” procedure.

- The solution of the problem is to perform a new acquisition of the “I/O serial ouputs”.

Notice

Attention

The quantity and position of the “bars” (serial outpus boards) is set in the appropriate Setup heading.
This data must correspond to the actual layout (assembly) available on the machine.
Normally this “bars” setting is already right as the default provided in the software (“eprom custom”) is set the value as used for the machine.

Reference

Furthers informations are available in :
GUIDE OF USER INTERFACE

1. Customer configuration
2. Bars configuration
3. Outputs self-configuration
4. -ERRORS

5. -ALARMS

CHuA02: General Serial outputs

This alarm indicates that the Inputs/Outputs Serial Line is not working.
This is a generic error, does not indicate with precision the cause of the problem.

Reference

For checks relating to these types of error refer to the section:
I/O Serial line

CHuA03: ERROR MISSING ON SERIAL OUTPUTS

This alarm refers to internal software management.
This alarm appears when a machine software error (custom) occurs in:
- coding of the error messages.

This problem is probably due to a software failure, and it is supposed it will never be displayed to the user.

Notice

Attention

Contact Lonati technical staff for further information and for an eventual Software update.

CHuA04: SERIAL BARS SAVED. SWITCH MACH. OFF

This alarm appears at the end of the operation ofConfiguration or Reset of the Setup data relative the “Bar of the serial outputs”.
The user is also obliged by the alarm to turn off the machine.
The next time the machine will be turned on it is working with the new Learning of the Outputs connected.
In case of Reset instead, no Learning will become available, then the erial Outputs configuration will be missing.
In this casee, must then running a new acquisition of the “Serial I/O”.

Reference

Furthers informations are available in :
GUIDE OF USER INTERFACE
1. Customer configuration
2. Outputs self-configuration
3. -ERRORS

CHuA05: SERIAL BARS SAVING ERROR. WRONG WRITING

This message informs the user of the failed saving of the Setup configuration to the FLASH memory of board Pcb_2007.
Practically, after performing the Acquisition or Reset of the “Serial I/O”, the operation has not been successful , and the data are not saved.
The most common causes that determine this problem are:
- An hardware malfunction of the board Pcb_2007.
  Replace the board Pcb_2007.
- A wrong size in the Software of the space available for data saving, or however in general a problem in the machine software.

Notice

Attention

Before replacing the boards or intervening in any way:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Reference

Furthers informations are available in :
GUIDE OF USER INTERFACE
1. Customer configuration
2. Outputs self-configuration
3. -ERRORS

CHuA07: Missing 24 VDC external serial line

Equipment with Pcb 3868 (1st version).

The control signal is interfaced by the Pcb 3868 board.

Signal generation:	Pcb_3759	
Signal path:	Pcb_3759 conn. J2 pin 02-03	Pcb_3868 conn. J3 pin 01-04
Signal path:	Pcb_3868 conn. J4 pin 05	Pcb_2008 conn. J9 pin 02
Signal input:	Pcb_2008 J09 p02	

Equipment without Pcb 3868 (2nd version).

The control signal reaches directly the Pcb_2008 board.

Signal generation:	Pcb_3759	
Signal path:	Pcb_3759 J02 p02	Pcb_2008 J09 p02
Signal input:	Pcb_2008 J09 p02	

This alarm appears when from the external board Pcb_3759 not arrives to the board Pcb_2008 the signal of “CHECK 24 Vdc” (return of the signal of control on the correct presence of the tension 24 VDC Serial).
The path of this control signal depends on the hardware equipment version.

The external board Pcb_3759 is powered with the voltage “24 Vdc Serial”.
This voltage is then used by the “Outputs” command boards connected to the board itself.
From these “Output” boards a return signal shall communicate to the board that the voltage 24 Vdc is present.
Also are present connectors where is available this voltage (protected by a PTC) for connecting of external devices.
A circuit of control on the Pcb_3759 board processes all the control signals and return to the Pcb_2008 board a signal that in normal conditions is roughly +24 Vdc.
It indicates that the voltage 24 Vdc is available to all the external boards.
Otherwise appears this alarm.

In case of error check the voltage 24 Vdc in input to the I/O external interface board (Pcb_3759 J02 p01 p04).

If there is no 24VDC voltage, the problem is due to the equipment providing the power supply, so:

- *Check the integrity of the cable that connects the board Pcb_3759 to the Morsettiera internal the equipment.*
- *Check the integrity of the F4 on the Morsettiera.*
- *Check the presence of the volatge 24 Vdc on the Morsettiera.*
  It comes from the power supply board Pcb_3787B/1.

If the voltage is correct, the device correctly powers the external I/O board, so:

- *Check the signal “CHECK 24V” on the Pcb_3759 board.*
  It must have the value of approximately 24 Vdc.

If the signal is correct (about 24 VDC), the problem has not an external cause, so:

- *Check the wiring of these control signals between the boards previously indicated in the path.*
- *Replace the board Pcb 3868, if present.*
- *Replace the board Pcb_2008.*

If the signal is not correct (no 24 VDC), the problem has an external cause, so:

- *Check the position of the Jumpers present on the Pcb_3759 board, compare them with those of a machine equal and working correctly.*
- *Check the integrity of the fuses present on the Pcb_3759 board.*
  In case of fuse broken assess if a manual operation on the external boards of the Serial Ou-

tputs with the machine turned on may have caused a short-circuit on powers.
Replace any fuse broken and check the functionality of the board.

- *Replace the board Pcb_3759.*
- *Check if the return +24 Vdc signal from the "Outputs External Bars" is correct.*
  Otherwise check the cables between the Bars and the Pcb_3759 board.
  Check the correct operation of the "Bars" (Output boards), evetually replace them.
  Check that there are not present short-circuits between the power supply (+24 Vdc) and the Ground.

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

In fact an alarm of this type may be due to broken boards (Serial outputs boards) caused by the behaviour of users.
For Example operate on the Serial Outputs boards or on Solenoid valves to their related when the machine is turned on.
This behavior may cause the damage of various boards (cascade), with difficulties of the user in precise identification of the problem.
It is also possible that the replacement of a single board, with the other connected boards damaged, cause the rupture of the replaced board.
Therefore not make any further substitutions of boards without having first contacted the Lonati/Dinema technical staff.

Messages on the Saw management

CHuA09: Hook forced motor saw

This message refers to the operation of the motorized "Saw".
It may appear when is performed a Release or Hook of the "Saw".
The software in this point change modes of command of the "Saw" motor to perform this operation.
If during this transition the software detects a problem on the CAN management is displayed this message.
This problem is probably due to a software failure, and it is supposed it will never be displayed to the user.

In case of the occurrence of this error after a Software Update.

- *Run again the Updating procedure, is possible that the copy operation of Software in FLASH memory is not carried out correctly.*

Even if not specific with respect to the real problem, this error may appear in the event of an hardware problem (a fault):

- *To any CAN module.*
- *To the board Pcb_2008.*
- *To the wirings between these boards.*

- A problem in the software writing, an hardware problem on the CAN boards, a disorder on the CAN transmission:
  All these conditions may cause CAN Errors/Alarms not related to the real failure, but General of the CAN system.

Therefore in general, for all the CAN Errors/Alarms, after having evaluated the specific problem indicated by error, also to assess as a possible cause a general problem of the CAN system (software and hardware).

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

CHuA15: Cutter engage proximity in an incorrect position

Sensor input:
Pcb_3759 J14 p01

Command output:
G54JCT: въ16 e7 — GL-544CT: въ16 e7 — GL-61QCT: въ16 e7

The input board for this signal is Pcb_3759.

This message exists in the only machine prepared with “Traditional Closed Toe”.
This message concerns control of the Release/Hook procedure, i.e. detachment and return of movement transmission between Cylinder and Saw (Dial).
This movement is determined by the command that reaches the relative Solenoid Valve.
The control is carried out through the signals given by the sensor:
Rephaser engage stage stop prox.switch
This sensor check the integrity of one of gears that are part of the “Phase control” device used in the procedure for the Dial Phase Control.
This sensor is placed in reading on a special gear, the sequence of Reading (empty and full) is controlled by the software.
The lack of respect of these sequences, depending on the controlled movement, determines the appearance of a specific error/alarm message.

This alarm appears both during the Release procedure that during the Hook procedure, if the sensor is detected in a not correct status during or at the end of the Release/Hook sequence.

The likely cause of the problem is:
The rupture of the gear.
This prevents any next procedure of restoration.
The User is forced to turn off the machine and solve the mechanical problem.

Outside of the procedure of Phase control the sensor is positioned so that not read the passage of any mechanical part.
The right status of the sensor in this phase is:
Input status = “Open”.
Autotest = “0”.
Otherwise appears this alarm.
The appearance of this message in this phase is typically an electrical problem, therefore:
- Replace the sensor.
- Replace the Input board.

In addition to the specific mechanical malfunction just described, this problem may have other causes.
In general, the problem is due to:
- Mechanical malfunction of the device (not reached the intended position).
- Slow response of the solenoid valve of command.
- Sensor adjustment not correct.
- Malfunction of the sensor.

Reference

For the information on the procedure of Toe Closure see the heading:
Dial management for Traditional Toe Closure procedure

CONSOLE

```
Co10: Setup elements number not correct
Co1: Data saved. Switch machine OFF
Co2: Setup data saving in FLASH impossible
Co3: Reset FLASH setup done. Switch mach. OFF
Co4: Linking program incompatible
Co5: Buffer manual MPP commands is full
Co9: Machine setup reloading from flash,failed
Co6: Calibration saving OK. Switch off machin
Co7: Calibration saving impossible
Co8: Reset Eeprom calibration OK. Switch off machin
COuA01: Numeration CAN Impossible
COuA02: Numeration CAN Incomplete
COuA03: Numeration YOYO Impossible
COuA04: Numeration YOYO Incomplete
```

Internal software failure

Co10: Setup elements number not correct

This alarm refers to internal software management.
This particular alarm is detected by this specific “Task”.
This problem is probably due to a software failure, and it is supposed it will never be displayed to the user.

Notice

Attention

Contact Lonati technical staff for further information and for an eventual Software update.

Messages on operations in FLASH

Co1: Data saved. Switch machine OFF

This alarm generally appears at the end of the operation of Setup configuration, after the request of saving of the modify data.
The user is also obliged by the alarm to turn off the machine.
The next time the machine will be turned on it will use the data previously saved.

Co2: Setup data saving in FLASH impossible

This message informs the user of the failed saving of the Setup configuration to the FLASH memory of board Pcb_2007.
Practically, after leaving the Setup menu with a request for data saving, the oparation not successful and the data are not saved.
The most common causes that determine this problem are:

- An hardware malfunction of the board Pcb_2007.
  Replace the board Pcb_2007.
- A wrong size in the Software of the space available for data saving, or however in general a problem in the machine software.

Notice

Attention

Before replacing the boards or intervening in any way:

Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Co3: Reset FLASH setup done. Switch mach. OFF

This message appears after the execution of an operation of Setup Reset.
The user is also obliged by the alarm to turn off the machine.
The next time the machine will be turned on all the data relative to the Setup configuration will have been deleted.
An error message will inform the user that the Setup data were lost and that is necessary to run a new Setup.
In the meantime will be used the standard values (DEFAULT) available in the software (“eprom custom”).

Reference

Furthers informations are available in :
GUIDE OF USER INTERFACE
1. Machine Setup

Messages on problems in the Software Management

Co4: Linking program incompatible

This alarm indicates incompatibility between the programming software (GRAPHITRON) and the machine software (Eproms).
The problem appears, when during the execution of a Link Program, is activated a Sock Program incompatible with the version of the machine software.

- The solution, depending on the case, is to update the machine software (Eproms) or the GRAPHITRON software.

Of course in the case of GRAPHITRON updating the Sock Program must be coded again.

Other causes for this problem may be the machine software or programming software not valid because damaged or containing a mistake.

- Also in this case, the solution is to run the software update with a valid and compatible version.

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Co5: Buffer manual MPP commands is full

This alarm refers to internal software management.
This particular alarm indicates that the internal structure of the software that holds the manual controls relating the stepping motors (Buffer commands) is full; it is not able to accept other commands.
This problem is probably due to a software failure, and it is supposed it will never be displayed to the user.

Co9: Machine setup reloading from flash,failed

This alarm appears if, during an operation of Setup configuration, the attempt to read the Setup in the FLASH memory of the Pcb_2007 board fails.
In practice the software must re-read the values present in FLASH memory and then write them in RAM memory.
The most common causes that determine this problem are:

- An hardware malfunction of the board Pcb_2007.
  Replace the board Pcb_2007.
- A wrong size in the Software of the space available for data saving, or however in general a problem in the machine software.

Notice

Attention

Before replacing the boards or intervening in any way:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Messages on the Stitch Cams calibration

Co6: Calibration saving OK. Switch off machin

This particular message is relative the “Stich Cam self-calibration” procedure.
This alarm generally appears at the end of the operation of Setup configuration, after the request of saving of the modify data.
The user is also obliged by the alarm to turn off the machine.
The next time the machine will be turned on it will use the data previously saved.

Co7: Calibration saving impossible

This particular message is relative the “Stich Cam self-calibration” procedure.
This message informs the user of the failed saving of the Setup configuration to the FLASH memory of board Pcb_2007.
Practically, after leaving the Setup menu with a request for data saving, the oparation not successful and the data are not saved.
The most common causes that determine this problem are:

- An hardware malfunction of the board Pcb_2007.
  Replace the board Pcb_2007.
- A wrong size in the Software of the space available for data saving, or however in general a problem in the machine software.

Notice

Attention

Before replacing the boards or intervening in any way:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Co8: Reset Eeprom calibration OK. Switch off machin

This particular message is relative the “Stich Cam self-calibration” procedure.
This alarm appears after an operation to Reset the “Stich Cam self-calibration” Setup data.
The user is also obliged by the alarm to turn off the machine.
The next time the machine will be turned on all the data relative to the Setup configuration will have been deleted.
The next “Turning on” the machine a message warns the user that the “Self-calibration” is missing, is necessary to run an access to the “Self-calibration” procedure and perform at least a data saving.

Reference

Furthers informations are available in :
GUIDE OF USER INTERFACE

1. Stitch cams self-calibration

Messages on the CAN Numbering

COuA01: Numeration CAN Impossible

This alarm is displayed during or at the end of the “CAN module numbering” procedure when the software detects an error.
The user is therefore warned that has been detected a problem during the operation.

- Turn off and on the machine, then repeat the Numbering procedure.

Reference

Furthers informations are available in :
GUIDE OF USER INTERFACE
1. Numeration motor CAN

COuA02: Numeration CAN Incomplete

This alarm is displayed during or at the end of the “CAN module numbering” procedure when the software detects that the procedure has not been completed, and numbers all the modules present.
The user is therefore warned that has been detected a problem during the operation.
- Turn off and on the machine, then repeat the Numbering procedure.

Reference

Furthers informations are available in :
GUIDE OF USER INTERFACE
1. Numeration motor CAN

Messages on the YOYO Numbering

COuA03: Numeration YOYO Impossible

This alarm is displayed during or at the end of the “YOYO motors numbering” procedure when the software detects an error.
The user is therefore warned that has been detected a problem during the operation.
1. Turn off and on the machine, then repeat the Numbering procedure.

