TROUBLESHOOTING

Models equipped with PCB 2009
Models equipped with PCB 2014

Version 0.9.B

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

Attention

KEEP THIS MANUAL AND HAND IT OVER TO ANY NEW OWNERS.

Date: 2020.07

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TROUBLESHOOTING

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The models to which this document relates

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GL616DF3	GL616DF3
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GK625CTE	GL625
GL625	GL625
GL625CTE	GL625

Model =   Name displayed on screen (Control panel).

Graphitron =   Name displayed on computer

Models

GL
Models equipped with PCB 2009
"Touch screen" colour display + Keyboard

GK
Models equipped with PCB 2014
"Touch screen" colour display

Models CTE = Models F , H = Stitch-by-stitch models (S by S) = Machine equipped with: Seaming
        Robot

DONNA machines

Model	Graphitron		Model	Graphitron
LA02MJ	LA02MJ		LA45-5P7	LA45-5P7
LB02MJ	LA02MJ		LB45-5P7	LA45-5P7
LA04E7	LA04E7		LA45-5T	LA45-5T
LB04E7	LA04E7		LB45-5T	LA45-5T
LA04JS	LA04JS		LA45E7	LA45E7
LB04JS	LA04JS		LB45E7	LA45E7
LA04M7	LA04M7		LB45ME	LA45ME
LB04M7	LA04M7		LA4TS	LA4TS
LA04MJ	LA04MJ		LB4TS	LA4TS
LB04MJ	LA04MJ		LB50ME	LA50ME
LA08MJ	LA08MJ		LB55ME	LA55ME
LB08MJ	LA08MJ		LB60ME	LA60ME
LA10	LA10-12		LB02MJ-T	LB02MJ-T
LA12-LA12J	LA10-12		LB08MJ-T	LB08MJ-T
LB10	LA10-12		LB4TS-T	LB4TS-T
LB12-LB12J	LA10-12		LBOP	LBOP
LA24	LA24E7			
LB24	LA24E7		LB10Y	LB10Y
LB40ME	LA40ME		LB12Y	LB12Y
			LB41TVE	LB41TVE
LB41TV	LA41TV			

Model = Name displayed on screen (Control panel).

Graphitron = Name displayed on computer

Models

LA
Models equipped with PCB 2009
"Touch screen" colour display + Keyboard

LB
Models equipped with PCB 2014
"Touch screen" colour display

DC88 machines

Model	Graphitron
DC88X-1	DC88X-1
DC88X-1J	DC88X-1J
DC88X-2	DC88X-2
DC88X-3	DC88X-3
DC880X-1	DC88X-1
DC880X-1J	DC88X-1J
DC880X-2	DC88X-2
DC880X-3	DC88X-3
DC880X-2S	DC88X-2S (ex DC88X-2)
DC880X-2SO	DC88X-2

Model =   Name displayed on screen (Control panel).

Graphitron =   Name displayed on computer

Characteristics

DC88X (*)   = Machine equipped with:
"Touch screen" colour display (Pcb 2014),
Seaming Robot (**Closed Toe**).

DC880X =   Machine equipped with:
"Touch screen" colour display (Pcb 2014),
(**Open Toe**).

- n =   Number of feeds = 1 / 2 / 3

J =   This code indicates: Accessories / Design variant = 3 Mono-Actuators

(*)   This type is also called: External Closed Toe (**CTE**)   Or …   Stitch-by-stitch models (S by S) .

Nomenclature

This is how the machines are commercially identified.

DC88X E1 d n p X a
DC88X E1 — This prefix indicates the family.

DC88X E1 This prefix indicates the family.

d This code indicates: Cylinder diameter
The variable can have the following values:
0 = 2" 3/4
1 = 3"
2 = 3" 1/4
3 = 3" 1/2
4 = 3" 3/4
5 = 4"
6 = 4" 1/2

n This code indicates: Number of feeds + Type of work
The variable can have the following values:
2 = 2 Feeds , Derby Links
3 = 2 Feeds , Links Jacquard
4 = 3 Feeds , Links Jacquard
6 = 1 Feed , Derby Links

p This code indicates: Equipment
The variable can have the following values:
0 = Open Toe ,   High speed
H = Closed Toe ,   High speed
S = Open Toe , Terry
F = Closed Toe , Terry

a This code indicates: Accessories / Design variant
The variable can have the following values:
3 = 3 Mono-Actuators (only for … 1-feed models)
 absent = Standard
S = Shoe (upper)

Update the Graphitron software

Select downloads .
Take the following points into consideration:
Number of feeds + Accessories .

Update the machine software

Select downloads .
Take the following points into consideration:
Number of feeds + Accessories + Equipment .

Path to reach the window

GOAL machines

Welt raier and dial manuals	Stop *
DINEMA Trace	R-Z / Z
Bobbin end	F
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Linker motor Help	Fn+C-Help
Help	R-Help / Help
Password level	key
Quick menu	R
Management menu	Space
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<u>Graduation menu</u>	Space-A-B
Mod. stitch q.ty by cm/inch (Rest CM zones / Rest zones Inch)	Space-A-B-A
Set CM zone / Set zone Inch	Space-A-B-A-ê
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Modify economizations on sigle zone	Space-A-E-ê
<u>Yarns sliding menu</u>	Space-A-F
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Enable yarns sliding control	Space-A-F-A-A
Yarn sliding sensors identification	Space-A-F-A-B
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Parameters of sensors	Space-A-F-A-C
Yarn sliding control help	Space-A-F-A-C-Help
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Identification of Scorfil added/removed sensors	Space-A-F-A-D
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  * = Hold down the button.
ê = Enter
p1, p2, etc. = Page 1, Page 2, etc

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YOYO manual	Space-A-H-B
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All-sizes modification enabling setup	Space-D-C-p1-A-C-B
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DONNA machines

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Password level	Key
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Yarnfingers manuals	Tab-p2-A
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General data setting	Space-A-E-A-A
Diameter setup	Space-A-E-A-A-A
Machine needles setup	Space-A-E-A-A-B
Dedicated devices setup	Space-A-E-A-B
Lubrication unit	Space-A-E-A-B-A/B
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Speed and rev limit control	Space-A-E-A-E-p2-C
Medium speed [F6] light	Space-A-E-A-E-p2-D
Emergency light out of run	Space-A-E-A-E-p2-E
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 * = Hold down the button.
ê = Enter
p1, p2, etc. = Page 1, Page 2, etc

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Motor drive speed setup	Space-A-E-C-A-B
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PID current setting	Space-A-E-C-A-C-A
PID speed setting	Space-A-E-C-A-C-B
PID position setting	Space-A-E-C-A-C-C
PID speed setting crank	Space-A-E-C-A-C-D
Mechanical zero	Space-A-E-C-B
Resolver timing	Space-A-E-C-C
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Change of display interface	Space-A-E-F-D
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Export file *.art	Space-C-G-A
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Total piece-counter menu	Space-E-B
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All-sizes modification enabling setup	Space-H-A-A-B
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Yarn management	Space-H-F
Yarns sliding menu	Space-I
Yarns sliding setup	Space-I-A
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Yarn sliding sensors identification	Space-I-A-B
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Parameters of sensors level	Space-I-A-C-0
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Autotest levers	Space-N-A-D
Autotest various outputs	Space-N-A-E
Step motors menu	Space-N-B
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Autotest VPE	Space-N-B-B
Autotest sinker cap	Space-N-B-C
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DC88 machines

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DINEMA Trace   R-Z

Manual EV   **Tab**
Sinkers change   Tab-P
Yarn carrier threading   Tab-Z

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Linker motor Help   Fn+C-Help

Password level   **Key**

Management menu   **Space**

Work menu   **Space-A**
Change active size   Space-A-A
Graduation menu   Space-A-B
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Set zone   Space-A-B-A-ê

Yarn modification   **Space-A-D**
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Elastic 1 (Modify elastic in percentage)   Space-A-D-A-B
Elastic 2 (Modify elastic in percentage)   Space-A-D-A-B
Elastic 1 (Yarn zone)   Space-A-D-B
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Elastic 2 (Yarn zone)   Space-A-D-C
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Lycra motor feed 1 (Yarn zone)   Space-A-D-E
Set zone   Space-A-D-E-ê
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Set zone   Space-A-D-F-ê

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ê = Enter
p1, p2, etc. = Page 1, Page 2, etc

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YOYO menu   **Space-A-H**
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All-sizes modification enabling setup   Space-A-H-A-A-B
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Cam and lever autotest	Space-D-A-A-D
Autotest outputs external closed toe	Space-D-A-A-F
Step motors menu	Space-D-A-B
Plain knit motor autotest	Space-D-A-B-A
Purl motor autotest	Space-D-A-B-B
Heel size motor selftest	Space-D-A-B-C
Autotest VPE	Space-D-A-B-D
Autotest MPP	Space-D-A-B-E
Autotest of inputs	Space-D-A-C
Autotest of inputs	Space-D-A-C-A
Input Autotest external closed toe	Space-D-A-C-B
Setup menu	**Space-D-C**
Machine setup	**Space-D-C-p1-A**
General data setting	Space-D-C-p1-A-A
Diameter setup	Space-D-C-p1-A-A-A
Machine needles setup	Space-D-C-p1-A-A-B

Menu numbering   **Space-D-D**
MPP numeration   Space-D-D-A

Mono-Actuator diagnostic menu   **Space-D-E**
Searching Mono-Actuators missing pins   Space-D-E-A
Mono-Actuators distance calibration   Space-D-E-B
Searching Mono-Actuators needles   Space-D-E-C
Simulating Mono-Actuators patterns   Space-D-E-D

Production data   **Space-D-F**
Date and time   Space-D-F-A
Error statistics   Space-D-F-B

Pieces counter menu   **Space-E**
General piece-counter menu   Space-E-A
Total piece-counter menu   Space-E-B
Shifts piece-counter menu   Space-E-C
Modify shift item-counter   Space-E-C-ê
Baskets piece-counter menu   Space-E-D
Link change settings   Space-E-E
Edit single file.co concatenation settings   Space-E-E-ê
Link list   Space-E-F
Link modify   Space-E-F-ê

Menu versions   **Space-G**
MPP versions   Space-G-A
YOYO versions   Space-G-B
Motor Drive version   Space-G-C
SPYDER versions   Space-G-D
Version Drums   Space-G-E
Driver version   Space-G-F
Expansion versions of 3ENC   Space-G-G
Infrared barriers versions   Space-G-H
Mono-Actuators board software version   Space-G-I

Reference

For further information, refer to the brochure:
Wiring diagrams (FOGLIO GUIDA DOCUMENTAZIONE APPARECCHIATURA).

Legend

PCB = printed circuit board = SK = Board

Mpp = Stepping Motors

Ev = Solenoid valve

VPE = Valvola parzializzatrice elettrica (VPE) / Stepping vacuum valve

Command output

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.

For further information, refer to the brochure: **Serial line repair.**

Furthermore …
Remember that:
In order for the machine to run smoothly, it must be adjusted properly.
For more information, refer to the manual: **Mechanical Adjustments**

Legend for … Autotest of inputs

The sensor is a switch that is opened (or closed) by a physical parameter.

- **Green Led** = Input to ground (0 Vdc)
- **Red Led** = input is NOT to Ground

Safety

The electric part of the machine is potentially hazardous and can cause damages to persons and property.
The persons assigned to maintenance and repairs should follow these rules:

- Be instructed.
- Work with the machine out of tension by acting on the disconnector or by disconnecting it from the mains.
- If it is indispensable to work with the machine on, take all precautions so as not to come into contact with powered parts.
  For this purpose, wear rubber gloves and use special insulated tools suitable for 10,000 Volt.
  In any case … Do not disconnect powered parts with the power on.
- Do not make changes of any kind that would by-pass the measures adopted to prevent accidents.
  Use only original replacements to ensure respect of the safety.
- Close the pneumatic feed in case of replacement interventions on the pneumatic part.
- It is forbidden to alterate the protections inserted by the producer.

Glossary

Machine software and machine eprom are synonymous.

[Eprom System is the part of the machine software common to all the machines in the series. Epron Custom is the part specific for the model.]

Machine Software : This software is the most important, it must be compatible with all the other software of the machine (CAN, EDSP, GRAPHITRON, etc.).

In fact: The machine in addition to normal machine Software (system + custom) installed on the Motherboard, also uses other software installed on other boards.

In practice: Each machine programme is associated with a software package for all the devices mounted. The software package is called Extrafile.

[The 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, …).]

For further information, refer to the brochure: **How to update the machine software**

GRAPHITRON is the computer designed with the software used to create specific chains for each machine model. (Graphitron-6/ Digraph-3 Plus)
 [Check the compatibility with the machine software.].

Chain, chain program, article, sock or coded program are synonymous.

The step (chain step) is the programming unit. It contains the list of operations to perform during a cylinder revolution.

The article is comprised of a certain number of chain steps.

The articles come with a ".co" extension.

The zone (or block) is a sequence of steps with a common parameter. For the meaning and types of zones, refer to GRAPHITRON programming.

Chain (Linking p.) sequence indicates the programming of a cyclic sequence of articles via the Graphitron.

The article chain (sequence) has the ".cn" extension.

The sensor is a switch that is opened (or closed) by a physical parameter.
[For further information see also: Wikipedia.org].
The sensor provides the software a signal. [Input].
Namely … The sensors transmit electrical signals to the processor to stop the machine in case of failure.
[Therefore: The input (and/or sensor) is also called "stop".]
In practice: Input sensors detect that the operation progresses correctly and safely for the operator.

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
The wording means that: This problem is probably due to a software failure, and it is supposed it will never be displayed to the user.
Namely … The message is for our technicians during the assembly of the machine.
Contact the Technical Customer Service.

Foreword

Since the software is subject to improvement, it may be replaced with updated and reviewed versions.
Therefore it may happen that the text of the message differs from the one considered.
In this case, refer to the message code.
It is the code that defines the message.

Classification of messages

Warning (Notification)

The Warnings (Notifications) appear in the low part of the display.
The Warnings inform about the machine status or the operation in progres.

a. The appearance of the message does not activate the screen in stand-by.
    Simply touch the surface to reactivate the display.
    Or … Press any key.

b. The message can be cleared by pressing: **[F8]**
    If the message is not cleared, or it reappears immediately, it means that the condition that had originated it is still active.

c. The characteristics of the Warning is that it doesn't obstruct the machine movement with the various start Button.
    (Machine Start Button , [Handle 1] , [Handle 2]) .

d. The message does not inhibit the blackout procedure.
    In the event of a power failure (blackout), the machine saves the data of the current sock cycle (hibernation).
    The blackout procedure also activates at step zero if at that time Routine CT is enabled. (Seaming Robot)

e. The message does not discontinue learning.
    It is not disrupted when yarn feed learning is in progress.

f. This type of message does not cause the Seaming Robot to stop.

Info (Information)

Infos are displayed on the screen and provide information of the machine status or current operation.
This type of message has its own window, which ensure better visibility.

    In computer science, these types of boxes are called "pop-ups". See also … Wikipedia.org

_. For other characteristics, refer to the item: **Warning (Notification)**

Error

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.
In order for the machine regain its correct functioning the cause of the Error has to be eliminated.

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

!   **The appearance of the message causes the machine to stop.**

a.   The appearance of the message automatically turns on the display.

b.   The message can be cleared by pressing: **[F8]**
       If the message is not cleared, or it reappears immediately, it means that the condition that had originated it is still active.

c.   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.

d.   The message does not inhibit the blackout procedure.
       In the event of a power failure (blackout), the machine saves the data of the current sock cycle (hibernation).
       The blackout procedure also activates at step zero if at that time Routine CT is enabled. (Seaming Robot)

e.   **After this error the software puts the Yarn Sliding system in Suspension status.**
       The machine will repeat the incomplete step during the next cycle.

f.   This type of message can stop immediately the Seaming Robot.
       This effect depends on the message content.
       In any case … The robot and machine are independent. They operate in synchronisation during sock extraction.

Error - Movement impossible

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.

c.   This machine status is such that machine operation with the Start button is inhibited for safety reasons.
       Furthermore …
       Operation of the buttons specified below IS NOT enabled:
       •   Handle-1 (Degree/Degree) key
       •   Handle-2 key [Continuous]

_.   For other characteristics, refer to the item: **Error**

Alarm

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.

Before turning off the machine 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.
The list of the Keys and Menu active in this window, and its meaning, is available in:
GUIDE OF USER INTERFACE

!   **The appearance of the message causes the machine to stop.**

a.   The appearance of the message automatically turns on the display.

b.   **The message cannot be cleared with no key.**
        The machine has to be turned off. When turned on it automatically goes to the "end of cycle" step.

c.   This machine status is such that machine operation with the Start button is inhibited for safety reasons.
        Furthermore …
        Operation of the buttons specified below IS NOT enabled:
        •   Handle-1 (Degree/Degree) key
        •   Handle-2 key [Continuous]

d.   **The appearance of the message excludes hibernation.**
        If the machine is switched off when the message active, this does not trigger the blackout procedure.
        La procédure (automatique) de black-out garantit la sauvegarde des données de la machine (état, position, etc.) grâce à des batteries tampon.

e.   **After this error the software puts the Yarn Sliding system in Suspension status.**
        The machine will repeat the incomplete step during the next cycle.

f.   This type of message can stop immediately the Seaming Robot.
        This effect depends on the message content.
        In any case … The robot and machine are independent. They operate in synchronisation during sock extraction.

Initial error

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 message can only appear on switching on.
In order for the machine regain its correct functioning the cause of the Error has to be eliminated.

In general, with the window active it is not possible to access the various menus of the machine or use direct keys.
Some direct keys are however enabled because their function is necessary for the resolution of the damage.
The list of the Keys and Menu active in this window, and its meaning, is available in:
GUIDE OF USER INTERFACE

b.   The message can be cleared by pressing: **[F8]**
         If the message is not cleared, or it reappears immediately, it means that the condition that had originated it is still active.

_.   For other characteristics, refer to the item: **Alarm**

Seaming Robot : Warning (Notification)

This type of message concerns the robot and informs of its state or the operation in progress.
The message is visible in the dedicated window.
From the Main window press: **FN+C**

a. The appearance of the message automatically turns on the display.

_. For other characteristics, refer to the item: **Warning (Notification)**

Seaming Robot : Error

This type of message concerns the robot and informs of its state or the operation in progress.
This type of message informs the operator of the presence of a malfunction.
The message is visible in the dedicated window.
From the Main window press: **FN+C**
The main (red) background field shows the exact error name in big characters.

a. The appearance of the message automatically turns on the display.

f. This type of message causes the Robot stop.
On display in the dedicated area, is shown the corresponding icon.
During work, the robot defect does not stops the machine.
In any case … The robot and machine are independent. They operate in synchronisation during sock extraction.
When the robot stops, the machine stops at the sock pick-up point.

_. For other characteristics, refer to the item: **Warning (Notification)**

Seaming Robot : Error + Machine Stop

This type of message concerns the robot and informs of its state or the operation in progress.
This type of message informs the operator of the presence of a malfunction.
The message is visible in the dedicated window.
From the Main window press: **FN+C**
The main (red) background field shows the exact error name in big characters.

! **The appearance of the message causes the machine to stop.**

a. The appearance of the message automatically turns on the display.

e. The message does not discontinue learning.
It is not disrupted when yarn feed learning is in progress.

f. This type of message causes the Robot stop.
Furthermore … **The machine stops.**
On display in the dedicated area, is shown the corresponding icon.

_.   For other characteristics, refer to the item: **Error**

Enclosure

Setup correctly saved.

The data are saved in the memory and therefore are an integral part of the machine.
The data are directly saved in the FLASH memory and become part of the "General Setup", and will not be lost.

See the following page.

For further information, refer to the brochure: **How to update the machine software**

Machine setup

The Flash of the board contains the Setup data.
When the update fails, the memory is deleted.
Therefore:
Before an update save the data.
So it will be possible restore the Setup by the machine console.

Concerning this see the menu: **Export setup**

See also the menu: **Import setup**

Behaviour from Version … 21 .0 . [4]

Before each update, the Setup is copied to USB pen drive.
To this end, please refer to: Previous page

Setup files

The setup storage files are identified with two names: Global and Local.
The Global file contains the settings that can be extended to all the machine serial numbers of the same model.
The Local file includes the settings that are specific to a serial number.
When uploaded to another serial number, the local file of a serial number virtually performs a cancellation: the setup must then be redone.

(4)   Boot version

Table   :   See the following page.

Reference

Software inputs

In this case, refer to the section:

39.   **Messages on Inputs - DONNA machines**

42.   **Messages on Inputs - Goal machines**

62.   **Messages on Inputs - DC88 machines**

48.   **Messages dedicated to the Seaming Robot - GOAL machines , DC88 machines**

Position of Pneumatic Outputs

In this case, refer to the section:

40. / 41.   **Short circuit   / Not connected   - Donna machines**

43. / 44.   **Short circuit   / Not connected   - Goal machines**

60. / 61.   **Short circuit   / Not connected   - DC88 machines**

48.   **Messages dedicated to the Seaming Robot - GOAL machines , DC88 machines**

Table

Machine inputs

i. = software inputs (inputs for the software)

B / C / P = Board, Connector, Pin

i.	B / C / P	i.	B / C / P	i.	B / C / P
6	Pcb 4866, J14, pin 03	57	Pcb 4866, J3, pin 01		
7	Pcb 4866, J13, pin 03	58	Pcb 4866, J3, pin 03	105	Pcb 3896, J1, pin 05
8	Pcb 4866, J15, pin 03	59	Pcb 4866, J3, pin 05	106	Pcb 3896, J1, pin 06
13	Pcb 4866, J7, pin 04	60	Pcb 4866, J3, pin 07	107	Pcb 3896, J1, pin 07
14	Pcb 4866, J7, pin 03	61	Pcb 4866, J3, pin 09	108	Pcb 3896, J1, pin 08
15	Pcb 4866, J7, pin 02	62	Pcb 4866, J3, pin 11	109	Pcb 3896, J1, pin 09
16	Pcb 4866, J7, pin 01	63	Pcb 4866, J3, pin 13	110	Pcb 3896, J1, pin 10
17	Pcb 4866, J6, pin 08	64	Pcb 4866, J3, pin 15	111	Pcb 3896, J1, pin 11
18	Pcb 4866, J6, pin 07	65	Pcb 4866, J3, pin 16	112	Pcb 3896, J1, pin 12
19	Pcb 4866, J6, pin 06	66	Pcb 4866, J3, pin 14	113	Pcb 3896, J2, pin 05
20	Pcb 4866, J6, pin 05	67	Pcb 4866, J3, pin 12	114	Pcb 3896, J2, pin 06
21	Pcb 4866, J6, pin 04	68	Pcb 4866, J3, pin 10	115	Pcb 3896, J2, pin 07
22	Pcb 4866, J6, pin 03	69	Pcb 4866, J3, pin 08	116	Pcb 3896, J2, pin 08
23	Pcb 4866, J6, pin 02	70	Pcb 4866, J3, pin 06	117	Pcb 3896, J2, pin 09
24	Pcb 4866, J6, pin 01	71	Pcb 4866, J3, pin 04	118	Pcb 3896, J2, pin 10
25	Pcb 4866, J5, pin 01	72	Pcb 4866, J3, pin 02	119	Pcb 3896, J2, pin 11
26	Pcb 4866, J5, pin 03	73	Pcb 4866, J2, pin 01	120	Pcb 3896, J2, pin 12
27	Pcb 4866, J5, pin 05	74	Pcb 4866, J2, pin 03	121	Pcb 3896, J3, pin 11
28	Pcb 4866, J5, pin 07	75	Pcb 4866, J2, pin 05	122	Pcb 3896, J3, pin 12
29	Pcb 4866, J5, pin 09	76	Pcb 4866, J2, pin 07	123	Pcb 3896, J3, pin 13
30	Pcb 4866, J5, pin 11	77	Pcb 4866, J2, pin 09	124	Pcb 3896, J3, pin 14
31	Pcb 4866, J5, pin 13	78	Pcb 4866, J2, pin 11	125	Pcb 3896, J3, pin 15
32	Pcb 4866, J5, pin 15	79	Pcb 4866, J2, pin 13	126	Pcb 3896, J3, pin 16
33	Pcb 4866, J5, pin 16	80	Pcb 4866, J2, pin 15	127	Pcb 3896, J3, pin 01
34	Pcb 4866, J5, pin 14	81	Pcb 4866, J2, pin 16	128	Pcb 3896, J3, pin 02
35	Pcb 4866, J5, pin 12	82	Pcb 4866, J2, pin 14	129	Pcb 3896, J5, pin 05
36	Pcb 4866, J5, pin 10	83	Pcb 4866, J2, pin 12	130	Pcb 3896, J5, pin 06
37	Pcb 4866, J5, pin 08	84	Pcb 4866, J2, pin 10	131	Pcb 3896, J5, pin 07
38	Pcb 4866, J5, pin 06	85	Pcb 4866, J2, pin 08	132	Pcb 3896, J5, pin 08
39	Pcb 4866, J5, pin 04	86	Pcb 4866, J2, pin 06	133	Pcb 3896, J5, pin 09
40	Pcb 4866, J5, pin 02	87	Pcb 4866, J2, pin 04	134	Pcb 3896, J5, pin 10
41	Pcb 4866, J4, pin 01	88	Pcb 4866, J2, pin 02	135	Pcb 3896, J5, pin 11
42	Pcb 4866, J4, pin 03	89	Pcb 4866, J1, pin 01	136	Pcb 3896, J5, pin 12
43	Pcb 4866, J4, pin 05	90	Pcb 4866, J1, pin 03	137	Pcb 3896, J4, pin 05
44	Pcb 4866, J4, pin 07	91	Pcb 4866, J1, pin 05	138	Pcb 3896, J4, pin 06
45	Pcb 4866, J4, pin 09	92	Pcb 4866, J1, pin 07	139	Pcb 3896, J4, pin 07
46	Pcb 4866, J4, pin 11	93	Pcb 4866, J1, pin 09	140	Pcb 3896, J4, pin 08
47	Pcb 4866, J4, pin 13	94	Pcb 4866, J1, pin 11	141	Pcb 3896, J4, pin 09
48	Pcb 4866, J4, pin 15	95	Pcb 4866, J1, pin 13	142	Pcb 3896, J4, pin 10
49	Pcb 4866, J4, pin 16	96	Pcb 4866, J1, pin 15	143	Pcb 3896, J4, pin 11
50	Pcb 4866, J4, pin 14	97	Pcb 4866, J1, pin 16	144	Pcb 3896, J4, pin 12
51	Pcb 4866, J4, pin 12	98	Pcb 4866, J1, pin 14		
52	Pcb 4866, J4, pin 10	99	Pcb 4866, J1, pin 12		
53	Pcb 4866, J4, pin 08	100	Pcb 4866, J1, pin 10		
54	Pcb 4866, J4, pin 06	101	Pcb 4866, J1, pin 08		
55	Pcb 4866, J4, pin 04	102	Pcb 4866, J1, pin 06		
56	Pcb 4866, J4, pin 02	103	Pcb 4866, J1, pin 04		
		104	Pcb 4866, J1, pin 02		

Inp. sw = software Input; Inp. hw = hardware Input; **Input sw ≠ Input hw**

By false error is meant a defect signal not generated by an actually dangerous situation but only electric disturbances and/or hardware defects.

In this case there are 2 possibilities.

Situation 1

The message can be cleared by pressing: [F8] .
Check that the sensor is functioning and properly positioned.
In the auto-test menu, check that the status of the input switches.

Situation 2

The message cannot be deleted.
If the message is not cleared, or it reappears immediately, it means that the condition that had originated it is still active.
With error active (non-erasable with [F8] key), access to Inputs Autotest.
● 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 the connection between the sensor and the board.
In particular …
● Check that the wire in its path between the device and the inputs board is not to ground.
● Check that the wire in its path between the device and the inputs board is not interrupted.

Eventually replace these components. and/ or Replace the cables.

Furthermore …

The "Output Autotest" can be sued to check operation of the solenoid valves or the motors and the associated control signal.

Reference

In this case, refer to the section: **Matching software and hardware inputs**

Checking the pneumatic system

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

- Check that the movement of the device is not slowed down or blocked by mechanical obstacoles.
- Check that the compressed air ducts are not clogged.
- Check that the pneumatic part of the Solenoid valves is no clogged, or mechanically damaged.
- Check the operation of the solenoid valve/s related to the command.

Concerning this see the menu: **Autotest menu**

In particular: **Manual commands menu**
In particular: **Autotest various outputs**

See also the menu: **Manual EV**

Eventually …
- Replace the Solenoid valve concerned.
- Replace the board.
  (The boards controlling the pneumatic solenoid valves are called "bars".).
- Replace the device.

If the control device has not intervened, proceed as follows.
In this case, refer to the section: **Matching software and hardware inputs**

Reference

For further information see also:

40. / 41.	**Short circuit / Not connected - Donna machines**
43. / 44.	**Short circuit / Not connected - Goal machines**
60. / 61.	**Short circuit / Not connected - DC88 machines**
48.	**Messages dedicated to the Seaming Robot - GOAL machines , DC88 machines**

How to locate the position of the solenoid valves

Detecting the electrovalves

Certain machine models have been provided with a few **bistable** electrovalves because when turning off they maintain their status .

The **monostable** have **2 pin** (left at fig.1) .
The **bistable** electrovalves have **3 pin** (right at fig.1) .
The board are inside the support of fig.2.
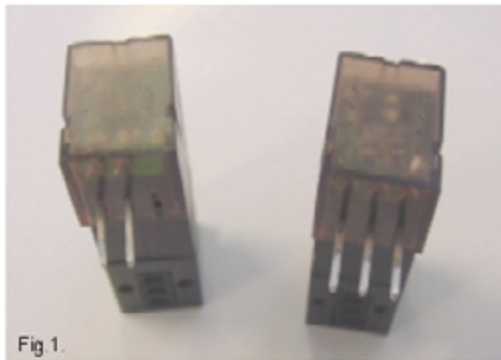
Fig.1. Ev monostable on the left and bistable on the right.
Fig.2. Electrovalve bar-support with electrovalve.