Reference

Furthers informations are available in :
GUIDE OF USER INTERFACE
1. YOYO motors numbering

COuA04: Numeration YOYO Incomplete

This alarm is displayed during or at the end of the “YOYO motors numbering” procedure when the software detects that the procedure has not been completed, and numbers all the modules present.
The user is therefore warned that has been detected a problem during the operation.
- Turn off and on the machine, then repeat the Numbering procedure.

Reference

Furthers informations are available in :
GUIDE OF USER INTERFACE
1. YOYO motors numbering

DRUM

```
Dr4: Drums number is wrong
Dr5: Drums subprogram missing
Dr6: Stitches subprogram missing
Dr12: Yarnfinger subprogram missing
Dr13: Number of colour yarnfinger feeds wrong
Dr20: Codify incompatible SW subprogram JACQ
Dr21: Codify incompatible SW subprogram GUID
Dr2: Stitch loading not completed
Dr7: Drum task too slow
Dr14: Colour yarnfinger logic too slow
Dr16: Yarnf. control buffer loading not completed
Dr9: Program needles number not correct
Dr11: Too many patterns overlapped
Dr15: Too many patterns on same course
Dr17: Colour yarnfinger patterns overlapped
Dr19: Device of colour finger logic not expected
Dr24: Too many commands single feed colour fng. on same course
Dr22: Setup elements number not correct
Dr10: BIT CONFIGURATION NOT OK
```

Messages on problems in the Software Management

Dr4: Drums number is wrong

This alarm indicates incompatibility between the programming software (GRAPHITRON) and the machine software (Eproms).
In this case the number of Pattern Drums coded in the Sock Program is greater than the maximum possible set in the machine software.

- The solution, depending on the case, is to update the machine software (Eproms) or the GRAPHITRON software.

Other causes for this problem may be the machine software or programming software not valid because damaged or containing a mistake.

- Also in this case, the solution is to run the software update with a valid and compatible version.

Notice

Attention

Contact Lonati technical staff for further information and for an eventual Software update.

Dr5: Drums subprogram missing

Dr6: Stitches subprogram missing

This alarm indicates incompatibility between the programming software (GRAPHITRON) and the machine software (Eproms).
In this case, a part of the software expected by the machine is missing.

- The solution, depending on the case, is to update the machine software (Eproms) or the GRAPHITRON software.

Other causes for this problem may be the machine software or programming software not valid because damaged or containing a mistake.

- Also in this case, the solution is to run the software update with a valid and compatible version.

Notice

Attention

Contact Lonati technical staff for further information and for an eventual Software update.

Dr12: Yarnfinger subprogram missing

This alarm indicates incompatibility between the programming software (GRAPHITRON) and the machine software (Eproms).
In this case, a part of the software expected by the machine is missing.

- The solution, depending on the case, is to update the machine software (Eproms) or the GRAPHITRON software.

Other causes for this problem may be the machine software or programming software not valid because damaged or containing a mistake.

- Also in this case, the solution is to run the software update with a valid and compatible version.

Notice

Attention

Contact Lonati technical staff for further information and for an eventual Software update.

Dr13: Number of colour yarnfinger feeds wrong

This alarm indicates incompatibility between the programming software (GRAPHITRON) and the machine software (Eproms).
In particular, the number of “Color Yarns-Fingers Feeds” coded in the Sock Program is greater than the maximum set in the machine software.

- The solution, depending on the case, is to update the machine software (Eproms) or the GRAPHITRON software.

Other causes for this problem may be the machine software or programming software not valid because damaged or containing a mistake.

- Also in this case, the solution is to run the software update with a valid and compatible version.

Notice

Attention

Contact Lonati technical staff for further information and for an eventual Software update.

Dr20: Codify incompatible SW subprogram JACQ

Dr21: Codify incompatible SW subprogram GUID

This alarm indicates incompatibility between the programming software (GRAPHITRON) and the machine software (Eproms).

- The solution, depending on the case, is to update the machine software (Eproms) or the GRAPHITRON software.

Other causes for this problem may be the machine software or programming software not valid because damaged or containing a mistake.

- Also in this case, the solution is to run the software update with a valid and compatible version.

Notice

Attention

Contact Lonati technical staff for further information and for an eventual Software update.

Messages on the speed of data processing

Dr2: Stitch loading not completed

Dr7: Drum task too slow

This alarm appears when the software in the time given is not able to carry out all the operations expected by the software.
In this case the operation is any managed by task “DRUM”, then relative the “Pattern”.

The most common causes that determine this problem are:
- Pattern very complex for the speed of the machine in that point.
- Speed too high for the article in production.
- Presence of superimposed Patterns in poitnts of the Sock where speed is high.
- Change of Patterns in the poits of motor acceleration (positive speed changes).
- Problems on the Encoder/Resolver counting, there are very close impulses.

First check whether the problem is linked to one of the points listed above.
Therefore lower the speed in the point of the alarm, change the Pattern with one less complex, move the Pattern, etcetera.

If the problem persists:
The cause of the problem must be search in the Hardware chain for the counting management.
Proceed as follows to solve the problem:
- Check the wiring between the Pcb_2008 board and the Motor Drive board.
- Check the wiring between the Motor Resolver and the Motor Drive board.
- Replace the Motor Drive board.
- Replace the board Pcb_2008.
- Replace the motor.
- Replace the resolver.

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Dr14: Colour yarnfinger logic too slow

Dr16: Yarnf. control buffer loading not completed

This alarm appears when the software in the time given is not able to carry out all the operations expected by the software.
In this case the opration not completed is on the “Color Yarn-Fingers” management.

The most common causes that determine this problem are:
- Pattern very complex for the speed of the machine in that point.
- Speed too high for the article in production.
- Presence of superimposed Patterns in poitnts of the Sock where speed is high.
- Change of Patterns in the poits of motor acceleration (positive speed changes).
- Problems on the Encoder/Resolver counting, there are very close impulses.

First check whether the problem is linked to one of the points listed above.
Therefore lower the speed in the point of the alarm, change the Pattern with one less complex, move the Pattern, etcetera.

If the problem persists:
The cause of the problem must be search in the Hardware chain for the counting management.
Proceed as follows to solve the problem:
- Check the wiring between the Pcb_2008 board and the Motor Drive board.
- Check the wiring between the Motor Resolver and the Motor Drive board.
- Replace the Motor Drive board.
- Replace the board Pcb_2008.
- Replace the motor.
- Replace the resolver.

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Messages on Programming and Setup

Dr9: Program needles number not correct

This alarm is displayed when, on Sock Program activation, the software detects a difference between the “Number of needles” in the Coded Program and that under machine Setup.
The user is required to check the “Number of needles” set in the Sock Program and compare it with that shown in the machine identification plate.

- If it doesn’t corresponds, correct the Sock Program by GRAPHITRON.
- If it corresponds, access to the machine Setup and set the correct value.

A typical situation in which may appear this problem is a result of a Setup Reset or replacement of the Pcb_2007 board. In both cases the user is obliged to set again the Setup, with the possibility of oversight or error in the set of this value.

Reference

Furthers informations are available in :
GUIDE OF USER INTERFACE

1. Needles number selection

Dr11: Too many patterns overlapped

This alarm appears when in the Coded Program there are too many superimposed patterns.
Programming of this type should be reported already in the coding by GRAPHITRON.

- The solution is to correct the Program by erasing any excess patterns.

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Dr15: Too many patterns on same course

This alarm appears when in the Coded Program there are too many patterns on the same Course.
Programming of this type should be reported already in the coding by GRAPHITRON.

- The solution is to correct the Program by erasing any excess patterns.

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Dr17: Colour yarnfinger patterns overlapped

This alarm appears when in the Coded Program there are too many superimposed patterns.
Programming of this type should be reported already in the coding by GRAPHITRON.

- The solution is to correct the Program by erasing any excess patterns.

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Dr19: Device of colour finger logic not expected

This alarm appear when in the coded Program are present working not provided in the machine software.
The machine is not prepared for the functioning of the programmed devices.

- The solution is to correct the Program.
  We need to eliminate the working or devices that the machine model does not support.

This message was introduced because the same type of GRAPHITRON may be used to create Sock Programs for different machine models.

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Dr24: Too many commands single feed colour fng. on same course

This alarm appears when in the Coded Program there are too many commands associated to a single “Colour feed” on the same Course.
Programming of this type should be reported already in the coding by GRAPHITRON.

- The solution is to correct the Program by erasing any excess patterns.

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Internal software failure

Dr22: Setup elements number not correct

This alarm refers to internal software management.
This particular alarm is detected by this specific “Task”.
This problem is probably due to a software failure, and it is supposed it will never be displayed to the user.

Notice

Attention

Contact Lonati technical staff for further information and for an eventual Software update.

Dr10: BIT CONFIGURATION NOT OK

This alarm appears when the software notes a situation not expected during a status passage internal to the machine software (incorrect values for registers or data).
This particular alarm is detected by this specific “Task”.
The cause could be an anomaly in the the main microprocessor functioning of the Pcb_2007 board.

Notice

Attention

Before replacing the boards or intervening in any way:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

GFILE

Gf1: OPERATION FINISHED. SWITCH MACH. OFF
Gf5: Writing on flash for file.up update aborted
GFuA38: Failure update SW board CAN MPP
GFuA85: YOYO SW updating failed
GFuA67: ECODD Update failed
GFuA152: 3ENC board SW update failed
Gf2: Flash update program incompatible
Gf3: EPR_CUS: ID module CAN already assigned
GFuA01: CAN Unknown command
GFuA02: CAN Motor actuator module
GFuA76: YOYO command unknown
GFuA65: ECODD Unknown control
GFuA151: 3ENC comand unknown
GFuA77: YOYO module drive
GFuA66: ECODD Generic
GFuA111: CAN in overrun
GFuA112: CAN buffer full
GFuA113: CAN bus off
GFuA86: YOYO device unknown
GFuA08: Tension tall feeding sizing motor
GFuA09: Tension tall feeding vacuum valve
GFuA10: Tension tall feeding sinker cap motors
GFuA11: Tension tall feeding elastic 1
GFuA12: Tension tall feeding sinker cap motors
GFuA13: Tension tall feeding saw blade device
GFuA14: Tension tall feeding elastic 2
GFuA15: Tension tall feeding elastic cad 1
GFuA16: Tension tall feeding straighten welt
GFuA17: Tension tall feeding dial motor
GFuA49: CAN High supply tension PYF 1
GFuA52: CAN High supply tension PYF 2
GFuA55: CAN High supply tension PYF 3
GFuA58: CAN High supply tension PYF 4
GFuA87: High supply voltage Turn.device valve
GFuA91: High supply tension stitch cam feed 1
GFuA95: High supply tension stitch cam feed 2
GFuA99: High supply tension stitch cam feed 3
GFuA103: High supply tension stitch cam feed 4
GFuA107: High supply tension heel return s.c.
GFuA114: Vertical arm supply voltage high
GFuA118: Angle arm supply voltage high
GFuA122: Turn.device down supply voltage high
GFuA126: Turn.device up supply voltage high
GFuA130: Pin feeder supply voltage high
GFuA134: tension tall feeding linker motor
GFuA138: Turn.dev inclin. motor power supply high
GFuA142: Pin unit rotat. motor power supply high
GFuA147: Ext. CT shutter valve power supply high
GFuA18: Power of tall phase sizing motor
GFuA19: Power of tall phase vacuum valve
GFuA20: Power of tall phase sinker cap motors
GFuA21: Power of tall phase elastic 1
GFuA22: Power of tall phase sinker cap motors
GFuA23: Power of tall phase saw blade device
GFuA24: Power of tall phase elastic 2
GFuA25: Power of tall phase elastic cad 1
GFuA26: Power of tall phase straighten welt
GFuA27: Power of tall phase dial motor

GFuA50: CAN High phase current PYF 1
GFuA53: CAN High phase current PYF 2
GFuA56: CAN High phase current PYF 3
GFuA59: CAN High phase current PYF 4
GFuA88: High phase current Turn.device valve
GFuA92: High phase current stitch cam feed 1
GFuA96: High phase current stitch cam feed 2
GFuA100: High phase current stitch cam feed 3
GFuA104: High phase current stitch cam feed 4
GFuA108: High phase current heel return s.c.
GFuA115: Vertical arm phase current high
GFuA119: Angle arm phase current high
GFuA123: Turn.device down phase current high
GFuA127: Turn.device up phase current high
GFuA131: Pin feeder phase current high
GFuA135: power of tall phase linker motor
GFuA139: Turn.dev inclin. motor phase current high
GFuA143: Pin unit rotat. motor phase current high
GFuA148: Ext. CT shutter valve phase current high
GFuA28: Feeding. tall temperature sizing motor
GFuA29: Feeding. tall temperature vacuum valve
GFuA30: Feeding. tall temperature sinker cap motors
GFuA31: Feeding. tall temperature elastic 1
GFuA32: Feeding. tall temperature sinker cap motors
GFuA33: Feeding. tall temperature saw blade device
GFuA34: Feeding. tall temperature elastic 2
GFuA35: Feeding. tall temperature elastic cad 1
GFuA36: Feeding. tall temperature straighten welt
GFuA37: Feeding. tall temperature dial motor
GFuA51: CAN High drive board temp. PYF 1
GFuA54: CAN High drive board temp. PYF 2
GFuA57: CAN High drive board temp. PYF 3
GFuA60: CAN High drive board temp. PYF 4
GFuA89: High actuation temp. Turn.device valve
GFuA93: High drive board temp. stitch cam feed 1
GFuA97: High drive board temp. stitch cam feed 2
GFuA101: High drive board temp. stitch cam feed 3
GFuA105: High drive board temp. stitch cam feed 4
GFuA109: High drive board temp. heel return S.C.
GFuA116: Vertical arm operating temper high
GFuA120: Angle arm operating temp. high
GFuA124: Turn.device down operating temp. high
GFuA128: Turn.device up operating temper. high
GFuA132: Pin feeder operating temper. high
GFuA136: Feeding tall temperature linker motor
GFuA140: Turn.dev inclin. motor operating temper. high
GFuA144: Pin unit rotat. motor operating temper. high
GFuA149: Ext. CT shutter valve operating temper. high
GFuA39: HW board not recognized sizing motor
GFuA40: HW board not recognized vacuum valve
GFuA41: HW board not recognized sinker cap motors
GFuA42: HW board not recognized elastic 1
GFuA43: HW board not recognized sinker cap motors
GFuA44: HW board not recognized saw blade device
GFuA45: HW board not recognized elastic 2
GFuA46: HW board not recognized elastic cad 1
GFuA47: HW board not recognized straighten welt
GFuA48: HW board not recognized dial motor
GFuA61: Unknow HW board PYF 1
GFuA62: Unknow HW board PYF 2
GFuA63: Unknow HW board PYF 3
GFuA64: Unknow HW board PYF 4
GFuA90: hardware board not recognised Turn.device valve

GFuA94: Unknow HW board stitch cam feed 1
GFuA98: Unknow HW board stitch cam feed 2
GFuA102: Unknow HW board stitch cam feed 3
GFuA106: Unknow HW board stitch cam feed 4
GFuA110: Unknow HW board heel return s.c.
GFuA117: Vertical arm board hardware not recognised
GFuA121: Angle arm board hardware not recognised
GFuA125: Turn.device down board hardware not recognised
GFuA129: Turn.device up board hardware not recognised
GFuA133: Pin feeder board hardware not recognised
GFuA137: board not recognized linker motor
GFuA141: Turn.dev inclin. motor board hardware not recognised
GFuA145: Pin unit rotat. motor board hardware not recognised
GFuA150: Ext. CT shutter valve board hardware not recognised
GFuA68: ECODD 3.3 Volt KO
GFuA69: ECODD Motor shortcircuit
GFuA70: ECODD Resolver failure
GFuA71: ECODD External Reset
GFuA72: ECODD Max speed exceeded
GFuA73: ECODD Wrong direction
GFuA74: ECODD Motion prevented
GFuA146: Move encoder zero of pin feeder motor
Gf4: Setup elements number not correct

Messages on operations in FLASH

Gf1: OPERATION FINISHED. SWITCH MACH. OFF

This alarm appears at the end of a generic writing in FLASH memory of a board (saving data or Software Update).
The user is also obliged by the alarm to turn off the machine.
The next time the machine will be turned on it will use the data previously saved.