Fig.1.   Fig.2.
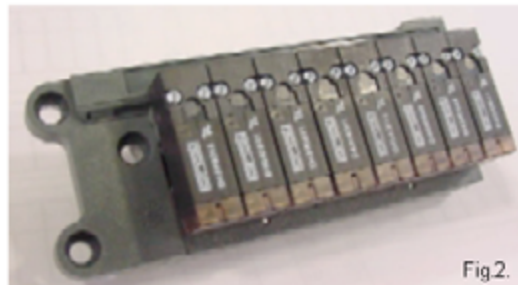
Electrovalves position

If the message on the display does not show the name or the function of the electrovalve it is indicated with the occupied position. Also see the tag placed on the support .
The numeration is made by starting by the non fixed end of the support.
You count 1 for each place (Ev or plug). The closest position to the fixing holes will be 8.
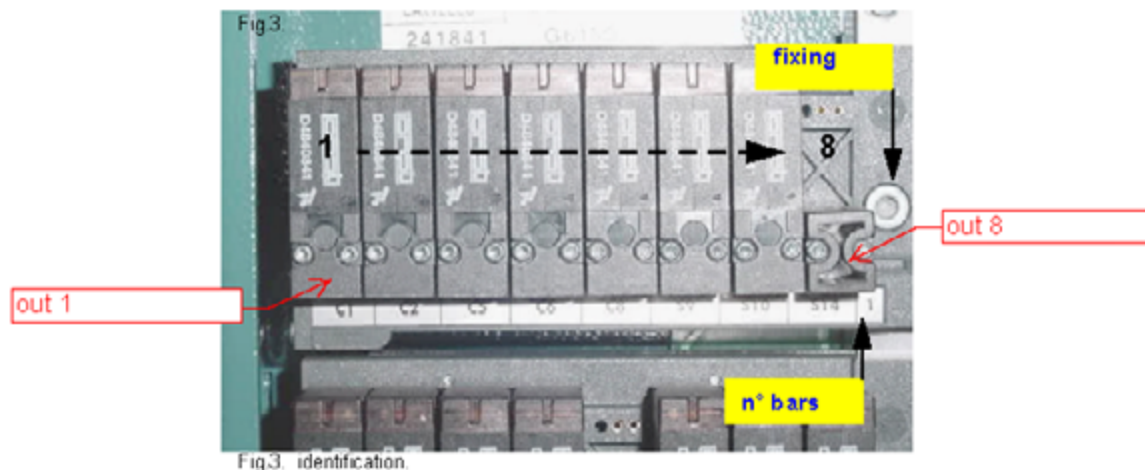
Fig.3. identification.

Messages

0. User Interface - Display

Refer to the menu: **Display setting**
See also the menu: **Password level**

0.0:   Language "%s" not found   Error

Alerts that the set language is not supported by the software.
The display sets itself to the default language.

0.1:   Language saved   Warning

Data has been acquired (stored) successfully.
Informs that the set language has been saved correctly.

0.2:   Language saving failure   Error

Alerts that the set language has not been saved due to software problems.
The display sets itself to the default language.

0.3:   Contrast saved   Warning

Data has been acquired (stored) successfully.
Informs that the set display contrast data have been saved correctly.

0.4:   Contrast saving failure   Warning

Informs that the set display contrast data have not been saved due to software problems.
The display automatically sets on the default contrast data.

0.5:   LCD timeout saved   Warning

Data has been acquired (stored) successfully.
Informs that the set LCD data have been saved correctly.

0.6:   LCD timeout saving failure   Warning

Alerts that the data of the display sleep time settings have not be saved due to software problems. The
display automatically sets to default data.

0.7:	Protected window: please insert password	Information

Informs that the access to the window is password protected.
Enter the password.
For further information, refer to the brochure: **Password management**

0.8:	Protected level activated	Warning

Alerts that the password level has been enabled.
Depending on the set password level, some windows and functions are unlocked.

0.9:	Invalid Password!	Warning

Informs that the password entered is incorrect.
Enter the correct password.

0.10:	Protected level reactivated	Warning

Informs that the password unlock time has expired.
All password-protected windows and functions are locked again.

0.11:	Message not found, Plugin:%d Message:%d	Error

Internal software failure . Contact the Technical Customer Service.

0.12:	Connection resource %s inconsistent	Alarm

Internal software failure . Contact the Technical Customer Service.

1.   Mod. stitch q.ty by cm/inch

Refer to the menu: **Graduation menu**
See also the menu: **Restoring menu**

1.0:   REST values in CM/ INCH out of range (min. %d - max. %d)   Warning

This message informs the user that the value placed aboard the machine in the active Sock Program is not permitted.
Informs that values below / above the standard allowed have been entered.
The message indicates the range of accepted values.
The value is expressed as motor steps.

1.1:   REST values in CM/ INCH correctly saved   Warning

The operation was performed successfully.

1.2:   REST values in CM/ INCH encoding writing failure   Warning

The changes have not been saved. This particular message is a symptom of a Hardware or Software problem.
Go back to the menu and try again. Or … Reboot the machine and repeat the operation. If the problem persists, please contact the Technical Customer Service.

1.3:   No change step following CM/INCH switching in area %s   Warning

Informs that the change made is so minimal that it will not affect the motor steps.

1.4:   Values in CM/ INCH outside limits for program: %s (min. %d - max. %d)   Warning

See the description provided for the message: 1.0
This message appears when an article in the Chain is modified. The change in step is applied exactly in the selected areas with the same name. At least in an article, the change entailed exceeding the values allowed.
From Graphitron you can disable this type of area association.
%s = is the first programme of the sequence where it has not been possible to make the change.

1.5:   Operation not allowed. The motors do not have the same number of zones   Information

Do not currently managed.

2.   Modify economizations

Refer to the menu: **Modify economizations**
See also the menu: **Restoring menu**

2.0:   Operation not allowed (code %d)   Warning

Message no longer menaged. Update the machine software .

2.1:   Economizer data correctly saved   Warning

The operation was performed successfully.

2.2:   Economizer data correctly restored   Warning

Informs that the programmed values have been restored.

2.3:   Unauthorised operation under change economies: zero not allowed   Warning

Informs that it is not possible to set a zero value.

2.4:   Unauthorised operation under change economies: the economies must be even numbers
Warning

Informs that the number of economies must be even.

2.5:   Unauthorised operation under change economies: the economies must be odd numbers
Warning

Informs that the number of economies must be odd.

2.6:   Prohibited Transaction in changing economies: economies, it is not editable in this area
Warning

Informs that the operation cannot be performed under the current circumstances.
This is for safety reasons.
The current zone cannot be modified.

2.7:   Unauthorised operation under change economies: machine not at end of cycle   Warning

Informs that the operation cannot be performed under the current circumstances.
The operation is only possible at the end of the sock.

2.8:   Entered value is out of allowed limits (min. %d - max. %d)   Warning

This message informs the user that the value placed aboard the machine in the active Sock Program is not permitted.
Informs that values below / above the standard allowed have been entered.
The message indicates the range of accepted values.

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3.   Sizes setting - Steps modification

Refer to the menu: **Graduation menu**
See also the menu: **Restoring menu**

3.0:   REST values out of range (min. %d - max. %d)   Warning

This message informs the user that the value placed aboard the machine in the active Sock Program is not permitted.
Informs that values below / above the standard allowed have been entered.
The message indicates the range of accepted values.
The value is expressed as motor steps.

3.1:   REST values correctly saved   Warning

The operation was performed successfully.

3.2:   REST values correctly restored   Warning

Informs that the programmed values have been restored.

3.3:   REST values encoding writing failure   Warning

The changes have not been saved. This particular message is a symptom of a Hardware or Software problem.
Go back to the menu and try again. Or … Reboot the machine and repeat the operation. If the problem persists, please contact the Technical Customer Service.

3.4:   Operation not allowed. The motors do not have the same number of zones   Information

Do not currently managed.

4.   Modify speed

Refer to the menu: **Modify speed**
This information only applies to the following models:
DONNA machines (single-cylinder models, for pantyhose) .

4.0:   Void speed not allowed   Warning

Informs that it is not possible to set a zero value.

4.1:   Speed not alowed (max. %d)   Warning

Informs that values below / above the standard allowed have been entered.
In the message, the variable indicates: Maximum settable value .

4.2:   Void revolutions not allowed   Warning

Informs that it is not possible to set a zero value.

4.3:   Speed data correctly saved   Warning

The operation was performed successfully.

4.4:   Speed data correctly restored   Warning

Informs that the programmed values have been restored.

4.5:   Unauthorised operation under change speed: machine not at end of cycle   Warning

Informs that the operation cannot be performed under the current circumstances.
The operation is only possible at the end of the sock.

5. System status

Refer to the menu: **USB software management**
See also: **Setup IP address**
See also the menu: **Production data**

5.0:	Command %s run error	Error

Generally alerts when a read/ write operation on a USB stick has failed.

5.1:	Ethernet data correctly saved	Warning

The operation was performed successfully.

5.2:	Ethernet data not correctly saved	Warning

Informs of the presence of saving problems or wrong data.

Go back to the menu and try again. Or … Reboot the machine and repeat the operation. If the problem persists, please contact the Technical Customer Service.

5.3:	Save Date and Time not executed correctly	Alarm

Informs of the presence of saving problems or wrong data.

Go back to the menu and try again. Or … Reboot the machine and repeat the operation. If the problem persists, please contact the Technical Customer Service.

5.5:	Loading %s performed correctly	Warning

The operation was performed successfully.
The name of the current file is indicated.

5.6:	Loading %s NOT performed correctly	Warning

Informs of the presence of saving problems or wrong data.
The operation failed. The name of the current file is indicated.
Go back to the menu and try again. Or … Reboot the machine and repeat the operation. If the problem persists, please contact the Technical Customer Service.

5.7:	Date and time saving performed correctly	Warning

Data has been acquired (stored) successfully.

| 5.8: | The USB mass storage device can now be removed safely from the machine | Information |

The operation was performed successfully.
The message confirms that: You can safely remove the USB flash drive.
This occurred following the pressure of the dedicated command.

| 5.9: | System error: %s | Error |

Internal software failure . Contact the Technical Customer Service.

| 5.10: | The USB mass storage device was not removed correctly | Information |

The procedure has not been complied with. Follow the procedure to prevent damaging the device.
Namely … At the end of the operations press [R].
After which …
Wait for the message: 5.8

6. Codify Program

Refer to the menu: **Activate program**

6.0: Conversion successfully finished — Warning

The operation was performed successfully.

6.1: Conversion %s INTERRUPTED — Error

The operation failed. Parameter %s indicated a string to indentify where/when the problem occurred.

6.2: Conversion in progress — Warning

Informs that a procedure/operation is in progress and the machine is processing data.
Await the outcome of the operation.

6.3: Insufficient memory — Error

Alerts that the machine memory is not sufficient to perform the conversion of the article.
Go back to the menu and try again. Or … Reboot the machine and repeat the operation. If the problem persists, please contact the Technical Customer Service.

6.4: Number of drum levers (%d) set higher than the expected maximum number (%d) — Error

Alerts that article is not encoded for the software version installed in the machine. !da duplicazione!
Check the software version of the machine and upgrade it to the Graphitron version, or vice versa.

6.5: Lever command %d too far from the preceding one — Error

Alerts that the pattern drum lever shown is too distant (in terms of relative position) from the previous one.
Check the programming of article.
If the problem persists, please contact the Technical Customer Service.

6.6: Writing failed — Error

Alerts that some data, or even all, have not been written in memory.
Repeat the operation.

6.7: Programmed height %ls for maximum limit exceeded

Error

%ls = This variable indicates: The motor.
The message appears when the Sock Programme is activated.
Informs that values below / above the standard allowed have been entered.
Check programming from Graphitron.

6.8: Programmed level %ls out of minimum limit

Error

See the description provided for the message:

6.7

6.9: Program CRC not congruous

Error

Try to re-encode the article from Graphitron.

If the problem persists: Check the software version.
Eventually …
Update the machine software and/ or
Update the Graphitron software .

7.   I/O Serial line

Refer to the menu: **Outputs autoconfiguration**

| 7.0: | **Outputs autoconfiguration missing** | Error |

Alerts that the self-configuration of serial outputs has not yet been performed.
Enter setup, set the associated devices and perform auto-configuration.

| 7.1: | **Select the existing bars and confirm to start the autoconfiguration** | Warning |

The devices present must be enabled and those missing must be disabled.

| 7.2: | **Output autoconfiguration aborted** | Warning |

Alerts that the serial output auto-configuration setup has been exited without saving and the operation has been cancelled.

| 7.3: | **Output autoconfiguration finished** | Warning |

Informs that the auto-configuration of the serial outputs has been saved.

| 7.4: | **Outputs autoconfiguration in progress** | Warning |

Informs that the auto-configuration of the serial outputs is in progress.
Wait for the message: 7.3

| 7.5: | **No output detected on the SPI line** | Warning |

No selection made.
The devices present must be enabled and those missing must be disabled.

Donna machines

This information only applies to the following models:
DONNA machines (single-cylinder models, for pantyhose) .

Description

On entering this window you access a "Testing program". (Programme that tests the operation of the device.)
The chain is specific for current calibration.
Each stitch cam has 3 work quotas (Set-point) for the knitting fabric.
The adjustment must be made for each height.
With a special instrument measure the how much yarn is absorbed on each "Yarn Feed".
When the quantities of yarn absorbed by each "Yarn Feed" are equal, calibration for this quota (Set-point) is completed.
The adjustment must be made for each device.

Reference

Refer to the menu: **Stitch-cams calibration**

See also the menu: **Autotest Stitch cam**

8.0:	**Cams calibration missing**	Error

Refer to the menu: **Position calibration**

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.

(*)

● Perform the procedure in the appropriate menu.
Indeed … In the meantime will be used the standard values (default) available in the software (eprom custom).

Or …
● Delete the message by pressing [F8].
The message remain disabled until a following machine turning off.

Or …
● Load the specific *.xml file of this part of the Setup.

(*) In this case …
Save the Setup part you are interested in on the USB stick.
Namely … Keep the archive of the Setup files updated.

In order to deepen the concept see: **Machine setup / Setup files** (Enclosure)

8.1:	**Saving stitch-cam calibration in progress. Please wait…**	Warning

Informs that the setup saving is in progress.
Await the outcome of the operation.

8.2:	**Stitch-cam autocalibration correctly saved**	Warning

Data has been acquired (stored) successfully.

8.3:	**Autocalibration not correctly saved for the motor %ls**	Error

Informs of the presence of saving problems or wrong data.
Or … The software ascertains that the value required to continue is missing.
Go back to the menu and try again. Or … Reboot the machine and repeat the operation. If the problem persists, please contact the Technical Customer Service.

8.4:	**Stitch-cam autocalibration not correctly saved**	Error

Informs that saving has failed. Go back to the menu and try again.
Or … Reboot the machine and repeat the operation.
If the problem persists, please contact the Technical Customer Service.

| **8.5:** | **Cams calibration empty!** | Warning |

The operation was performed successfully.

The message confirms that: The Reset operation is completed properly.

The result of this operation is the restoration of the default, as defined in the Eprom.

| **8.6:** | **Incorrect cancellation of stitch cam calibration** | Error |

Informs of the presence of saving problems or wrong data.

Go back to the menu and try again. Or … Reboot the machine and repeat the operation. If the problem persists, please contact the Technical Customer Service.

| **8.7:** | **Configuration for stitch cam calibration cancelled!** | Warning |

The operation was performed successfully.

The message confirms that: The Reset operation is completed properly.

The result of this operation is the restoration of the default, as defined in the Eprom.

| **8.8:** | **Incorrect cancellation of stitch cam configuration** | Error |

Informs of the presence of saving problems or wrong data.

Go back to the menu and try again. Or … Reboot the machine and repeat the operation. If the problem persists, please contact the Technical Customer Service.

| **8.9:** | **Operation not allowed stitch-cam autocalibration in progress** | Information |

Informs that the operation cannot be performed under the current circumstances.

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.

9.   Sock counter

Refer to the menu: **Single-item-counter setting**
See also the menu: **Pieces counter menu**

9.0:   Piece-counter target (%d) reached!   Warning

Informs that the production of the number of items set in the piece-counter has been completed.
(%d) = Produced = Programmed

Concerning this see the menu: **General piece-counter menu**
See also the menu: **Link change settings**

9.1:   Sock not ejected!   Error

Alerts that the article has not been ejected. Check that the item end is not trapped by needles or hooks.

Check that the sensor is functioning and properly positioned. In the auto-test menu, check that the status of the input switches. Check the connection between the sensor and the board. Eventually replace these components. and/ or Replace the cables.

Please refer also to paragraph: **In the event of a false error …**   (Enclosure)

9.2:   Wait for sock passage…   Warning

The machine has completed a sock and activates detection to make sure it is ejected.
Await the outcome of the operation. The message will shortly be replaced by others.

9.3:   Piece-counter setup correctly saved   Warning

The operation was performed successfully.
Data has been acquired (stored) successfully.
In order to deepen the concept see: **Machine setup / Setup files** (Enclosure)

9.4:   Saving of piece-counter setup failed   Warning

Informs that saving has failed. Go back to the menu and try again.
Or … Reboot the machine and repeat the operation.
If the problem persists, please contact the Technical Customer Service.

9.5:   Piece-counter setup erased!   Warning

The operation was performed successfully.
The message confirms that: The Reset operation is completed properly.
The result of this operation is the restoration of the default, as defined in the Eprom.

9.6:	Operation not allowed. The question was not answered	Information

The machine needs to advance by a value (or the indication of a preference).
Machine run disabled until the software receives the reply.
This operation is only performed after the answer in the confirmation window.

Refer to the menu: **General piece-counter menu**

See also: **8.9**

9.7:	Basket piece count target (%d) achieved!	Warning

Informs that the production of the number of items set in the piece-counter has been completed.
(%d) = Produced = Programmed = Bag ready

Concerning this see the menu: **Baskets piece-counter menu**
See also the menu: **Link change settings**

9.8:	Basket not available!	Information

The message refers to the item: Bag-ready control with A-B options
Management has been enabled. Therefore: The user is prompted to confirm the operation.
Press the key: [.]
On display in the dedicated area, is shown the corresponding icon.
 (Concerning this see the menu: Help)

9.9:	Operation not permitted in the presence of data collection	Information

Informs that the operation cannot be performed under the current circumstances.
Sock count is handled by the host computer.
Therefore: These values are not editable in this window.

9.10:	Piece-counter change saving performed correctly	Warning

The operation was performed successfully.
Data has been acquired (stored) successfully.

9.11:	Piece-count failure (code: %d)	Error

Internal software failure . Contact the Technical Customer Service.
(%d) = This variable expresses the error via the code for internal use.
The cause of this problem can be a wrong programming by Graphitron.
In general these situations of incorrect programming are intercepted and therefore should not happen to the user during the sock cycle.
Check the programming.
In particular, refer to: Edit single file.co concatenation settings
View the field: Programmed = N .
The field has significance only in the following case: N > 0 .

| 9.12: | Modify not-accepted link produced sock counter | Information |

The change to the count was confirmed at the same time with the increase in the counter.
For this reason the change was not accepted.
Go back to the menu and try again.

| 9.13: | Modify not-found link produced sock counter | Information |

The change to the count was confirmed at the same time with the increase in the counter.
The automatic increase has cancelled the change.
For this reason, no changes were detected.
Go back to the menu and try again.

| 9.14: | Sock 1 passage, machine side obstructed or damaged | Error |

Sock passage control

For the device to work, you need to enter specific codes in the sock programme (Graphitron).
In particular: Sock passage abilitation

The message appears if:
The sensor is already reading when it is enabled.
The solution is: clear the sensor.
Check the connecting cables between the sensor and the inputs board.

Please refer also to paragraph: **In the event of a false error …** (Enclosure)

| 9.15: | Piece-counter target (%d) reached! | Error |

Message no longer menaged. Update the machine software .

Informs that the production of the number of items set in the piece-counter has been completed.
The message appears in the following circumstances: Machine on hold at Step Zero.

See the description provided for the message: **9.0**

| 9.16: | Basket piece count target (%d) achieved! | Error |

Message no longer menaged. Update the machine software .

Informs that the production of the number of items set in the piece-counter has been completed.
The message appears in the following circumstances: Machine on hold at Step Zero.

See the description provided for the message: **9.7**

10.   Manual commands

Refer to the menu: **Manual commands in hazardous areas**

10.0:	Motion disabled by EV manual command logics	Information

The message refers to the item: Manual command protection on reciprocating motion
Management has been enabled. Therefore: Informs that the operation cannot be performed under the current circumstances.
The zones of the sock in which the cylinder alternating motion is set are called "heel blocks".

10.1:	Correct manual setup saving in hazardous areas	Warning

The operation was performed successfully.
The data are saved in the memory and therefore are an integral part of the machine.
The data are directly saved in the FLASH memory and become part of the "General Setup", and will not be lost.

10.2:	Incorrect manual setup saving in hazardous areas	Warning

Informs that saving has failed. Go back to the menu and try again.
Or … Reboot the machine and repeat the operation.
If the problem persists, please contact the Technical Customer Service.

10.3:	Machine zeroing disabled by EV manualcommand logics	Information

The message appears after trying to reset the machine.
This message appears when trying to perform zeroing while the TAB + Z manual command is still active.
The reset is disabled until you exit the page correctly.
Press [Esc] to close the window.

10.4:	Run the machine in crank mode to terminate the manual command	Information

This message informs the user that the machine cannot be Run.

Operate the mechanical or electric handle (1 and 2) to rotate the cylinder a few turns.
This operation serves to facilitate the stitching of the wires.
The message disappears when it becomes possible to start up.

11.

Do not currently managed.

12. Manual commands - stepping motors

12.0: VPE valve in manual state. Normal functioning resumes with machine running
Warning

Informs that the VPE has been positioned with a manual command.
Restoring operation is possible by pressing either the run button or the dedicated key.

12.1: Sinker cap in SINKER EXTRACTION position
Warning

This message informs the user that the various "Sinker Caps" are positioned so as to allow the extraction and therefore the replacement of the "Sinker".
Until to that these devices ("Caps") shall remain in "Sinkers extraction" position the "Run" is disabled.

12.2: Operation not allowed manual command in progress stepping motor
Information

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. (Stepping Motors)

13. Manual commands - Solenoid valves

13.0: Motion disabled by manual out logics
Information

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. (Solenoid valve commands)

14. Messages on various Management and Operations (machine)

14.0: Wrong Plugin loading
Alarm

Alerts that the initialisation of the application has aborted (e.g. USB reading).
The user must turn off and then turn on the machine. If the problem persists, please contact the Technical Customer Service.

14.1: MAKY: insufficient memory
Alarm

Alerts that the memory is insufficient for the software installed.
In case of the occurrence of this message contact the Lonati technical staff.

14.2: Article not active
Warning

Informs that no article is active. Activate an article to continue production.

14.3: New article activated
Warning

Informs that a new article has been enabled and the machine is ready to start production.

14.4: Modified article active
Warning

Informs that the article has been resumed with the changes made or an article has been loaded with the same name as the current one.

14.5: Mini-article %s unavailable
Error

Alerts that the mini-article indicated, and required for this procedure, is not present in the memory.
In case of the occurrence of this message contact the Lonati technical staff.

14.6: Encoder counting: revolution lost
Error

Alerts that a malfunction has occurred in the encoder pulse count.
Check the connection of the resolver, the motor and the motor drive.
If the connections are correct, replace the motor and/or the motor drive and/or Pcb 2010.
Type of the motor drive CAN board: EcoDD .
The PCB software is named: FD_xxxx.up (where xxxx is the version).

14.7: Encoder IRQ lost
Error

See the description provided for the message: 14.6

14.8: Buffered data reading/writing error
Warning

Informs that an error has occurred while reading/writing in RAM.
Go back to the menu and try again. Or … Reboot the machine and repeat the operation. If the problem persists, please contact the Technical Customer Service.

14.9:	**Unexpected destination directory**	Error

Informs that an error has occurred while reading a file on a USB stick.
Remove the pen drive. (Follow the procedure to prevent damaging the device. = Press the key: [R]).
Insert the USB pen drive into the panel socket.
Repeat the operation.

14.10:	**Peripheral reading error**	Error

See the description provided for the message: 14.9
Informs that an error has occurred while reading a file on a USB stick.
Try again; if the outcome is still negative replace the USB stick.

14.11:	**Operation in progress. Please wait…**	Warning

Informs that the software is performing a task (e.g. reading a file from USB).
Await the outcome of the operation.

14.12:	**Operation correctly finished**	Warning

Informs that the software has run and completed the current operation.

14.13:	**Reading device connection lost**	Error

Informs that there is an internal software error concerning the connection between devices.
Turn the machine off and on again.

14.14:	**CAN %s initialization error (code: %d)**	Alarm

This error is usually generated on switching on the machine and is caused by the software when it is not connected to a CAN device.
Contact the Technical Customer Service.

14.15:	**Operation on CAN device error (code: %d)**	Alarm

This error is generated when the software detects a general anomaly on the CAN line.

14.16:	**Error executing %s command %s**	Error

This error is generated when a CAN command towards the motors is not executed.

14.17:	**Zeroing in progress…**	Warning

Informs that the [F0] procedure has commenced.
This key is used to reset the program (i.e. move the machine to the end-of-cycle position).

14.18:   Machine stopped for cycle end   Warning

Informs that the machine has stopped at end of article due to F3 insertion.

14.19:   Machine stopped for F1 active   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.
Outside the step Zero, if is activated the [F1] key to block the step chain progress is also active the 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.
The activation of the key outside the step Zero is used only for maintenance or tests.

14.20:   Machine stopped for stop-at-step function active   Warning

Informs that the machine has stopped at the step programmed due to F4 insertion.

14.21:   Temperature too high!   Alarm

Alerts that the cylinder thermal probe has measured a too high temperature.
If it is not truthful, check the connection between Pcb 2010 (J39, pins 1-2-3) and the thermal probe (pins 1-2-3); if it is ok, replace the thermal probe and/or the Pcb 2010.

14.22:   Machine stopped for end of yarn bobbin   Warning

Indicates that the machine has stopped at the end of the article due to the activation of the "empty reel stop" command.
In the main window by pressing F you access a window where is possible to program the number of Sock Cycles after which the machine will stop.
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.

14.23:   Machine in emergency   Error - Movement impossible

Alerts that the emergency button has been pressed or the software has caused an emergency due to internal problems.
When you press this self-retaining button, the machine stops instantly and both the software and hardware are disabled.
The machine can be restarted after the button has been released (unscrew) and the error reset.
Check an eventual enablement to the movement.

14.24:   No programming of motor %s   Error - Movement impossible

Alerts that the motor specified has not been programmed.
Check the programming of article.

14.25:	Device %ls manually disabled	Error

Alerts that the device specified is disabled.
Enable the device again to resume operation.
Or … Check programming from Graphitron.

14.26:	Required to effect knitting! Press F0	Warning

The message reminds the user what action is to be performed.

14.27:	Set clock, then enter the serial number and save it	Warning

The message reminds the user what action is to be performed.
The clock must always be set since it is used by the software for controlling other devices or menus.
Refer to the menu: **Production data**
After which …
See also the menu: **Leasing Management**

14.28:	WARNING! Void serial number not allowed	Warning

First refer to what specified for the previous entry.
Set the machine serial number. May not be written a value equal to zero.

14.29:	Serial number saved correctly	Warning

Data has been acquired (stored) successfully.

14.30:	Unlock request file created correctly	Warning

Refer to the menu: **Leasing Management**
In particular, refer to item: **Build a USB request activation / renewal leasing**
Insert the USB pen drive into the panel socket. After which … Press the button: [B] .
The operation was performed successfully.
The file extension will be: ".pc" .

14.31:	No USB memory stick	Warning

Insert the USB pen drive into the panel socket. After which … Press the button: [B] / [C] .

14.32:	USB unlock file non-existent or incorrect	Warning

The file has the following extension: ".mc" .
The specific file is entitled: **xxxx** etc.**.mc** ,
[**xxxx** = **machine serial number**]

The file is too big for the available space on the external memory device.
The solution is cancel a few programs/ files to free the space in USB memory.

Furthermore … Failure can be caused by …
File not existing
Or …
The unlock file data are corrupted.

14.33:	Lease COMPLETED machine unlocked permanently	Warning

The operation was performed successfully.
Informs that the lease disable procedure has been executed.

14.34:	Lease RENEWED until next expiry	Warning

The operation was performed successfully.
Informs that the unlock file has been loaded.

14.35:	WARNING! Data error: operation not performed	Warning

Repeat the operation. ([B] / [C]) .
On the USB flash drive there must be only one unlock file: the one for the machine on which the key is inserted.

14.36:	WARNING! Data not valid	Warning

Internal software failure . Contact the Technical Customer Service.

14.37:	Lease expired. Renewal requested	Error **-** Movement impossible

Insert the USB pen drive into the panel socket. After which … Press the button: [B] .
See the description provided for the message: 14.30

14.38:	**Timer machine not active. You need to adjust and save Date and Time**	Initial error

Alerts that the machine is locked due to data loss.
Perform the procedure to disable/renew leases and set the date and time.

14.39:	**Start of drums warming movement**	Warning

Informs that the shake of the actuator levers is in progress.
If the machine remains stopped or switched off for some time, the heating stage is restored.

14.40:	**Solenoid valves shake active**	Warning

When the "Shake" procedure is enabled, with the machine on step zero, you can force execution of this procedure by clicking a key in the relevant menu.
If the machine remains stopped or switched off for some time, the heating stage is restored.

14.41:	**Operation not allowed. Machine not stopped at end of cycle**	Warning

Informs that the operation is not allowed.
Stop the machine by pressing F3 and repeat the operation.

14.42:	**WATCH DOG useful**	Alarm

In case of the occurrence of this message contact the Lonati technical staff.