Gf5: Writing on flash for file.up update aborted

GFuA38: Failure update SW board CAN MPP

This alarm informs the user that the attempt to update the Pcb_3836 board with its specific software has failed.
The file ".up" is not copied in the FLASH memory of the Board or module.
The failure of this operation is rare, usually can happen if the file in activation is damaged or if happen a traumatic end of the operation (for example turn off the machine during the copy).
Proceed as follows to solve the problem:

- Repeat the procedure of loading and activation of the software.
- Replace the board or module concerned the software upgrade.

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Reference

For the information concerning the procedures mentioned in previous explanations make reference to the section:
Operations on the Software machine

GFuA85: YOYO SW updating failed

This alarm informs the user that the attempt to update YOYO modules with its specific software has failed.
The file ".up" is not copied in the FLASH memory of the Board or module.

The failure of this operation is rare, usually can happen if the file in activation is damaged or if happen a traumatic end of the operation (for example turn off the machine during the copy).
Proceed as follows to solve the problem:

- Repeat the procedure of loading and activation of the software.
- Replace the board or module concerned the software upgrade.

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Reference

For the information concerning the procedures mentioned in previous explanations make reference to the section:
Operations on the Software machine

GFuA67: ECODD Update failed

This alarm informs the user that the attempt to update Motor Drive board with its specific software has failed.
The file ".up" is not copied in the FLASH memory of the Board or module.
The failure of this operation is rare, usually can happen if the file in activation is damaged or if happen a traumatic end of the operation (for example turn off the machine during the copy).
Proceed as follows to solve the problem:

- Repeat the procedure of loading and activation of the software.
- Replace the board or module concerned the software upgrade.

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Reference

For the information concerning the procedures mentioned in previous explanations make reference to the section:
Operations on the Software machine

GFuA152: 3ENC board SW update failed

The message refers to the board:
Pcb_4752.
This alarm informs that the attempt to update the board and its specific software has failed.
The file ".up" is not copied in the FLASH memory of the Board or module.
The failure of this operation is rare, usually can happen if the file in activation is damaged or if happen a traumatic end of the operation (for example turn off the machine during the copy).
Proceed as follows to solve the problem:

- Repeat the procedure of loading and activation of the software.
- Replace the board or module concerned the software upgrade.

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Reference

For the information concerning the procedures mentioned in previous explanations make reference to the section:
Operations on the Software machine

Messages on Software not compatible

Gf2: Flash update program incompatible

This alarm alerts the user that the Partial Update File that seeks to activate is incompatible with a the other part of machine software that would still be in the machine.
In practice this alarm may appear only if you search to activate a part of the machine software, for example the “eprom custom”, if this is incompatible with the “eprom system”.
These 2 parts of software are the main components of the “Machine Software”.
The “eprom custom” and “eprom system”, to avoid possible incompatibilities between them have a compatibility table (codes of version identification).
The control of these codes is made on the files in “.up” format before allowing the software activation.
The compatibility control prevents possible misalignments of software version can cause the block of the machine.

- The solution is to install and then activate a compatible software.

With this check, by entering and activating a partial software in file format type “.up”, is impossible cause a software block.
If the file “.up” is incompatible the activation is prevented.

The partial software are used by Lonati technicians only in special cases and following precise indications.
The Lonati company normally provides Update Software in the complete form (“Update.up”), for which this problem may not appear (misalignment impossible).

The user can have the availability of partial machine software, without that they are provided by the Lonati staff.
This is possible through the utility of extraction and copy in RAM memory of machine partial software available on the machine.
Subsequently, these software can be copied on an external memory device and used to update other machines.
However also in this case is active the compatibility control.

Notice

Note

The loading of a partial software through a file of the “mach.bin” type (direct mode that excludes every control) does not allow the compatibility control.
Therefore in case of not compatibility of version is possible that the next time you turn on the machine it not functions for a software block.
A software block caused by an Update operation not correct (for example by using a “mach.bin” file) requires a special intervention of restoration.
This restoration is executed through the use of files in “mach.bin” format (software or clear), or through the use of the “update” board Pcb_2779.
These operations require a certain expertise and the availability of tools and software that the User may not have.
Evaluate with the Lonati staff the best option for the problem solution.

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Reference

For the information concerning the procedures mentioned in previous explanations make reference to the section:
Operations on the Software machine

Furthers informations are available in :
GUIDE OF USER INTERFACE
1. Download software

Messages on problems in the Software Management

Gf3: EPR_CUS: ID module CAN already assigned

This alarm refers to internal software management.
This alarm appears when a machine software error (custom) occurs in:
- management of the CAN numbering.

This problem is probably due to a software failure, and it is supposed it will never be displayed to the user.

Notice

Attention

Contact Lonati technical staff for further information and for an eventual Software update.

GFuA01: CAN Unknown command

This alarm refers to internal software management.
Only in the case of incorrect and partial software upgrades is possible the appearance of this alarm.
This alarm concerns CAN management.
This problem is probably due to a software failure, and it is supposed it will never be displayed to the user.

Notice

Attention

Contact Lonati technical staff for further information and for an eventual Software update.

GFuA02: CAN Motor actuator module

This alarm indicates that the software has detected a problem on the CAN logic, but failed to define the type of problem.
This problem is probably due to a software failure, and it is supposed it will never be displayed to the user.
- A problem in the software writing, an hardware problem on the CAN boards, a disorder on the CAN transmission:
  All these conditions may cause CAN Errors/Alarms not related to the real failure, but General of the CAN system.

Therefore in general, for all the CAN Errors/Alarms, after having evaluated the specific problem indicated by error, also to assess as a possible cause a general problem of the CAN system (software and hardware).

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

GFuA76: YOYO command unknown

This alarm refers to internal software management.
Only in the case of incorrect and partial software upgrades is possible the appearance of this alarm.
This alarm concerns management of the YOYO in CAN module.
This problem is probably due to a software failure, and it is supposed it will never be displayed to the user.

Notice

Attention

Contact Lonati technical staff for further information and for an eventual Software update.

GFuA65: ECODD Unknown control

This alarm refers to internal software management.
Only in the case of incorrect and partial software upgrades is possible the appearance of this alarm.
This alarm concerns management of the ECODD Drive board in CAN module.
This problem is probably due to a software failure, and it is supposed it will never be displayed to the user.

Notice

Attention

Contact Lonati technical staff for further information and for an eventual Software update.

GFuA151: 3ENC comand unknown

This alarm refers to internal software management.
Only in the case of incorrect and partial software upgrades is possible the appearance of this alarm.
This problem is probably due to a software failure, and it is supposed it will never be displayed to the user.

Notice

Attention

Contact Lonati technical staff for further information and for an eventual Software update.

GFuA77: YOYO module drive

This alarm indicates that the software has detected a problem on the CAN logic, but failed to define the type of problem.
In particular, the problem is detected on the CAN line related to the YOYO motors.
This problem is probably due to a software failure, and it is supposed it will never be displayed to the user.

- A problem in the software writing, an hardware problem on the CAN boards, a disorder on the CAN transmission:
  All these conditions may cause CAN Errors/Alarms not related to the real failure, but General of the CAN system.

Therefore in general, for all the CAN Errors/Alarms, after having evaluated the specific problem indicated by error, also to assess as a possible cause a general problem of the CAN system (software and hardware).

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

GFuA66: ECODD Generic

This alarm indicates that the software has detected a problem on the CAN logic, but failed to define the type of problem.
In this case, the software has however established that the problem is on the management of the ECODD15 Motor Drive board in CAN.
This problem is probably due to a software failure, and it is supposed it will never be displayed to the user.

- A problem in the software writing, an hardware problem on the CAN boards, a disorder on the CAN transmission:
  All these conditions may cause CAN Errors/Alarms not related to the real failure, but General of the CAN system.

Therefore in general, for all the CAN Errors/Alarms, after having evaluated the specific problem indicated by error, also to assess as a possible cause a general problem of the CAN system (software and hardware).

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Messages on the CAN communication (Tx)

GFuA111: CAN in overrun

GFuA112: CAN buffer full

GFuA113: CAN bus off

This message informs the user that too much information concerning the CAN devices overload the data transmission between the Pcb_2008 board and the CAN modules.
Have to assess if these problems have undermined the machine functioning, in general, if this happens other errors and alarms on the CAN system are displayed.

Notice

Attention

Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Messages on Hardware not compatible

GFuA86: YOYO device unknown

This message informs the user that on the CAN line related to the YOYO motors is connected a device unknown to the software.
Each CAN device connected to the machine must have its own identification number which is stored in the main board.
The identification number is imprinted on board during its manufacture and must be recognised by the software.
If these correspondences are missing appears this alarm.

- The solution is to eliminate by the CAN connection the device unrelated.

CAN messages: Hardware faulty

GFuA08: Tension tall feeding sizing motor

GFuA09: Tension tall feeding vacuum valve

GFuA10: Tension tall feeding sinker cap motors

GFuA11: Tension tall feeding elastic 1

GFuA12: Tension tall feeding sinker cap motors

GFuA13: Tension tall feeding saw blade device

GFuA14: Tension tall feeding elastic 2

GFuA15: Tension tall feeding elastic cad 1

GFuA16: Tension tall feeding straighten welt

GFuA17: Tension tall feeding dial motor

GFuA49: CAN High supply tension PYF 1

GFuA52: CAN High supply tension PYF 2

GFuA55: CAN High supply tension PYF 3

GFuA58: CAN High supply tension PYF 4

GFuA87: High supply voltage Turn.device valve

GFuA91: High supply tension stitch cam feed 1

GFuA95: High supply tension stitch cam feed 2

GFuA99: High supply tension stitch cam feed 3

GFuA103: High supply tension stitch cam feed 4

GFuA107: High supply tension heel return s.c.

GFuA114: Vertical arm supply voltage high

GFuA118: Angle arm supply voltage high

GFuA122: Turn.device down supply voltage high

GFuA126: Turn.device up supply voltage high

GFuA130: Pin feeder supply voltage high

GFuA134: tension tall feeding linker motor

GFuA138: Turn.dev inclin. motor power supply high

GFuA142: Pin unit rotat. motor power supply high

GFuA147: Ext. CT shutter valve power supply high

This message indicates that the CAN module associated with the motor is powered at a higher voltage than allowed.
The software recognizes through the Hardware of the module that this value is not within the margins established.
Then is displayed a specific alarm.
Proceed as follows to solve the problem:

- Check the power supply (voltage) of the CAN board (for example a Pcb_3836 relative the motor indicated in the message.
- Replace the CAN module (board Pcb_3836) associated with the motor indicated in the message.
- A problem in the software writing, an hardware problem on the CAN boards, a disorder on the CAN transmission:
  All these conditions may cause CAN Errors/Alarms not related to the real failure, but General of the CAN system.

Therefore in general, for all the CAN Errors/Alarms, after having evaluated the specific problem indicated by error, also to assess as a possible cause a general problem of the CAN system (software and hardware).

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

GFuA18: Power of tall phase sizing motor

GFuA19: Power of tall phase vacuum valve

GFuA20: Power of tall phase sinker cap motors

GFuA21: Power of tall phase elastic 1

GFuA22: Power of tall phase sinker cap motors

GFuA23: Power of tall phase saw blade device

GFuA24: Power of tall phase elastic 2

GFuA25: Power of tall phase elastic cad 1

GFuA26: Power of tall phase straighten welt

GFuA27: Power of tall phase dial motor

GFuA50: CAN High phase current PYF 1

GFuA53: CAN High phase current PYF 2

GFuA56: CAN High phase current PYF 3

GFuA59: CAN High phase current PYF 4

GFuA88: High phase current Turn.device valve

GFuA92: High phase current stitch cam feed 1

GFuA96: High phase current stitch cam feed 2

GFuA100: High phase current stitch cam feed 3

GFuA104: High phase current stitch cam feed 4

GFuA108: High phase current heel return s.c.

GFuA115: Vertical arm phase current high

GFuA119: Angle arm phase current high

GFuA123: Turn.device down phase current high

GFuA127: Turn.device up phase current high

GFuA131: Pin feeder phase current high

GFuA135: power of tall phase linker motor

GFuA139: Turn.dev inclin. motor phase current high

GFuA143: Pin unit rotat. motor phase current high

GFuA148: Ext. CT shutter valve phase current high

This message indicates that the CAN module associated with the motor provides to the motor a phase current more high than allowed.
The software recognizes through the Hardware of the module that this value is not within the margins established.
Then is displayed a specific alarm.
Proceed as follows to solve the problem:

- Check the power supply (voltage) of the CAN board (for example a Pcb_3836 relative the motor indicated in the message.
- Check the wiring that connect the sensor and the motor to the command board (in general the Pcb_3836 board).
- Replace the CAN module (board Pcb_3836) associated with the motor indicated in the message.
- Replace the stepping motor indicated in the message.
- A problem in the software writing, an hardware problem on the CAN boards, a disorder on the CAN transmission:
  All these conditions may cause CAN Errors/Alarms not related to the real failure, but General of the CAN system.

Therefore in general, for all the CAN Errors/Alarms, after having evaluated the specific problem indicated by error, also to assess as a possible cause a general problem of the CAN system (software and hardware).