14.43:	**WATCH DOG drive motor: %s**	Alarm

This alarm appears when the management software of the motor is blocked.
The actuator is the electronic equipment (board) the drives the cylinder motor.
The user must turn off and then turn on the machine. If the problem persists: Replace the board.

14.43:   See also … Wikipedia.org , In particular: watchdog and/ or deadlock

14.44:	Driver %s incompatible. Request version %d. %d. %d	Alarm

In case of the occurrence of this message contact the Lonati technical staff.

14.45:	Testing blackout battery…	Warning

A test carried out automatically by the software check the integrity of this battery (residual charge).
Await the outcome of the operation. You need to wait a few seconds.

Black-out procedure
In order to deepen the concept see: **Quick menu**
In particular, refer to item: **Reset**

See also the menu: **Autotest menu**
This menu allows the following operations: Manual check of the battery state.

14.46:	Flat Black-out battery	Warning

First refer to what specified for the previous entry.
Furthermore …
Check that the batteries are connected.
Check the connection between the following elements: Pcb 3812, J6 - Pcb 2010, J36 .
Replace the batteries. (2 x 12V).
Eventually replace the cables and/or the boards concerned.

14.47:	Automatic speed reduction active	Warning

Refer to the menu: **Warm up machine**
Management has been enabled.
If the machine remains stopped or switched off for some time, the heating stage is restored.
In this warm-up stage, the speed is limited to 50% of that set by Graphitron.

14.48:	Automatic speed reduction disabled	Warning

First refer to what specified for the previous entry.
The machine starts functioning again at the programmed speed.

14.49:	Black-out battery charged	Warning

See the description provided for the message: 14.45
No abnormalities were found during the check.

14.50: Hibernation or recovery from hibernation in progress. Please wait…   Information

Informs that, due to a power failure, memorisation is in progress (hibernation) of the positions of the actuators or their resumption following a restart.

Await the outcome of the operation.

See also: **14.45**

14.51: Reset: turn off machine   Alarm

The message appears in the following circumstances:

The user has launched the command that turns off the machine without hibernation.

Turn off the machine from the main switch.

See also: **14.45**

14.52: Blackout not executed   Error - Movement impossible

This message can only appear on switching on.

It warns that the software failed to perform hibernation.

The causes of the alert can be the following:

- Flat Black-out battery
- Following the appearance of an "Alarm" message.

Remember that: With an alarm active, switching off the machine does not launch the blackout procedure.

In the first case …

See the description provided for the message: **14.46**

14.53: Motor running stop broken selectors   Information

This error is due to intervention of the "Selector" breakage control mechanism.

The message reminds that …

The user must perform at least 2 rounds, with the [Handle] key before proceeding further.

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.

14.54:   Broken selectors in dangerous zone. Press [F0]   Error **-** Movement impossible

This error is due to intervention of the "Selector" breakage control mechanism.
The user cannot eliminate the error, but 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".
The repair can be easily carried out with machine at End of Cycle.

14.55:   CAN motor connection %ls   Alarm

Check the wiring between the motor and its PCB.

14.56:   CAN line error: %d (codice: %d)   Alarm

Internal software failure . Contact the Technical Customer Service.

14.57:   Anomaly line SPI (code: %d)   Alarm

Internal software failure . Contact the Technical Customer Service.

14.58:   Anomaly line SPI-INTERN (code: %d)   Alarm

Internal software failure . Contact the Technical Customer Service.

14.59:   Anomaly line SPI-DRUMS (code: %d)   Alarm

Internal software failure . Contact the Technical Customer Service.

14.60:   SOCKET anomaly (code: %d)   Alarm

Internal software failure . Contact the Technical Customer Service.

14.61:   WATCH DOG IRQ Timer   Alarm

Internal software failure . Contact the Technical Customer Service.

14.62:   Stroke count IRQ   Alarm

Internal software failure . Contact the Technical Customer Service.

14.63:   Cylinder motor direction of rotation inconsistent with the software   Alarm

Internal software failure . Contact the Technical Customer Service.

14.64: Anomaly SOCKET (WATCH DOG)   Error - Movement impossible

Internal software failure . Contact the Technical Customer Service.

14.65: Current type of file NOT handled by the system   Error - Movement impossible

In case of the occurrence of this message contact the Lonati technical staff.

14.66: High time program conversion   Error - Movement impossible

Repeat the operation. and/ or Try to re-encode the article from Graphitron.
Furthermore … To resolve the problem … The user must turn off and then restart the machine.
If the problem persists, please contact the Technical Customer Service.

14.67: Operation not allowed for file programme. CS enabled   Information

The message reminds the user that a ".cs" type Test programme is active.
This type of article or special coded (*.cs) is performed to achieve set results.
Therefore: During the execution of the *.cs file some operations are not permitted.

14.68: Operation not allowed   Information

Informs that the operation cannot be performed under the current circumstances.
This is for safety reasons.

14.69: Operation not allowed none article active   Information

Informs that the operation cannot be performed under the current circumstances.
Activate an article to continue production.

14.70: Operation not allowed initialization CAN

Informs that the operation cannot be performed under the current circumstances.
You need to wait a few seconds.

14.71: Operation not allowed solenoid valves shake active

Informs that the operation cannot be performed under the current circumstances.
This is for safety reasons.
Wait until the end of the operation. On display in the dedicated area, is shown the corresponding icon.

14.72: Operation not allowed machine reset disable

Informs that the operation cannot be performed under the current circumstances.
This is for safety reasons.

14.73: Loading file *.xml executed. Turn off the machine

The operation was performed successfully.
The user must turn off and then turn on the machine.
The file is read when the machine is turned on.

14.74: Encoder not connected

Alerts that a malfunction has occurred in the encoder pulse count.
Check the connection of the resolver, the motor and the motor drive.
If the connections are correct, replace the motor and/or the motor drive and/or Pcb 2010.
Type of the motor drive CAN board: EcoDD .
The PCB software is named: FD_xxxx.up (where xxxx is the version).

14.75: Board %s reset (code: %d)

Interference on the transmission.
The user must turn off and then turn on the machine. If the problem persists, please contact the Technical Customer Service.

14.76: Resetting enabled by hand-crank only

This message informs the user that the Start button is disabled.
Only [Handle 1]/ [Handle 2] key must be used.

14.77: Timeout BUSY motor %ls

The stepper motor shown exceeded the time allowed for the operation.
The software has not received a response.
The Timeout is activated via the reset command. (Motor Zero) .
The user must turn off and then turn on the machine. If the problem persists, please contact the Technical Customer Service.

See also: **CAN Line messages**

14.78:   Operation not allowed. Machine not stopped.   Information

Do not currently managed.

14.79:   Cancellation of TOUCH display calibration completed. Turn off the machine   Alarm

Refer to the menu: **Display setting**

When the display is replaced, it may occur that the windows are not centred.

In this situation, pressing the icons gives no results.

To centre the windows back in the display, you need to launch the Reset command.

Obviously … Adjustments can be made directly from the menu only in case of slight misalignment.

If the new display cannot be handled (excessive misalignment), other adjustments must be made.

The intervention requires the availability of: USB pen drive previously prepared through the file image

For further information, refer to the brochure: **How to update the machine software**

14.80:   Interface exchange effected. Turn off the machine   Alarm

Refer to the menu: **Display setting**

Do not currently managed.

A new interface (structure and graphics) is being developed.

This interface is named: QML Interface .

It is possible to operate with either the new type or the previous type. (QML Interface / UI Interface).

Switch the command as required in the indicated menu.

Therefore … Wait for the message to appear, then turn the machine off to validate the settings.

The unavailable item is displayed in grey.

14.81:   File.cs disabling operation not allowed. All calibrations for external closed toe not performed.   Information

Refer to the menu: **Linker Motor**
In particular, refer to item: **Calibration menu**

On entering this window you access a "Testing program".

[Test Programme (*.CS) = speciall coded   = testing program]

Some Robot positions need to be set (adjusted).

The stations visited are considered completed if the data is saved by the operator.

If the menu data is not saved, setting will be re-proposed at the next cycle.

Only if all the calibrations have been performed, the procedure can be exited (test programme).

14.82:   Operation not allowed – current article cancellation in progress   Information

Informs that the operation cannot be performed under the current circumstances.

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.

You need to wait a few seconds.

| 14.83: | CAN boards initialization failed, in recovery from blackout | Alarm |

| See in this regard as reported under the item: | 14.49 |
| See also: | 14.52 |

This alarm alerts the user that the Black-out procedure is failed.

It warns that the software failed to perform hibernation.

In particular: The CAN board of at least one motor failed to communicate.

The best solution is to run the zeroing (F0) to arrive at the End of Sock.

After which …

Turn the machine off and on again.

| 14.84: | Percentage value editing performed correctly | Warning |

The operation was performed successfully.

| 14.85: | Percentage value editing performed incorrectly | Warning |

Informs of the presence of saving problems or wrong data.

Go back to the menu and try again. Or … Reboot the machine and repeat the operation. If the problem persists, please contact the Technical Customer Service.

| 14.86: | Data for motor in percentage change not matching | Error |

Internal software failure . Contact the Technical Customer Service.

| 14.87: | Data for yoyo in percentage change not matching | Error |

Internal software failure . Contact the Technical Customer Service.

| 14.88: | Programming table management (code: %d) | Error |

Internal software failure . Contact the Technical Customer Service.

| 14.89: | Fingers data saving finished. | Warning |

The operation was performed successfully.

| 14.90: | Fingers data saving failed. | Warning |

Informs of the presence of saving problems or wrong data.

Go back to the menu and try again. Or … Reboot the machine and repeat the operation. If the problem persists, please contact the Technical Customer Service.

14.91: Automatic identification in progres — Warning

Do not currently managed.

14.92: Automatic identification completed — Warning

Do not currently managed.

14.93: Inching crank handle disabled by programme — Information

Do not currently managed.

14.94: March disabled during setup fingers modification — Information

Before starting the cylinder, you must exit the menu.
See in this regard as reported under the item: **8.9**

14.95: Need to update the machine with USB key to version 14.0 or later versions — Alarm

For further information, refer to the brochure: **How to update the machine software**
In particular, refer to the paragraph: **USB pen drive configuration**

14.96: Relative zero calibration, motor %s, missing — Error

This information only applies to the following models:
GOAL machines (single-cylinder models, for men's socks) .
Concerning this see the menu: **Set cylinder-raising motor**
In particular, refer to item: **Cylinder raising motor relative zero**
The message reappears until the (default or otherwise) parameter value is confirmed.
Therefore:
Press the [Ent]: you will see the edit window.
Confirm with [OK].
Then …
Press [Esc] to exit until the window with the data storage button appears. (menu with OK button).
Confirm with [OK].

14.97:   **WATCH DOG internal Input-Output management**   Alarm

Internal software failure . Contact the Technical Customer Service.

14.98:   **Machine stopped by Program Stop insertion**   Warning

Concerning this see the menu: **Programmed Stop**
Do not currently managed.

14.99:   **The test shortens the battery life. Do not repeat it before %d minutes**   Warning

Concerning this see the menu: **Autotest menu**
In particular, refer to item: **Blackout battery test**
Between a test and the next must take a minimum time set in the Software.
A message will indicate the residual waiting time.

14.100:   **Flat Black-out battery**   Error

A test carried out automatically by the software check the integrity of this battery (residual charge).
In case the battery charge had been exhausted this message warns the user, which will then replace the battery.
The replacement does not entail any loss of data.

14.101:   **March disabled after blackout. Restore with two handle revolutions**   Information

This message informs the user that the machine cannot be Run.
Informs that the operation cannot be performed under the current circumstances.
This is for safety reasons.

Use the crank to perform N turns to the cylinder.

Lors du rallumage, la machine reprend à partir du point où elle s'était arrêtée.
Operate the mechanical or electric handle (1 and 2) to rotate the cylinder a few turns. (N = 2) .
Then will be possible press the [RUN] button.

The zones of the sock in which the cylinder alternating motion is set are called "heel blocks".
In this case … N = 3 .

14.102:   **WAIT: modify saving in progress**   Warning

After varying an article, wait for the end of the cycle.
The modification made becomes operational at the next Zero Step pass.
At that moment, the F1 function is entered.
When the operation is complete, the function is switched off.
A message will warn the user of the correctly saving.

14.103: Size check: over the maximum threshold: %ls   Error

Refer to the menu: **Size check calibration**
This message informs the user that the value placed aboard the machine in the active Sock Program is not permitted.
Informs that values below / above the standard allowed have been entered.
The message indicates the range of accepted values.
Do not exceed the indicated value.

14.104: Size check: below the maximum threshold: %ls   Error

See the description provided for the message: 14.103
Do not go below the indicated value.

14.105: File not existing in machine   Warning

Refer to the menu: **Export file log**
In the indicated menu, the [Fn+W] command has been pressed.
The operation has not positive outcome, and the data are not saved.
The message indicates that the following item is not enabled under Setup: File
Concerning this see the menu: **Enable closed toe device traces**

14.106: GESIRQLOOP called in vain by the logic id=%d %s   Alarm

Internal software failure . Contact the Technical Customer Service.

14.107: GESTIMERIRQLOOP called in vain by the logic id=%d %s   Alarm

Internal software failure . Contact the Technical Customer Service.

14.108: Operation not allowed. Machine in MANUAL STOP (Nautilus)   Error

Refer to the Dinema instructions relating to the management of "NAUTILUS system for the production control".

The optical barriers are active.

With the option enabled, when the robot is in motion the machine stops when the barriers are trespassed.

Refer to the menu: **General setup external closed toe**

In particular …

[B]   **Stop barriers**

With management enabled:

The optical barriers are active. With the option enabled, when the robot is busy the machine stops when the barriers are trespassed.

(The seaming robot is busy = sock not yet ejected).

Special cases : Phase stop   (The device advances by one phase at each pulse by the operator.)

Indeed …   The barriers are only enabled when executing the phase (moving parts) and return in suspension during hold time

With management disabled:

The disabled device is not handled even when it is connected.

See in this regard as reported under the item: Barrier active warning light

| 14.110: | Blackout failed | Alarm |

Internal software failure . Contact the Technical Customer Service.

| 14.111: | Setup configuration deleted. Switch off the machine | Alarm |

Do not currently managed.

| 14.112: | Run not allowed: exit operations from a manual stop | Error |

Refer to the Dinema instructions relating to the management of "NAUTILUS system for the production control".

| 14.113: | WATCH DOG: MAIN LOOP slowdown | Error |

Or …

| 14.113: | WATCH DOG: MAIN LOOP slowdown %d msec | Error |

Internal software failure . Contact the Technical Customer Service.

| 14.114: | NFC writing correctly performed | Warning |

NFC = Near Field Communication
See also: Wikipedia.org
The operation was performed successfully.
Data has been acquired (stored) successfully.
The NFC token now contains the password.
Refer to the menu: **Programming NFC**
For further information, refer to the brochure: **Password management**

| 14.115: | Incorrect NFC writing | Warning |

At first, view the contents of the previous message.
Informs of the presence of saving problems or wrong data.
Go back to the menu and try again.
- Replace the device.

| 14.116: | Awaiting end of seaming. Sock target achieved. | Warning |

The message appears in the following circumstances:
The last sock is being produced in the cylinder compared to the set target.
Only at the end of the sewing the production "Target" will actually be reached.

After which …
See the description provided for the message: **9.0**

14.117:   Awaiting end of seaming. Basket target achieved.   Warning

The last sock is being produced in the cylinder compared to the set target.
Only at the end of the sewing the production "Target" will actually be reached.

After which …
See the description provided for the message: **9.7**

14.118:   Await end of seaming. Article change request activated   Warning

When activating a new program, it will start at step zero.
After varying an article, wait for the end of the cycle.
The modification made becomes operational at the next Zero Step pass.

External Closed Toe
Article change / Modify the datum   : This function stops the machine at the end of the current knitting cycle.
After which …   The device picks up the item from the cylinder and transfers it to seaming.
The machine will stop pending the completion of the seaming operation of the last sock produced.
Only at the end of the sewing the command will be executed. (Program activation).
After which …   The machine is ready to start production.

14.119:   Machine identification code absent. Enter it in setup   Error

The software ascertains that the value required to continue is missing.
A Setup item has been added to the machine software.
The data to insert is the following: **Machine ID** .
Go to the dedicated menu.
Concerning this see the menu: **Machine ID**
The menu comes under section: **General data setting**

14.120:   Forcing of mechanical reset disabled   Information

Forcing mechanical reset (ex Reset meccanico manuale)

Concerning this see the menu: **Quick menu**

The function is enabled onlty for the following models: Double-cylinder models, for men's socks .
This function can be activated in the following cases: Machine on hold at Step Zero.
Otherwise a message is displayed.

14.121:   Stop program programmed at end of cycle   Warning

Concerning this see the menu: **Quick menu**
In particular, refer to item:

                                                                    Socks stop program

The function is enabled onlty for the following models: DONNA machines (single-cylinder models, for pantyhose) .
This window is used to program a machine stop after a set number of articles.
Indeed …
At the end of the period the machine will be in the following condition:
Machine running at step zero, with F1 activated.
The message reminds the reason of the current state of the machine.

14.122: Article deactivated for missing closed-toe calibration Error

Message no longer menaged. Update the machine software .
See the next message.

14.122: Activate file.CS to make closed-toe calibration Error

The software ascertains that the value required to continue is missing.
This can happen if the procedure has never been performed, or the Reset has been carried out.
Concerning this see the menu: **External closed toe setup menu**

Therefore …
A *.cs programme can be activated.
Refer to the menu: **Activate test program**

Activate the article after the operation.
Press the button: Fn+F3 .
See the menu: **Quick menu**

14.123: Stop economizer [F2] forced unto the end of cycle Warning

For some specific anomalies the software can force the elimination of the repetition of the steps.
This conduct serves to finish the sock faster.

14.124: Movement prevented by data collection logic: defects Error

Refer to the Dinema instructions relating to the management of "NAUTILUS system for the production control".

14.125: Movement prevented by data collection logic for general target achieved Error

Refer to the Dinema instructions relating to the management of "NAUTILUS system for the production control".

14.126: Production manual stop Target achieved Error

Refer to the Dinema instructions relating to the management of "NAUTILUS system for the production control".

15.   Boards numbering

The section contains the messages concerning the Numbering of the boards (of the CAN circuits).

There are various types of boards.
The boards are specific to the devices they need to manage.
The same or homogeneous boards (from the same family) belong to one circuit.
The circuit elements must be numbered through the dedicated menus.

When there is only one board on the machine, the software does not require Numbering: it is performed automatically.
If only one of the possible boards of the series is mounted on the machine, then the software simply requires confirmation to assign it a number.
The numbering is only required when in the machine are present simultaneously in 2 or more boards "Not Numbered".
When replacing a single board on a machine that has already been configured, the software does not require the Numbering: it is carried out automatically.

Therefore:
At present …

The operating menus for numbering are the following:
(menu for devices managed by more than one board)

- MPP numeration,
- YOYO numbering,
- Mono-Actuator boards numbering,
- I/O numeration.

The menu is operative only if data acquisition is required.
Therefore …
Launch the reset command before executing a new acquisition.

Note

- The following messages belong to family 1:
  0 ÷ 7, 9, 12, 15, 18 .

- The following messages belong to family 2:
  10, 13, 16, 19, 39 ÷ 46 .

- The following messages belong to family 3:
  27 ÷ 30, 55 ÷ 62 .

- The following messages belong to family 4:
  63 ÷ 74 .

15.0:	**Select the motor and confirm by pressing OK**	Warning

Informs that, during numbering, it is necessary to determine the number of the motor that has the light on.
Use the arrow keys to scroll through the list of available codes. ([Large Arrows Up/Down])
Confirm with [OK].

15.1:	**No board detected for this family. It is possible to save the void numeration or abort the procedure**	Warning

Informs that no connected device has been detected during numbering.
If you wish to continue working without said devices, save the numbering or cancel and check the connections of the devices.

15.2:	**Save the new numeration?**	Warning

Informs that the numbering procedure has been completed. Confirm with [OK].

15.3:	**Saving numeration in progress. Please wait…**	Warning

The message confirms that: It was decided to save data.
Informs that a procedure/operation is in progress and the machine is processing data.
Await the outcome of the operation.

15.4:	**Numeration aborted**	Warning

The message confirms that: It was decided to NOT save data.
Informs that the numbering procedure has been cancelled manually.
The procedure must be repeated.

15.5:	**Confirm step-by-step motor drive board removal?**	Warning

The message informs that at least one previously numbered device is missing.
The window shows the undetected device.
If the absence of the device is confirmed, it will no longer be handled.

15.6:	**Numeration anomaly (code: %d)**	Error

Internal software failure . Contact the Technical Customer Service.

15.7:	**Family already numbered. To renumber reset the existing numeration**	Warning

Informs that the numbering procedure is impossible because the devices are already numbered.
If you wish to re-run numbering, you first need to reset the numbering stored (enter the appropriate reset menu).

15.8:	**ECODD numeration saving finished**	Warning

See the description provided for the message: **15.9**

15.9:	**MPP numeration saving finished**	Warning

Data has been acquired (stored) successfully.

15.10:	**YOYO numeration saving finished. Remember to reset the loading cell**	Warning

See the description provided for the message: **15.9**

Remove yarn from all feeders before resetting the loading cell.

The adjustment is to place at "zero grams" the reading of the "Load Cell" when there is no yarn inside, it is also called "Zeroing of the Load Cell ".

Viewing the window of "Absorption YOYO" you can verify that the zeroing of the "Load Cell" has been executed correctly.

15.11:	**The ECODD family boards are not numbered**	Initial error

See the description provided for the message: **15.12**

15.12:	**The MPP family boards are not numbered**	Initial error

Alerts that the software has detected non-numbered boards.

The message also specifies: Name of the board family responsible for controlling the device .

Perform numbering in the appropriate menu.

15.13:	**The YOYO family boards are not numbered**	Initial error

See the description provided for the message: **15.12**

15.14:	**ECODD boards removed and/or added. Perform numeration**	Initial error

See the description provided for the message: **15.15**

15.15:	**MPP piloting boards removed and/or added. Perform numeration**	Initial error

Alerts that the software has detected previously non-numbered or numbered devices that are now absent.

The software only requires the numbering of new boards, and the confirmation of the elimination for those removed.

Therefore:

Perform the numbering for added devices. Or … Confirm the absence of the devices removed from the CAN circuit.

15.16:	**YOYO removed and/or added. Carry out numbering**	Initial error

See the description provided for the message: **15.15**

15.17:	**Association rejected. Piloting motor with %s, selection %s wrong**	Information

See the description provided for the message: **15.18**

| 15.18: | Association rejected. Piloting motor with %s, selection %s wrong | Information |

The first variable indicates: Name of the board family responsible for controlling the device .
The second variable indicates: Incorrectly selected name to manage those devices .

A check carried out proved that the item selected is wrong.
Each motor or CAN device in the machine must be associated with a board or CAN module.
The device performing Numbering has the green light on. Furthermore … The motor performs a few movements.

| 15.19: | Association rejected. Piloting motor with %s, selection %s wrong | Information |

See the description provided for the message: **15.18**

| 15.20: | INFRARED BARRIER numbering backup completed | Warning |

See the description provided for the message: **15.9**

| 15.21: | The infrared barriers family boards are not numbered | Initial error |

See the description provided for the message: **15.12**

| 15.22: | INFRARED BARRIER boards removed and/or added. Execute numbering | Initial error |

See the description provided for the message: **15.15**

| 15.23: | Association rejected. Infrared barrier with %s, selection %s wrong | Information |

See the description provided for the message: **15.18**

| 15.24: | Numeration saving %s finished | Warning |

Message no longer menaged. Update the machine software .

| 15.25: | The family boards %s are not numbered | Warning |

Message no longer menaged. Update the machine software .

| 15.26: | Boards %s removed and/or added. Perform numeration | Initial error |

Message no longer menaged. Update the machine software .

| 15.27: | The MONO-ACTUATOR family boards are not numbered | Initial error |

See the description provided for the message: **15.12**

| 15.28: | MONO-ACTUATOR boards removed and/or added. Perform numbering | Initial error |

See the description provided for the message: **15.15**

15.29:	Association rejected. Mono-Actuator with %s, selection %s wrong	Information

See the description provided for the message: **15.18**

15.30:	MONO-ACTUATOR boards numbering save procedure completed	Warning

See the description provided for the message: **15.9**

15.31:	Select the motor and confirm by pressing OK	Warning

See the description provided for the message: **15.0**

15.32:	No board detected for this family. It is possible to save the void numeration or abort the procedure	Warning

See the description provided for the message: **15.1**

15.33:	Save the new numeration?	Warning

See the description provided for the message: **15.2**

15.34:	Saving numeration in progress. Please wait…	Warning

See the description provided for the message: **15.3**

15.35:	Numeration aborted	Warning

See the description provided for the message: **15.4**

15.36:	Confirm motor drive board removal?	Warning

See the description provided for the message: **15.5**

15.37:	Numeration anomaly (code: %d)	Error

See the description provided for the message: **15.6**

15.38:	Family already numbered. To renumber reset the existing numeration	Warning

See the description provided for the message: **15.7**

15.39:	Select the motor and confirm by pressing OK	Warning

See the description provided for the message: **15.0**

15.40:	No board detected for this family. It is possible to save the void numeration or abort the procedure	Warning
	See the description provided for the message:	**15.1**

15.41:	Save the new numeration?	Warning
	See the description provided for the message:	**15.2**

15.42:	Saving numeration in progress. Please wait…	Warning
	See the description provided for the message:	**15.3**

15.43:	Numeration aborted	Warning
	See the description provided for the message:	**15.4**

15.44:	Confirm removal YOYO?	Warning
	See the description provided for the message:	**15.5**

15.45:	Numeration anomaly (code: %d)	Error
	See the description provided for the message:	**15.6**

15.46:	Family already numbered. To renumber reset the existing numeration	Warning
	See the description provided for the message:	**15.7**

15.47:	Select the motor and confirm by pressing OK	Warning
	See the description provided for the message:	**15.0**

15.48:	No board detected for this family. It is possible to save the void numeration or abort the procedure	Warning
	See the description provided for the message:	**15.1**

15.49:	Save the new numeration?	Warning
	See the description provided for the message:	**15.2**

15.50:	Saving numeration in progress. Please wait…	Warning
	See the description provided for the message:	**15.3**

15.51:	Numeration aborted	Warning

See the description provided for the message: **15.4**

15.52:	Do you want to confirm removal of the INFRARED BARRIER board?	Warning

See the description provided for the message: **15.5**

15.53:	Numeration anomaly (code: %d)	Error

See the description provided for the message: **15.6**

15.54:	Family already numbered. To renumber reset the existing numeration	Warning

See the description provided for the message: **15.7**

15.55:	Select the MONO-ACTUATOR board and confirm with OK	Warning

See the description provided for the message: **15.0**
See also: **15.18**

For the numbering of the CAN modules you must open the cover of the electronic panel of the machine in order to see the CAN modules. This is necessary to verify the status of the green led on the board.

15.56:	No board detected for this family. It is possible to save the void numeration or abort the procedure	Warning

See the description provided for the message: **15.1**

15.57:	Save the new numeration?	Warning

See the description provided for the message: **15.2**

15.58:	Saving numeration in progress. Please wait…	Warning

See the description provided for the message: **15.3**

15.59:	Numeration aborted	Warning

See the description provided for the message: **15.4**

15.60:	Confirm MONO-ACTUATOR board removal?	Warning

See the description provided for the message: **15.5**

15.61:	Numeration anomaly (code: %d)	Error

See the description provided for the message: **15.6**

15.62:	Family already numbered. To renumber reset the existing numeration	Warning
	See the description provided for the message:	**15.7**

15.63:	Select the motor and confirm by pressing OK	Warning
	See the description provided for the message:	**15.0**

15.64:	No board detected for this family. It is possible to save the void numeration or abort the procedure	Warning
	See the description provided for the message:	**15.1**

15.65:	Save the new numeration?	Warning
	See the description provided for the message:	**15.2**

15.66:	Saving numeration in progress. Please wait…	Warning
	See the description provided for the message:	**15.3**

15.67:	Numeration aborted	Warning
	See the description provided for the message:	**15.4**

15.68:	Confirm IO piloting board removal ?	Warning
	See the description provided for the message:	**15.5**

15.69:	Numeration anomaly (code: %d)	Error
	See the description provided for the message:	**15.6**

15.70:	Family already numbered. To renumber reset the existing numeration	Warning
	See the description provided for the message:	**15.7**

15.71:	IO piloting board numeration saving finished	Warning
	See the description provided for the message:	**15.9**

15.72:	The IO family boards are not numbered	Initial error
	See the description provided for the message:	**15.12**

15.73:	IO piloting board remove and/or add. Perform numeration	Initial error

See the description provided for the message: **15.15**

15.74:	Association rejected. IO piloting board with %s, selection %s wrong	Information

See the description provided for the message: **15.18**

15.75:	Select the motor and confirm by pressing OK	Warning

See the description provided for the message: **15.0**

15.76:	No board detected for this family. It is possible to save the void numeration or abort the procedure	Warning

See the description provided for the message: **15.1**

15.77:	Save the new numeration?	Warning

See the description provided for the message: **15.2**

15.78:	Saving numeration in progress. Please wait…	Warning

See the description provided for the message: **15.3**

15.79:	Numeration aborted	Warning

See the description provided for the message: **15.4**

15.80:	Confirm board removal?	Warning

See the description provided for the message: **15.5**

15.81:	Numeration anomaly (code: %d)	Error

See the description provided for the message: **15.6**

15.82:	Family already numbered. To renumber reset the existing numeration	Warning

See the description provided for the message: **15.7**

15.83:	Saving of external universal device numbering completed	Warning

See the description provided for the message: **15.9**

15.84:	The boards in the family of universal external devices are not numbered	Initial error

See the description provided for the message: **15.12**

15.85:	Boards of the family of external universal devices removed and/or added. Perform numbering.	Initial error

See the description provided for the message: **15.15**

15.86:	Association rejected. Piloting motor with %s, selection %s wrong	Information

See the description provided for the message: **15.18**

15.87:	Select the RGB lamp and confirm with OK	Warning

See the description provided for the message: **15.0**

15.88:	No board detected for this family. It is possible to save the void numeration or abort the procedure	Warning

See the description provided for the message: **15.1**

15.89:	Save the new numeration?	Warning

See the description provided for the message: **15.2**

15.90:	Saving numeration in progress. Please wait…	Warning

See the description provided for the message: **15.3**

15.91:	Numeration aborted	Warning

See the description provided for the message: **15.4**

15.92:	Confirm RGB lamp piloting board removal?	Warning

See the description provided for the message: **15.5**

15.93:	Numeration anomaly (code: %d)	Error

See the description provided for the message: **15.6**

15.94:	Family already numbered. To renumber reset the existing numeration	Warning

See the description provided for the message: **15.7**

15.95:	RGB lamp piloting board numeration saving finished	Warning

See the description provided for the message: **15.9**

15.96:	The RGB lamp family boards are not numbered	Initial error

See the description provided for the message: **15.12**

15.97:	RGB lamp piloting board remove and/or add. Perform numeration	Initial error

See the description provided for the message: **15.15**

15.98:	Association rejected. RGB lamp piloting board with %s, selection %s wrong	Information

See the description provided for the message: **15.18**

Donna machines

This information only applies to the following models:
DONNA machines (single-cylinder models, for pantyhose) .
More in particular: Models equipped with the following device: Mechanical oiler
No configuration menu is provided for the models shown.

The Antitwist rotation through a device (pump) sends in pressure the oil circuit allowing lubrication of the various moveable parts of the machine.
A pressure switch check that the pressure is correct for a proper pumping.
On the pressure switch there is a contact that opens or closes depending on pressure.

After some minutes of functioning with higher-speed to 249 Rpm, the software check that the contact is closed.
After 5 minutes of machine stop (not in motion) necessary for the gradual adaptation of Pressure Switch, the software check that the Contact is open.

For the position of the input refer to the instructions given in the message   **37.** (p.176)
In particular, refer to the paragraph: Outputs   /   Inputs

Eventually replace these components. and/ or Replace the cables.

16.0:   **Oil missing**   Error **-** Movement impossible

This error is caused by the lowering of the tank oil level. Check the oil level and eventually restore it.
With stop activated, the inputs Autotest shows the following value: **Green Led** .

16.1:   **Oil pressure**   Error **-** Movement impossible

This error informs the user that the pressure (necessary for the effective lubrification) is not enough.
Failure can be caused by … Air bubbles near the sensor. Air bubbles may form when pouring oil.
In this case is neccessary … Create air vent.
See figure on next page. Loosen the screws indicated.
At this point erase the error with [F8] and start the machine.
Wait until the lubricant bleeds from the small space (clearance) underneath the plate. [D4540404]
Stop the machine. Return the mechanical unit to the home position.
When the sensor is reading, the input Autotest LED colour is … **Green** .

16.2:   **Oil pressure still present**   Error **-** Movement impossible

The lubrication circuit is still pressurized.
This error informs the user that, after a certain period of time with the machine stopped, the return signal from the Pressure control device is not in the correct status.
Check that the ducts are not blocked.

Mechanical unit
D5930162
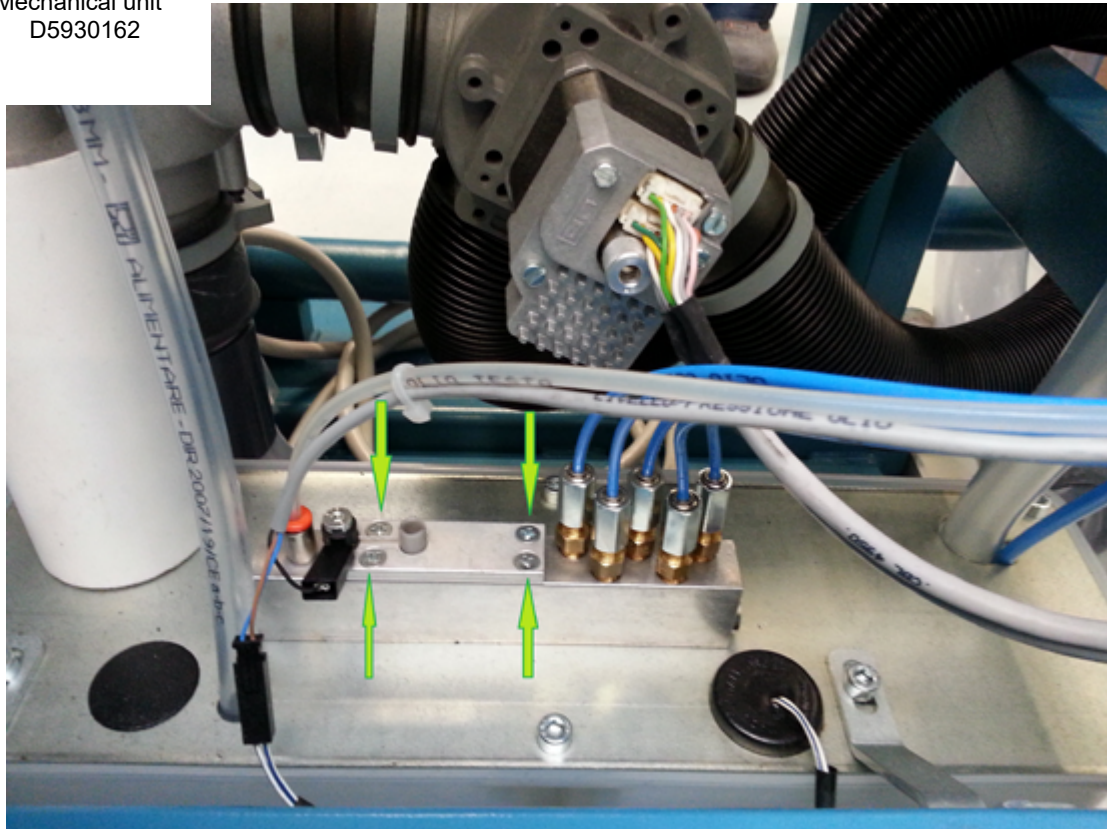
For the position of the input refer to the instructions given in the message: **37.** (p.176)
In particular, refer to the paragraph: Outputs   / Inputs

17. Yarns sliding

Refer to the menu: **Yarns sliding menu**

17.1: Saving yarn sliding setup... Warning

This message informs the user that Setup data is being saved.
Await the outcome of the operation. You need to wait a few seconds.

17.2: Yarn sliding setup saving finished Warning

The operation was performed successfully.
Data has been acquired (stored) successfully.
In order to deepen the concept see: **Machine setup / Setup files** (Enclosure)

17.3: Yarn sliding setup saving error Error

Informs that saving has failed. Go back to the menu and try again.
Or … Reboot the machine and repeat the operation.
If the problem persists, please contact the Technical Customer Service.

17.4: SPYDER numeration not found, perform numeration Initial error

Perform numbering in the appropriate menu.

17.5: SPYDER numeration completed Warning

The sensors have been numbered. The message confirms that you can exit the menu. Press [Esc] to exit until the Save Setup window is displayed: click [Y] to confirm.

17.6: Overrun in comunicating with sensors Error

Internal software failure . Contact the Technical Customer Service.

17.7: No SPYDER sensor found: please check the connections Initial error

Alerts that the board has not detected the sensors.
Check the wiring from the interface connector to the board.

17.8: The SPYDER sensors (DFil????.up) do not have the correct software: required version %d.%d Initial error

For a correct functioning, even if is not essential, is useful that all the sensors mounted are updated with the same version. This software must be compatible with the machine software.
Update the sensors to the required version.

17.9:   SPYDER error - Yarn broken n. %d

<div align="right">Error</div>

This error alerts the user that the yarn matched to the sensor "%d" is broken, or it is however stationary when it should be in sliding.

The sensors reading is mainly determined by a series of parameter.

Concerning this see the menu: **Parameters of sensors**

See also: **Enable yarns sliding control**

If this stop occurs while the yarn is sliding, it is clearly a false error.

Proceed with the following operations:

- Clean the reading window of the sensor. Eventually carry out a new Learning.
- Check that the sensor does not consider the yarn stationary (led ?) even if it is in sliding. Eventually raise the sensibility of the sensor. Or … Replace the sensor that has found the error.

For further information see also: **GUIDE OF USER INTERFACE**

In particular: Leds status of the SPYDER sensors

17.10:   Updating yarn sliding software...

<div align="right">Warning</div>

This message alerts the user that an upgrading of the specified board(s) is in progress.

Await the outcome of the operation.

Levels : After a software update, the default values are restored.

The change determines the loss of the previous Learning and therefore, in automatic, in the machine it will activate the status of Learning.

17.11:   Yarn sliding software update successfully installed

<div align="right">Warning</div>

The operation was performed successfully.

17.12:   Yarn sliding software update failed

<div align="right">Warning</div>

The message informs that board(s) upgrading failed. Go back to the menu and try again.

Or … Reboot the machine and repeat the operation.

If the problem persists, please contact the Technical Customer Service.

17.13: Sampling of sensor %d failed
Error

Interference on the transmission. The user must turn off and then turn on the machine. If the problem persists, please contact the Technical Customer Service.

17.14: Command dispatch to sensors failed
Error

Check the connection between the sensor and the board.

17.15: SPYDER sensors added or removed
Initial error

Alerts that the software has detected sensors that had been previously non-numbered or numbered but are now missing.

Refer to the menu: **Yarn sliding sensors identification**

In particular, refer to the paragraph: In case of Addition, Replacement, or Removal of one or more sensors.

17.16: Wrong sensor %d configuration
Initial error

Internal software failure . Contact the Technical Customer Service.

Furthermore …

Check the connection between the sensor and the board.

Check the senosor status, eventually replace it.

17.17: Wait for sensor ID assignment
Warning

The device being numbered has one light off. The green light is the one that goes off. Evaluate the ordinal number to assign.

Refer to the menu: **Yarn sliding sensors identification**

In particular, refer to the paragraph: **Procedure**

17.18: Sensor logical ID already assigned
Warning

Use the arrow keys to scroll through the list of available codes.

The list of codes not yet assigned reduces gradually as you advance.

Confirm with [OK].

17.19: Numeration already existing. To renumber, reset the old numeration
Warning

Access to the menu is only allowed in the following case: The dedicated memory is completely empty.

Launch the reset command before executing a new acquisition.

17.20:   Sampling command sent by the AXE failed — Error

Internal software failure . Contact the Technical Customer Service.
Furthermore …
Check the connection between the sensor and the board.
Check the senosor status, eventually replace it.

17.21:   AXE reception queue of sensor data full — Error

Internal software failure . Contact the Technical Customer Service.
Furthermore …
Check the connection between the sensor and the board.
Check the senosor status, eventually replace it.

17.22:   SPYDER numeration finished, Save the new numeration? — Warning

Confirm with [OK].   [A] to cancel.

17.23:   SPYDER habilitations saved — Warning

Data has been acquired (stored) successfully.
The sensor remain disabled until a following machine turning off.

17.24:   SPYDER parameters copied — Warning

The operation was performed successfully.
All the devices have now the same parameter configuration (level).

17.25:   SPYDER parameters restored   Warning

The operation was performed successfully.
Restoration of the DEFAULT parameters, the standard configuration present in the software.
All the devices have starting parameters.

17.26:   Cannot access the file scorFil.xml   Error

The message informs that there are file write/read problems.
The file contains data referring to: Yarn sliding acquisition.
Furthermore … To resolve the problem … The user must turn off and then restart the machine.
If the problem persists, please contact the Technical Customer Service.

17.27:   Uncut yarn sensor %d   Error

This message informs the user that: The yarn matched to the sensor "%d" has not been cut, or it is still sliding when it should be stationary.
If this stop occurs while the yarn is stationary, it is clearly a false error.
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.

See the description provided for the message: **17.9**

Proceed with the following operations:
- Check that the sensor does not consider the yarn in sliding (Led ?) even if it is stationary. Eventually lower the sensibility of the sensor. Or … Replace the sensor that has found the error.
- Clean the reading window of the sensor. Eventually carry out a new Learning.

17.28:   Cannot access the file scorTrac.log   Error

The message informs that there are file write/read problems.
The file contains data referring to: Recent behaviour of the system.
Concerning this see the menu: Export file log
This menu is for use by our technicians.
Command used to create a diagnostic file of recent behaviour.

17.29:   File scorTrac.log successfully created   Warning

The operation was performed successfully.

17.30:   Anomaly line SPYDER (code: %d)   Alarm

Internal software failure . Contact the Technical Customer Service.

17.31:   Overflow buffer messagges line SPYDER   Alarm

Internal software failure . Contact the Technical Customer Service.

17.32:   At least one non-controllable SPYDER found. Remove it   Initial error

The models to which this document relates only accept the following devices: Sensors **Spyder 2S** or any
subsequent versions .

17.33:   None signal from sensors SPYDER   Error

Check the connection between the sensor and the board.

17.34:   Sensor parameters acquired   Warning

The operation was performed successfully.
The user can create a further Level personalized (Level 0) through the modify of the single parameters.
Confirm with [OK].

17.35:   The stop bit was not received correctly   Error

Internal software failure . Contact the Technical Customer Service.

17.36:   Unsuitable value according to masking   Error

Internal software failure . Contact the Technical Customer Service.

17.37:   Invalid yarn sliding learning. New learning forced   Error

The message appears in the following circumstances: When the machine is switched on.
This message informs the user that:
The machine was turned off before the procedure was completed.
A new "Learning" phase will start in the next sock.

The cutter is a sharp disc that cuts off the yarns. (Saw   + Knife   ) .
The device can be motorized.

Donna machines

This information only applies to the following models:
DONNA machines (single-cylinder models, for pantyhose) .
More in particular:
Models without the following device: Saw blade motor
Therefore:
This section does not concern Medical machines (ME).

Reference

Refer to the menu: **Autotest special functions**
In particular, refer to item: Sf 84 Stop saw device

See also the menu: **Autotest of inputs**
In particular, refer to item: Saw motion checking
Dial vertical piston/ Saw stop motion
Saw stop for high welt

Furthermore …
Remember that:
In order for the machine to run smoothly, it must be adjusted properly.
For more information, refer to the manual: **Mechanical Adjustments**

In particular:
●   Check the mechanical phase between the Dial and the Cylinder.
●   Check the correct setting of the mechanical Zero.

Description

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 equipped with Motorized Saw instead the movement may also be determined by a stepping motor.

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. [Sf 84 Stop saw device]

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.

If you raise the Dial, 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 and putting in motion the machine, the Saw automatically is hooked without making any particular procedure (the Solenoid valve is immediately de-energized).

For the device to work, you need to enter specific codes in the sock programme (Graphitron).

It 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.

Dial position   :

The Dial position is controlled by the software via the value read by a sensor. [= i. 90] *

End of stroke sensor =	Dial vertical piston/ Saw stop motion
	This item is specific for the models equipped with: **Raising dial motor**
	See the description provided for the message: **26.**
	Otherwise:
Zero sensor =	Saw stop for high welt =
	Input for upper mechanical dial .
	When the Dial is low the control sensor is in a reading status.

*   **i.** :   input (input code for the software = software input)
Input :   To this end, see table:
               Matching software and hardware inputs (**Enclosure**)
[Saw   + Dial   = Dial unit   ]

Saw blade phase proximity

The shaft rotation is verified through a proximity switch.

[Saw motion checking = i. 95] *

This shaft has a slot (hollow).

This shaft has a point of phase compared with mechanical Zero. (Check the correct setting of the mechanical Zero.) .

When the slot passes under the sensor, it is not reading.

To the achievement of two specific cylinder degrees the signal shall be respectively "open" and "closed".

With Saw hooked the Software must read in both the control points the correct status of the sensor.

With the saw released (stationary) the software should not read no change of the sensor status.

The check is disabled only in the phase of Hook or Release.

18.0:	Machine running disabled by saw device	Information

This message informs the user that the machine cannot be Run.

Movement is not allowed as the mechanical group (Dial) is not in the working position (it is not low).

Fully lower the mechanical group.

Operate the mechanical or electric handle (1 and 2) to rotate the cylinder a few turns.

At this point, the running is again enabled.

Therefore:

Use the crank to perform N turns to the cylinder. (N = 4)

Then will be possible press the [RUN] button.

18.1:	Saw A control failed	Error

With Saw hooked the Software must read in both the control points the correct status of the sensor.

Instead … The sensor is in reading when it should be off.

In case of error the first thing to check is the integrity of the phase sensor of the Saw.

Check that the sensor is functioning and properly positioned.

In the auto-test menu, check that the status of the input switches.

Use the [Handle] keys to rotate the cylinder.

Check the connection between the sensor and the board.

Eventually replace these components. and/ or Replace the cables.

Please refer also to paragraph: **In the event of a false error …**   (Enclosure)

18.2:	Saw B control failed	Error

With Saw hooked the Software must read in both the control points the correct status of the sensor.

Instead … The sensor is always off.

For the explanation/ solution, see what specified for the previous entry.

*   **i.** :   input (input code for the software = software input)

Input :   To this end, see table:

    Matching software and hardware inputs (**Enclosure**)

[Saw + Dial = Dial unit]

18.3: Saw is not released Error

With the saw released (stationary) the software should not read no change of the sensor status.
For the explanation/ solution, see what specified for the previous entry.

18.4: Dial manually raised Warning

The message reminds the reason of the current state of the machine.
When maintenance is completed, proceed as follows: Return the mechanical unit to the home position.

18.5: Saw setup correctly saved Warning

Refer to the menu: **Saw blade setup**

The operation was performed successfully.
Data has been acquired (stored) successfully.
In order to deepen the concept see: **Machine setup / Setup files** (Enclosure)

18.6: Saw setup saving error Warning

Informs that saving has failed. Go back to the menu and try again.
Or … Reboot the machine and repeat the operation.
If the problem persists, please contact the Technical Customer Service.

19.   Machine setup

19.0:   Setup modification cancelled   Warning

The message confirms that: It was decided to NOT save data.

19.1:   Setup saving completed   Warning

The operation was performed successfully.
Data has been acquired (stored) successfully.
In order to deepen the concept see: **Machine setup / Setup files** (Enclosure)

19.2:   Setup saving error   Warning

Informs that saving has failed. Go back to the menu and try again.
Or … Reboot the machine and repeat the operation.
If the problem persists, please contact the Technical Customer Service.

20.	Contactor

If machine is prepared for the external Suction Fan, then is mounted a device which is a Contactor and a Thermal Relay, on the Vac Line (Power) for the same Fan.

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.

Remember that:

In the machine Setup must be enabled the functioning of the external Suction Fan.

The disabled device is not handled even when it is connected.

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.

Functioning (Type of enable)

In any case …

The emergency button stops the fan.

When the fan must stop, the logic unit await until the VPE is at a standstill.

The fan always activates when the manual command is used for the VPE.

Enabled (standard)

As a rule, the fan is always in operation.

The device is stopped in the following circumstances:
- When function F1 is enabled at step Zero or End of Cycle.
- When the machine is stopped by the user. (Machine Stop Button)
  In this case: the device stops after the time set in the specific field.

Enabled (stop with error)

In this case, there are other situations in addition to that described above.

Therefore:

The device is stopped in the following circumstances:
- When the machine is stopped due to the presence of a failure.

[Ent]   **Zero position AIR VACUUM VALVE**

The control valve follows the program instructions and addresses the suction flow.

The stepping motor-driven valve rotates one revolution every 400 steps.

The value is expressed as motor steps.

With an external fan, enter "380".

In this way …

Alternative management prevents the nozzle from continuing suction, which thus prevents the external fan motor from overheating.

► Autotest various outputs → EV fan contactor
► Autotest of inputs → Stop fan thermal clips
► Autotest menu → Stepping Motors → Electronic stepping vacuum valve

20.0:	**Fan contactor still energized!**	Error - Movement impossible

The message informs that the device is still in operation instead of being at a standstill.
Clearly … the condition is verified compared to processing and settings.

First consult the information contained at the start of the section.
► See also … Autotest menu
Check that the input/output status switches.

If the fan is not running, then … Replace the Input board of the signal control.
If the device is in operation, then … Check the presence of the 24 Vdc command in arrival to the Contactor coil.
In positive case: Replace the command signal output board.
In negative case: Replace the device: Contactor + Thermal relay.

20.1:	**Fan contactor not energized!**	Error - Movement impossible

First refer to what specified for the previous entry.

The message informs that the device is still stopped instead of running.
Clearly … the condition is verified compared to processing and settings.
If the device is in operation, then … Replace the Input board of the signal control.
If the fan is not running, then … Check the presence of the 24 Vdc command in arrival to the Contactor coil.
In positive case: Replace the device: Contactor + Thermal relay.
In negative case: Replace the command signal output board.

20.2:	**Fan contactor setup correcly saved**	Warning

Data has been acquired (stored) successfully.

20.3:	**Fan contactor setup saving error**	Warning

Informs that saving has failed. Go back to the menu and try again.
Or … Reboot the machine and repeat the operation.
If the problem persists, please contact the Technical Customer Service.
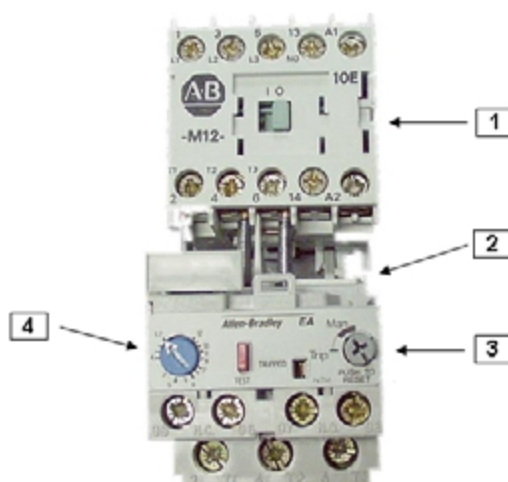
Contactor + Thermal relay

1) Contactor
2) Thermal Relay
3) Reset button
4) Release Current adjustment

21.   Software Upgrade

21.0:   Starting update for %s CAN line %d. Please wait…   Warning

This message alerts the user that an upgrading of the specified board(s) is in progress.
Await the outcome of the operation.
In the message, the variable indicates:
%s = family of boards ; %d = CAN line
The *.up file will NOT be eliminated automatically once it has been activated.

21.1:   File.up not matching with any of the defined devices   Warning

A board update file has been selected but for board a not present in the current package.
Remember that: The disabled device is not handled even when it is connected.

21.2:   Updating anomaly (code: %d)   Warning

Internal software failure . Contact the Technical Customer Service.

21.3:   Operation correctly finished   Warning

The message confirms that:
The updating has been completed successfully.

21.4:   The family %s_??.up does not have the correct software installed (requires version %d.%d.%d)   Initial error

The machine in addition to normal machine Software (system + custom) installed on the Motherboard, also uses other software installed on other boards.
This message appears in the case the "external software" installed is not compatible with the machine software.
When is turned on the machine it performs always this verification.
Load and activate the *.up file updated to the specified version.

21.5:   No device can be updated for the selected family   Warning

A board update file has been selected but for board a not present in the current package.
Remember that: The disabled device is not handled even when it is connected.

22. Mechanical zero acquisition

Refer to the menu: Mechanical zero (= Motor setup menu → Mechanical zero setting)

For more information, refer to the manual: **Mechanical Adjustments**

22.0: Mechanical zero missing
Initial error

The zero proximity angular position has not yet been stored.

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.

Otherwise a message is displayed.

The solution is to access the machine Setup and acquire the "Mechanical Zero" through the proper procedure.

22.1: Proceed with handle 1 or 2 as indicated
Warning

This message informs the user that the Start button is disabled.

Only [Handle 1]/ [Handle 2] key must be used.

22.2: Mechanical zero procedure aborted
Warning

The message confirms that:

It was decided to exit the procedure.

The key figure has to be acquired.

22.3: Mechanical zero saving completed
Warning

Data has been acquired (stored) successfully.

22.4: Mechanical zero setup saving error
Error - Movement impossible

Informs that saving has failed. Go back to the menu and try again.

Or … Reboot the machine and repeat the operation.

If the problem persists, please contact the Technical Customer Service.

22.5: No response from motor drive
Error - Movement impossible

Check the correct connections of the CAN cable between the Pcb 2010 board and the Motor Drive board.

Eventually replace the cables and/or the boards concerned.

22.6:	**Machine synchronized: press RETURN to confirm**	Warning

In the menu mentioned: after a few turns of crank the degree count starts.
At that moment the message appears.
The message confirms that: The user can now proceed with other operations.
Then, using the mechanical or electric handle (1 and 2) position the zero cylinder correctly according to the specific model:
To store the mechanical zero position press ... **[Return] / (OK)**

For this calibration/ adjustment is possible to use the specific gauge.
The caliber is specific to each model.

22.7:	**Automatic mechanical zero acquired**	Warning

Do not currently managed.

22.8:	**Press the start button and wait for the acquisition of the automatic mechanical zero**	Warning

Do not currently managed.

23.   Program conversion

The message appears when the Sock Programme is activated.

Or …

If the article is already active then the message appears as soon as the conversion is finished.

23.0:   Needles machine number %d not found in maz2maky   Error

Alerts that the number of needles set in the setup menu is not handled by the software.

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.

Set the "Needles number" of the machine cylinder.

23.1:   Function type %d not found (function id = %d - max. managed function num. = %d)
step:%d degree:%d   Error

Alerts that article is not encoded for the software version installed in the machine. !da duplicazione!

Check the software version of the machine and upgrade it to the Graphitron version, or vice versa.

23.2:   Wrong encoded number of drums (%d) (expected number = %d)   Error

Alerts that article is not encoded for the software version installed in the machine. !da duplicazione!

Check the software version of the machine and upgrade it to the Graphitron version, or vice versa.

23.3:   Suspended pattern not found   Error

Alerts that there is inconsistency in article programming halt/ restart.

Internal software failure . Contact the Technical Customer Service.

23.4:   Program needles number (%d) not matching the machine needles number (%d)   Error

The message appears if:

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 motherboard.

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.

23.5:   **Encoded diameter %d not matching the diameter %d set in the machine**   Error

The message appears if:

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.

Proceed as already shown for message: 23.4 .

23.6:   **Codified program version %d.%d not compatible with the %d.%d set up in machine**   Error
- Movement impossible

This alarm indicates incompatibility between the programming software (Graphitron) and the machine software (Eprom). 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 and/ or the Graphitron. Of course, in the case of Graphitron updating the sock program must be coded again.

23.7:   **Encoded machine name not compatible with the machine**   Error - Movement impossible

Sock Program not compatible with the machine software.

This Program not corresponds to the machine model, it regards another machine model, for which is not valid.

Load a specific article for that model.

23.8 ÷ 23.17

Do not currently managed.

23.18:   **No programming of motor %ls**   Error - Movement impossible

Alerts that the motor shown has not been programmed in article.

Check and correct the encoded article.

23.19: **Eccentric stitch cam encoded (%d) different from eccentric set in machine (%d)** — Error
- Movement impossible

The message refers to the item: **Stitch cam gauge**
Based on the value of this parameter, a specific mechanical part must be mounted.
The software has detected a difference between the mechanical part entered under Setup and that entered in the Programme.

Refer to the menu: **Configure stitch cam gauge**
The user must check the value set in the sock program and compare it with the one set in the Machine Setup.
Correct the Sock Program by Graphitron.
Or … Access to the machine Setup and set the correct value.

23.20: **Wrong routine picker programming degree** Error **-** Movement impossible

The degree of start of picker routine is greater than the end value.
Check programming from Graphitron.

23.21: **Article %s is not present in the machine** Error **-** Movement impossible

This error is usually generated on activation of a concatenated work. Operation on chaining is meaningful if the called-up items are present.
The user should load on the Sock program that wants to produce.

23.22: **Size %d not codified in article** Error **-** Movement impossible

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.

23.23: **Confirmation selection position: FORWARD %d (Min=%d Max=%d)** Error

For basic information, refer to: **Mechanical Adjustments** (manual).
In particular: Adjusting the terry pattern drum angle position

The message refers to the item: **Terry drum angular position**
The first variable indicates: Current value of data. .
The second variable indicates: Minimum accepted value .
The third variable indicates: Maximum settable value .

Refer to the menu: **Cylinder angle position setting drum for terry**

Informs that values below / above the standard allowed have been entered.
The message indicates the range of accepted values.

Forward = normal rotation of the cylinder .
The position of the part is out of tolerance.
Launch the reset command before executing a new acquisition (calibration).
Activate the article after the operation. Perform calibration on completion of mechanical resetting.
Acquisition is required for all menu items.

Refer to the menu: **Setup menu drum for terry**

23.24: **Closed-toe codified program version %d not compatible with the %d set in machine**　　Error

Alerts that article is not encoded for the software version installed in the machine. !da duplicazione!
Check the software version of the machine and upgrade it to the Graphitron version, or vice versa.

23.25: **Concatenated data not valid (code: %d)**　　Error - Movement impossible

Check programming from Graphitron.
Re-encode the file from Graphitron.
If the problem persists, please contact the Technical Customer Service.

23.26: **The program was renamed. Name: %s, which is not congruous with the internal to the file: %s**　　Error - Movement impossible

The file has been renamed manually. The machine does not accept this operation.
The message shows the current value, and the original one.
Solution : Re-encode the file from Graphitron.

23.27: **Confirmation selection position: BACKWARDS %d (Min=%d Max=%d)**　　Error

Backward = reversed rotation of the cylinder .

See the description provided for the message:　　**23.23**

23.28: **Programme valid for motorized stitch cams. Activation enabled by setup**　　Warning

This information only applies to the following models:
Models equipped with: Stitch-cams not motorized .