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

GFuA28: Feeding. tall temperature sizing motor

GFuA29: Feeding. tall temperature vacuum valve

GFuA30: Feeding. tall temperature sinker cap motors

GFuA31: Feeding. tall temperature elastic 1

GFuA32: Feeding. tall temperature sinker cap motors

GFuA33: Feeding. tall temperature saw blade device

GFuA34: Feeding. tall temperature elastic 2

GFuA35: Feeding. tall temperature elastic cad 1

GFuA36: Feeding. tall temperature straighten welt

GFuA37: Feeding. tall temperature dial motor

GFuA51: CAN High drive board temp. PYF 1

GFuA54: CAN High drive board temp. PYF 2

GFuA57: CAN High drive board temp. PYF 3

GFuA60: CAN High drive board temp. PYF 4

GFuA89: High actuation temp. Turn.device valve

GFuA93: High drive board temp. stitch cam feed 1

GFuA97: High drive board temp. stitch cam feed 2

GFuA101: High drive board temp. stitch cam feed 3

GFuA105: High drive board temp. stitch cam feed 4

GFuA109: High drive board temp. heel return S.C.

GFuA116: Vertical arm operating temper high

GFuA120: Angle arm operating temp. high

GFuA124: Turn.device down operating temp. high

GFuA128: Turn.device up operating temper. high

GFuA132: Pin feeder operating temper. high

GFuA136: Feeding tall temperature linker motor

GFuA140: Turn.dev inclin. motor operating temper. high

GFuA144: Pin unit rotat. motor operating temper. high

GFuA149: Ext. CT shutter valve operating temper. high

This message indicates that the CAN module associated with that motor reads a temperature value of the board/motor unit higher than the value allowed.
The software recognizes through the Hardware of the module that this value is not within the margins established.
Then is displayed a specific alarm.
Proceed as follows to solve the problem:

- Check the power supply (voltage) of the CAN board (for example a Pcb_3836 relative the motor indicated in the message.
- Check the wiring that connect the sensor and the motor to the command board (in general the Pcb_3836 board).
- Replace the CAN module (board Pcb_3836) associated with the motor indicated in the message.
- Replace the stepping motor indicated in the message.
- A problem in the software writing, an hardware problem on the CAN boards, a disorder on the CAN transmission:
  All these conditions may cause CAN Errors/Alarms not related to the real failure, but General of the CAN system.

Therefore in general, for all the CAN Errors/Alarms, after having evaluated the specific problem indicated by error, also to assess as a possible cause a general problem of the CAN system (software and hardware).

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

GFuA39: HW board not recognized sizing motor

GFuA40: HW board not recognized vacuum valve

GFuA41: HW board not recognized sinker cap motors

GFuA42: HW board not recognized elastic 1

GFuA43: HW board not recognized sinker cap motors

GFuA44: HW board not recognized saw blade device

GFuA45: HW board not recognized elastic 2

GFuA46: HW board not recognized elastic cad 1

GFuA47: HW board not recognized straighten welt

GFuA48: HW board not recognized dial motor

GFuA61: Unknow HW board PYF 1

GFuA62: Unknow HW board PYF 2

GFuA63: Unknow HW board PYF 3

GFuA64: Unknow HW board PYF 4

GFuA90: hardware board not recognised Turn.device valve

GFuA94: Unknow HW board stitch cam feed 1

GFuA98: Unknow HW board stitch cam feed 2

GFuA102: Unknow HW board stitch cam feed 3

GFuA106: Unknow HW board stitch cam feed 4

GFuA110: Unknow HW board heel return s.c.

GFuA117: Vertical arm board hardware not recognised

GFuA121: Angle arm board hardware not recognised

GFuA125: Turn.device down board hardware not recognised

GFuA129: Turn.device up board hardware not recognised

GFuA133: Pin feeder board hardware not recognised

GFuA137: board not recognized linker motor

GFuA141: Turn.dev inclin. motor board hardware not recognised

GFuA145: Pin unit rotat. motor board hardware not recognised

GFuA150: Ext. CT shutter valve board hardware not recognised

This message indicates that the indicated motor is associated with a CAN module that the software considers incompatible.
The software run a compatibility test between the CAN modules and the associated motors through internal tables internal already set.
If the configuration is not among those provided for appears this alarm.
This problem is probably due to a software failure, and it is supposed it will never be displayed to the user.

- A problem in the software writing, an hardware problem on the CAN boards, a disorder on the CAN transmission:
  All these conditions may cause CAN Errors/Alarms not related to the real failure, but General of the CAN system.

Therefore in general, for all the CAN Errors/Alarms, after having evaluated the specific problem indicated by error, also to assess as a possible cause a general problem of the CAN system (software and hardware).

Notice

Attention

Contact Lonati technical staff for further information and for an eventual Software update.

CAN messages on the ECODD Drive motor board

GFuA68: ECODD 3.3 Volt KO

This message indicates that the Motor Drive board has detected a malfunction on the internal analogic tension of the board.
The software recognizes this problem by the hardware of the module.

Proceed as follows to solve the problem:

- Replace the Motor Drive board.
- A problem in the software writing, an hardware problem on the CAN boards, a disorder on the CAN transmission:
  All these conditions may cause CAN Errors/Alarms not related to the real failure, but General of the CAN system.

Therefore in general, for all the CAN Errors/Alarms, after having evaluated the specific problem indicated by error, also to assess as a possible cause a general problem of the CAN system (software and hardware).

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

GFuA69: ECODD Motor shortcircuit

This message indicates that the Motor Drive board has noted a problem of short-circuit on the power phases from the Motor Drive and that arrive to the motor.
The software recognizes this problem by the hardware of the module.

Proceed as follows to solve the problem:

- Check the wiring that connect the Motor to the Motor Drive board, passing through the Motor Contactor.
- Replace the Motor Drive board.
- Replace the motor.
- A problem in the software writing, an hardware problem on the CAN boards, a disorder on the CAN transmission:
  All these conditions may cause CAN Errors/Alarms not related to the real failure, but General of the CAN system.

Therefore in general, for all the CAN Errors/Alarms, after having evaluated the specific problem indicated by error, also to assess as a possible cause a general problem of the CAN system (software and hardware).

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

GFuA70: ECODD Resolver failure

This message indicates that the Motor Drive board has noted a problem on Resolver phases entering the Motor Drive.
The software recognizes this problem by the hardware of the module.

Proceed as follows to solve the problem:

- Check the wiring between the Motor Resolver and the Motor Drive board.
- Replace the Motor Drive board.
- Replace the resolver.
- A problem in the software writing, an hardware problem on the CAN boards, a disorder on the CAN transmission:
  All these conditions may cause CAN Errors/Alarms not related to the real failure, but General of the CAN system.

Therefore in general, for all the CAN Errors/Alarms, after having evaluated the specific problem indicated by error, also to assess as a possible cause a general problem of the CAN system (software and hardware).

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

GFuA71: ECODD External Reset

This message indicates that the Motor drive board has noted a Manual Reset of the board itself, this has resulted in a loss of the operating parameters.

- The alarm obliges the user to Turn off and then Turn on the machine.
  In this way when the machine is turned on are again loaded (copied from machine software) the correct parameters of operation.
- A problem in the software writing, an hardware problem on the CAN boards, a disorder on the CAN transmission:
  All these conditions may cause CAN Errors/Alarms not related to the real failure, but General of the CAN

system.

Therefore in general, for all the CAN Errors/Alarms, after having evaluated the specific problem indicated by error, also to assess as a possible cause a general problem of the CAN system (software and hardware).

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

GFuA72: ECODD Max speed exceeded

This message indicates that the Motor Drive board has detected an error of maximum speed, i.e. it has found that the motor has turned to a highest speed of the maximum speed settable.
This alarm regards the only machines that work in “Speed loop” without alternate motion (without Heel), e.g. certain models of Pantyhose machines.

- A problem in the software writing, an hardware problem on the CAN boards, a disorder on the CAN transmission:
  All these conditions may cause CAN Errors/Alarms not related to the real failure, but General of the CAN system.

Therefore in general, for all the CAN Errors/Alarms, after having evaluated the specific problem indicated by error, also to assess as a possible cause a general problem of the CAN system (software and hardware).

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

GFuA73: ECODD Wrong direction

This message indicates that the Motor Drive board has detected an error of Motor direction, i.e. it has found that the motor has tried to move in the opposite direction to that provided.
This alarm regards the only machines that work in “Speed loop” without alternate motion (without Heel), e.g. certain models of Pantyhose machines.

- A problem in the software writing, an hardware problem on the CAN boards, a disorder on the CAN transmission:
  All these conditions may cause CAN Errors/Alarms not related to the real failure, but General of the CAN system.

Therefore in general, for all the CAN Errors/Alarms, after having evaluated the specific problem indicated by error, also to assess as a possible cause a general problem of the CAN system (software and hardware).

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

GFuA74: ECODD Motion prevented

This error informs the user something has obstructed the machine motion.
In particular the speed reference has been for more than 20 Ms at the maximum speed (+/-10 Vdc) without the machine has moved (the software has not seen the correct signals from the Resolver motor).
Generally the problem is due to the fact that the Cylinder movement found a resistance to prevent the rotation (friction very strong), and in particular this happens in departures when the machine is stopped.
If the error is caused by this reason, it usually occurs when the machine is being Run-in, or after the replacement of particular regarding the rotation and that therefore since they are new they produce friction higher than normal.
Another possible situation is the mechanical rupture, for example on the cylinder, that compromise the rotation, causing its blocking.

- In all these cases, is necessary to intervene on the mechanical causes by oiling the parts with friction and

Run-in the mechanical parts.

Another cause of error is due to the main motor and its transmission organs.
Proceed as follows to solve the problem:

- Check the gears and the drive belt.
- Replace the motor.
- Replace the resolver.
  The Resolver determines the proper functioning of the motor.
  The Resolver malfunction is the main cause of motor malfunction.

Other causes of this problem may be due to the complex of boards and wiring that determine the motor movement.
The speed reference exits from the Pcb_2008 board and reaches the Motor drive board.
The Resolver phases, from the motor reaches the Motor drive board, which uses in 2 ways.

1. They are used for the motor control.
2. They are processed, transforming them into an encoder for degrees/needles counting, and then they are sended to the Pcb_2008.

In case of ECODD15 Motor drive board there is also a wiring for the connection between the CAN board Pcb_2008 and the Motor drive board.
The power phases for the motor command exit from the Motor drive board, reach the Motor Contactor which is controlled by the Pcb_2008 board (Start/Stop management), pass for the interface D4840496 and finally reach the motor.

Proceed as follows to solve the problem:

- Check the wiring between the Pcb_2008 board and the Motor Drive board.
- Check the wiring between the Motor Resolver and the Motor Drive board.
- Replace the Motor Drive board.
- Replace the motor Contactor TL1.
- Replace the board Pcb_2008.
- A problem in the software writing, an hardware problem on the CAN boards, a disorder on the CAN transmission:
  All these conditions may cause CAN Errors/Alarms not related to the real failure, but General of the CAN system.

Therefore in general, for all the CAN Errors/Alarms, after having evaluated the specific problem indicated by error, also to assess as a possible cause a general problem of the CAN system (software and hardware).

Notice

Note

This alarm is similar to the normal error:
Mo1
The difference with the latter, is that this message is of type Alarm.
Therefore, after the turned off, when the machine is turned on it reachs the End of Cycle step, virtually by executing a Reset.
In case of problems of this type, as a matter of priorities and type of control would intervene in any case before the error this alarm.

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Messages on the management of the Encoder counting

GFuA146: Move encoder zero of pin feeder motor

Pin frwd. Motor

The motor is equipped with an encoder.
The encoder sends a signal depending on the phase (angle) of the driveshaft
After any maintenance, the motor is remounted but the random position of the shaft creates a blind point: the encoder zero signal is too close to the proximity zero (motor unit in the home position).

Proceed as follows to solve the problem:

- Dismount the motor, rotate the shaft by half turn and remount it.

The following message appears after the intervention:
CHuE341

In the event of false errors, take note of the following information:

The following signals are monitored to identify the defect:

- Encoder signal.
  From the device, the signal reaches the board:
  Pcb_3836 Nr. 2
- Proximity signal.
  From the device, the signal reaches the board:
  Pcb_3836 Nr. 2

Reference

Refer to the documentation provided.
In particular:
Wiring diagrams (FOGLIO GUIDA DOCUMENTAZIONE APPARECCHIATURA).

NOTE:

By false error is meant a defect signal not generated by an actually dangerous situation but only electric disturbances and/or hardware defects.

Internal software failure

Gf4: Setup elements number not correct

This alarm refers to internal software management.
This particular alarm is detected by this specific “Task”.
This problem is probably due to a software failure, and it is supposed it will never be displayed to the user.

Notice

Attention

Contact Lonati technical staff for further information and for an eventual Software update.

MAIN

Ma1: Zero encoder management
Ma3: Encoder counting
Ma2: Alarm information programs WRONG
Ma4: DSP version incompatible
Ma6: Version SW FOURSTEP-DIGISTEP incompatible
Ma9: Codify not compatible with the machine
Ma13: Version Sw YOYO not compatible
Ma24: ECODD Version SW incompatible
Ma31: Software version of 3ENC board incompatible
Ma28: Version Software USB incompatible
Ma5: Codify not compatibile with subpr. SUPE
Ma7: Timeout set. logic address to CAN modules
Ma8: Linking program incompatible
Ma25: Timeout set address logical CAN ECODD
Ma26: Timeout set logic address CAN YOYO
Ma10: Additional module CAN FOURSTEP
Ma11: Added YOYO
Ma16: Lost degree because of crossing
Ma17: Lost needle because of crossing
Ma18: End of writing on FLASH. Switch off machin
Ma19: Writing FLASH impossible
Ma20: Operation finished Switch mach. OFF
Ma23: TX CAN ECODD impossible
Ma29: TX CAN 3ENC board impossible
MAuA01: WATCH-DOG CIO
MAuA02: WATCH-DOG Drums
MAuA03: Mechanical zero not acquired
Ma21: Setup elements number not correct

Messages on the management of the Encoder counting

Ma1: Zero encoder management

This alarm appears if at the starting of the machine, before the synchronism of habilitation of the counting, is read more than one “Zero” phase within one cylinder revolution.
This alarm is due to a problem in the Encoder counting.

- The cause of the problem must be search in the Hardware chain for the counting management.

Briefly, the path of the counting signals is composed of these steps:

1. The motor running jointly liable with a Resolver, that is used for its control.
2. The Resolver signals are also processed by the Motor Drive board, obtaining a simulated Encoder.
3. These Encoder signals arrive then to the Pcb_2008 board.
4. The position of the “Zero” phase is random, depends on the Motor and Resolver assembly.
5. The Mechanical Zero is acquired aboard the machine, as offset compared to the real “Zero” phase.
6. All the Needles and Degrees counting is based on this Mechanical Zero acquired.

Proceed as follows to solve the problem:

- Check the wiring between the Pcb_2008 board and the Motor Drive board.
- Check the wiring between the Motor Resolver and the Motor Drive board.
- Replace the Motor Drive board.
- Replace the board Pcb_2008.
- Replace the motor.
- Replace the resolver.

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Ma3: Encoder counting

This alarm is found if the Encoder impulses (phase “A” and phase “B”) are not in a certain “range” of synchronization with the phase “Zero”.
In fact this alarm appears always in connection with the arrival of phase “Zero”.
This alarm is due to a problem in the Encoder counting.

- The cause of the problem must be search in the Hardware chain for the counting management.