Refer to the menu:　　**Configuration stitch cams calibration**

The message refers to the item: **Motorized stitch cam programme control**

If an article is re-encoded using a recent version of Graphitron, the motorized stitch cam line is compiled.
This disabling option has been added to solve compatibility problems for new programs with non-updated models.

Let us now consider the following situation:
Activation of an article with motorized stitch cams. .

With management enabled:
Machines with pneumatic stitch cams reject the programme.
The article will not be activated.
The machine will report the situation via a message. (50. 5)

With management disabled:
The machine accepts the programme.
The article will be produced.
The machine will report the situation via a message. (23. 28)
This option is not recommended due to the potential danger.
[option recommended : Correct the Sock Program by Graphitron.]

See the description provided for the message:　　**50.5**

23.29:   Confirmation selection position: FORWARD with piston %d (Min=%d Max=%d)   Error

Do not currently managed.

23.30:   Programme toe sliders number (%d) other than setup toe sliders (%d)   Error

Message no longer menaged. Update the machine software .

23.31:   Economies programmed on end-of-cycle step or for-step that includes that step   Error

The message is specific for the following models: Open Toe .
The message states that: A programming error was committed through the Graphitron.
The end-of-cycle step cannot be repeated. Check programming from Graphitron.

23.32:   flag100 value inconsistent with encoded value   Error - Movement impossible

Do not currently managed.

23.33:   flag200 value inconsistent with encoded value   Error - Movement impossible

Do not currently managed.

23.34:   Programme not executable. Welt motor height during sock extraction other than zero.   Error

The message is specific for the following models: External Closed Toe .
The message states that: A programming error was committed through the Graphitron.
The mentioned motor, in the indicated step, must be at zero. Check programming from Graphitron.

23.35:   Non-executable programme. Sewing machine disabled from setup.   Error

The message is specific for the following models: External Closed Toe .
An attempt was made to activate an aricle that is not compatible with the equipment and/ or model.
Or …
The equipment required by the article is disabled.

Refer to the menu: **General setup external closed toe**
In particular, refer to item:
[A]   Sock extraction and seaming

With management enabled:
The robot and machine are independent. They operate in synchronisation during sock extraction.
For the device to work, you need to enter specific codes in the sock programme (Graphitron).

With management disabled:
The disabled device is not handled even when it is connected.
Sock programmes encoded for the robot (pick-up, sewing, ejection) cannot be activated.
With the correct programmes, the machine operates like the models without a robot.
Therefore: With "Closed toe" disabled, the sock comes out of the ejction device unseamed.

Correct the Sock Program by Graphitron.
Or … Access to the machine Setup and set the correct value.

23.36: **Number of feeders in the programme greater than those on machine** Error **-** Movement impossible

Internal software failure . Contact the Technical Customer Service.

23.37: **Half-gauge inconsistent between .CO and machine** Error

Refer to the menu: **General data setting**
Correct the Sock Program by Graphitron.
Or … Access to the machine Setup and set the correct value.

23.38: **Internal knit raising tube motor funtions missing** Error

Refer to the menu: **General setup external closed toe**
In particular, refer to item: **Motorized Internal knit raising tube management**

Correct the Sock Program by Graphitron.
Or … Access to the machine Setup and set the correct value.

23.39: **Type of Take-Down inconsistent between .CO and machine** Error

Correct the Sock Program by Graphitron.
Or … Access to the machine Setup and set the correct value.

Refer to the menu: **Take-Down setup**
In particular, refer to item: **Type of Take-Down**

The menu offers the choice between 2 options.
Select the actual equipment.
- Helical Take-down [= Mechanical Take-Down + heel sack-pusher] . (a)
- Standard Take-down [= Take-Down for open toe (Open Toe)] .

(a) **Italiano**: Tiraggio meccanico + spingisacca tallone .

24.　　　　　　　　Maintenance of improvements

Refer to the menu:　　　　　　　　　　　　　　　　　　　　　　　**Import file**

When a coded item is reloaded on machine, the "holding procedure" starts automatically.
The process consists of comparing two files of the same name by the software.
The procedure is used to hold the improvements made to current item from the machine console.

If the result is positive, any changes to economy, speed, narrowing, elastic yarn feed and stepper motor settings will be held.

Concerning this see the menu:　　　　　Restoring menu
　　　　This menu can be used to cancel on the current item some or all the modifications made from the machine console.

Obviously …
If the following condition is met, the operation will be successful.
The two files must have the same number of zones and be part of the same order.

Any item features not involved in optimisations will be overwritten.
If the item being loaded is active, any changes will take effect from the next work cycle.

24.0:　　MAINTENANCE decompression ko　　　　　Error - Movement impossible

Internal software failure . Contact the Technical Customer Service.

24.1:　　MAINTENANCE INTERRUPTED: %s　　　　　Error - Movement impossible

Internal software failure . Contact the Technical Customer Service.

24.2:　　MAINTENANCE successfully finished　　　　　Warning

The operation was performed successfully.

25. Drums

Refer to the menu: Inputs setup (= Machine management setting → Inputs enable)

See also the menu: Autotest levers (Drums)

Drums board   Pcb 3819 : LED light meaning

LED light	colour	Function
Ds1	Yellow	Presence of -100V
Ds2	Red	Presence of +100V
Ds3	Red	Short-circuiting alarm
Ds4	Red	Alarm - Pattern drum not connected
Ds5	Green	Presence of SPI clock

25.00:   Short circuit drums board 1
Error **-** Movement impossible

A pattern drum or control board short-circuiting was detected.
The causes of the alert can be the following:
1. The pattern drum has short-circuited.
2. Faulty board.
3. The cable is damaged.

Cut out part of the circuit to find out the faulty element.
If when disabling a device, the errors disappear, it means that device was the source of the malfunction.
This operation must be performed with the machine turned off. Turn off the machine from the main switch.

Disconnect all the pattern drums from the control board. Turn on the machine again.
If the error disappears, one of the cut-out elements is faulty.
Disconnect one of the pattern drums from the control board. Turn on the machine again. Repeat the procedure until the error disappears. At this point, it means that the element that caused the alert has been cut out. Replace the Pattern Drum.

If the error persists, it means that the fault has originated from the circuit elements.
Replace the cable or the board.

Other similar messages

	25.1 Short circuit drums board 2
25.2 Short circuit drums board 3	25.3 Short circuit drums board 4
25.48 Short circuit drums board 5	25.49 Short circuit drums board 6

25.70:   BUS connection drum board 1
Error **-** Movement impossible

Check the wiring from the connector to the board.
In particular:
CVP 320 : Pcb 5716 , J1 / Pcb 2010 , J18

Other similar messages

	25.71 BUS connection drum board 2
25.72 BUS connection drum board 3	25.73 BUS connection drum board 4
25.74 BUS connection drum board 5	25.75 BUS connection drum board 6

25.4: Drum 4 not connected (SK1-J1)

Error - Movement impossible

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.

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.

Check the wiring from the connector to the board. Eventually replace these components.

Replace the Pattern Drum.

Other similar messages

25.7	Drum 1 not connected (SK1-J4)	25.27	Drum 1a not connected (SK1-J1)
25.28	Drum 1a not connected (SK1-J2)	25.52	Drum 1r not connected (SK2-J3)
25.53	Drum 1r not connected (SK2-J4)	25.20	Drum 2 not connected (SK1-J1)
25.21	Drum 2 not connected (SK1-J2)	25.6	Drum 2 not connected (SK1-J3)
25.50	Drum 2 not connected (SK2-J1)	25.51	Drum 2 not connected (SK2-J2)
25.31	Drum 2 not connected (SK2-J3)	25.32	Drum 2 not connected (SK2-J4)
25.56	Drum 2a not connected (SK3-J3)	25.57	Drum 2a not connected (SK3-J4)
25.29	Drum 2a not connected (SK2-J1)	25.30	Drum 2a not connected (SK2-J2)
25.54	Drum 2r not connected (SK3-J1)	25.55	Drum 2r not connected (SK3-J2)
25.5	Drum 3 not connected (SK1-J2)	25.25	Drum 3 not connected (SK2-J3)
25.26	Drum 3 not connected (SK2-J4)	25.35	Drum 3 not connected (SK3-J3)
25.36	Drum 3 not connected (SK3-J4)	25.60	Drum 3 not connected (SK4-J3)
25.61	Drum 3 not connected (SK4-J4)	25.42	Drum 3 not connected (SK2-J1)
25.43	Drum 3 not connected (SK2-J2)	25.46	Drum 3a not connected (SK3-J3)
25.47	Drum 3a not connected (SK3-J4)	25.58	Drum 3a not connected (SK4-J1)
25.59	Drum 3a not connected (SK4-J2)	25.33	Drum 3a not connected (SK3-J1)
25.34	Drum 3a not connected (SK3-J2)	25.64	Drum 3r not connected (SK5-J3)
25.65	Drum 3r not connected (SK5-J4)		
25.4	Drum 4 not connected (SK1-J1)	25.23	Drum 4 not connected (SK2-J1)
25.24	Drum 4 not connected (SK2-J2)	25.39	Drum 4 not connected (SK4-J3)
25.40	Drum 4 not connected (SK4-J4)	25.62	Drum 4 not connected (SK5-J1)
25.63	Drum 4 not connected (SK5-J2)	25.44	Drum 4 not connected (SK3-J1)
25.45	Drum 4 not connected (SK3-J2)	25.68	Drum 4a not connected (SK6-J3)
25.69	Drum 4a not connected (SK6-J4)	25.37	Drum 4a not connected (SK4-J1)
25.38	Drum 4a not connected (SK4-J2)	25.66	Drum 4r not connected (SK6-J1)
25.67	Drum 4r not connected (SK6-J2)		
25.11	Drum 5 not connected (SK2-J4)	25.10	Drum 6 not connected (SK2-J3)
25.9	Drum 7 not connected (SK2-J2)	25.8	Drum 8 not connected (SK2-J1)
25.15	Drum 9 not connected (SK3-J4)	25.14	Drum 10 not connected (SK3-J3)
25.13	Drum 11 not connected (SK3-J2)	25.12	Drum 12 not connected (SK3-J1)
25.19	Drum 13 not connected (SK4-J4)	25.18	Drum 14 not connected (SK4-J3)
25.17	Drum 15 not connected (SK4-J2)	25.16	Drum 16 not connected (SK4-J1)

25.41: Lack of tension drums board

Error - Movement impossible

Voltage +/-100 Vdc (pattern drum power) is created on supply board "Res off-line 100", it is read by the 220 Vac supply on the board.

The information on the integrity of this tension (control signal) comes out of this board and arrives to the Pcb 2010 board. (J45)

In the event of an error, check that the output voltage of supply board is +/- 100VDC.

If there isn't this voltage: Replace the board.

If the voltage is correct: Check the wiring that connect that connect the various boards.

Or … Eventually replace the cables and/or the boards concerned.

Donna machines

This information only applies to the following models:
DONNA machines (single-cylinder models, for pantyhose) .
More in particular:
Models equipped with the following device: **Raising dial motor** .
The motor does not have an encoder.

Reference

Refer to the menu: **Rest enabling setup**
See also: **Dial raiser manuals**

Remember that:
In order for the machine to run smoothly, it must be adjusted properly.
Concerning this see the menu: **Raising dial motor**
[… / Autotest menu / Stepping Motors / »]

For more information, refer to the manual: **Mechanical Adjustments**

       Dial position   :

The Dial position is controlled by the software via the value read by a sensor. [= i. 90] *
                        Concerning this see the menu: **Raising dial motor**

Zero sensor =	Motor zero sensor = input integrated on the motor board
	When the Dial is low the control sensor is in a reading status.
End of stroke sensor =	Dial vertical piston/ Saw stop motion
	This item is specific for the models equipped with: **Raising dial motor**
	Otherwise:
Zero sensor =	Saw stop for high welt =
	Input for upper mechanical dial .
	When the Dial is low the control sensor is in a reading status.

(*)   **i.** :   input (input code for the software = software input)

       Input :   To this end, see table:
                     Matching software and hardware inputs (**Enclosure**)

Foreword

The situation is critical each time dial jacks project during operation.

Therefore: Work is discontinued when the Weld unit is raised and the dial jacks are out.

At this point we will have two possibilities:

Situation 1

If an attempt is made to start the cylinder (Run or Crank button), the resetting is performed automatically.
(1)

Wait for the message: 26.5

Situation 2

Vice versa …

To continue, bring the group to the low position.

Therefore: Press the start button.

The machine will resume production.

<u>Note</u>

Remember that:

If an item has grey only the button, it means that it cannot be activated or it is inaccessible , in that moment.

Wait for the message: 26.5

(1)   For more information, refer to the manual: USER INTERFACE
                In particular, refer to the paragraph: Main Window / Commands available / [F0] .

26.0:   Saving setup welt-raise correct   Warning

Data has been acquired (stored) successfully.

26.1:   Error saving setup welt-raise   Warning

Informs that saving has failed. Go back to the menu and try again.
Or … Reboot the machine and repeat the operation.
If the problem persists, please contact the Technical Customer Service.

26.2:   Reset Dial manually   Error - Movement impossible

When switched on, the machine checks the zero position of the mechanical unit.
The zero sensor is not in reading. (input integrated on the motor board)
Press the button: **Lower dial manual** .
Touching the icon, the mechanical unit moves downwards.

26.3:   Dial head not in correct position   Error - Movement impossible

The device has not reached the end position.
The sensor is not in reading.

Delete the message by pressing [F8].
Go back to the menu and try again.
Press the button: **Dial raising manual** (Hold down the button.)

See also:
39.   **Messages on Inputs - DONNA machines**
In particular:

                                                i. 90 = Dial vertical piston/ Saw stop motion

26.4:   Manual rise dial not executable during dial-jacks movement   Information

Informs that the operation cannot be performed under the current circumstances.
This is for safety reasons.
The button is temporarily disabled.
The situation is critical each time dial jacks project during operation.
Wait until the end of the operation. [Dial jacks enter / Dial jacks exit]

26.5:   Edge Manuals rehabilitated. Complete the manual movement Information

This message informs the user that has been restored the command relative the function:
[Dial Raiser] / [Dial Lower] .
The command is enabled wherever required and there is no hazards.

The message appears in the following circumstances:
Watch beginning of section.

26.6:   Start disabled for manual dial raise not completed Information

The device has not reached the end position.
Informs that the operation cannot be performed under the current circumstances.
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.
See the description provided for the message: **26.3**

26.7:   Manual dial raising disabled Information

Informs that the operation cannot be performed under the current circumstances.
The button is temporarily disabled.

The message appears in the following circumstances:
The motor is executing the commands set by the software to check the correct positioning.
Therefore: The device is engaged.
Wait until the end of the operation.

27.   Steps modification

Refer to the menu: **Work menu**
See also the menu: **Restoring menu**
In particular, refer to item: Stepping Motors (sizing, sinker cap, etc.)

27.0:   MPP values out of range (min. %d - max. %d)   Warning

Message no longer menaged. Update the machine software .

Informs that values below / above the standard allowed have been entered.
The value is expressed as motor steps.
See the next message.

27.0:   MPP values out of range   Warning

Informs that values below / above the standard allowed have been entered.
For this reason the change was not accepted.
Therefore:
Informs that the programmed values have been restored.

27.1:   MPP values correctly saved   Warning

The operation was performed successfully.

27.2:   MPP values correctly restored   Warning

Informs that the programmed values have been restored.

27.3:   MPP values encoding writing failure   Warning

The changes have not been saved. This particular message is a symptom of a Hardware or Software problem.
Go back to the menu and try again. Or … Reboot the machine and repeat the operation. If the problem persists, please contact the Technical Customer Service.

27.4:   Operation not allowed. The motors do not have the same number of zones   Information

This information only applies to the following models:
DC88 machines (double-cylinder models, for men's socks) .
Internal software failure . Contact the Technical Customer Service.

Try to re-encode the article from Graphitron.

If the problem persists: Check the software version.
Eventually …
Update the machine software and/ or
Update the Graphitron software .

28. Elastic motors

Refer to the menu: **Yarn modification**
See also the menu: **Restoring menu**

28.0:   **YARN data out of range (min. %d - max. %d)**   Warning

Informs that values below / above the standard allowed have been entered.
The value is expressed in RPM (revolutions per minute).

28.1:   **YARN data correctly saved**   Warning

The operation was performed successfully.

28.2:   **YARN data correctly restored**   Warning

Informs that the programmed values have been restored.

28.3:   **YARN data encoding writing failure**   Warning

The changes have not been saved. This particular message is a symptom of a Hardware or Software problem.
Go back to the menu and try again. Or … Reboot the machine and repeat the operation. If the problem persists, please contact the Technical Customer Service.

Elastic motors

29. YOYO

Refer to the menu: **Modify YOYO**
See also the menu: **Restoring menu**

| 29.0: | **YOYO data out of range (min. %d - max. %d)** | Warning |

Informs that values below / above the standard allowed have been entered.
The value is expressed as motor steps.

| 29.1: | **YOYO data correctly saved** | Warning |

The operation was performed successfully.

| 29.2: | **YOYO data correctly restored** | Warning |

Informs that the programmed values have been restored.

| 29.3: | **YOYO data encoding writing failure** | Warning |

The changes have not been saved. This particular message is a symptom of a Hardware or Software problem.
Go back to the menu and try again. Or … Reboot the machine and repeat the operation. If the problem persists, please contact the Technical Customer Service.

| 29.4: | **Operation not allowed. The motors do not have the same number of zones** | Information |

Do not currently managed.

Internal software failure . Contact the Technical Customer Service.

Try to re-encode the article from Graphitron.

If the problem persists: Check the software version.
Eventually …
Update the machine software and/ or
Update the Graphitron software .

30. IRO

Do not currently managed.

30.0:	IRO data out of range (min. %d - %d)	Warning

Informs that values below / above the standard allowed have been entered.
The value is expressed in RPM (revolutions per minute).

30.1:	IRO data correctly saved	Warning

The operation was performed successfully.

30.2:	Recovery of the program original values successfully finished	Warning

Informs that the programmed values have been restored.

30.3:	IRO data encoding writing failure	Warning

The changes have not been saved. This particular message is a symptom of a Hardware or Software problem.
Go back to the menu and try again. Or … Reboot the machine and repeat the operation. If the problem persists, please contact the Technical Customer Service.

IRO

General Description

CAN is a special connection protocol, it connects to the "machine main processor" devices that will perform specific functions authorized by the processor.
Each board must be numbered so that it's recognized by the software.

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).
More in particular:
A problem in the software writing, an hardware problem on the CAN boards, a disorder on the CAN transmission.

Reference

Refer to the menu: **Rest setup**

See also: **Menu numbering**

See also: **Step motors menu**
   (Self-Test menu, where, through some manual command, you can verify the movement of the motor.)

Legend

The message contains two variables.

In the message, the variable indicates:

(%d) = This variable expresses the error via the code for internal use.

%ls = This variable indicates: The motor.

The variable can have the following values:

SIZING MOTOR	AIR VACUUM VALVE
SINKER CAP	SINKER ANGLE
STITCH-CAM HEEL RETURN	STITCH CAM 1
STITCH CAM 2	STITCH CAM 3
STITCH CAM 4	DIAL RAISER
PYF 1	PYF 2
PYF 3	PYF 4
PYF 5	PYF 6
PYF 7	PYF 8
RADIAL MOTOR 1	RADIAL MOTOR 2
RADIAL MOTOR 3	RADIAL MOTOR 4
Elastic 1	ELASTIC 2
SAW	SHUTTER VALVE EXTERNAL CLOSED TOE
VERTICAL PICKUP DEVICE ARM	ANGLE PICKUP ARM
TURNING DEVICE DOWN	TURNING DEVICE UP
PIN FEED	LINKER MOTOR
TURNING DEVICE DOWN INCLINATION	PIN UNIT REVERSE
PLAIN FEED 1	PLAIN FEED 2
RIB FEED 1	RIB FEED 2
HEEL	TAKE-DOWN TUBE
Tucking cam feed 1	Clearing cam feed 1
Extra cam feed 1	Tucking cam feed 2
Clearing cam feed 2	Extra cam feed 2
Tucking cam feed 3	Clearing cam feed 3
Extra cam feed 3	Tucking cam feed 4
Clearing cam feed 4	Extra cam feed 4

First consult the information contained at the start of the section.

In the message, the variable indicates … Watch beginning of section. (**Legend**) .

31.0:	**Supply tension too high: %ls (%d)**	Alarm

Proceed as follows to solve the problem:

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.

Proceed as follows to solve the problem:

- Check the power supply (voltage) of the CAN board relative the motor indicated in the message. Replace the board(s) if necessary.
- Check that the output voltage of supply board is +24 VDC.   and/ or
- Check that the output voltage of supply board is +40 VDC.
- Check the wiring that connect that connect the various boards.
- Check that the connections are correct.

31.1:	**Phase current too high: %ls (%d)**	Alarm

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.

Proceed as follows to solve the problem:

- Check the power supply (voltage) of the CAN board relative the motor indicated in the message. Replace the board(s) if necessary.
- Replace the stepping motor indicated in the message.
- 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).

31.2:	**Excessive temperature: %ls (%d)**	Alarm

See the description provided for the message: 31.1

The sensor has detected an excessive temperature. The device has been disabled.

The user must turn off the machine. Wait for the card to cool down.

31.3:	**Pin motor encoder phase Z not found during zeroing %ls (%d)**	Alarm

Motor … **PIN FEED**

The motor position is controlled by 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.

First consult the information contained at the start of the section.

In the message, the variable indicates … Watch beginning of section. (**Legend**) .

31.4:   ID CAN: %ls (%d)   Alarm

Refer to the menu: MPP numeration

Remember that:

In this window you can run the numbering of the CAN modules.

Each board present in the machine must be numbered so that it's recognized by the software; for each board will be at the same time associated the motors available on the machine.

The message indicates that a control module has lost the identification number.

Check the wiring from the connector to the board.

Check the wiring between the motor and its PCB.

Replace the CAN module associated with the motor indicated in the message.

To this end, see table: **Motor in Numbering / Board in numbering**

Motor in Numbering	Board in numbering
DIAL RAISER	DG_STEP_MOT_ALZABORDO
DIAL RAISER	REMOTE_STEPX_MOT_ALZABORDO
SIZING MOTOR	REMOTE_POWER_ALZACILINDRO
SIZING MOTOR	REMOTE_STEPX_ALZACIL
CYLINDER RAISING- DIAL RAISING- SAW DEVICE	FOUR_STEP_ALZACIL_BORDO_SEG
SIZING MOTOR ELASTIC 1&2 DIAL RAISER	FOUR_STEP_ALZACIL_ELA1e2_ALZABORDO
SIZING MOTOR ELASTIC 1&2 DIAL RAISER SAW	FOUR_STEP_ALZACIL_ELA1e2_BORDO_SEG
SIZING MOTOR ELASTIC 1&2 ELASTIC 2	FOUR_STEP_ALZACIL_ELA1e2_ELA2
SINKER ANGLE	REMOTE_STEP_COP_PLAT_ANG
SINKER ANGLE + ENCODER	REMOTE_POWER_COP_PLAT_ANG
SINKER ANGLE + ENCODER	REMOTE_STEPTX_COP_PLAT_ANG
PIN FEED-LINKER	REMOTE_STEPTX_AVSPILLI_CUCI
PIN FEED-LINKER-TURNING DEVICE-FLIPPING FEED	FOUR_STEP_AVSPILLI_CUCI_ROVINCLI_RIBSPILLI
ANGLE PICKUP ARM	REMOTE_STEPX_BRACCIO_ANG
VERTICAL PICKUP DEVICE ARM	REMOTE_STEPX_BRACCIO_VERT
VERTICAL-ANGLED PICKUP DEVICE ARM UP-DOWN TURNING DEVICE	FOUR_STEP_BRACCIO_VERTeANG_ROV_BASSOeALTO
SINKER CAP	REMOTE_STEP_COP_PLAT
PLAIN FEED 1	REMOTE_STEP_DIRITTO_CAD_1
PLAIN FEED 2	REMOTE_STEP_DIRITTO_CAD_2
ELASTIC 1 or ELASTIC 1and2	REMOTE_STEPX_ELASTICO_1e2
ELASTIC 2	REMOTE_POWER_ELASTICO_2
ELASTIC 2	REMOTE_STEPX_ELASTICO_2
TURNING DEVICE DOWN INCLINATION	REMOTE_STEPX_ROV_INCLI
PYF 1	PYF_PLUS_PYF_1
PYF 1	REMOTE_STEPX_PYF_1
PYF 1-2-3-4	FOUR_STEP_PYF_1a4
PYF 2	PYF_PLUS_PYF_2
PYF 2	REMOTE_STEPX_PYF_2
PYF 3	PYF_PLUS_PYF_3
PYF 3	REMOTE_STEPX_PYF_3
PYF 4	PYF_PLUS_PYF_4
PYF 4	REMOTE_STEPX_PYF_4
PYF 5	PYF_PLUS_PYF_5
PYF 5	REMOTE_STEPX_PYF_5
PYF 5-6-7-8	FOUR_STEP_PYF_5a8
PYF 6	PYF_PLUS_PYF_6
PYF 6	REMOTE_STEPX_PYF_6
PYF 7	PYF_PLUS_PYF_7
PYF 7	REMOTE_STEPX_PYF_7
PYF 8	PYF_PLUS_PYF_8

First consult the information contained at the start of the section.

In the message, the variable indicates … Watch beginning of section. (**Legend**) .

Motor in Numbering	Board in numbering
PIN UNIT REVERSE	REMOTE_STEP_RIBALTA_SPILLI
TURNING DEVICE UP	REMOTE_STEPX_ROV_ALTO
TURNING DEVICE DOWN	REMOTE_STEPX_ROV_BASSO
RIB FEED 1	REMOTE_STEP_ROVESCIO_CAD_1
RIB FEED 2	REMOTE_STEP_ROVESCIO_CAD_2
Clearing cam feed 1	REMOTE_STEPRL_SCA_CAD_1
Clearing cam feed 2	REMOTE_STEPRL_SCA_CAD_2
Clearing cam feed 3	REMOTE_STEPRL_SCA_CAD_3
Clearing cam feed 4	REMOTE_STEPRL_SCA_CAD_4
SAW	REMOTE_STEPX_SEGHETTA
Extra cam feed 1	REMOTE_STEPRL_ICS_CAD_1
Extra cam feed 2	REMOTE_STEPRL_ICS_CAD_2
Extra cam feed 3	REMOTE_STEPRL_ICS_CAD_3
Extra cam feed 4	REMOTE_STEPRL_ICS_CAD_4
HEEL	REMOTE_STEP_TALLONE
Tucking cam feed 1	REMOTE_STEPRL_TRA_CAD_1
Tucking cam feed 2	REMOTE_STEPRL_TRA_CAD_2
Tucking cam feed 3	REMOTE_STEPRL_TRA_CAD_3
Tucking cam feed 4	REMOTE_STEPRL_TRA_CAD_4
STITCH CAM 1	REMOTE_STEP_TRIA1
STITCH CAM 2	REMOTE_STEP_TRIA2
STITCH CAM 3	REMOTE_STEP_TRIA3
STITCH CAM 4	REMOTE_STEP_TRIA4
STITCH-CAM HEEL RETURN	REMOTE_STEP_TRIA_RIT_TALL
TAKE-DOWN TUBE	REMOTE_STEPX_TUBO_TIRAGGIO
TUBO TIRAGGIO ELASTICO 1e2 PYF 1-2	FOUR_STEP_TUBO_TIRAG_ELA1e2_PYF1_2
SHUTTER VALVE EXTERNAL CLOSED TOE	REMOTE_STEP_VPE_CTEXT

31.5: Tx impossible: %ls (%d)	Error

Internal software failure . Contact the Technical Customer Service.
Check the wiring that connect that connect the various boards.
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 problem is probably due to a software failure, and it is supposed it will never be displayed to the user.
Contact Lonati technical staff for further information and for an eventual Software update.

31.6: Rx busy: %ls (%d)	Error

For the explanation/ solution, see what specified for the previous entry.

31.7: Disabled module: %ls (%d)	Error

The motor indicated has no torque.
Failure can be caused by:
Following the appearance of an "Alarm" message.

See the following page.

First consult the information contained at the start of the section.

In the message, the variable indicates … Watch beginning of section. (**Legend**) .

Therefore …
After turn on again the machine …
Press the button: [F8] .

If the message is not cleared, or it reappears immediately, it means that the condition that had originated it is still active.
In this case …
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.
Therefore:
Failure can be caused by:
See the description provided for the message: **31.2**

31.8:   Motor busy: %ls (%d)   Error

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).

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.
In case the problem remains:
Contact Lonati technical staff for further information and for the information necessary for the problem solution.

31.9:   LVDT reading: %ls (%d)   Error

Do not currently managed.

31.10:   Cell readout: %ls (%d)   Error

Do not currently managed.

31.11:   skCanMppSegnalazione 12: %ls (%d)   Error

Do not currently managed.

31.12:   ADC reading wrong: %ls (%d)   Error

Do not currently managed.

First consult the information contained at the start of the section.

In the message, the variable indicates … Watch beginning of section. (**Legend**) .

31.13:   **Impossible approach to 0: %ls (%d)**   Error

The message refers to the procedure called: Approach (motor approaching zero).
The message appears if any irregularities occur during the procedure.

More in particular:
The message appears in the following circumstances:

a) The Zero sensor is in reading before the motor has finished its movement.

Or …

b) The zero sensor is not in reading despite the motor has already completed the movement.

Software routine

Movement of zeroing of the motor.
During the normal Sock cycle, each step motor receives at least a command to go to the share of Zero (rest).
This command is part of the normal programming for each Stich motor (GRAPHITRON).

When the motor receives the command to go to zero, X steps are not executed.
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.

a) In this case …   **The direction in leaving from the Zero position.**

If the first phase of the procedure is correct (so the Zero sensor is still open) it continues for the second.

The subsequently sequence of movement of the motor provides that "step by step" the motor run the last "X steps" missing to reach the Zero position. In practice runs a precision approach.
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.

b) In this case …   **The direction in approaching to the Zero position.**

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 Zero sensor.