Briefly, the path of the counting signals is composed of these steps:

1. The motor running jointly liable with a Resolver, that is used for its control.
2. The Resolver signals are also processed by the Motor Drive board, obtaining a simulated Encoder.
3. These Encoder signals arrive then to the Pcb_2008 board.
4. The position of the “Zero” phase is random, depends on the Motor and Resolver assembly.
5. The Mechanical Zero is acquired aboard the machine, as offset compared to the real “Zero” phase.
6. All the Needles and Degrees counting is based on this Mechanical Zero acquired.

Proceed as follows to solve the problem:

- Check the wiring between the Pcb_2008 board and the Motor Drive board.
- Check the wiring between the Motor Resolver and the Motor Drive board.
- Replace the Motor Drive board.
- Replace the board Pcb_2008.
- Replace the motor.
- Replace the resolver.

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Messages on Programming and Setup

Ma2: Alarm information programs WRONG

This alarm appears at the entry in Working status if the Codified Program is not compatible with the nmachine software or however contains some information that is not manageable by the machine software.
A typical case of this alarm is when the Size set in the machine is not between those coded in the Program (GRAPHITRON).

- In this case correct the setting present on the machine.

Another cause for this alarm is when there isn’t sufficient free RAM memory on the Pcb_2007 board to allocate the Program with its data.

- In this case cancel from the RAM memory any programs not used.

To solve the problem turn off and turn on the machine with the key in the Programming position.
Run the operations necessary to eliminate the problem and then enter in Working status.

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Messages on Software not compatible

Ma4: DSP version incompatible

The machine, in addition to normal machine Software (system + custom) installed on the Pcb_2007 board, also uses other software installed on other boards.
One of these boards is Pcb_2008, which mounts “EDSPxxxx” software, where “xxxx” identifies the version.
This software must be compatible with the machine software, where is always present a Compatibility Table (which versions of the “external software” are compatible with it).
When is turned on the machine it performs always this verification.
This alarm appears in the case the “external software” installed is not compatible with the machine software itself.

- The solution is to install and then activate a compatible “external software”.

In this case the message refers to board Pcb_2008 Updating, the external software to install is that entitled “EDSPxxx”.

This alarm usually appears during a procedure for the software Updating, after having installed the new machine software, if it requires “external software” more updated.
Usually an machine software Update to a specific version requires that are provided all the software files relating to that software version (“update.up”, “edspxxxx.up”, “4mppxxxx.up”, “edd_xxxx.up”, “yoyoxxx.up”).
The procedure requires initially the installation of the machine software file (“update.up”).
Subsequently the appearance of compatibility alarms forces the user to install the “external software” not compatible with the machine software.

This alarm may also appear when replacing board Pcb_2008, when installing “EDSPxxxx” software that is not compatible with the machine software installed on board Pcb_2007.

Notice

Note

Since the machine in Alarm status, the User may not have access to the normal maintenance menu.
To execute the necessary software Update the user must therefore access the “Alarm menu” by pressing the [SPACE] key.

Attention

Contact Lonati technical staff for further information and for an eventual Software update.

Reference

Furthers informations are available in :
GUIDE OF USER INTERFACE

1. Visualize version
2. -ALARM MENU
3. Software management

Ma6: Version SW FOURSTEP-DIGISTEP incompatible

The machine, in addition to normal machine Software (system + custom) installed on the Pcb_2007 board, also uses other software installed on other boards.
One of these boards is Pcb_3836, which mounts “4mppxxxx” software, where “xxxx” identifies the version.
This software must be compatible with the machine software, where is always present a Compatibility Table (which versions of the “external software” are compatible with it).
When is turned on the machine it performs always this verification.
This alarm appears in the case the “external software” installed is not compatible with the machine software itself.

- The solution is to install and then activate a compatible “external software”.

In this case the message refers to board Pcb_3836 Updating, the external software to install is that entitled “4mppxxx”.

This alarm usually appears during a procedure for the software Updating, after having installed the new machine software, if it requires “external software” more updated.
Usually an machine software Update to a specific version requires that are provided all the software files relating to that software version (“update.up”, “edspxxxx.up”, “4mppxxxx.up”, “edd_xxxx.up”, “yoyoxxx.up”).
The procedure requires initially the installation of the machine software file (“update.up”).

Subsequently the appearance of compatibility alarms forces the user to install the “external software” not compatible with the machine software.

This alarm may also appear when replacing board Pcb_3836, when installing “4mppxxxx” software that is not compatible with the machine software installed on board Pcb_2007.

Notice

Note

Since the machine in Alarm status, the User may not have access to the normal maintenance menu.
To execute the necessary software Update the user must therefore access the “Alarm menu” by pressing the [SPACE] key.

Attention

Contact Lonati technical staff for further information and for an eventual Software update.

Reference

Furthers informations are available in :
GUIDE OF USER INTERFACE
1. Visualize version
2. -ALARM MENU
3. Software management

Ma9: Codify not compatible with the machine

This alarm indicates incompatibility between the programming software (GRAPHITRON) and the machine software (Eproms).
The version of the machine software is not compatible with the GRAPHITRON software version.
To avoid problems due to natural evolution of hardware and software implementations, was created a Compatibility Control.
The machine software and the GRAPHITRON software need to be aligned to the same software version.
Practically, every time that in the machine evolution a modification of the software machine requires an obligatory modification of the GRAPHITRON software, are increased the version indices.
The machine software check that the Codified Program has a Version index compatible with that of the machine.
- The solution, depending on the case, is to update the machine software (Eproms) or the GRAPHITRON software.

Of course in the case of GRAPHITRON updating the Sock Program must be coded again.

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Ma13: Version Sw YOYO not compatible

The machine, in addition to normal machine Software (system + custom) installed on the Pcb_2007 board, also uses other software installed on other boards.
One of these boards is YOYO motor, which mounts “4mppxxxx” software, where “xxxx” identifies the version.
This software must be compatible with the machine software, where is always present a Compatibility Table (which versions of the “external software” are compatible with it).
When is turned on the machine it performs always this verification.
This alarm appears in the case the “external software” installed is not compatible with the machine software itself.
- The solution is to install and then activate a compatible “external software”.

In this case the message refers to YOYO motor Updating (CAN modules), the external software to install is that entitled “yoyoxxx”.

This alarm usually appears during a procedure for the software Updating, after having installed the new machine software, if it requires “external software” more updated.

Usually an machine software Update to a specific version requires that are provided all the software files relating to that software version (“update.up”, “edspxxxx.up”, “4mppxxxx.up”, “edd_xxxx.up”, “yoyoxxx.up”).
The procedure requires initially the installation of the machine software file (“update.up”).
Subsequently the appearance of compatibility alarms forces the user to install the “external software” not compatible with the machine software.

This alarm may also appear when replacing a YOYO motor, when installing “yoyoxxxx” software that is not compatible with the machine software installed on board Pcb_2007.

Notice

Note

Since the machine in Alarm status, the User may not have access to the normal maintenance menu.
To execute the necessary software Update the user must therefore access the “Alarm menu” by pressing the [SPACE] key.

Attention

Contact Lonati technical staff for further information and for an eventual Software update.

Reference

Furthers informations are available in :
GUIDE OF USER INTERFACE
1. Visualize version
2. -ALARM MENU
3. Software management

Ma24: ECODD Version SW incompatible

The machine, in addition to normal machine Software (system + custom) installed on the Pcb_2007 board, also uses other software installed on other boards.
One of these boards is ECODD15 Moto Drive, which mounts “edd_xxxx” software, where “xxxx” identifies the version.
This software must be compatible with the machine software, where is always present a Compatibility Table (which versions of the “external software” are compatible with it).
When is turned on the machine it performs always this verification.
This alarm appears in the case the “external software” installed is not compatible with the machine software itself.
- The solution is to install and then activate a compatible “external software”.

In this case the message refers to Motor Drive board ECODD15 Updating, the external software to install is that entitled “edd_xxx”.

This alarm usually appears during a procedure for the software Updating, after having installed the new machine software, if it requires “external software” more updated.
Usually an machine software Update to a specific version requires that are provided all the software files relating to that software version (“update.up”, “edspxxxx.up”, “4mppxxxx.up”, “edd_xxxx.up”, “yoyoxxx.up”).
The procedure requires initially the installation of the machine software file (“update.up”).
Subsequently the appearance of compatibility alarms forces the user to install the “external software” not compatible with the machine software.

This alarm may also appear when replacing Motor Drive board ECODD15, when installing “edd_xxxx” software that is not compatible with the machine software installed on board Pcb_2007.

Notice

Note

Since the machine in Alarm status, the User may not have access to the normal maintenance menu.
To execute the necessary software Update the user must therefore access the “Alarm menu” by pressing the [SPACE] key.

Attention

Contact Lonati technical staff for further information and for an eventual Software update.

Reference

Furthers informations are available in :
GUIDE OF USER INTERFACE
1. Visualize version
2. -ALARM MENU
3. Software management

Ma31: Software version of 3ENC board incompatible

The machine, in addition to normal machine Software (system + custom) installed on the Pcb_2007 board, also uses other software installed on other boards.
One of these boards is “Expansion 3 Encoder Board”, which has a software entitled “3E00xxxx.up”, where “xxxx” indicates the version.
This software must be compatible with the machine software, where is always present a Compatibility Table (which versions of the “external software” are compatible with it).
When is turned on the machine it performs always this verification.
This alarm appears in the case the “external software” installed is not compatible with the machine software itself.

Proceed as follows to solve the problem:

- The solution is to load and then activate a compatible “external software”.

This alarm usually appears during a procedure for the software Updating, after having installed the new machine software, if it requires “external software” more updated.
Usually an machine software Update to a specific version requires that are provided all the software files relating to that software version (“update.up”, “edspxxxx.up”, “4mppxxxx.up”, “edd_xxxx.up”, “yoyoxxx.up”).
The procedure requires initially the installation of the machine software file (“update.up”).
Subsequently the appearance of compatibility alarms forces the user to install the “external software” not compatible with the machine software.

This alarm can be generated even when a resident board is replaced with another equipped with a software that is non compatible with the machine software installed on Pcb_2007.

Notice

Note

Since the machine in Alarm status, the User may not have access to the normal maintenance menu.
To execute the necessary software Update the user must therefore access the “Alarm menu” by pressing the [SPACE] key.

Attention

Contact Lonati technical staff for further information and for an eventual Software update.

Reference

Furthers informations are available in :
GUIDE OF USER INTERFACE
1. Visualize version
2. -ALARM MENU
3. Software management

Ma28: Version Software USB incompatible

This alarm refers to internal software management.
The machine, within the software “custom”, contains a part of software on the USB board management.
This part of software must be compatible with the basis software of the machine.
The appearance of this message informs the user that is was a mistake during the creation of the Programming software.
This problem is probably due to a software failure, and it is supposed it will never be displayed to the user.

Notice

Attention

Contact Lonati technical staff for further information and for an eventual Software update.

Messages on problems in the Software Management

Ma5: Codify not compatibile with subpr. SUPE

This alarm indicates incompatibility between the programming software (GRAPHITRON) and the machine software (Eproms).

- The solution, depending on the case, is to update the machine software (Eproms) or the GRAPHITRON software.

Other causes for this problem may be the machine software or programming software not valid because damaged or containing a mistake.

- Also in this case, the solution is to run the software update with a valid and compatible version.

Notice

Attention

Contact Lonati technical staff for further information and for an eventual Software update.

Ma7: Timeout set. logic address to CAN modules

This is a system error, it means that in the maximum time for the operation on the CAN line, the system has not been answered (logic timeout).
This problem is probably due to a software failure, and it is supposed it will never be displayed to the user.
However, can exist situations or hardware broken that could cause the appearance of this error.
This specific problem has occurred on the CAN line associated with the stepping motor control boards (Pcb_3836, etc.).

In case of the occurrence of this error after a Software Update.

- *Run again the Updating procedure, is possible that the copy operation of Software in FLASH memory is not carried out correctly.*

Even if not specific with respect to the real problem, this error may appear in the event of an hardware problem (a fault):

- *To any CAN module.*
- *To the board Pcb_2008.*
- *To the wirings between these boards.*

- A problem in the software writing, an hardware problem on the CAN boards, a disorder on the CAN transmission:
  All these conditions may cause CAN Errors/Alarms not related to the real failure, but General of the CAN system.

Therefore in general, for all the CAN Errors/Alarms, after having evaluated the specific problem indicated by error, also to assess as a possible cause a general problem of the CAN system (software and hardware).

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Ma8: Linking program incompatible

This alarm indicates incompatibility between the programming software (GRAPHITRON) and the machine software (Eproms).
The problem appears, when during the execution of a Link Program, is activated a Sock Program incompatible with the version of the machine software.

- The solution, depending on the case, is to update the machine software (Eproms) or the GRAPHITRON software.

Of course in the case of GRAPHITRON updating the Sock Program must be coded again.

Other causes for this problem may be the machine software or programming software not valid because damaged or containing a mistake.

- Also in this case, the solution is to run the software update with a valid and compatible version.

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Ma25: Timeout set address logical CAN ECODD

This is a system error, it means that in the maximum time for the operation on the CAN line, the system has not been answered (logic timeout).
This problem is probably due to a software failure, and it is supposed it will never be displayed to the user.
However, can exist situations or hardware broken that could cause the appearance of this error.
This specific problem has occurred on the CAN line associated with the Motor Drive board (ECODD Drive board).

In case of the occurrence of this error after a Software Update.

- *Run again the Updating procedure, is possible that the copy operation of Software in FLASH memory is not carried out correctly.*

Even if not specific with respect to the real problem, this error may appear in the event of an hardware problem (a fault):

- *To any CAN module.*
- *To the board Pcb_2008.*
- *To the wirings between these boards.*

- A problem in the software writing, an hardware problem on the CAN boards, a disorder on the CAN transmission:
  All these conditions may cause CAN Errors/Alarms not related to the real failure, but General of the CAN system.

Therefore in general, for all the CAN Errors/Alarms, after having evaluated the specific problem indicated by error, also to assess as a possible cause a general problem of the CAN system (software and hardware).

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Ma26: Timeout set logic address CAN YOYO

This is a system error, it means that in the maximum time for the operation on the CAN line, the system has not been answered (logic timeout).
This problem is probably due to a software failure, and it is supposed it will never be displayed to the user.
However, can exist situations or hardware broken that could cause the appearance of this error.
This specific problem has occurred on the CAN line associated with the YOYO motor control boards (YOYO motor).

In case of the occurrence of this error after a Software Update.

- *Run again the Updating procedure, is possible that the copy operation of Software in FLASH memory is not carried out correctly.*

Even if not specific with respect to the real problem, this error may appear in the event of an hardware problem (a fault):

- *To any CAN module.*
- *To the board Pcb_2008.*
- *To the wirings between these boards.*

- A problem in the software writing, an hardware problem on the CAN boards, a disorder on the CAN transmission:
  All these conditions may cause CAN Errors/Alarms not related to the real failure, but General of the CAN system.

Therefore in general, for all the CAN Errors/Alarms, after having evaluated the specific problem indicated by error, also to assess as a possible cause a general problem of the CAN system (software and hardware).

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Messages on the CAN modules management

Ma10: Additional module CAN FOURSTEP

This alarm appears, when is turned on the machine, if the software detects a CAN module more than those provided for and previously stored.
The CAN module found is on the command line of stepping motors (Pcb_3836, etcetera).
To each CAN module, is given an identification number when it is built, which during numbering is stored in the CAN modules Setup.
When the machine is turned on it always controls the coherent presence of the CAN modules, as provided for by previously storage.
If is found a CAN module with an identification number that is unknown to the software, appears this alarm.
This may be, for example when adding a new board on the CAN line, or if are replacing a board with another CAN board that for construction has an identification number different.

- The solution is to run a new numbering of the CAN modules.

Notice

Attention

At a certain level of machines software Update was introduced a new management.
In case of replacement of a single CAN module with another of the same type, the software automatically stores the identification number of the new board (replace the previous one).
The CAN modules Setup is automatically updated with the identification data of the new module.
For the user the operation is transparent, he must not intervene in any way.
Of course, this management is only possible in case of replacement of a single CAN module at a time.
If instead, after the CAN module replacement, when the machine is turned on appears an alarm of: “CAN module not numbered”, means that this management is not implemented in the software.
In this case the user is obliged to perform a new procedure of CAN modules Numbering.

Reference

Furthers informations are available in :
GUIDE OF USER INTERFACE

1. Numeration motor CAN

Ma11: Added YOYO

This alarm appears, when is turned on the machine, if the software detects a CAN module more than those provided for and previously stored.
The CAN module found is of the YOYO type.
To each CAN module, is given an identification number when it is built, which during numbering is stored in the CAN modules Setup.
When the machine is turned on it always controls the coherent presence of the CAN modules, as provided for by previously storage.
If is found a CAN module with an identification number that is unknown to the software, appears this alarm.
This may be, for example when adding a new YOYO motor on the CAN line, or if are replacing a YOYO motor with ano-

ther that for construction has an identification number different.

- The solution is to run a new numbering of the CAN modules.

Notice

Attention

At a certain level of machines software Update was introduced a new management.
In case of replacement of a single CAN module with another of the same type, the software automatically stores the identification number of the new board (replace the previous one).
The CAN modules Setup is automatically updated with the identification data of the new module.
For the user the operation is transparent, he must not intervene in any way.
Of course, this management is only possible in case of replacement of a single CAN module at a time.
If instead, after the CAN module replacement, when the machine is turned on appears an alarm of: “CAN module not numbered”, means that this management is not implemented in the software.
In this case the user is obliged to perform a new procedure of CAN modules Numbering.

Reference

Furthers informations are available in :
GUIDE OF USER INTERFACE

1. Setup YOYO in CAN
2. YOYO motors numbering

Messages on the speed of data processing

Ma16: Lost degree because of crossing

Ma17: Lost needle because of crossing

This alarm appears when the software in the time given is not able to carry out all the operations expected by the software.
Practically there are too many operations to be made at a certain speed, which is not able to complete them, so the machine is blocked with this alarm.
The most common causes that determine this problem are:

1. A problem in the machine software.
2. Speed too high for the article in production.
3. Problems on the Encoder/Resolver counting, there are very close impulses.

First check whether the problem is linked to one of the points listed above.

- In particular check if the problem may be linked to the programming of some specific functions (GRAPHITRON), because without them the Sock program works correctly.

The problem may also be due to the presence into the machine of a Dinema Testing software, inserted for the assessment of eventually malfunctions.

- In these cases require the Lonati a standard software Update for the evaluation of the problem.

If the problem persists:
The cause of the problem must be search in the Hardware chain for the counting management.
Proceed as follows to solve the problem:

- Check the wiring between the Pcb_2008 board and the Motor Drive board.
- Check the wiring between the Motor Resolver and the Motor Drive board.
- Replace the Motor Drive board.
- Replace the board Pcb_2008.
- Replace the motor.
- Replace the resolver.

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Messages on operations in FLASH

Ma18: End of writing on FLASH. Switch off machin

This alarm appears at the end of a generic writing in FLASH memory of a board (saving data or Software Update).
The user is also obliged by the alarm to turn off the machine.
The next time the machine will be turned on it will use the data previously saved.

Ma19: Writing FLASH impossible

This alarm appears if is failed the generic writing in FLASH memory of a board (Saving Data or Software Update).
Practically, the operation has not positive outcome, and the data are not saved.
The most common causes that determine this problem are:

- An hardware defect of the board on which are copied the data.
  Replace the board concerned.
- A wrong size in the Software of the space available for data saving, or however in general a problem in the machine software.

Notice

Attention

Before replacing the boards or intervening in any way:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Ma20: Operation finished Switch mach. OFF

This alarm appears at the end of an operation of software Update through activation of a ".up" file.
The user is also obliged by the alarm to turn off the machine.
The next turning on the machine it is working with the new software version.

Messages on the CAN communication (Tx)

Ma23: TX CAN ECODD impossible

This is an internal alarm, it indicates that the machine software is not able to communicate properly through the CAN line with the CAN modules, and then send and receive the operation data.
This particular alarm is detected by this specific "Task".
It also concerns CAN communication with the Motor Drive board ECODD15.
This problem is probably due to a software failure, and it is supposed it will never be displayed to the user.

Notice

Attention

Contact Lonati technical staff for further information and for an eventual Software update.

Ma29: TX CAN 3ENC board impossible

This is an internal alarm, it indicates that the machine software is not able to communicate properly through the CAN line with the CAN modules, and then send and receive the operation data.
This particular alarm is detected by this specific "Task".
The message refers to the CAN communication with the board Pcb_4752.
This problem is probably due to a software failure, and it is supposed it will never be displayed to the user.

Notice

Attention

Contact Lonati technical staff for further information and for an eventual Software update.

This alarm refers to internal software management.
This alarm appears when a machine software error (custom) occurs in:
- implementation of the logic of operation.

This problem is probably due to a software failure, and it is supposed it will never be displayed to the user.

Notice

Attention

Contact Lonati technical staff for further information and for an eventual Software update.

Messages on HARDWARE faulty

MAuA01: WATCH-DOG CIO

This alarm indicates that communication between the main processor (Pcb_2007) and the DSP on the board (Pcb_3820) is interrupted.
There is virturally no communication between these two boards.
When communication is correct, the Led Pcb_2008 Ds33 light flashes, otherwise it switches off.
Proceed as follows to solve the problem:
- Check the integrity of the connection “flat” cable between the 2 boards.
- Replace the board Pcb_2008.
- Replace the board Pcb_2007.

Notice

Attention

Before replacing the boards or intervening in any way:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

MAuA02: WATCH-DOG Drums

This alarm indicates that communication between the main processor (Pcb_2007) and the logic interface board of the pattern drums (Pcb_3820) is interrupted.
There is virturally no communication between these two boards.
When communication is correct, the Led Pcb_3820 Ds1 light flashes, otherwise it switches off.
Proceed as follows to solve the problem:
- Check the integrity of the connection “flat” cable between the 2 boards.
- Replace the board Pcb_3820.
- Replace the board Pcb_2007.

Notice

Attention

Before replacing the boards or intervening in any way:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Messages on Zero cylinder management

MAuA03: Mechanical zero not acquired

This alarm appears at the Working entry, and informs the user that there is no value for the “Mechanical Zero” data.
The machine to work properly must have acquired and stored a value (almost a “offset”) which indicates the differnce (phasing) between the electrical Zero and the mechanical Zero, and is used for the calculation of the real machine Zero.
If no value is available appears this alarm.

- The solution is to access the machine Setup and acquire the “Mechanical Zero” through the proper procedure.

However we must distinguish 2 different situations due to the machine arrangement.

A. Machine equipped with the “Motor drive control” board of the type RUNNER
B. Machine equipped with the “Motor drive control” board of the type ECODD15

Machine equipped with the “Motor drive control” board of the type RUNNER

With this preparation this error can never appear.
In these conditions the mechanical Zero is executed and stored directly on the RUNNER Motor Drive board, no data is present on the Pcb_2007 board.

Motor Drive board type RUNNER: Mechanical Zero management

This Mechanical Zero is a configuration contained into the Motor Drive itself, in case of its replacement or inversion with other machine the user should run a new acquisition of this Zero.

Machine equipped with the “Motor drive control” board of the type ECODD15

In the second case is succeeded a completely new management.
This ECODD Motor Drive board is connected through a CAN protocol to the Pcb_2008 board.
All of the operating parameters of the Motor Drive board are contained in the software of personalization of the machine (“eprom custom”).
When the machine is turned on they are being sent to the ECODD Motor Drive board, which will be adapted to the machine model.
The machine (software) recognised in automatic the type of Motor Drive board that is mounted.
If is present and active on the CAN line, assumes that the machine is equipped with the Motor Drive board of type ECODD and performs accordingly.
The operation data will be sent to the Motor Drive board, also will use a “set” of “Heel parameters” specific for this type of Motor Drive board.
Otherwise it is ready for operation with a Motor Drive board of type RUNNER.

In case of ECODD Motor Drive board, the “Mechanical Zero”, besides that be stored in the FLASH memory of the Pcb_2007 board (machine Setup), is also stored in the FLASH memory of the Motor Drive board.
In this way the same data (“Mechanical Zero”) is stored in 2 places physical different, on the Pcb_2007 board and on ECODD Motor Drive board.
This dual system of storage of the “Mechanical Zero” allows the software to run to each turning on the machine a check of coherence of the 2 data.
This fact was not possible with the previous RUNNER Motor Drive board, as there was no CAN link between it and the logic board of the machine.

This alarm appears when the value of “Mechanical Zero” is absent, as well as in the machine Setup (FLASH memory of the Pcb_2007 board), also in the memory of the ECODD Motor Drive board.
Through this message the software informs the user that in both the memory locations is not written any valid data.
Therefore the user is obliged to perform a procedure for the Mechanical Zero acquisition.

This alarm appears at the Working entry, if the machine Setup is not considered valid and if no “Mechanical Zero” is stored on the Motor Drive board.
This usually happens the first turning on the machine, after the assembly of the machine.
Subsequently not should never appear, as the zero is located on 2 different boards (Pcb_2007 and ECODD Motor Drive board).
If are not replace the 2 boards at the same time is always possible to copy this Zero from a board to the other (keys [FN] + [A] or [FN] + [Z]).

Advice for the user.

In all these situations in which is acquired a Mechanical Zero (particularly when was confirmed a Zero with [FN] + [A] or [FN] + [Z]) is recommended that the user checks that if the acquired Zero corresponds to the Mechanical Zero.
Therefore with [F1] (stop chain) active and machine at the step Zero, to start the machine and ensure that the Zero degree on the machine Display corresponds with the actual Zero actual of the cylinder.
This actual Mechanical Zero depends by the various machine models (first long-butt needle or first short-butt needle), but generally the marked canal (with the electric pen) of the cylinder must be in correspondence to a fixed point of the cylinder support (hole of Zero, stitch cam, etc.).

Notice

Note

In the case of ECODD Motor Drive board the functioning data specific for the macchine model are present in the machine software (eprom custom).
When the machine is turned on they are being sent to the ECODD Motor Drive board, which will be adapted to the machine model.
The ECODD Motor Drive Boards are therefore equal for all the models of Lonati machine.
In addition to these operation data used directly by Motor Drive board there are also the “Heel parameters” used by the machine software.
Between the 2 types of Motor Drive board, RUNNER and ECODD, these parameters are different.
These 2 “Set” of parameters are both available in the machine software, which recognizes the type of Motor Drive board mounted and automatically use the correct “Set”.

Reference

For information on the “Mechanical zero acquisition” procedure see the section :
Procedure of “Mechanical zero acquisition” for:
Machines GOAL / PANTYHOSE

Furthers informations are available in :
GUIDE OF USER INTERFACE
1. Motor setup

Internal software failure

Ma21: Setup elements number not correct

This alarm refers to internal software management.
This particular alarm is detected by this specific “Task”.
This problem is probably due to a software failure, and it is supposed it will never be displayed to the user.

Notice

Attention

Contact Lonati technical staff for further information and for an eventual Software update.

MOTO

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Mo1: Excessive motor speed
Mo2: Defective motor resolver
Mo3: Motor resolver not connected
Mo4: Contactor already open
Mo6: WATCH DOG ECODD
Mo7: Parameters for different actuation
Mo8: Speed change failed
Mo14: Enter in Heel failed
Mo16: BLACK-OUT Failed
Mo9: Data saved. Switch machine OFF
Mo17: FLASH reading/writing failed
Mo10: Configuration commands wrong
Mo18: Setup elements number not correct
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Messages on the Motor and Resolver management

Mo1: Excessive motor speed

This alarm appear when the motor speed is higher than the maximum speed allowed by the machine software.
The control of this speed is done through the Resolver/Encoder signals.
In the programming is not allowed set a speed higher than the limit referred to, so the cause of the problem must be serched in the hardware chain for the command of the motor.

Proceed as follows to solve the problem:

- Check the wiring between the Pcb_2008 board and the Motor Drive board.
- Check the wiring between the Motor Resolver and the Motor Drive board.
- Replace the Motor Drive board.
- Replace the board Pcb_2008.
- Replace the motor.
- Replace the resolver.

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Mo2: Defective motor resolver

This alarm appears when arrive Encoder phases not valid to the board of counting management.
The cause of the problem must be search in the Hardware chain for the counting management.

Proceed as follows to solve the problem:

- Check the wiring between the Pcb_2008 board and the Motor Drive board.
- Replace the Motor Drive board.
- Replace the board Pcb_2008.

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Mo3: Motor resolver not connected

This alarm appears when not arrive one Encoder phase to the board of counting management.
The cause of the problem must be search in the Hardware chain for the counting management.

Proceed as follows to solve the problem:
- Check the wiring between the Pcb_2008 board and the Motor Drive board.
- Replace the Motor Drive board.
- Replace the board Pcb_2008.

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Messages on HARDWARE faulty

Mo4: Contactor already open

The “Motor Contactor” is a component place between the power output of the Motor Drive board and the input of the main motor.
Through a command this relay is closed and the power tension from the Motor Drive board can reach the Motor itself.
To avoid damage of the contacts of this Contactor the change of status of the command that opens or closes the contacts of the Relay must follow precise rules.

The change of status of the Relay command should never be done with voltage to the heads of Contactor. In particular the situation more dangerous to remove the Relay command is when the motor is stationary in torque.

The torque on the motor is determined by the arrival of a “Software Enable” to the Motor Drive board.

Therefore the rule is that the opening command of Contactor must be given only after the software has removed the “Enable” signal on the Motor Drive board.

When the “Enable” signal is removed, if the software detects that the Contactor is already open (this through the auxiliary contact of the Contactor himself), the machine displays this alarm.
This alarm is a symptom of malfunction, because this is logically impossible.
Should not appear, if not in the case of anomalous situations especially in the case of continue and not coherent pressures of the [Handle 1] key.

In the event of frequent appearance of this problem provide for the replacement of the Motor Contactor.