To solve the problem … See the following page.

To solve the problem

The best solution is to run the zeroing (F0) to arrive at the End of Sock.
The machine can then return to its normal operation.

Turn off, and turn on, the machine keeps the machine in the same point (starts the black-out procedure).
The Reset (Ctrl+Del) brings the machine to End of Cycle, but could cause mechanical damage.
If the problem is not resolved it will recur in the same point of the subsequent sock.

- With the mechanical position of the motor correct.

Check that the sensor is functioning and properly positioned. **(*)**
If the sensor does not switches on/off (always open or closed), it means it is broken.
Proceed to its adjustment and eventually replace it.
Furthermore …
In reference to this, check the status of the LED of zero on the board on the motor indicated in the message.
Replace the CAN module associated with the motor indicated in the message.

- With the mechanical position of the motor not correct.

Check the wiring that connect the sensor and the motor to the command board.
Check if the motor movement has found mechanical obstacles or a very high resistance.
Replace the stepping motor indicated in the message.

Note
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.

"Mpp CAN" board: Pcb 4887 , LED light meaning

LED light	Motor	Led status with motor in zero position
Ds18	Motor 1	On
Ds14	Motor 2	On
Ds11	Motor 3	On
Ds12	Motor 4	On

The components shown are close to connector J17.

"Mpp CAN" board: Pcb 4899 , LED light meaning

See the image on the next page.

(*)   Remember that:
In order for the machine to run smoothly, it must be adjusted properly.
For more information, refer to the manual: **Mechanical Adjustments**
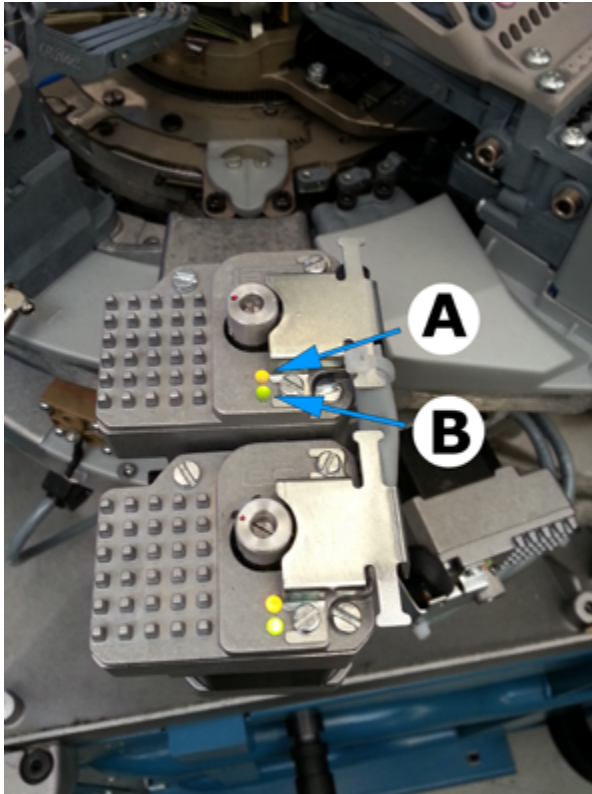
"Mpp CAN" board: Pcb 4899

LED light meaning

State	Function
LED light **A** ON - Orange	**Motor Zero**
LED light **B** Flashing - Green	**Communication OK**

In the example shown in the figure:
Sinkers cap ,
Sinker cap position .

Goal machines : Data stitch cam
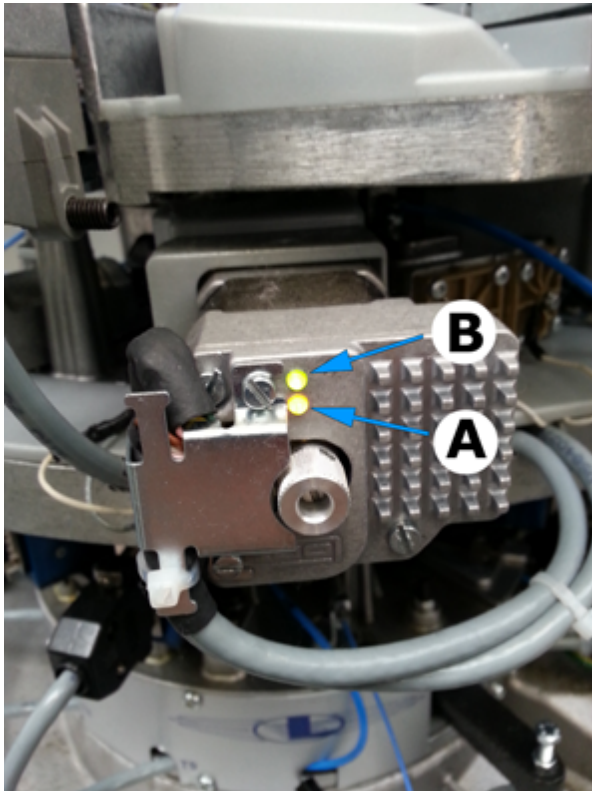
"Mpp CAN" board: Pcb 4899

LED light meaning
Data stitch cam

State	Function
LED light **A**	
ON - Orange	Motor Zero
Two-colour alternating light : Orange / Red	Software Upgrade
LED light **B**	
Flashing - Orange	**Out** (Solenoid valves de-energized)
Flashing - Green	**Intermediate position** (Stitch cam feed N, position A)
Flashing - Red	**In** (Stitch cam feed N, position B)

First consult the information contained at the start of the section.

In the message, the variable indicates … Watch beginning of section. (**Legend**) .

31.14: Lost steps: %ls (%d)	Error

Movement of zeroing of the motor. (**during work**)
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.

At present …
The message refers to the item: Vacuum valve
Check the correct position of the Vacuum Valve.

For the explanation/ solution, see what specified for the previous entry.

31.15: Overrun: %ls (%d)	Error

This message warns the user that there is transmission error on the CAN line between board Pcb 2010 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.
Also assess the frequency of occurrence of the error and if it determines malfunctions of the concerned motor or of other CAN devices.

31.16: Checksum in update: %ls (%d)	Error

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 associated with the motor indicated in the message.

31.17: Page updating length: %ls (%d)	Error

See the description provided for the message: 31.16

31.18: FLASH writing in update: %ls (%d)	Error

See the description provided for the message: 31.16

31.19: Number of page in updating: %ls (%d)	Error

See the description provided for the message: 31.16

First consult the information contained at the start of the section.

In the message, the variable indicates … Watch beginning of section. (**Legend**) .

31.20: Motor ENCODER tolerance: %ls (%d). Theoretical/actual values: Step %d-%d - Encoder %d-%d
Error - Movement impossible

Encoder offset

The software verifies the movement of the device through an Encoder. The encoder sends a signal depending on the phase (angle) of the driveshaft
The encoder detects whether the motor has reached the steps provided.
If the motor position differs from the software instruction, an error is displayed.

The message contains 6 variables. In the message, the variable indicates:

variable 1 = Watch beginning of section.
variable 2 = Watch beginning of section.
variable 3 = This variable indicates:
Planned value, i.e. the value to be reached by the motor.
The value is expressed as motor steps.
variable 4 = This variable indicates:
Measured value. Real share reached by the motor.
To this end, please refer to: variable 6 .
The value is expressed as motor steps.

variable 5 = This variable indicates:
Planned value, i.e. the value to be reached by the motor.
The parameter is expressed as encoder divisions (or encoder value).
variable 6 = This variable indicates:
Current value actually measured.
The parameter is expressed as encoder divisions (or encoder value).

Check that the movement of the device is not slowed down or blocked by mechanical obstacoles.
Check the mechanical functionality of the components linked to the motor movement.
Or …
Check the wiring that connect that connect the various boards. Eventually replace the cables and/or the boards concerned.
Replace the stepping motor indicated in the message.
Replace the CAN module (command board) associated with the motor indicated in the message.
Replace the device: Encoder .

31.21: Supply tension too low: %ls (%d)
Error

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.

Proceed as follows to solve the problem:
If the problem persists, please contact the Technical Customer Service.
● Check the power supply (voltage) of the CAN board relative the motor indicated in the message. Replace the board(s) if necessary.
● Check that the output voltage of supply board is +24 VDC.   and/ or
● Check that the output voltage of supply board is +40 VDC.
● Check the wiring that connect that connect the various boards.
● Check that the connections are correct.

First consult the information contained at the start of the section.

In the message, the variable indicates … Watch beginning of section. (**Legend**) .

31.22:   **Zeroing impossible: %ls (%d)**   Error

This error appears if the software detects anomalies in the behaviour of stepping motors in two specific conditions: during the procedure of Zeroing (F0/ Fn+F0), and in phase of Working Enter.
Under these circumstances, the motor is first properly reset and then a check is made to verify the correct Zero position via a sensor (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.
The zero position is found when the sensor is obscured (or pressed): the motor stops.
If during this step, the sensor is already in reading mode (motor set to zero), it first moves away by a certain number of "steps" and then it performs the precision approach.

Proceed as follows to solve the problem:
See the description provided for the message: **31.13**

31.23:   **Bobbin end: %ls (%d)**   Error

This error is related to the Pyf Plus 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 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 controlled input that generates the message is integrated on the board (motor board).]

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

Please refer also to paragraph: **In the event of a false error …**   (Enclosure)

31.24:   **Broken Yarn: %ls (%d)**   Error

This error is related to the Pyf Plus indicated in the message.

The device is equipped with a Spyder ("yarn sliding" sensor).
This error alerts the user that the yarn matched to the sensor is broken.
[The controlled input that generates the message is integrated on the board (motor board).]

Each sensor can be Enabled or Disabled.
Each sensor may be associated with a specific "Level".
Keep the device up to date.

Reference

Concerning this see the menu: **Setup elastic motors**

In particular: **Type of motors mounted**

See also the menu: **Yarn sensor Pyf Plus**

Software Upgrade

Concerning this see the menu: **Pyf Plus Spyder update**

Parameters of sensors

The sensors reading is mainly determined by a series of parameter.

These parameters determine sensibility and characteristics of the signal detected by the sensor.

Some values of these parameters have been grouped into fixed combinations ("set").

A fixed set of parameter values is identified as a "Level".

The software provides 10 Levels.

Lower is the the value more sensitive is the device.

The default value is: 5 .

Concerning this see the menu: **Parameters of sensors**

The table shows the values when it is drawn up.

Lonati reserves the right to change data without notice.

L	A	B	C	D
1	7	100	3	30
2	6	100	3	30
3	5	70	3	30
4	3	70	3	30
5	0	45	3	30
6	0	30	2	30
7	0	20	1	30

Legend

L = Level

A = Attenuation

B = Sensibility

C = Frequency for start

D = Frequency for stop

Note

This information only applies to the following models:

a) GOAL machines (single-cylinder models, for men's socks) ,

b) DONNA machines (single-cylinder models, for pantyhose) .

The devices used in this context do not require the following procedures:

● Identification of sensors ,

● Yarn sliding acquisition.

First consult the information contained at the start of the section.

In the message, the variable indicates … Watch beginning of section. (**Legend**) .

31.25:	Movement impossible: %ls (%d)	Error

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. Therefore: The message appears in the following circumstances:
- The motor does not receive the command (the board not controls the motor). Or …
- The sensor did not detect the change of status.

Proceed as follows to solve the problem:
See the description provided for the message: **31.13**

31.26:	Pulls piece %ls (%d)	Error

Do not currently managed.

31.27:	Sewing device needle and ratch.wheel pin not synchronized: %ls (%d) Press Fn + F0	Error

Pin holding unit

Rotation of the unit is driven by a motor.
This motor is called: Pin feeder
In this context, the term "rotation" means "revolution", i.e. rotation around a vertical axis.

Stage: toe seaming

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.

The user must continue to Reset the Seaming Robot.
Press the button: 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.
- Check and if necessary replace all the hardware components linked to the Encoder counter.
- When replacing the motor, the control encoder is replaced automatically as well.

31.28:	No answer from 3ENC board: %ls (%d)	Alarm

The message is specific for the following models: Models equipped with PCB 2009 .
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.
This board is a module used to handle the signals of three encoders and integrate them in the CAN line.

First consult the information contained at the start of the section.

In the message, the variable indicates … Watch beginning of section. (**Legend**) .

The board requires its own software. (**Glossary**).
Check the compatibility with the machine software.
The specific component software is an ".up" file.
The file name is: 3ENCxxxx.up.
xxxx represents the version identification number.

Concerning this see the menu: **Menu versions**
In particular: **Expansion versions of 3ENC**

Stitch-by-stitch models

The encoder sends a signal depending on the phase (angle) of the driveshaft
The motors interested in this are:

- Vertical pickup arm
- Angle pickup arm
- Lower turning device

The board is reported as absent when all the CAN motors requesting it have been disabled by the user.
All the CAN motors of the Seaming Robot are disabled by deactivating the following Setup item:

Sock extraction and seaming

Check that the specified Setup item has been enabled.

Reference

See the description provided for the message: **23.35**

31.29:	Acceleration limit: %ls (%d)	Warning

Message no longer menaged.

31.30:	Lost communication between 3ENC board and CAN module: %ls (%d)	Alarm

The message is specific for the following models: Models equipped with PCB 2009 .
First …
See the description provided for the message: **31.28**

Replace the board concerned.
and/ or
Replace the CAN module (command board) associated with the motor indicated in the message.

31.31:	FOURSTEP board type unknown: %ls (%d)	Alarm

The message appears in the following circumstances:

- When the machine is switched on.
- During work.

In the first case …
Replace the board concerned.

In the second case …
Turn the machine off and on again.

First consult the information contained at the start of the section.

In the message, the variable indicates … Watch beginning of section. (**Legend**) .

31.32:	Software start occured after board %ls (%d) reset	Alarm

The card appears to have been reset.
Failure can be caused by:
- Temporary discontinuation of the power supply.
- Manual card resetting.

See the description provided for the message:　　**14.75**

31.33:	MPP board %ls (%d) software malfunction	Alarm

Turn the machine off and on again.
If the problem is not resolved …
Replace the CAN module (command board) associated with the motor indicated in the message.

31.34:	Value out of limits: %ls (%d)	Error

The machine does not accept this operation.
See the description provided for the message:　　**2.8**

31.35:	Parameters transmission to MPP out of range: %ls (%d)	Initial error

The machine does not accept this operation.
See the description provided for the message:　　**6.7**
Internal software failure . Contact the Technical Customer Service.

31.36:	CAN command syntax error: %ls (%d)	Error

Internal software failure . Contact the Technical Customer Service.

31.37:	CAN family not yet assigned: %ls (%d)	Error **-** Movement impossible

The software did not recognize the type of card: the device cannot be managed.
Internal software failure . Contact the Technical Customer Service.

31.38:	Excessive temperature: %ls (%d)	Error **-** Movement impossible

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.

Proceed as follows to solve the problem:
- Wait for the card to cool down.
- Check the power supply (voltage) of the CAN board relative the motor indicated in the message.
- Replace the CAN module. (The sensor is integrated into the card.)
- Replace the motor.

First consult the information contained at the start of the section.

In the message, the variable indicates … Watch beginning of section. (**Legend**) .

31.39:	**Remote Step board %ls (%d) hardware error**	Error **-** Movement impossible

Replace the CAN module associated with the motor indicated in the message.

31.40:	**Motor non connected to Remote step: %ls (%d)**	Error **-** Movement impossible

(" Remote step " = CAN board)
Check the wiring that connect the motor to the command board.
Replace the motor.
Replace the CAN module associated with the motor indicated in the message.

31.41:	**Overflow buffer message CAN (software): %ls (%d)**	Error **-** Movement impossible

Internal software failure . Contact the Technical Customer Service.
The message appears in the following circumstances:
Has been found a misalignment of the data in communication protocol.

31.42:	**Overflow buffer message CAN (component): %ls (%d)**	Alarm

For the explanation/ solution, see what specified for the previous entry.

31.43:	**Offset ADC: %ls (%d)**	Error

Internal software failure . Contact the Technical Customer Service.
Motor not engaged.

31.44:	**Excessive Temperature (component): %ls (%d)**	Alarm

Proceed as follows to solve the problem:
See the description provided for the message: **31.38**
In this case …
The sensor has detected an excessive temperature. The device has been disabled.
The user must turn off the machine. Wait for the card to cool down.

31.45:	**Movement interrupted: %ls (%d)**	Error **-** Movement impossible

For many reasons the motor did not complete the movement.
Press the button: [F8] .
Try to restore the correct position using the control specified.

31.46:	**Non-executable command by the family: %ls (%d)**	Alarm

Internal software failure . Contact the Technical Customer Service.

31.47:	**Configuration wrong %ls (%d)**	Alarm

Internal software failure . Contact the Technical Customer Service.

First consult the information contained at the start of the section.

In the message, the variable indicates … Watch beginning of section. (**Legend**) .

31.48:   **Zeroing at end of stroke impossible: %ls (%d)**   Error - Movement impossible

What has been said for the zero (start of stroke) also applies for the end-of-stroke point.

Proceed as follows to solve the problem:
See the description provided for the message: **31.22**

During reading, replace the original text with that shown in the table.

original text	replacement text
Motor Zero	Course end
Motor zero proximity	Proximity Course end

31.49:   **Approach to 0 impossible (end of stroke): %ls (%d)**   Error - Movement impossible

For the explanation/ solution, see what specified for the previous entry.

31.50:   **Configuration incomplete: %ls (%d)**   Alarm

Internal software failure . Contact the Technical Customer Service.

31.51:   **Channel configuration impossible: %ls (%d)**   Alarm

Internal software failure . Contact the Technical Customer Service.

31.52:   **Configuration command impossible. Motor %ls (%d) already paired**   Alarm

Internal software failure . Contact the Technical Customer Service.

31.53:   **Configuration impossible: %ls (%d)**   Alarm

Internal software failure . Contact the Technical Customer Service.

31.54:   **Motor energy I2T: %ls (%d)**   Error - Movement impossible

Proceed as follows to solve the problem:
See the description provided for the message: **31.1**
Eventually … Replace the motor.

31.55:   **Approach to 0 impossible: %ls (%d). Proximity switch already covered.**   Error

Proceed as follows to solve the problem:
See the description provided for the message: **31.13**
In particular … Please refer to point: a)

First consult the information contained at the start of the section.

In the message, the variable indicates … Watch beginning of section. (**Legend**) .

| **31.56:** | **Approach to end of stroke impossible: %ls (%d). Proximity switch already covered.** | Error |
| | **-** Movement impossible | |

For the explanation/ solution, see what specified for the previous entry.
See also: **31.48**

| **31.57:** | **Approach to 0 impossible: %ls (%d). Proximity switch not found.** | Error |

Proceed as follows to solve the problem:
See the description provided for the message: **31.13**
In particular … Please refer to point: b)

| **31.58:** | **Approach to end of stroke impossible: %ls (%d).Proximity switch not found.** Error **-** Movement |
| | impossible |

For the explanation/ solution, see what specified for the previous entry.
See also: **31.48**

| **31.59:** | **Spyder sensor mounted on Pyf Plus : %ls (%d) has not the correct software version.** | |
| | **Manual updating required** | Initial error |

Concerning this see the menu: **Pyf Plus Spyder update**
From the Error window you can also quickly access this menu.
To start executing the command, press: OK .
After which …
Operator intervention is not necessary.
The machine carries out the procedure autonomously.
Await the outcome of the operation.
See the next message.

| **31.60:** | **Spyder updating of Pyf Plus completed: %ls (%d)** | Initial error |

The message confirms that:
The operation was performed successfully.

First consult the information contained at the start of the section.

In the message, the variable indicates … Watch beginning of section. (**Legend**) .

31.61:	Spyder updating of Pyf Plus completed: %ls (%d). Turn off the machine.	Alarm

At first, view the contents of the previous message.
The message is specific for the following models:
Models equipped with: Pcb 5786/A .
The models quoted require:
Turn the machine off and on again.

31.62:	Spyder updating of Pyf Plus in progress: %ls (%d)	Warning

This message alerts the user that an upgrading of the specified board(s) is in progress.
Await the outcome of the operation.

31.63:	Output %ls not in manual mode (%d)	Error

Do not currently managed.

31.64:	Output command buffer %ls busy (%d)	Error

Do not currently managed.

32. CAN messages on the YOYO device

The message contains two variables.

%ls = This variable indicates: Number of the YOYO motor.

(%d) = This variable expresses the error via the code for internal use.

YOYO switches on/off via the ENABLE button.
The status is indicated by the on/off light.
The disabled device is not handled even when it is connected.

The device requires its own software. (**Glossary**).
Check the compatibility with the machine software.

32.0: Tx impossible: %ls (%d)   Error

Tx = Transmission
Interference on the transmission.
This message warns the user that there is transmission error on the CAN line between board Pcb 2010 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.

Also assess the frequency of occurrence of the error and if it determines malfunctions of the concerned motor or of other CAN devices.

Proceed as follows to solve the problem:
- Check the wiring that connect that connect the various boards.
- Replace the CAN module (YOYO motor indicated in the message).
- Replace the board Pcb 2010.

32.1: RX impossible: %ls (%d)   Error

Rx = Reception
For the explanation/ solution, see what specified for the previous entry.

32.2: Bus off: %ls (%d)   Error

Internal software failure . Contact the Technical Customer Service.

32.3: Wake up: %ls (%d)   Error

Internal software failure . Contact the Technical Customer Service.

32.4: Bus error: %ls (%d)   Error

Internal software failure . Contact the Technical Customer Service.

32.5:   **Broken Yarn: %ls (%d)**   Error

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.

This "Yarn broken" control may be disabled through the GRAPHITRON programming.
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.

32.6:   **PWM: %ls (%d)**   Error

Internal software failure . Contact the Technical Customer Service.

32.7:   **Sensor of Hall: %ls (%d)**   Error

This message informs the user that at least a "Hall sensor", of the YOYO motor indicated, 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).

32.8:   **Reset: %ls (%d)**   Error

The device has turned off and then on autonomously.
The instruction memory of the device is reset.

- Replace the CAN module (YOYO motor indicated in the message).

32.9:   **Obstructed motion (overcurrent): %ls (%d)**   Error

This message indicates that the CAN module associated with the motor provides to the motor a current more high than allowed.
An excessive resistence to the rotation increases the current provided by the board, going over the limit imposed by the software.
Check the mechanical condition.

- Restore the correct transition of the yarn and eliminate the error.

Or …

- Replace the CAN module (YOYO motor indicated in the message).

32.10:	**FLASH writing in update: %ls (%d)**	Error

This error appears in the case in which the memory of the board is damaged.

- Replace the CAN module (YOYO motor indicated in the message).

32.11:	**Yarn type maintenance not expected: %ls (%d)**	Error

Alerts that article is not encoded for the software version installed in the machine. !da duplicazione!

Check the software version of the machine and upgrade it to the Graphitron version, or vice versa.

32.12:	**Weight value out of range: %ls (%d)**	Error

For the explanation/ solution, see what specified for the previous entry.

The message contains two variables.

%ls = This variable indicates: Name of the board   [Motor drive control].

(%d) = This variable expresses the error via the code for internal use.

The device requires its own software. (**Glossary**).

Check the compatibility with the machine software.

General Description

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).

More in particular:

A problem in the software writing, an hardware problem on the CAN boards, a disorder on the CAN transmission.

Remember that:

In order for the machine to run smoothly, it must be adjusted properly.

For more information, refer to the manual: **Mechanical Adjustments**

In particular: Synchronisation of the resolver with the motor

33.0:	Lack of 3.3V logic tension: %ls (%d)	Alarm

This message indicates that the Motor Drive board has detected a malfunction on the internal logic tension of the board.

- Replace the Motor Drive board.

33.1:	SHORT CIRCUIT %ls (%d)	Alarm

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.

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.

33.2:	Resolver Management %ls (%d)	Alarm

This message indicates that the Motor Drive board has noted a problem on Resolver phases entering the Motor Drive.

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 board Pcb 2010.
- Replace the resolver.

(*)   Contactor = if device present

33.3:	Starting software upon pressing the reset push button: %ls (%d)	Alarm

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.
Message no longer menaged.

33.4:	Maximum speed exceeded: %ls (%d)	Alarm

This message indicates that the Motor Drive board has found that the motor has turned to a highest speed of the maximum speed settable.
Proceed as follows to solve the problem:
First consult the information contained at the start of the section.
Or …
Internal software failure . Contact the Technical Customer Service.

33.5:	Opposite direction: %ls (%d)	Alarm

This message indicates that the Motor Drive board has detected that the motor has tried to move in the opposite direction to that expected.
In particular:
Rotation contrary to the one imposed. : **Tolerance**
- Handle (mechanical or electric 1/ 2) = 5 Machine needles
- Machine running   = 2 Machine needles
The data indicate the value over which the machine is stoped by the alarm.

Proceed as follows to solve the problem:
First consult the information contained at the start of the section.
Or …
Internal software failure . Contact the Technical Customer Service.

33.6:	Obstructed motion (I*T: %ls (%d))	Error - Movement impossible

This error informs the user something has obstructed the machine motion. (rotation of the cylinder)
[= The software has not seen the correct signals from the Resolver.]

Check if the motor movement has found mechanical obstacles or a very high resistance.
[frictions, assembling defective, mechanical damages]
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.
- Check the current absorption of the motor: if it is high, check the Resolver timing.
- 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.

Furthermore …

In the event of a false error …

By false error is meant a defect signal not generated by an actually dangerous situation but only electric disturbances and/or hardware defects.

In the event of a false error, refer to the following instructions.

a) The "speed" reference (signal) exits from the Pcb 2010 board and reaches the Motor drive board.

b) There is also a wiring for the CAN connection between the board Pcb 2010 and the Motor drive board.

c) The power phases (for the motor) exit from the Motor drive board, reach the Motor Contactor which is controlled by the Pcb 2010 board (Run management), pass for the interface D4840496 and finally reach the motor. **(*)**

Therefore:
● Check the wiring that connect that connect the various boards. (a) , (b) , (c) .
● Check the wiring between the Motor Resolver and the Motor Drive board.
● Replace the Motor Drive board.
● Replace the board Pcb 2010.
● Replace the device: Contactor. **(*)**
● Replace the motor.

(*)   Contactor = if device present

33.7:	**Motor driver tension: %ls (%d)**	Alarm

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 Motor Drive board.

If the voltage is correct:
● Replace the Motor Drive board.

If the voltage is incorrect:
● Check that the output voltage of the autotransformer is 220 Vac.
    (power autotransformer)
● Check that the output voltage of the "Faston" board is 220 Vac.
    ("power interface" board)
● Check the wiring that connect that connect the various boards.
● Eventually replace the cables and/or the boards concerned.

33.8:   Motor thermal relay: %ls (%d)   Alarm

Alerts that the thermal probe has measured a too high temperature. (OverTemperature motor   ) .
A device too hot is a symptom of an excessive friction or abnormal operation.

Check if the motor movement has found mechanical obstacles or a very high resistance.
[frictions, assembling defective, mechanical damages]
This condition may determine a high current absorption by the motor.

Only after excluding any mechanical problems proceed to the search for other causes.
- Check the wiring between the Pcb 2010 board and the Motor Drive board.
- Check the wiring between the Motor Resolver and the Motor Drive board.
- Check the current absorption of the motor: if it is high, check the Resolver timing.

Concerning this see the menu: **Motor setup menu**
The window cointains the field that shows the value in real time. [Motor driver active].
The field indicates: Current absorption . The value is expressed in mA.
Compare this data with that of another specimen of the same model.
The machine must be of the same model, and produce the same sock.
Perform the data comparison for the same sock zones.

- Replace the Motor Drive board.
- Replace the motor.

33.9:   Dissipator thermal relay: %ls (%d)   Alarm

This message indicates that the Motor Drive board has detected an error due to the Dissipator thermal relay place on the board.
A device too hot is a symptom of an excessive friction or abnormal operation.

For the explanation/ solution, see what specified for the previous entry.

33.10:	Motor energy I2T: %ls (%d)	Alarm

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.

For the explanation/ solution, see what specified for the previous entry.

33.11:	Tx impossible: %ls (%d)	Alarm

This message warns the user that there is transmission error on the CAN line between board Pcb 2010 and the Motor Drive board.
The problem may be caused by a transmission defect, and then by a malfunction of hardware concerned.
Also assess the frequency of occurrence of the error and if it determines malfunctions of the concerned motor or of other CAN devices.
- Check the wiring between the Pcb 2010 board and the Motor Drive board.
- Replace the Motor Drive board.
- Replace the board Pcb 2010.

33.12:	RX impossible: %ls (%d)	Alarm

For the explanation/ solution, see what specified for the previous entry.

33.13:	Commands overlap: %ls (%d)	Alarm

Internal software failure . Contact the Technical Customer Service.
This error happens when comes a command without the previous has been fully executed.
- Update the machine software .
- Perform the software update of the Motor Drive board.

The board requires its own software. (**Glossary**).
Check the compatibility with the machine software.
The specific component software is an ".up" file.
The file name is: FD_xxxx.up.
xxxx represents the version identification number.

- Replace the board Pcb 2010.
- Replace the Motor Drive board.

33.14:	FLASH writing in update: %ls (%d)	Alarm

Internal software failure . Contact the Technical Customer Service.
This error may occur during the software update.
Repeat the Update operation, loading again the file "up" (software) in the FLASH memory and activate it.
- Replace the board Pcb 2010.

33.15: **Set of parameters: %ls (%d)**	Alarm

Internal software failure . Contact the Technical Customer Service.

This message informs the user that when the machine is turned on is detected an incompatibility error in the parameters sent by the machine (Pcb 2010) to the Motor Drive board.

This coherence control is the first evaluation: check that the parameters sent are not clearly erroneous.

- Perform the software update of the Motor Drive board.

In this regard, see the description provided for the message: **33.13**

33.16: **Parameters RDC: %ls (%d)**	Alarm

For the explanation/ solution, see what specified for the previous entry.