Notice

Note

From a specific software version, in addition to this alarm, the Motor Contactor management also provides for a control of the status (open or closed) of this Relay, which is thus always controlled.
Considering the status of the Contactor “Auxiliary contact”, in the case of position not correct, the software is able to intervene immediately with a position error of the Contactor.
In fact, depending of the command status, the Contactor “Auxiliary contact” must be in a given position (Open or Closed).

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Reference

Furthers informations are available in the section :

MANAGEMENT OF THE START/STOP CONTACTOR

Mo6: WATCH DOG ECODD

This message informs the user that has been detected an error on the communication with the board Pcb_2008 that generate a general malfunction of the Motor Drive board.
This alarm is detected by the machine software, which does not communicate with the Motor Drive board.
The next time the machine will be turned on, in the case continues the absence of CAN communication between the 2 boards, will not appear more this alarm, but the generic error “Motor Drive alarm”.
Proceed as follows to solve the problem:

- Check the wiring between the Pcb_2008 board and the Motor Drive board.
- Replace the Motor Drive board.
- Replace the board Pcb_2008.

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Messages on the management of the various Drive motor board

Mo7: Parameters for different actuation

This alarm appears when Turning on the machine if the software notes that has been changed the type of Motor Drive bourd present into the machine.
If you pass by a RUNNER Motor Drive board to a ECODD15 board in CAN, or vice versa, the software can see the difference and view this alarm.
The user, following this alarm is obliged to perform a “Heel parameters” Reset, so to activate the DEFAULT parameters (standard) valid for the4 new type of Motor Drive board present.
Only after this Reset, the next turning on the machine will not appear more this alarm.

This procedure is made necessary by the fact that the 2 types of Motor Drive board use different “Set” of Heel Parameters, in this way avoids the most possible errors in the set of these parameters.
The software recognizes the type of Motor Drive board mounted considering the presence of the CAN line.
If by the CAN line are transmitted valid data the software configure it for the operation with the ECODD Motor Drive board; otherwise (absence of the CAN line) configure it for the operation with the RUNNER Motor Drive board.

Notice

Attention

In case of machine equipped with ECODD Motyor Drive board and absence of the CAN line (for example for a connection error of the cable), the machine configures it for the RUNNER type, but will display the generic error generic of “MOTOR DRIVE BOARD alarm”.
The reason is that the line of error relative the RUNNER Motor Drive board is not closed, beacuse is present an ECODD Motor Drive board.
In these cases the user should intervene to solve the cable error.

Reference

Furthers informations are available in the section :
CHuE03

Furthers informations are available in :
GUIDE OF USER INTERFACE

1. -SETUP MOTO
2. Hell parameters

Messages on Hw/Sw faulty

Mo8: Speed change failed

This is an internal alarm, indicates that the machine software has generated command ramps for the motor not correct.
This problem is probably due to a software failure, and it is supposed it will never be displayed to the user.
Theoretically this error may be caused by a hardware defect of the Pcb_2008 board or by the [Motor Drive board + Resolver] system, but it is very unlikely.

Notice

Attention

Contact Lonati technical staff for further information and for an eventual Software update.

Mo14: Enter in Heel failed

This alarm appears in the case of incorrect programming of the Heel entry by GRAPHITRON.

- Check the proper programming (GRAPHITRON) of the Heel Enter and Toe Enter functions in the Sock Program active.

A hardware defect in the motor control, sending Encoder/Resolver signals not correct, can cause this alarm.
Check and if necessary replace all the hardware components linked to the Encoder counter.

- Check the wiring between the Pcb_2008 board and the Motor Drive board.
- Check the wiring between the Motor Drive board and the Motor.
- Replace the Motor Drive board.
- Replace the board Pcb_2008.
- Replace the motor.
- Replace the resolver.

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Mo16: BLACK-OUT Failed

This alarm appear during the “Black-out” procedure, if the software retains to have losto some information related to the status of the software management on the motor movement.
In practice, during the procedure of saving information made by the software as a result of “Black-out”, it detects an internal error.
This alarm alerts the user that the “Black-out” procedure is failed.
This problem is probably due to a software failure, and it is supposed it will never be displayed to the user.

A hardware defect in the management of the “Black-out” procedure can cause this alarm.
Check and if necessary replace all the hardware components linked to the “Black-out” procedure.

- Check the wiring between the Black-Out batteries, the Pcb_3787B/1 Supplier board and the Pcb_3812 board.
- Replace the “Black-out” batteries (12 volt x 2).
- Replace the board Pcb_3787B/1.
- Replace the board Pcb_3812.
- Replace the board Pcb_2008.

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Messages on operations in FLASH

Mo9: Data saved. Switch machine OFF

This message appears at the end of the operation of Setup Configuration or Setup Reset after the saving request of the modified data.
These data are related to the motor functioning (for example Heel Parameters and Acceleration).
The user is also obliged by the alarm to turn off the machine.
The next time the machine will be turned on it will use the data previously saved.
In case of Reset instead will be used the DEFAULT values present in the machine software (“eprom custom”).

Mo17: FLASH reading/writing failed

This alarm appears if, during an operation of Setup configuration, the attempt to read the Setup in the FLASH memory of the Pcb_2007 board fails.
In practice the software must re-read the values present in FLASH memory and then write them in RAM memory.
This particular alarm refers to the part of Setup on the “Heel Parameters and Heel Accelerations”.
The most common causes that determine this problem are:

- An hardware malfunction of the board Pcb_2007.
  Replace the board Pcb_2007.
- A wrong size in the Software of the space available for data saving, or however in general a problem in the machine software.

Notice

Attention

Before replacing the boards or intervening in any way:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Messages on problems in the Software Management

Mo10: Configuration commands wrong

This alarm refers to internal software management.
This alarm appears when the management software of the motor is blocked.
This problem is probably due to a software failure, and it is supposed it will never be displayed to the user.

Notice

Attention

Contact Lonati technical staff for further information and for an eventual Software update.

Internal software failure

Mo18: Setup elements number not correct

This alarm refers to internal software management.
This particular alarm is detected by this specific “Task”.
This problem is probably due to a software failure, and it is supposed it will never be displayed to the user.

Notice

Attention

Contact Lonati technical staff for further information and for an eventual Software update.

MPP

Mp1: Subprogram MPP missing
Mp3: Step not executed
Mp7: Manual command number not existing
Mp17: Command GR6 tolerance degrees exceeded
Mp21: Special manual parameters wrong
Mp4: MPP number command GR6 not existing
Mp5: Code MPP command GR6 not existing
Mp6: MPP type command GR6 not existing
Mp8: MPP number manual command not existing
Mp9: MPP code manual command not existing
Mp10: MPP type manual command not existing
Mp11: MPP number not existing utility command
Mp12: MPP code utility command not existing
Mp13: MPP type utility command not existing
Mp14: MPP number in IN/OUT status not existing
Mp15: MPP code in IN/OUT status not existing
Mp16: MPP type in IN/OUT status not existing
Mp20: Codify not compatible SW Sub-program MPP
Mp24: Codify not compatible SW Sub-program EMPP
Mp25: Commands crossing with machine stopped
Mp28: Time out CAN busy MPP
Mp2: MPP Motor not numbered
Mp27: TX CAN impossible MPP
MPuA05: END RUN DIAL MOTOR
MPuA06: Mpp dial not at zero mach. Tampering off
Mp26: Setup elements number not correct
Mp19: BIT CONFIGURATION NOT OK

Messages on problems in the Software Management

Mp1: Subprogram MPP missing

This alarm indicates incompatibility between the programming software (GRAPHITRON) and the machine software (Eproms).
In this case, a part of the software expected by the machine is missing.

- The solution, depending on the case, is to update the machine software (Eproms) or the GRAPHITRON software.

Other causes for this problem may be the machine software or programming software not valid because damaged or containing a mistake.

- Also in this case, the solution is to run the software update with a valid and compatible version.

Notice

Attention

Contact Lonati technical staff for further information and for an eventual Software update.

Mp3: Step not executed

Mp7: Manual command number not existing

Mp17: Command GR6 tolerance degrees exceeded

Mp21: Special manual parameters wrong

This alarm indicates incompatibility between the programming software (GRAPHITRON) and the machine software

(Eproms).

- The solution, depending on the case, is to update the machine software (Eproms) or the GRAPHITRON software.

Other causes for this problem may be the machine software or programming software not valid because damaged or containing a mistake.

- Also in this case, the solution is to run the software update with a valid and compatible version.

Notice

Attention

Contact Lonati technical staff for further information and for an eventual Software update.

Mp4: MPP number command GR6 not existing

Mp5: Code MPP command GR6 not existing

Mp6: MPP type command GR6 not existing

Mp8: MPP number manual command not existing

Mp9: MPP code manual command not existing

Mp10: MPP type manual command not existing

Mp11: MPP number not existing utility command

Mp12: MPP code utility command not existing

Mp13: MPP type utility command not existing

Mp14: MPP number in IN/OUT status not existing

Mp15: MPP code in IN/OUT status not existing

Mp16: MPP type in IN/OUT status not existing

This alarm indicates incompatibility between the programming software (GRAPHITRON) and the machine software (Eproms).

- The solution, depending on the case, is to update the machine software (Eproms) or the GRAPHITRON software.

Other causes for this problem may be the machine software or programming software not valid because damaged or containing a mistake.

- Also in this case, the solution is to run the software update with a valid and compatible version.

Notice

Attention

Contact Lonati technical staff for further information and for an eventual Software update.

Mp20: Codify not compatible SW Sub-program MPP

Mp24: Codify not compatible SW Sub-program EMPP

This alarm indicates incompatibility between the programming software (GRAPHITRON) and the machine software (Eproms).

- The solution, depending on the case, is to update the machine software (Eproms) or the GRAPHITRON software.

Other causes for this problem may be the machine software or programming software not valid because damaged or containing a mistake.

- Also in this case, the solution is to run the software update with a valid and compatible version.

Notice

Attention

Contact Lonati technical staff for further information and for an eventual Software update.

Mp25: Commands crossing with machine stopped

This alarm appears when the software in the time given is not able to carry out all the operations expected by the software.
In this particular case the operations must be carried out in a point of the Sock Program in which the machine is stopped.
Each operation must be carried out within a certain time, otherwise appears this alarm.

Generally the uncompleted operations are relative the movement of some stepping motors.

Verify which movements do not have been completed and then check all the components linked to these movements.

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Mp28: Time out CAN busy MPP

This is a system error, it means that in the maximum time for the operation on the CAN line, the system has not been answered (logic timeout).
This problem is probably due to a software failure, and it is supposed it will never be displayed to the user.
However, can exist situations or hardware broken that could cause the appearance of this error.

In case of the occurrence of this error after a Software Update.

- *Run again the Updating procedure, is possible that the copy operation of Software in FLASH memory is not carried out correctly.*

Even if not specific with respect to the real problem, this error may appear in the event of an hardware problem (a fault):

- *To any CAN module.*
- *To the board Pcb_2008.*
- *To the wirings between these boards.*

- A problem in the software writing, an hardware problem on the CAN boards, a disorder on the CAN transmission:
  All these conditions may cause CAN Errors/Alarms not related to the real failure, but General of the CAN system.

Therefore in general, for all the CAN Errors/Alarms, after having evaluated the specific problem indicated by error, also to assess as a possible cause a general problem of the CAN system (software and hardware).

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Messages on CAN modules not numbered

Mp2: MPP Motor not numbered

Each stepping motor enabled by software or Setup must be associated with a CAN module (CAN board for the motors

control).
In practice, for each enabled motor, its identification number must be associated with a CAN module.
If this not happens, when turn on the machine the software displays an alarm of: “Motor not numbered (associated)”, generic of the “Tasks” to which belongs the motor not associated.
This “Task” (“Mpp”) refers, for instance, to VPE motor.

- The solution is access to the CAN modules Setup and proceed to the Association of motors to the CAN modules.

Reference

All information relating to the CAN management procedures, (Association, Numbering, etc.) are available in:
GUIDE OF USER INTERFACE

1. Numeration motor CAN

Messages on the CAN communication (Tx)

Mp27: TX CAN impossible MPP

This is an internal alarm, it indicates that the machine software is not able to communicate properly through the CAN line with the CAN modules, and then send and receive the operation data.
This particular alarm is detected by this specific “Task”.
This problem is probably due to a software failure, and it is supposed it will never be displayed to the user.

Notice

Attention

Contact Lonati technical staff for further information and for an eventual Software update.

Messages on the Dial management

MPuA05: END RUN DIAL MOTOR

This message informs the user that the “Dial”, following a manual command ([Dial Lower]), has reached the “End of Run” position, down more than the Zero position.
Through the encoder connected to the “Dial” is always controlled the device position.
There is also a Zero sensor for the control of the lower position (“Dial” low).

When run a manual command [Dial Lower] the number of steps made must enable the “Dial” to reach the proper lower position (Encoder at Zero).
Reached this share the Zero sensor must be in reading.
This alarm appears when the Zero sensor is in reading before the “Dial” motor has finished its movement.
In practice, the “Dial” is found in a position that is lower than the set one.

- The restoration is no longer possible, and then the alarm forces the user to turn off and on the machine.

MPuA06: Mpp dial not at zero mach. Tampering off

This message informs the user that the “Dial”, following a manual command ([Dial Lower]), has not reached the Zero position (“Dial” low).
Through the encoder connected to the “Dial” is always controlled the device position.
There is also a Zero sensor for the control of the lower position (“Dial” low).

When run a manual command [Dial Lower] the number of steps made must enable the “Dial” to reach the proper lower position (Encoder at Zero).
Reached this share the Zero sensor must be in reading.
This alarm appears when the Zero sensor is not in reading when the “Dial” motor has finished its movement.
In practice, the “Dial” is found in a position that is higher than the set one.

- The restoration is no longer possible, and then the alarm forces the user to turn off and on the machine.

Internal software failure

Mp26: Setup elements number not correct

This alarm refers to internal software management.
This particular alarm is detected by this specific “Task”.
This problem is probably due to a software failure, and it is supposed it will never be displayed to the user.

Notice

Attention

Contact Lonati technical staff for further information and for an eventual Software update.

Mp19: BIT CONFIGURATION NOT OK

This alarm appears when the software notes a situation not expected during a status passage internal to the machine software (incorrect values for registers or data).
This particular alarm is detected by this specific “Task”.
The cause could be an anomaly in the the main microprocessor functioning of the Pcb_2007 board.