33.17: **WATCH DOG motor driver: %ls (%d)**	Alarm

Internal software failure . Contact the Technical Customer Service.

This message warns the user that there is comunication error on the CAN line between board Pcb 2010 and 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:
See the description provided for the message: **33.11**

33.18: **Drive motor not configured: %ls (%d)**	Alarm

Internal software failure . Contact the Technical Customer Service.

This message informs the user that has been detected an error: the Motor Drive board has received an enabling command without having been preconfigured.

In practice does not have been sent to the Motor Drive board the operating parameters, which should happen when the machine is turned on.

Proceed as follows to solve the problem:
See the description provided for the message: **33.13**

33.19: **RUN DISABLED: %ls (%d)**	Information

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

33.20: **HANDLE 2 disabled : %ls (%d)**	Information

This message informs the user that the machine cannot be run by pressing this key: Handle-2 (Continuous) .
This movement is not possible as it is disabled from the active Software management at the time.

| 33.21: | HANDLE 1 degree-degree disabled: %ls (%d) | Information |

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.

| 33.22: | JOG disabled : %ls (%d) | Information |

Do not currently managed.

| 33.23: | Motor positioning: %ls (%d) | Error - Movement impossible |

There are stations that require certain mechanical settings to continue without errors.
This message is related to the control of the cylinder position.

This message appears if the expected position (Encoder quote) has not been reached within the time limit. Therefore:
This error informs the user something has obstructed the machine motion. (rotation of the cylinder)
[= The software has not seen the correct signals from the Resolver.]

Or …
The message appears if any cause moves the cylinder from the expected position position (out of tolerance).

If the position control occurs at the end of the cycle, causes due to the hardware malfunction can be excluded.
(For example: position for "Head Movement" and for "Sock Extraction".)
Delete the message by pressing [F8].

Other cases
Check that the movement of the mechanical part can be carried out without problems.
At this point erase the error with [F8] and start the machine.

Also assess the frequency of occurrence of the error.
If the problem persists, please contact the Technical Customer Service.

Mechanical problems

Loss of "steps" due to mechanical factors (Obstructed movement).
Proceed as follows to solve the problem:
See the description provided for the message: **33.6**

| 33.24: | Course not set in heel: %ls (%d) | Alarm |

The cause of this problem can be a wrong programming by Graphitron.
Check the programming.
Iin the sock program check the proper programming of the following functions:
- Heel entrance
- Toe Entry

Other causes

The problem may be caused by a transmission defect, and then by a malfunction of hardware concerned.
Proceed as follows to solve the problem:
See the description provided for the message: **33.2**

33.25:	**Reverse motion out of range: %ls (%d)**	Alarm

Internal software failure . Contact the Technical Customer Service.

During the alternate motion, the cylinder did not reverse the direction within a certain angle.

[ANGLE ≥ 30 ° : Value above the maximum threshold.]

The article will be considered a waste.

Proceed as follows to solve the problem:

See the description provided for the message: **33.6**

See also: **33.33**

33.26:	**WRONG RESOLVER TIMING: %ls (%d)… repeat procedure**	Error **-** Movement impossible

The message appears in the following circumstances:

Synchronisation of the resolver with the motor .

Concerning this see the menu: **Synchronisation of the resolver with the motor**

Repeat the operation. Namely …

Keep the [Handle−2] key pressed until the cylinder will move suddenly until it stops in a certain position.

When the button is released, the software checks that the phase point (maximum torque) has been rea-ched.

The message appears if any irregularities occur during the procedure.

The causes of the alert can be the following:

The rotation of the cylinder is hindered by mechanical loading, so the phasing current is not sufficient to bring the motor to the maximum torque point.

The solution is to free the cylinder, even partially, from the mechanical load and repeat the attempt.

In this regard, see the description provided for the message: **33.6**

Or …

Even a too-free cylinder can cause the problem because an oscillation is triggered around the phase point.

In this case is neccessary …

Release the [Handle 2] button only when the oscillation is finished.

33.27:	**Hardware enabling input: %ls (%d)**	Alarm

Internal software failure . Contact the Technical Customer Service.

To the motor drive a movement command is arrived, but not the hardware enabling (Enable).

See also: **33.11**

33.28:	**Hardware not compatible: %ls (%d)**	Alarm

Internal software failure . Contact the Technical Customer Service.

● Replace the Motor Drive board.

33.29:	**Zero masking proximity: %ls (%d)**	Error **-** Movement impossible

This information only applies to the following models:

DC88 machines (double-cylinder models, for men's socks) .

For more information, refer to the manual: **Mechanical Adjustments**

In particular: **Adjusting the mechanical zero control proximity switch**

See the following page.

The software checks the status of the sensor in certain phases of the sock cycle.
From the device, the signal reaches the board: Motor drive .

The message states that:
The sensor is always off. Or …
The sensor is in reading when it should be off.

Proceed as follows to solve the problem:
● Check the integrity and the correct adjustment of the sensor.
● Check the connecting cables between the sensor and the inputs board. [Motor drive   ].
● Replace the sensor.

33.30:   Cylinder moved while the machine was off. Blackout lost.: %ls (%d)   Alarm

The message appears in the following circumstances:
When the machine is switched on.
The message states that:
The cylinder is not in the position saved by the Blackout procedure.

The alarm obliges the to turn off the machine.
With an alarm active, switching off the machine does not launch the blackout procedure.
When the machine is turned on it reachs the End of Cycle step executing practically a Reset.

33.31:   WATCH DOG not received: %ls (%d)   Error **-** Movement impossible

Proceed as follows to solve the problem:
See the description provided for the message: **33.17**

33.32:   Zero resolver too close to masking proximity switch: %ls (%d) space them apart.   Error
- Movement impossible

This information only applies to the following models:
DC88 machines (double-cylinder models, for men's socks) .

For more information, refer to the manual: **Mechanical Adjustments**
In particular: **Adjusting the mechanical zero control proximity switch**

The message states that:
The Resolver zero is too close to the peak of the sensor signal.
● Move the proximity to the nearby position (already set up to solve this problem).
After the operation, it is necessary to perform a new acquisition of the mechanical Zero, even if the machine does not require it.
Concerning this see the menu: **Mechanical zero**

33.33:   Reverse motion out of range: %ls (%d)   Error - Movement impossible

During the alternate motion, the cylinder did not reverse the direction within a certain angle.
[15 ° < ANGLE < 30 ° (*)].
Within this range it is assumed that the sock cycle can still continue.
Visually check the position taken by the mechanical part concerned the movement.

If the sock can be recovered:
●   Press the key: [F8] .
●   Use the [Handle] keys to rotate the cylinder.
●   If everything is in order, you can restart the machine. Press the key: [RUN] .

If the sock cannot be recovered:
●   Press the key: [F8] .
●   Press the key: [F0] .

(*)   Tolerance = 15 ° : Production continues without any signal.

33.34:   Resolver zero too close to mechanical Zero : %ls (%d) perform new resolver timing   Error - Movement impossible

This information only applies to the following models:
DC88 machines (double-cylinder models, for men's socks) .

For more information, refer to the manual: **Mechanical Adjustments**

The message states that:
The mechanical Zero just acquired is too close to the peak of the Resolver signal.

In this case is neccessary …

(1)   ●   Repeat the procedure. [Synchronisation of the resolver with the motor].
Concerning this see the menu: **Synchronisation of the resolver with the motor**

(2)   ●   Now that the resolver is synchronised with the motor, the zero must sent to the machine, i.e. at what
point on the cylinder to start counting the degrees and needles.
Concerning this see the menu: **Mechanical zero acquisition**

(3)   Proceed as follows if the error persists:
Accidentally the reciprocal positions are identical to before.
●   Repeat from point … 1 .

34.   Saw - Goal machines

The cutter is a sharp disc that cuts off the yarns. (Saw + Knife) .
The device can be motorized.

Remember that:
The motors are controlled via the CAN Line.
For the device to work, you need to enter specific codes in the sock programme (Graphitron).

Reference

Refer to the menu: **Autotest various outputs**
In particular, refer to item: Saw blade release

See also the menu: **Autotest of inputs**
In particular, refer to item: Saw blade phase proximity
                                                                              Yarnfingers plate lock
                                                              Mechanical welt proximity switch

Furthermore …
Remember that:
In order for the machine to run smoothly, it must be adjusted properly.
For more information, refer to the manual: **Mechanical Adjustments**

In particular:
● Check the mechanical phase between the Dial and the Cylinder.
● Check the correct setting of the mechanical Zero.

Description

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 equipped with Motorized Saw instead the movement may also be determined by a stepping motor.

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. [Saw blade release]

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.

If you raise the Dial, 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 and putting in motion the machine, the Saw automatically is hooked without making any particular procedure (the Solenoid valve is immediately de-energized).

For the device to work, you need to enter specific codes in the sock programme (Graphitron).

It 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.

Dial position :

The motor position is controlled by an encoder.

Sensor   =   Yarnfingers plate lock

      This item is specific for the models equipped with: **Raising dial motor**
      See the description provided for the message: **36.**

               Otherwise:

Sensor   =   Mechanical welt proximity switch =
             Input for upper mechanical dial   .

Saw motion checking

The shaft rotation is verified through a proximity switch.

[Saw blade phase proximity = i. 94] *****

This shaft has a slot (hollow).

This shaft has a point of phase compared with mechanical Zero. (Check the correct setting of the mechanical Zero.) .

When the slot passes under the sensor, it is not reading.

To the achievement of two specific cylinder degrees the signal shall be respectively "open" and "closed".

With Saw hooked the Software must read in both the control points the correct status of the sensor.

With the saw released (stationary) the software should not read no change of the sensor status.

The check is disabled only in the phase of Hook or Release.

*****   **i.** :   input (input code for the software = software input)
Input :   To this end, see table:
             Matching software and hardware inputs (**Enclosure**)
[Saw + Dial = Dial unit]

Motorized Saw

The motorized Saw is used to adjust the length of cut yarns via the rotation speed.
The cut yarn length depends on the ratio between the cylinder and the cutter speeds.
The greater the cutter rotation compared to the cylinder the shorter the yarn is cut.

For the device to work, you need to enter specific codes in the sock programme (Graphitron).
It 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.
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.
In any case … In the programming software (Graphitron) there is a protection for which the start command of the Saw motor is not accepted if the Saw is mechanically hooked.

With motorized Saw, the machine can still be working as with the normal Saw: is sufficient not programming the start of the Saw motor.

34.0:	Saw setup correctly saved	Warning

Message no longer menaged. Update the machine software .

34.1:	Saw setup saving error	Warning

Message no longer menaged. Update the machine software .

34.2:	Saw A control failed	Error

With Saw hooked the Software must read in both the control points the correct status of the sensor.
Instead … The sensor is in reading when it should be off.

In case of error the first thing to check is the integrity of the phase sensor of the Saw.
Check that the sensor is functioning and properly positioned.
In the auto-test menu, check that the status of the input switches.
Use the [Handle] keys to rotate the cylinder.

Check the connection between the sensor and the board.
Eventually replace these components. and/ or Replace the cables.

Please refer also to paragraph: **In the event of a false error …**   (Enclosure)

34.3:	Saw B control failed	Error

With Saw hooked the Software must read in both the control points the correct status of the sensor.
Instead … The sensor is always off.
For the explanation/ solution, see what specified for the previous entry.

34.4:	Saw C control failed	Error

With Saw released by the cylinder rotation and Saw motor stopped the Saw must not move.
This message informs the user that the Saw is moving at a point at which the software expected it to be stopped.

Check the functionality of the command for the saw hook/ release.
In particular check the functioning of the solenoid valve and of the command board (bar), and the status of the pipe.

34.5:	Saw D control failed	Error

With Saw released from the cylinder rotation and Saw motor in rotation, the Saw should turn at the motor speed.
This message informs the user that the Saw is stopped at a point at which the software expected it in movement.
For the explanation/ solution, see what specified for the previous entry.

34.6:	The machine was moved at least 1 impulse with RAISED saw in dangerous zone (WELT ZONE)	Warning

Message no longer menaged. Update the machine software .

34.7:	Machine running disabled by saw device	Information

This message informs the user that the machine cannot be Run.
Movement is not allowed as the mechanical group (Dial) is not in the working position (it is not low).

Fully lower the mechanical group.
Operate the mechanical or electric handle (1 and 2) to rotate the cylinder a few turns.
At this point, the running is again enabled.

Therefore:
Use the crank to perform N turns to the cylinder. (N = 4)
Then will be possible press the [RUN] button.

34.8:	Machine running disabled by saw device: carry out 4 cylinder full turns by handle till the normal functioning is restored	Warning

This message is displayed when the software detects an attempt to start the machine.

First check the procedure adopted in the previous condition.
(For the explanation see what specified for the previous entry.)
The procedure was not completed. (N < 4)

34.9:	Dial manually raised	Warning

The message confirms that:
The mechanical group (Dial) is not in the working position (it is not low).
The message is specific for the following models:
Models without the following device: Raising dial motor .

Reference

Refer to the menu: **Autotest Cam**
In particular, refer to item: [17] Eliminate raising n. picker of heel return
                                           [18] Eliminate raising n. picker of feed 1
                                                                [19] Dropper right
                                                                 [20] Dropper left

See also the menu: **Autotest of inputs**
In particular, refer to item: Right dropper proximity
                                                            Left dropper proximity

See also:
42.   **Messages on Inputs - Goal machines**

Furthermore …
Remember that:
In order for the machine to run smoothly, it must be adjusted properly.
For more information, refer to the manual: **Mechanical Adjustments**

In particular:
► Pneumatic stitch-forming units - adjusting the needle-raising pickers
► Motorized stitch formation units - adjusting the needle raising pickers

Foreword

The zones of the sock in which the cylinder alternating motion is set are called "heel blocks".
To start the "heel" processing, part of the needles are raised (to exclude them).
Then the alternating motion begins.
The processing is divided into two phases.

● first part   : During the formation of the knit, 1 needle is removed from each rank.   [- 1]
   (Rank = inversion of the cylinder rotation) .
   The procedure continues up to the value set in the program.
   After which … Another operation is added to this one.

● second part   : 2 needles are added each rank. [+ 2]
   The result of the previous operation is as follows …
   - 1 + 2 = **+ 1**
   The procedure continues until it reaches the initial value (of needles).

In practice:

After that in the first part of the Heel the mechanical "Needle-raising Picker" have raised a certain number of needles, in the second part the "Needle-lowering Picker"(right and left) devices will lower the same needles.

Description

The position of the "Needle-lowering Picker" (high and low) is controlled by a Hall sensor mounted on a small board that is an integral part of the device itself.

The ON or OFF status of the Led place on this board visually indicates to the user the status of the input.

► The rest condition is:
  Picker in up position = Solenoid valve de-energized = LED Off .

No command is activated until the entry into the Heel and no control is active.

Heel : first part

At the entry into the Heel, and for all the first part of the Heel is active the command that lowers the Picker.
At the same time is activated the procedure for the control of the position.
Reached a certain degree, the software will run a control on the status of the input signal related the device.

► The correct condition is:
  Picker in down position = Solenoid valve energized = LED On .

To this end, please refer to:

Heel : second part

When starts the second part of the Heel, the Picker must lower 2 needles for each time.
The command is disabled and the Picker gets up awaiting to meet the needles that should be lowered, what will happen to a certain point during the Cylinder rotation.

Verification A

Reached a certain degree, the software will run a control on the status of the input signal related the device.

► The correct condition is:
  Picker in up position = Solenoid valve de-energized = LED Off .
  Otherwise a message is displayed. (anomaly)

Continuing with the cylinder rotation, the needles hit the Picker whose "blade" has a recess that may contain the 2 needles.
Normally in the Sock Program is set the function "Picker Stop".
With this programming, when the software receives the signal due to the impact of the needles against the Picker then the command to lower it is activated.
The picker hit by the needles is lowered bringing with itself the 2 needles in the hollow.
The device will retained low.

Verification B

Reached a certain degree, the software will run a control on the status of the input signal related the device.

► The correct condition is:
  Picker in down position = Solenoid valve energized = LED On .
  Otherwise a message is displayed. (anomaly)

In the following step the picker gets up again, ready to repeat the same operation with other 2 needles.
This will continue until have been lowered all the needles envisaged in the Sock Program (Heel economizers).

35.0:	**Plugins Picker : insufficient memory**	Alarm

Internal software failure . Contact the Technical Customer Service.

35.1:	**Left Dropper stuck**	Error

The message states that:
The Piker is stuck in low position and it was not raised.
To this end, please refer to: **Verification A**

35.2:	**Left Dropper: needle not lowered**	Error

The message states that:
The Piker has not reached the low position.
The impact of the needles has not been corrected and the Picker has not lowered until the intended quota.
To this end, please refer to: **Verification B**

35.3:	**Right Dropper stuck**	Error

See the description provided for the message: 35.1

35.4:	**Right Dropper: needle not lowered**	Error

See the description provided for the message: 35.2

To solve the problem

Solve the real problem that has caused the error.
In particular …
- Check the condition of movement and the functionality of the Picker.
- Replace the device.

If the control device has not intervened, proceed as follows.

In this case, refer to the section: **In the event of a false error …** (Enclosure)

Remember that:
In this case …
- The sensor is integrated into the card.

Goal machines

This information only applies to the following models:

GOAL machines (single-cylinder models, for men's socks) .

More in particular:

Models equipped with the following device: **Raising dial motor**

The motor position is controlled by an encoder.

[Saw   + Dial   = Dial unit   ]

Description

Raising dial motor : **The motor is also used for the Yarnfingers Plate movement.**

A coupling mechanism makes the movement of the two parts united.

(Dial unit   + Yarnfingers plate   ; Solenoid valve : Yarnfingers plate lock) .

A sensor verifies the status of the mechanism.

[Input   : **Stop Yarnfingers plate lock** = i. 38   ] *

If the situation is correct, movement is allowed.

The normal working condition (sock construction) for the device (yarn fingers plate) is the one at the lower end of run.

The position is controlled by the software via the value read by a sensor.

[Input   : **Stop yarnfingers plate position** = i. 27   ] *

If the situation is correct, movement is allowed.

A pneumatic piston however helps the motor in its further task.

This functionality is also useful in case of maintenance of the parties related to cylinder.

Through appropriate commands is possible raise and lower the unit.

The unit must be able to be raised in order to allow the sock transfer device (*) to carry out its task.

[*   = Seaming Robot]

The situation is critical each time dial jacks project during operation.

Therefore: Work is discontinued when the Weld unit is raised and the dial jacks are out.

(*)   **i.** :   input (input code for the software = software input)

        Input :   To this end, see table:

                Matching software and hardware inputs (**Enclosure**)

Dial position :

The motor position is controlled by an encoder.

Zero sensor =   Motor zero sensor = input integrated on the motor board
                             When the Dial is low the control sensor is in a reading status.

End of stroke sensor =   Not present =.
                             The encoder detects whether the motor has reached the steps provided.
                             [end of stroke value].

Yarnfingers plate position :

The position is controlled by the software via the value read by two sensors.

Concerning this see the menu: **Autotest of inputs**
In particular, refer to item: Yarnfingers plate position
                                                          Yarnfingers plate lock

Reference

Refer to the menu: **Rest enabling setup**
See also the menu: **Motorized welt raiser setup**
See also: **Welt raier and dial manuals**
See also: **Manual commands in hazardous areas**

Furthermore …
Remember that:
In order for the machine to run smoothly, it must be adjusted properly.

Concerning this see the menu: **Raising dial motor**
[… / Autotest menu / Stepping Motors / »]

For more information, refer to the manual: **Mechanical Adjustments**

In particular:
● Check the mechanical phase between the Dial and the Cylinder.
● Check the correct setting of the mechanical Zero.

<u>Note</u>

Remember that:
If an item has grey only the button, it means that it cannot be activated or it is inaccessible , in that mo-
ment.

36.0: Reset Dial manually
<div align="right">Error - Movement impossible</div>

This message informs the user that the machine cannot be Run.
When switched on, the machine checks the zero position of the mechanical unit.
The zero sensor is not in reading. (input integrated on the motor board)
Press the button: **Lower dial manual** .
Touching the icon, the mechanical unit moves downwards.

Or …
The message appears in the following circumstances:
The message may be displayed following Reset the Seaming Robot.

36.1: Dial head not in correct position
<div align="right">Error - Movement impossible</div>

This message informs the user that the machine cannot be Run.
The device has not reached the end position.
The sensor is not in reading.

Delete the message by pressing [F8].
Go back to the menu and try again.
Press the button: **Dial raising manual** (Hold down the button.)

36.2: Manual dial raising disabled
<div align="right">Information</div>

Informs that the operation cannot be performed under the current circumstances.
The button is temporarily disabled.

The message appears in the following circumstances:
The motor is executing the commands set by the software to check the correct positioning.
Therefore: The device is engaged.

Or …
Informs that a procedure/operation is in progress and the machine is processing data.
Wait until the end of the operation.

36.3: Saving setup welt-raise correct
<div align="right">Warning</div>

Data has been acquired (stored) successfully.

36.4: Error saving setup welt-raise
<div align="right">Warning</div>

Informs that saving has failed. Go back to the menu and try again.
Or … Reboot the machine and repeat the operation.
If the problem persists, please contact the Technical Customer Service.

36.5: Dial movement not allowed in this block
<div align="right">Information</div>

Informs that the operation cannot be performed under the current circumstances.
This is for safety reasons.
You need to wait a few seconds.

36.6:   Manual yarnfingers plate raising not completed   Error - Movement impossible

This message informs the user that the machine cannot be Run.
The device has not reached the end position.
The sensor is not in reading.

Delete the message by pressing [F8].
Go back to the menu and try again.
Press the button: **Plate raising manual** (Hold down the button.)

36.7:   Yarnfingers plate lock failed (prox. plate lock)   Error - Movement impossible

The control sensor does not give the software the right signal.
In case of error first check if has been intervened the control device (real error).
Therefore: Solve the real problem that has caused the error. Namely …
- Check that the movement of the device is not slowed down or blocked by mechanical obstacoles.
- Check that the compressed air ducts are not clogged.
- Check that the pneumatic part of the Solenoid valves is no clogged, or mechanically damaged.
- Check the operation of the solenoid valve/s related to the command.

If the control device has not intervened, proceed as follows.

In this case, refer to the section: **In the event of a false error …**   (Enclosure)

36.8:   Yarnfingers plate release failed (prox. plate lock)   Error - Movement impossible

The control sensor does not give the software the right signal.
For the explanation/ solution, see what specified for the previous entry.

36.9:   Yarnfingers plate down position not detected (prox. plate position)   Error - Movement impossible

The control sensor does not give the software the right signal.
Perhaps the group/device fails to reach the end of the excursion.
If necessary, clean the relevant components from the yarn residues.
For the explanation/ solution, see what specified for the previous entry.

36.10:   Yarnfingers plate detachment not detected (prox. plate position)   Error - Movement impossible

The control sensor does not give the software the right signal.
For the explanation/ solution, see what specified for the previous entry.

| 36.11: | **Yarnfingers plate movement not allowed in this block** | Information |

Informs that the operation cannot be performed under the current circumstances.

This is for safety reasons.

You need to wait a few seconds.

| 36.12: | **Yarnfingers plate movement not allowed till end of cycle** | Information |

The zones of the sock in which the cylinder alternating motion is set are called "heel blocks".

In the aforementioned areas if the device is raised then it will no longer be possible to lower it.

Wait for the sock to end. Or …

Run the zeroing (F0).

In any case … The article will be considered a waste.

| 36.13: | **Start disabled for manual dial raise not completed** | Information |

Informs that the operation cannot be performed under the current circumstances.

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 device has not reached the end position.

See the description provided for the message: **36.1**

| 36.14: | **Start disabled for manual raises flat yarnfinger not completed** | Information |

Informs that the operation cannot be performed under the current circumstances.

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 device has not reached the end position.

See the description provided for the message: **36.6**

| 36.15: | **Initialization thread flat low not performed (engine edge not to a zero)** | Information |

Internal software failure . Contact the Technical Customer Service.

36.16:	Yarnfingers plate or dial raising manual command interrupted by barrier obstruction - Movement impossible	Error

See the description provided for the message: **36.1**
Furthers informations are available in the item: **48.56**

36.17:	Run disabled due to knife 1 manual cycle not completed	Information

Refer to the menu: **Manual EV**
In particular, refer to item: Knife 1 raising command

This message informs the user that the machine cannot be Run.
The message states that:
The device has not reached the rest position.

Delete the message by pressing [F8].
Go back to the menu.
Press button [Ctrl+n] again. (n = 1) .

See also the menu: **Autotest of inputs**
In particular, refer to item: Stop clean knife 1

36.18:	Run disabled due to knife 2 manual cycle not completed	Information

For the explanation/ solution, see what specified for the previous entry.
(Obviously … n = 2) .

36.19:	Yarnfingers plate down position not detected (prox. plate position)	Alarm

The control sensor does not give the software the right signal.
The message appears in the following circumstances:
● Manual intervention (pressing of the dedicated command). [Dial raising manual].

Turn the machine off and on again.
Run the zeroing (F0).

Furthers informations are available in the item: **36.9**

36.20:	Yarnfinger plate not detected down on step one	Error - Movement impossible

The control sensor does not give the software the right signal.
The message appears in the following circumstances:
● cycle start
The device has not reached the rest position.
This error informs the user that the signal was not detected by the software within the expected time.
[step 1 - step 0 = time interval].
For the explanation/ solution, see what specified for the previous entry.

37.   Lubrication unit management

Refer to the menu: **Lubrication unit**

The machine can be equipped with the following devices:

- Pump with external pressure switch   [Standard]
- Pump with sensor   [Oil delivery control]
- Mechanical oiler [1] [2]

Refer to the documentation provided for ordering spare parts.

Outputs / Inputs

Stop oil filter clogs [1]	Sensor input:	Inp.sw 38
Stop oil absence	Sensor input:	Inp.sw 39
Stop oil pressure	Sensor input:	Inp.sw 40

Function 3 oil pump (Oiler)   Command output: …
The position of the solenoid valve depends on the model.

Sensor input:
To this end, see table: **Matching software and hardware inputs** (**Enclosure**)

See also the menu: Autotest menu

[1]   This information only applies to the following models:
                  DONNA machines (single-cylinder models, for pantyhose) .

[2]   In this case …
                  See the description provided for the message: **16.**

37.0:   Oil missing   Error - Movement impossible

This error is caused by the lowering of the tank oil level. Check the oil level and eventually restore it.
With stop activated, the inputs Autotest shows the following value: **Green Led** .

The fault can also be due to wrong selection of the device in the dedicated window.
Make sure the actual equipment was set in the menu.

37.1:   Oil pressure   Error - Movement impossible

The message refers to device a).
After activating the solenoid valve (pumping), the sensor did not detect any changes within the set time.
In practice: This error informs the user that the signal of "oil pumped active" was not detected by the software within the expected time.

37.2:   **Oil pressure still present**   Error - Movement impossible

The message refers to device a).

The sensor did not detect the change of status after the solenoid valve was de-energized.

In practice: The lubrication circuit is still pressurized. Check if the tube is obstructed.

37.3:   **Lack of pressure in oil pump (Oli depressurisation)**   Error - Movement impossible

The message refers to device a).

After activating the solenoid valve, the sensor detected the change, but for a shorter than expected time.

In practice: 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.

Check if there are losses in the oil circuit that does a decrease of pressure.

37.4:   **Oil pressure control wrong delivery**   Error - Movement impossible

The message refers to device b).

The signal indicates that the lubricating oil did not flow at least in one circuit.

Check if there are losses in the oil circuit that does a decrease of pressure.

Check if the tube is obstructed.

Check that the external compressed air ducts (tubes) are not blocked and/or clogged.

37.5:   **Saving setup lubrication unit correctly**   Warning

Data has been acquired (stored) successfully.

37.6:   **Wrong saving setup lubrication unit**   Error - Movement impossible

Informs that saving has failed. Go back to the menu and try again.

Or … Reboot the machine and repeat the operation.

If the problem persists, please contact the Technical Customer Service.

Goal machines

This information only applies to the following models:
GOAL machines (single-cylinder models, for men's socks) .

Description

On entering this window you access a "Testing program". (Programme that tests the operation of the device.)
The chain is specific for current calibration.
Each stitch cam has 3 work quotas (Set-point) for the knitting fabric.
The adjustment must be made for each height.
With a special instrument measure the how much yarn is absorbed on each "Yarn Feed".
When the quantities of yarn absorbed by each "Yarn Feed" are equal, calibration for this quota (Set-point) is completed.
The adjustment must be made for each device.

Reference

Refer to the menu: **Stitch-cams calibration**

See also the menu: **Autotest Stitch cam**

See also: **Modify stitch cam position**

38.0:	**Cams calibration missing**	Error

Refer to the menu: **Position calibration**

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.

(*)

● Perform the procedure in the appropriate menu.
Indeed … In the meantime will be used the standard values (default) available in the software (eprom custom).

Or …
● Delete the message by pressing [F8].
The message remain disabled until a following machine turning off.

Or …
● Load the specific *.xml file of this part of the Setup.

(*) In this case …
Save the Setup part you are interested in on the USB stick.
Namely … Keep the archive of the Setup files updated.

In order to deepen the concept see: **Machine setup / Setup files** (Enclosure)

38.1:	**Saving stitch-cam calibration in progress. Please wait…**	Warning

This message informs the user that Setup data is being saved.
Await the outcome of the operation. You need to wait a few seconds.

38.2:	**Stitch-cam autocalibration correctly saved**	Warning

The operation was performed successfully.
Data has been acquired (stored) successfully.
In order to deepen the concept see: **Machine setup / Setup files** (Enclosure)

38.3:	**Autocalibration not correctly saved for the motor %ls**	Error

Message no longer menaged. Update the machine software .

38.4:	**Stitch-cam autocalibration not correctly saved**	Error

Informs that saving has failed. Go back to the menu and try again.
Or … Reboot the machine and repeat the operation.
If the problem persists, please contact the Technical Customer Service.