Notice

Attention

Before replacing the boards or intervening in any way:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

REST

Re1: End of zone not reached
Re4: Cylinder diameter not correct
Re10: For-step crossed with graduation
Re14: Index of check absent
REuA31: Knit stitch cam gauge not compatible with coded
Re2: Maintenance not correct
Re3: Motor number wrong
Re6: Codify incompatible SW subprogram REST
Re7: Codify incompatible SW subprogram CLUN
Re9: REST logics params. not correct
Re12: TX Can impossible REST
Re13: Motors MPP-REST NOT numbered
REuA05: Graduation motor zone not found
REuA06: Sinkers pressure motor zone not found
REuA07: Sinker cap position motor zone not found
REuA21: Zone not found Heel Return Stitch Cam Motor
REuA23: Zone not found Stitch Cam Motor Feed 1
REuA25: Zone not found Stitch Cam Motor Feed 2
REuA27: Zone not found Stitch Cam Motor Feed 3
REuA29: Zone not found Stitch Cam Motor Feed 4
Re8: Setup elements number not correct
Re5: BIT CONFIGURATION NOT OK

Messages on Programming and Setup

Re1: End of zone not reached

This alarm appear when during a “Graduation” the current step chain was incongruous with the codifying of the Graduation Zones foreseen in the codified program (GRAPHITRON).
This particular “Graduation” is a linear variation of Knitting.
The cause of this problem can only be a wrong user programming by GRAPHITRON.

- The solution is correct the program or create a new one.

Other causes for this problem may be the machine software or programming software not valid because damaged or containing a mistake.

- The solution, depending on the case, is to update the machine software (Eproms) or the GRAPHITRON software.

Notice

Attention

Contact Lonati technical staff for further information and for an eventual Software update.

Re4: Cylinder diameter not correct

This alarm is displayed when, on Sock Program activation, the software detects a difference between the “Cylinder Diameter” in the Coded Program and that under machine Setup.
The user is required to check the “Diameter of cylinder” set in the Sock Program and compare it with that shown in the machine identification plate.

- If it doesn’t corresponds, correct the Sock Program by GRAPHITRON.
- If it corresponds, access to the machine Setup and set the correct value.

A typical situation in which may appear this problem is a result of a Setup Reset or replacement of the Pcb_2007 board. In both cases the user is obliged to set again the Setup, with the possibility of oversight or error in the set of this value.

Reference

Furthers informations are available in :
GUIDE OF USER INTERFACE
1. Select cylinder diameter

Re10: For-step crossed with graduation

This alarm alerts the user that was committed a programming error by GRAPHITRON.
The inclusion of the “For-Step” function (repeat for “n” times of a sequence of steps into the program) is not correct.
This function interferes with programming of “Graduation” regarding a “Rest” motor (e.g. a “Stitch” motor).
In practice the programming of “Start” and “End” of the Graduation are one inside and one outside (or vice versa) of the sequence of repeated steps (the “For-Step”).

- The solution is to correct the Program.
  This is because the positioning of the “For-Step” is wrong.

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Re14: Index of check absent

This alarm alerts the user that was committed a programming error by GRAPHITRON.
The machine software notes misalignment between the Sock Program and the rules provided for by the software itself.
The machine software not found coherent data in the Sock Program as regards the Stitych motor programming in some specific articles.

- The solution is to correct the Program.

Other causes for this problem may be the machine software or programming software not valid because damaged or containing a mistake.

- The solution, depending on the case, is to update the machine software (Eproms) or the GRAPHITRON software.

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

REuA31: Knit stitch cam gauge not compatible with coded

This alarm is displayed when, on Sock Program activation, the software detects a difference between the type of “Stitch Cam” in the Coded Program and that under machine Setup.
The user is required to check the type of “Stitch cams” set in the Sock Program and compare it with that set in the machine Setup.

- If it doesn’t corresponds, correct the Sock Program by GRAPHITRON.
- If it corresponds, access to the machine Setup and set the correct value.

A typical situation in which may appear this problem is a result of a Setup Reset or replacement of the Pcb_2007 board.
In both cases the user is obliged to set again the Setup, with the possibility of oversight or error in the set of this value.

Messages on the speed of data processing

Re2: Maintenance not correct

This alarm appears when a machine command (relative this Task of the Software) was not executed in the estimated time.

In the time unit the software was no able to complete all the operations in execution.
The most common causes that determine this problem are:

- An hardware malfunction of the board Pcb_2007.
  Replace the board Pcb_2007.
- A wrong size in the Software of the space available for data saving, or however in general a problem in the machine software.

Notice

Attention

Before replacing the boards or intervening in any way:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Messages on problems in the Software Management

Re3: Motor number wrong

This alarm indicates incompatibility between the programming software (GRAPHITRON) and the machine software (Eproms).
In particular the number of “Rest” motors (for example the “Stitch” motors) codified in the Sock Program is higher than the number provided in the machine software (“eprom custom”).

- The solution, depending on the case, is to update the machine software (Eproms) or the GRAPHITRON software.

Other causes for this problem may be the machine software or programming software not valid because damaged or containing a mistake.

- Also in this case, the solution is to run the software update with a valid and compatible version.

Notice

Attention

Contact Lonati technical staff for further information and for an eventual Software update.

Re6: Codify incompatible SW subprogram REST

Re7: Codify incompatible SW subprogram CLUN

This alarm indicates incompatibility between the programming software (GRAPHITRON) and the machine software (Eproms).

- The solution, depending on the case, is to update the machine software (Eproms) or the GRAPHITRON software.

Other causes for this problem may be the machine software or programming software not valid because damaged or containing a mistake.

- Also in this case, the solution is to run the software update with a valid and compatible version.

Notice

Attention

Contact Lonati technical staff for further information and for an eventual Software update.

Re9: REST logics params. not correct

This alarm refers to internal software management.
This particular alarm is detected by this specific “Task”.
This problem is probably due to a software failure, and it is supposed it will never be displayed to the user.

Notice

Attention

Contact Lonati technical staff for further information and for an eventual Software update.

Messages on the CAN communication (Tx)

Re12: TX Can impossible REST

This is an internal alarm, it indicates that the machine software is not able to communicate properly through the CAN line with the CAN modules, and then send and receive the operation data.
This particular alarm is detected by this specific “Task”.
This problem is probably due to a software failure, and it is supposed it will never be displayed to the user.

Notice

Attention

Contact Lonati technical staff for further information and for an eventual Software update.

Messages on CAN modules not numbered

Re13: Motors MPP-REST NOT numbered

Each stepping motor enabled by software or Setup must be associated with a CAN module (CAN board for the motors control).
In practice, for each enabled motor, its identification number must be associated with a CAN module.
If this not happens, when turn on the machine the software displays an alarm of: “Motor not numbered (associated)”, generic of the “Tasks” to which belongs the motor not associated.
This “Task” (“Rest”) refers, for instance, to “Stitch” control motors.

- The solution is access to the CAN modules Setup and proceed to the Association of motors to the CAN modules.

Reference

All information relating to the CAN management procedures, (Association, Numbering, etc.) are available in:
GUIDE OF USER INTERFACE

1. Numeration motor CAN

Messages on the management: [Zone not found]

REuA05: Graduation motor zone not found

REuA06: Sinkers pressure motor zone not found

REuA07: Sinker cap position motor zone not found

REuA21: Zone not found Heel Return Stitch Cam Motor

REuA23: Zone not found Stitch Cam Motor Feed 1

REuA25: Zone not found Stitch Cam Motor Feed 2

REuA27: Zone not found Stitch Cam Motor Feed 3

REuA29: Zone not found Stitch Cam Motor Feed 4

This alarm indicates incompatibility between the programming software (GRAPHITRON) and the machine software (Eproms).

In particular has not been found at least one “Stitch” motor Zone indicated in the message.

- The solution, depending on the case, is to update the machine software (Eproms) or the GRAPHITRON software.

Other causes for this problem may be the machine software or programming software not valid because damaged or containing a mistake.

- Also in this case, the solution is to run the software update with a valid and compatible version.

Notice

Attention

Contact Lonati technical staff for further information and for an eventual Software update.

Internal software failure

Re8: Setup elements number not correct

This alarm refers to internal software management.
This particular alarm is detected by this specific “Task”.
This problem is probably due to a software failure, and it is supposed it will never be displayed to the user.

Notice

Attention

Contact Lonati technical staff for further information and for an eventual Software update.

Re5: BIT CONFIGURATION NOT OK

This alarm appears when the software notes a situation not expected during a status passage internal to the machine software (incorrect values for registers or data).
This particular alarm is detected by this specific “Task”.
The cause could be an anomaly in the the main microprocessor functioning of the Pcb_2007 board.

Notice

Attention

Before replacing the boards or intervening in any way:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

SCORE

Sc2: Setup elements number not correct
Sc1: BIT CONFIGURATION NOT OK

Internal software failure

Sc2: Setup elements number not correct

This alarm refers to internal software management.
This particular alarm is detected by this specific “Task”.
This problem is probably due to a software failure, and it is supposed it will never be displayed to the user.

Notice

Attention

Contact Lonati technical staff for further information and for an eventual Software update.

Sc1: BIT CONFIGURATION NOT OK

This alarm appears when the software notes a situation not expected during a status passage internal to the machine software (incorrect values for registers or data).
This particular alarm is detected by this specific “Task”.
The cause could be an anomaly in the the main microprocessor functioning of the Pcb_2007 board.

Notice

Attention

Before replacing the boards or intervening in any way:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

YARN

Ya1: Previous movement not finished
Ya7: For-step programmed crossed
Ya2: Degrees maintenance too slow
Ya3: Number of motors is wrong
Ya5: Wrong codify version subprogram YARN
Ya6: Setup elements number not correct
Ya4: BIT CONFIGURATION NOT OK
Ya8: TX CAN impossible MPP-YARN
Ya12: TX CAN impossible YOYO
Ya9: Motor MPP-YARN NOT numbered
Ya10: Motor YOYO "x" not numbered

Messages on Programming and Setup

Ya1: Previous movement not finished

This alarm appear when during a "Graduation" the current step chain was incongruous with the codifying of the Graduation Zones foreseen in the codified program (GRAPHITRON).
This particular "Graduation" is a linear variation of Elastic.
The cause of this problem can only be a wrong user programming by GRAPHITRON.

- The solution is correct the program or create a new one.

Another possible cause is a problem in the software programming (GRAPHITRON).

Notice

Attention

Contact Lonati technical staff for further information and for an eventual Software update.

Ya7: For-step programmed crossed

This alarm alerts the user that was committed a programming error by GRAPHITRON.
The inclusion of the "For-Step" function (repeat for "n" times of a sequence of steps into the program) is not correct.
This function interferes with programming of "Graduation" regarding a "Yarn" motor (e.g. a "Elastic" motor).
In practice the programming of "Start" and "End" of the Graduation are one inside and one outside (or vice versa) of the sequence of repeated steps (the "For-Step").

- The solution is to correct the Program.
  This is because the positioning of the "For-Step" is wrong.

Notice

Attention

In case the problem remains:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Messages on the speed of data processing

Ya2: Degrees maintenance too slow

This alarm appears when a machine command (relative this Task of the Software) was not executed in the estimated time.
In the time unit the software was no able to complete all the operations in execution.
The most common causes that determine this problem are:

- An hardware malfunction of the board Pcb_2007.

Replace the board Pcb_2007.
- A problem in the machine software.

Notice

Attention

Before replacing the boards or intervening in any way:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Messages on problems in the Software Management

Ya3: Number of motors is wrong

This alarm indicates incompatibility between the programming software (GRAPHITRON) and the machine software (Eproms).
In particular the number of “Yarn” motors (for example the “Elastic” motors) codified in the Sock Program is higher than the number provided in the machine software (“eprom custom”).
- The solution, depending on the case, is to update the machine software (Eproms) or the GRAPHITRON software.

Other causes for this problem may be the machine software or programming software not valid because damaged or containing a mistake.
- Also in this case, the solution is to run the software update with a valid and compatible version.

Notice

Attention

Contact Lonati technical staff for further information and for an eventual Software update.

Ya5: Wrong codify version subprogram YARN

This alarm indicates incompatibility between the programming software (GRAPHITRON) and the machine software (Eproms).
- The solution, depending on the case, is to update the machine software (Eproms) or the GRAPHITRON software.

Other causes for this problem may be the machine software or programming software not valid because damaged or containing a mistake.
- Also in this case, the solution is to run the software update with a valid and compatible version.

Notice

Attention

Contact Lonati technical staff for further information and for an eventual Software update.

Internal software failure

Ya6: Setup elements number not correct

This alarm refers to internal software management.
This particular alarm is detected by this specific “Task”.
This problem is probably due to a software failure, and it is supposed it will never be displayed to the user.

Notice

Attention

Contact Lonati technical staff for further information and for an eventual Software update.

Ya4: BIT CONFIGURATION NOT OK

This alarm appears when the software notes a situation not expected during a status passage internal to the machine software (incorrect values for registers or data).
This particular alarm is detected by this specific “Task”.
The cause could be an anomaly in the the main microprocessor functioning of the Pcb_2007 board.

Notice

Attention

Before replacing the boards or intervening in any way:
Contact Lonati/Dinema engineers for an in-depth analysis of the problem and possible solutions.

Messages on the CAN communication (Tx)

Ya8: TX CAN impossible MPP-YARN

This is an internal alarm, it indicates that the machine software is not able to communicate properly through the CAN line with the CAN modules, and then send and receive the operation data.
This particular alarm is detected by this specific “Task”.
This problem is probably due to a software failure, and it is supposed it will never be displayed to the user.

Notice

Attention

Contact Lonati technical staff for further information and for an eventual Software update.

Ya12: TX CAN impossible YOYO

This is an internal alarm, it indicates that the machine software is not able to communicate properly through the CAN line with the CAN modules, and then send and receive the operation data.
This particular alarm is detected by this specific “Task”.
It also concerns CAN communication with the YOYO modules (motors).
This problem is probably due to a software failure, and it is supposed it will never be displayed to the user.

Notice

Attention

Contact Lonati technical staff for further information and for an eventual Software update.

Messages on CAN modules not numbered

Ya9: Motor MPP-YARN NOT numbered

Each stepping motor enabled by software or Setup must be associated with a CAN module (CAN board for the motors control).
In practice, for each enabled motor, its identification number must be associated with a CAN module.
If this not happens, when turn on the machine the software displays an alarm of: “Motor not numbered (associated)”, generic of the “Tasks” to which belongs the motor not associated.
This “Task” (“Yarn”) refers, for instance, to “Elastic” and PYF motors.

- The solution is access to the CAN modules Setup and proceed to the Association of motors to the CAN modules.

Reference

All information relating to the CAN management procedures, (Association, Numbering, etc.) are available in:
GUIDE OF USER INTERFACE

1. Numeration motor CAN

Ya10: Motor YOYO "x" not numbered

Each stepping motor enabled by software or Setup must be associated with a CAN module (CAN board for the motors control).
In practice, for each enabled motor, its identification number must be associated with a CAN module.
If this not happens, when turn on the machine the software displays an alarm of: "Motor not numbered (associated)", generic of the "Tasks" to which belongs the motor not associated.

- The solution is access to the CAN YOYO Setup and proceed to the Numbering of the motors.

This message refers to the YOYO motors connected to the CAN module.
Each YOYO motor is composed by the motor itself and by the CAN module for the command.
Each motor (to be Associated) corresponds to a CAN module which also corresponds to a single CAN board (to be Numbered).
Fong procedure automatically also executes the Association.

Reference

All information relating to the CAN management procedures, (Association, Numbering, etc.) are available in:
GUIDE OF USER INTERFACE

1. Setup YOYO in CAN
2. YOYO motors numbering

Lonati Reparto Grafica
Lonati Graphic Department