38.5:   Cams calibration empty!   Warning

The operation was performed successfully.
The message confirms that: The Reset operation is completed properly.
The result of this operation is the restoration of the default, as defined in the Eprom.

In this regard, see the description provided for the message: **38.0**

38.6:   Incorrect cancellation of stitch cam calibration   Error

Informs of the presence of saving problems or wrong data.
Go back to the menu and try again. Or … Reboot the machine and repeat the operation. If the problem persists, please contact the Technical Customer Service.

38.7:   Configuration for stitch cam calibration cancelled!   Warning

The operation was performed successfully.
The message confirms that: The Reset operation is completed properly.
The result of this operation is the restoration of the default, as defined in the Eprom.

38.8:   Incorrect cancellation of stitch cam configuration   Error

Informs of the presence of saving problems or wrong data.
Go back to the menu and try again. Or … Reboot the machine and repeat the operation. If the problem persists, please contact the Technical Customer Service.

38.9:   Operation not allowed stitch-cam autocalibration in progress   Information

Informs that the operation cannot be performed under the current circumstances.
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.

Signal input

The sensor is a switch that is opened (or closed) by a physical parameter.
[For further information see also: Wikipedia.org].
The sensor provides the software a signal. [Input   ].
Namely … The sensors transmit electrical signals to the processor to stop the machine in case of failure.
[Therefore: The input (and/or sensor) is also called "stop".]
In practice: Input sensors detect that the operation progresses correctly and safely for the operator.

If a signal does not comply with the safety conditions, a specific error will appear.
Concerning this see the menu: **Autotest of inputs**

By false error is meant a defect signal not generated by an actually dangerous situation but only electric disturbances and/or hardware defects.

Position of machine inputs

The section indicates the position of the inputs.
Furthermore …
There is indicated the signal value with sensor NOT in reading.
Remember that:

Green Led = The sensor is "Normally Open" type.
When the sensor is reading, the input Autotest LED colour is … **Red** .

Red Led = The sensor is "Normally Closed" type.
When the sensor is reading, the input Autotest LED colour is … **Green** .

Concerning this see the menu: **Autotest of inputs**

Command output

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 a sensor detects a movement, it is automatically associated with that output.
For the most important movements, the actuator is controlled by one/ two sensors.
A sensor detects the final position and another one the initial position.

Concerning this see the menu: **Autotest menu**

In particular: **Manual commands menu**
In particular: **Autotest various outputs**
In particular: **Step motors menu**

See also the menu: **Manual EV**

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. (I/O = Input / Output)
The board signals are coded and sent through a closed-loop circuit. The boards are placed in series along this loop.
The serial line circuit originates from the board Pcb 2010.
From here the serial line then reaches all the various Input and Output boards (located outside the electrical panel).
Main inputs board is the Pcb 4866.

To solve the problem

Solve the real problem that has caused the error.
In particular … See the pages that follow.
If the control device has not intervened, proceed as follows.

In this case, refer to the section: **In the event of a false error …**   (Enclosure)

Table : Messages and software inputs correspondence

For all models

Message		**Input**
39.0	Lack of power 36 VDC	Pcb 2010, J36, p01
39.1	Lack of power phase	Pcb 2010, J36, p02
39.2	Caution: cylinder carter open	Pcb 2010, J41
39.3	Lack of power 15 VDC positive	Pcb 2010, Internal
39.4	Lack of power 15 VDC negative	Pcb 2010, Internal
39.5	Battery B1 and B2 out of order	Pcb 2010
39.6	Lack of power 24 VDC serial line	i. 12
39.7	Lack of power 24 VDC yarnfingers unit	i. 11
39.8	Lack of power 24 VDC solenoid-valves unit	i. 10
39.9	Lack of power 24 VDC external expansion board	i. 9
39.10	Sock ejection	i. 36
39.11	Lack of air pressure	i. 35
39.12	Crank	**LA ≠ LB** (1)
39.13	Oil filter clogged	i. 38
39.14	Position clearing cam feed 4	i. 81
39.15	Position clearing cam feed 3	i. 82
39.16	Position clearing cam feed 2	i. 83
39.17	Position clearing cam feed 1	i. 84
39.18	Position tucking cam feed 4	i. 85
39.19	Position tucking cam feed 3	i. 86
39.20	Position tucking cam feed 2	i. 87
39.21	Position tucking cam feed 1	i. 88
39.22	Elastic 1	i. 93
39.23	Elastic 3	i. 94
39.24	Knife 1 clogged	i. 91
39.25	Knife 3 clogged	i. 92
39.26	Needl Butt Detector	i. 89
39.27	Saw motion checking	i. 95 (*)
39.28	Bobbin End	i. 32
39.29	Winders	i. 34
39.30	Supplementary latch detector 2 feed 3	i. 99
39.31	Supplementary latch detector 2 feed 1	i. 100
39.32	Latches 4	i. 101
39.33	Latches 3	i. 102
39.34	Latches 2	i. 103
39.35	Latches 1	i. 104

Input : To this end, see table:
Matching software and hardware inputs (**Enclosure**)

i. : input (input code for the software = software input)

(1) See the pages that follow.

(*) i. 95 = Saw motion checking
See the description provided for the message: 18. … / 67. … .

Warnings relating to an operation (start, in progress, end).

39.36 ÷ 39.39   Do not currently managed.

39.40   Zeroing accepted
39.41   Zeroing within welt zone: Wait for end of welt zone
39.42   Zeroing within welt zone: double dial-jack recovery activated
39.43   Normal zeroing out of the sock welt zone
39.44   Forced Zeroing: dial-jacks recovery activated
39.45   Resetting cams to position A
39.46   MOTOR resetting
39.47   Resetting Slides
39.48   Zeroing completed
39.49   Manual cleaning of the needles is required [Information]   (2)

39.50 ÷ 39.55   Do not currently managed.

39.56   Dial-jack yarn manual cleaning required [Error]   (2)
39.57   Mechanical Reset: START
39.58   Mechanical Reset: Dial-jacks recovery
39.59   Mechanical Reset: Slides positioning
39.60   Mechanical Reset: Cams positioning
39.61   Mechanical Reset: END
39.62   Stitch-cams autocalibration: starting positioning needles
39.63   Stitch-cams autocalibration: stitch-cams ready to be calibrated
39.64   Stitch-cams autocalibration: starting clearing needles
39.65   Stitch-cams autocalibration finished

39.66 ÷ 39.69   Code for internal use.

The Warnings (Notifications) appear in the low part of the display.
The Warnings inform about the machine status or the operation in progres.
Or … The message indicates the next operation.

(2)   The message appears in the following circumstances:
                   Program reset. ([F0]).

Message		Input
39.70	Position C needle stitch cam feed 4	i. 80
39.71	Position C needle stitch cam feed 3	i. 78
39.72	Position C needle stitch cam feed 2	i. 76
39.73	Position C needle stitch cam feed 1	i. 74
39.74	Position E needle stitch cam feed 4	i. 79
39.75	Position E needle stitch cam feed 3	i. 77
39.76	Position E needle stitch cam feed 2	i. 75
39.77	Position E needle stitch cam feed 1	i. 73
39.78	Heel/toe take-up	i. 66
39.79	Needles protection feed 4	i. 65
39.80	Cam heel entrance 4	i. 68
39.81	Cam heel exit 4	i. 67
39.82	Jack overturning feed 4	i. 69
39.83	Jack overturning feed 3	i. 70
39.84	Jack overturning feed 2	i. 71
39.85	Jack overturning feed 1	i. 72
39.86	Position C needle stitch cam heel return	i. 80
39.87	Position E needle stitch cam heel return	i. 79
39.88	Position extra cam feed 4	Do not currently managed.
39.89	Position extra cam feed 3	Do not currently managed.
39.90	Position extra cam feed 2	Do not currently managed.
39.91	Position extra cam feed 1	Do not currently managed.
39.97	Elastic 2	Do not currently managed.
39.98	Knife 2 clogs	Do not currently managed.

i. : input (input code for the software = software input)

Input : To this end, see table:
Matching software and hardware inputs (**Enclosure**)

Messages 39 .99 ÷ 39 .122 .

The controlled input that generates the message is integrated on the board (motor board).

The status is indicated by the on/off light.

The correct condition is:

- **Green Led** = Motor zero proximity = Position A

- **Red Led** = Course end = Position E

Concerning this see the menu: **Needle cam motors**

Message

39.99	Position tucking cam feed 1 (zero)
39.100	Position tucking cam feed 1 (end of stroke)
39.101	Position clearing cam feed 1 (zero)
39.102	Position clearing cam feed 1 (end of stroke)
39.103	Position extra cam feed 1 (zero)
39.104	Position extra cam feed 1 (end of stroke)
39.105	Position tucking cam feed 2 (zero)
39.106	Position tucking cam feed 2 (end of stroke)
39.107	Position clearing cam feed 2 (zero)
39.108	Position clearing cam feed 2 (end of stroke)
39.109	Position extra cam feed 2 (zero)
39.110	Position extra cam feed 2 (end of stroke)
39.111	Position tucking cam feed 3 (zero)
39.112	Position tucking cam feed 3 (end of stroke)
39.113	Position clearing cam feed 3 (zero)
39.114	Position clearing cam feed 3 (end of stroke)
39.115	Position extra cam feed 3 (zero)
39.116	Position extra cam feed 3 (end of stroke)
39.117	Position tucking cam feed 4 (zero)
39.118	Position tucking cam feed 4 (end of stroke)
39.119	Position clearing cam feed 4 (zero)
39.120	Position clearing cam feed 4 (end of stroke)
39.121	Position extra cam feed 4 (zero)
39.122	Position extra cam feed 4 (end of stroke)

LA ≠ LB

LA models

39.12   Crank   i. 37

LB models

39.12   Crank   a

a =   connector on motor board (Sizing motor) ,
           CAN type RX board

Dial unit / Saw

Dial position :

The Dial position is controlled by the software via the value read by a sensor. [= i. 90] *

End of stroke sensor =   Dial vertical piston/ Saw stop motion

                           This item is specific for the models equipped with: **Raising dial motor**
                           See the description provided for the message: **26.**

                              Otherwise:

Zero sensor =   Saw stop for high welt =
                           Input for upper mechanical dial   .
                           When the Dial is low the control sensor is in a reading status.

Lubrication unit

i. … =   For the position of the input refer to the instructions given in the message: **37.**

(*)   **i.** :   input (input code for the software = software input)

    Input :   To this end, see table:
                Matching software and hardware inputs (**Enclosure**)

Donna machines

This message indicates the Short-Circuit (40._, 43._, 60._) or the Load not connected (41._, 44._, 61._) to an output machine.
The message specifies the position of the output.

The position of the solenoid valve depends on the model.
The value is shown in the tables on the following pages.
The boards controlling the pneumatic solenoid valves are called "bars".

There are three types of solenoid valves: Normally Closed (NC), Normally Open (NO) and Bistable.
The command provided to these solenoid valves corresponds to the presence of the 24 Vdc voltage on their poles.
NC = The air is present at the exit of the Solenoid valve when command is active.
NO = The air is present at the exit of the Solenoid valve when command is NOT active.
In the third case (Bistable) the Solenoid valve switches its output (Closed/ Open) only when arrives the specific command.
Bistable solenoid valves maintain the status in which they are when the electric power goes off.

The bars are specific for monostable and bistable solenoid valves.
The bistable solenoid valves have 3 pins and require the specific 3719 PCB board.
However …
It is possible to mount a bistable EV on a monostable bar, if the adjacent place is kept free.

First …
Here is the complete list of messages from this group.
After which …
The specific tables for each model will follow.
(The position of the solenoid valve depends on the model.)

Command output

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.

Concerning this see the menu: **Autotest menu**

In particular: **Manual commands menu**
In particular: **Autotest various outputs**

See also the menu: **Manual EV**

For further information, refer to the brochure: **Serial line repair.**

msg	Solenoid valve		msg	Solenoid valve
.0	Air blow latch opener		.20	Needle butt detector
.1	Exclusion knife feed 4		.21	Air blow needle opener
.2	Exclusion knife feed 3		.22	Crank block
.3	Rubber binder 3		.23	Picot air blast
.4	Dial jacks return phase 2		.24	Air shoe cleaning air blast
.5	Dial jacks return phase 1		.25	Mechanical latch opener
.6	Dial jacks exit phase 2		.26	EV Tucking cam position C feed 3
.7	Dial jacks exit phase 1		.27	EV Tucking cam position E feed 3
.8	Rubber binder 5		.28	EV Clearing cam position C feed 3
.9	Stocking ejector air blast		.29	EV Clearing cam position E feed 3
.10	Plasmeca brake feed 3		.30	EV Extra Plain-mesh cam position C feed 3
.11	All push out cam for jack feed 3		.31	EV Extra Plain-mesh cam position E feed 3
.12	All push out cam for jack feed 1		.32	Basket changeover 1
.13	Lower throat plate feeds 1-2-3-4		.33	Basket changeover 2
.14	Lower throat plate feeds 1-3		.34	EV Tucking cam position C feed 2
.15	Lower throat plate feeds 2-4		.35	EV Tucking cam position E feed 2
.16	Command stop latches 1		.36	EV Clearing cam position C feed 2
.17	Command stop latches 3		.37	EV Clearing cam position E feed 2
.18	All push out cam for jack feed 2		.38	EV Extra Plain-mesh cam position C feed 2
.19	All push out cam for jack feed 4		.39	EV Extra Plain-mesh cam position E feed 2
.40	Stitch cam lower feed 2		.60	EV slide 14 drum 2
.41	Stitch cam lower feed 3		.61	EV slide 13 drum 2
.42	EV slide 16 drum 1		.62	EV slide 12 drum 2
.43	EV slide 15 drum 1		.63	EV slide 11 drum 2
.44	EV slide 14 drum 1		.64	EV slide 10 drum 2
.45	EV slide 13 drum 1		.65	EV slide 9 drum 2
.46	EV slide 12 drum 1		.66	EV slide 16 drum 3
.47	EV slide 11 drum 1		.67	EV slide 15 drum 3
.48	EV slide 10 drum 1		.68	EV slide 14 drum 3
.49	EV slide 9 drum 1		.69	EV slide 13 drum 3
.50	EV slide 8 drum 1		.70	EV slide 12 drum 3
.51	EV slide 7 drum 1		.71	EV slide 11 drum 3
.52	EV slide 6 drum 1		.72	EV slide 10 drum 3
.53	EV slide 5 drum 1		.73	EV slide 9 drum 3
.54	EV slide 4 drum 1		.74	EV slide 8 drum 3
.55	EV slide 3 drum 1		.75	EV slide 7 drum 3
.56	EV slide 2 drum 1		.76	EV slide 6 drum 3
.57	EV slide 1 drum 1		.77	EV slide 5 drum 3
.58	EV slide 16 drum 2		.78	EV slide 4 drum 3
.59	EV slide 15 drum 2		.79	EV slide 3 drum 3
.80	EV slide 2 drum 3		.100	EV Clearing cam position E feed 4
.81	EV slide 1 drum 3		.101	EV Clearing cam position C feed 4
.82	EV slide 16 drum 4		.102	EV Tucking cam position E feed 4
.83	EV slide 15 drum 4		.103	EV Tucking cam position C feed 4
.84	EV slide 14 drum 4		.104	Rubber binder 6
.85	EV slide 13 drum 4		.105	Release elastic feeder 4
.86	EV slide 12 drum 4		.106	Plasmeca brake feed 1
.87	EV slide 11 drum 4		.107	Release elastic feeder 2
.88	EV slide 10 drum 4		.108	Halt saw device
.89	EV slide 9 drum 4		.109	Dial lower
.90	Stitch cam lower feed 4		.110	Knife cleaning air blow
.91	Stitch cam lower feed 1		.111	Exclusion knife feed 2
.92	EV Extra Plain-mesh cam position E feed 1		.112	EV movable drop wire on feed 3
.93	EV Extra Plain-mesh cam position C feed 1		.113	EV movable drop wire on feed 1
.94	EV Clearing cam position E feed 1		.114	Rubber binder 4
.95	EV Clearing cam position C feed 1		.115	Rubber binder 2
.96	EV Tucking cam position E feed 1		.116	Exclusion knife feed 1
.97	EV Tucking cam position C feed 1		.117	Rubber binder 1
.98	EV Extra Plain-mesh cam position E feed 4		.118	Client 1
.99	EV Extra Plain-mesh cam position C feed 4		.119	Client 2

msg = Message (40. … / 41. …).

msg	Solenoid valve	msg	Solenoid valve
.120	Client 3	.140	Wefted slide feed 3
.121	Client 4	.141	Terry lever feed 1-2-3-4
.122	Adjustement yarn tension 1-3	.142	Stocking ejection special
.123	Adjustement yarn tension 2-3	.143	Command stop latches 2
.124	Release elastic feeder 1	.144	Command stop latches 4
.125	Release elastic feeder 3	.145	Raise throat plate feed 1-2-3-4
.126	Output for Nautilus	.146	Lower throat plate feed 1
.127	Selector protection ring	.147	Lower throat plate feed 2
.128	Fictitious Output	.148	Lower throat plate feed 3
.129	Stop yarn antibreak control 1	.149	Lower throat plate feed 4
.130	Yarn sliding for DACSY or MDS	.150	Seamed line 1
.131	End of cycle DACSY or MDS	.151	Seamed line 2
.132	Bag 2 collection socks	.152	Yarnfinger 1 feed 1
.133	Bag 1 collection socks	.153	Yarnfinger 2 feed 1
.134	Output User 4	.154	Yarnfinger 3 feed 1
.135	Output User 3	.155	Yarnfinger 4 feed 1
.136	Output User 2	.156	Yarnfinger 5 feed 1
.137	Output User 1	.157	Yarnfinger 6 feed 1
.138	Oil pump	.158	Plaiting yarnfinger 1 feed 1
.139	Wefted slide feed 1	.159	Plaiting yarnfinger 2 feed 1
.160	Plaiting yarnfinger 3 feed 1	.180	Yarnfinger 5 feed 3
.161	Plaiting yarnfinger 4 feed 1	.181	Yarnfinger 6 feed 3
.162	Plaiting yarnfinger 5 feed 1	.182	Plaiting yarnfinger 1 feed 3
.163	Plaiting yarnfinger 6 feed 1	.183	Plaiting yarnfinger 2 feed 3
.164	Yarnfinger 1 feed 2	.184	Plaiting yarnfinger 3 feed 3
.165	Yarnfinger 2 feed 2	.185	Plaiting yarnfinger 4 feed 3
.166	Yarnfinger 3 feed 2	.186	Plaiting yarnfinger 5 feed 3
.167	Yarnfinger 4 feed 2	.187	Plaiting yarnfinger 6 feed 3
.168	Yarnfinger 5 feed 2	.188	Yarnfinger 1 feed 4
.169	Yarnfinger 6 feed 2	.189	Yarnfinger 2 feed 4
.170	Plaiting yarnfinger 1 feed 2	.190	Yarnfinger 3 feed 4
.171	Plaiting yarnfinger 2 feed 2	.191	Yarnfinger 4 feed 4
.172	Plaiting yarnfinger 3 feed 2	.192	Yarnfinger 5 feed 4
.173	Plaiting yarnfinger 4 feed 2	.193	Yarnfinger 6 feed 4
.174	Plaiting yarnfinger 5 feed 2	.194	Plaiting yarnfinger 1 feed 4
.175	Plaiting yarnfinger 6 feed 2	.195	Plaiting yarnfinger 2 feed 4
.176	Yarnfinger 1 feed 3	.196	Plaiting yarnfinger 3 feed 4
.177	Yarnfinger 2 feed 3	.197	Plaiting yarnfinger 4 feed 4
.178	Yarnfinger 3 feed 3	.198	Plaiting yarnfinger 5 feed 4
.179	Yarnfinger 4 feed 3	.199	Plaiting yarnfinger 6 feed 4
.200	Radial yarnfinger feed 1	.220	Yarnfinger 10 feed 3
.201	Radial yarnfinger feed 2	.221	Yarnfinger 9 feed 4
.202	Radial yarnfinger feed 3	.222	Yarnfinger 10 feed 4
.203	Radial yarnfinger feed 4	.223	Wefted slide feed 2
.204	Plaiting yarnfinger radial feed 1	.224	Wefted slide feed 4
.205	Plaiting yarnfinger radial feed 2	.225	Position C needle stitch cam feed 1
.206	Plaiting yarnfinger radial feed 3	.226	Position E needle stitch cam feed 1
.207	Plaiting yarnfinger radial feed 4	.227	Position C needle stitch cam feed 2
.208	Elliptical yarnfinger 1 feed 1	.228	Position E needle stitch cam feed 2
.209	Elliptical yarnfinger 1 feed 2	.229	Position C needle stitch cam feed 3
.210	Elliptical yarnfinger 1 feed 3	.230	Position E needle stitch cam feed 3
.211	Elliptical yarnfinger 1 feed 4	.231	Position C needle stitch cam feed 4
.212	Needle extraction light	.232	Position E needle stitch cam feed 4
.213	Terry lever feed 1	.233	Closing air nozzle 2
.214	Terry lever feed 2	.234	All overturned feed 1A
.215	Terry lever feed 3	.235	All overturned feed 3A
.216	Terry lever feed 4	.236	Yarnfinger 1 feed 1A
.217	Yarnfinger 9 feed 2	.237	Yarnfinger 2 feed 1A
.218	Yarnfinger 10 feed 2	.238	Yarnfinger 1 feed 3A
.219	Yarnfinger 9 feed 3	.239	Yarnfinger 2 feed 3A

msg = Message (40. … / 41. …).

msg	Solenoid valve	msg	Solenoid valve
.240	Needle butt detector 2	.260	Mechanical binder on Air blow suction system 2
.241	Air blast clean sinkers	.261	Mechanical binder on Air blow suction system 4
.242	Radial pneumatic yarnfinger feed 1	.262	Trapper Feed 2
.243	Radial pneumatic yarnfinger feed 2	.263	EV movable drop wire on feed 4
.244	Radial pneumatic yarnfinger feed 3	.264	Second mechanical binder system 1
.245	Radial pneumatic yarnfinger feed 4	.265	Second mechanical binder system 3
.246	Trapper cutter-trapper 4	.266	EV heel/toe enter position E feed 4
.247	Trapper cutter-trapper 2	.267	EV heel/toe enter position E feed 4
.248	Needles protection piston feed 4	.268	EV heel/toe exit position E feed 4
.249	Needles protection piston feed 4A	.269	EV heel/toe exit position E feed 4
.250	EV heel/toe take-up 1	.270	Knit stitch cam slide, position C feed cam return
.251	EV heel/toe take-up 2	.271	Knit stitch cam slide, position C feed cam return
.252	Sinker extraction 1	.272	Knit stitch cam slide, position E feed cam return
.253	Sinker extraction 2	.273	Knit stitch cam slide, position E feed cam return
.254	Sinker extraction 3	.274	Sinker extraction 4
.255	Ducking central cam	.275	EV heel/toe take-up 3
.256	Lowering needle picker 1	.276	EV heel/toe take-up 4
.257	Lowering needle picker 2	.277	Tuck cam position E feed 4
.258	EV Picker raising needles	.278	Tuck cam position E feed 4
.259	EV Disk opener heel/toe take-up	.279	Tuck cam position E feed 1
.280	Tuck cam position E feed 1	.300	Yarnfinger 2 color 1 feed 2
.281	Equalizer slide feed 3	.301	Yarnfinger 1 color 1 feed 2
.282	Yarnfinger 7 feed 4	.302	Yarnfinger 2 color 2 feed 2
.283	Yarnfinger 8 feed 4	.303	Yarnfinger 1 color 2 feed 2
.284	Plaiting yarnfinger 8 feed 4	.341	Jacks exctration color 1 Feed 2
.285	Yarn knife	.342	Jacks exctration color 2 Feed 2
.286	Eliminate jacks feed 1-2 alternating motion	.343	Jacks exctration color 3 Feed 1
.287	Ducking s.c for laid-in f.1	.344	Jacks exctration color 4 Feed 1
.288	Ducking s.c for laid-in f.3	.349	SHORT-CIRCUIT output %d bar %d mobile plate SV, feed 2
.289	Ducking heel/toe stitch came	.350	supplementary knife SV , feed 1
.290	Equalizer slide feed 4	.351	supplementary knife SV, feed 2
.291	Machine inspection lamp	.353	lower needle cam position E feed 2
.292	Binder dream	.354	lower needle cam position C feed 2
.293	Dream door	.355	clearing-wefted cam position E feed 2
.294	extraction colour 1	.356	clearing-wefted cam position C feed 2
.295	extraction colour 2	.357	lower needle cam position E feed 1
.296	Yarnfinger 2 color 1 feed 1	.358	lower needle cam position C feed 1
.297	Yarnfinger 1 color 1 feed 1	.359	clearing-wefted cam position E feed 1
.298	Yarnfinger 2 color 2 feed 1	.360	clearing-wefted cam position C feed 1
.299	Yarnfinger 1 color 2 feed 1	.361	Yarnfinger 0 feed 1
.362	Yarnfinger 0 feed 2	.366	Plaiting yarnfinger 0 feed 2
.363	Yarnfinger 0 feed 3	.367	Plaiting yarnfinger 0 feed 3
.364	Yarnfinger 0 feed 4	.368	Plaiting yarnfinger 0 feed 4
.365	Plaiting yarnfinger 0 feed 1		

msg = Message (40. … / 41. …).

LA02MJ , LB02MJ , LB02MJ-T

msg	Ev						
.0	1.1	.111	16.2	.164	4.3	.232	11.1
.1	1.2	.112	16.3	.165	25.3	.233	15.5
.2	1.3	.113	16.4	.166	25.5	.234	7.5
.3	1.4	.114	16.5	.167	25.7	.235	13.7
.4	1.5	.115	16.6	.168	26.1	.236	24.5
.5	1.6	.116	16.7	.169	26.3	.237	24.7
.6	1.7	.117	16.8	.170	4.4	.238	28.5
.7	1.8	.118	8.1	.171	25.4	.239	28.7
.8	2.1	.119	8.2	.172	25.6	.240	15.6
.9	5.8	.120	8.3	.173	25.8	.291	I.2
.10	13.6	.121	8.4	.174	26.2	.292	13.3
.11	6.5	.122	12.1	.175	26.4	.293	13.2
.12	13.4	.123	12.2	.176	4.5		
.16	15.3	.124	10.4	.177	27.3		
.17	2.3	.125	10.3	.178	27.5		
.18	7.6	.126	21.3	.179	27.7		
.19	13.8	.128	22.1	.180	28.1		
.20	12.5	.129	I.1	.181	28.3		
.21	12.6	.132	I_BIS.1	.182	4.6		
.22	12.4	.133	I_BIS.2	.183	27.4		
.23	5.7	.134	I_BIS.5	.184	27.6		
.24	5.6	.135	I_BIS.6	.185	27.8		
.25	12.3	.136	I_BIS.7	.186	28.2		
.26	6.1	.137	I_BIS.8	.187	28.4		
.27	6.2	.139	13.5	.188	4.7		
.28	6.3	.140	6.6	.189	29.3		
.29	6.4	.142	13.1	.190	29.5		
.32	8.7	.143	2.2	.191	29.7		
.33	8.8	.144	15.2	.192	30.1		
.34	7.1	.145	15.4	.193	30.3		
.35	7.2	.146	12.8	.194	4.8		
.36	7.3	.147	2.8	.195	29.4		
.37	7.4	.148	2.7	.196	29.6		
.94	10.5	.149	12.7	.197	29.8		
.95	10.6	.150	8.5	.198	30.2		
.96	10.7	.151	8.6	.199	30.4		
.97	10.8	.152	4.1	.208	5.1		
.100	11.5	.153	23.3	.209	5.2		
.101	11.6	.154	23.5	.210	5.3		
.102	11.7	.155	23.7	.211	5.4		
.103	11.8	.156	24.1	.212	I_BIS.3		
.104	15.1	.157	24.3	.225	10.2		
.105	11.3	.158	4.2	.226	10.1		
.106	2.5	.159	23.4	.227	7.7		
.107	11.4	.160	23.6	.228	7.8		
.108	15.7	.161	23.8	.229	6.7		
.109	15.8	.162	24.2	.230	6.8		
.110	16.1	.163	24.4	.231	11.2		

msg = Message (40. … / 41. …).

Ev = Solenoid valve
The first number expresses: Solenoid valves bar (number of the board).
The second digit shows: the position of the solenoid valve .

LA04E7 , LB04E7

msg	Ev	msg	Ev	msg	Ev
.0	1.1	.97	10.8	.166	4.3
.1	1.2	.98	11.3	.167	4.4
.2	1.3	.99	11.4	.168	4.5
.3	1.4	.100	11.5	.169	4.6
.4	1.5	.101	11.6	.170	4.7
.5	1.6	.102	11.7	.171	4.8
.6	1.7	.103	11.8	.176	3.1
.7	1.8	.104	15.1	.177	3.2
.8	2.1	.105	15.3	.178	3.3
.9	2.2	.106	15.4	.179	3.4
.10	12.1	.107	15.6	.180	3.5
.11	2.4	.108	15.7	.181	3.6
.12	2.5	.109	15.8	.182	3.7
.14	12.7	.110	16.1	.183	3.8
.15	12.8	.111	16.2	.188	14.8
.16	2.7	.112	16.3	.189	14.7
.17	2.8	.113	16.4	.190	14.6
.18	2.3	.114	16.5	.191	14.5
.19	2.6	.115	16.6	.192	14.4
.20	12.5	.116	16.7	.193	14.3
.21	12.6	.117	16.8	.194	14.2
.22	12.4	.118	8.1	.195	14.1
.23	11.2	.119	8.2	.200	5.1
.24	12.2	.120	8.3	.201	5.2
.25	12.3	.121	8.4	.202	5.3
.26	6.1	.122	8.6	.203	5.4
.27	6.2	.123	8.5	.204	5.5
.28	6.3	.124	15.2	.205	5.6
.29	6.4	.125	15.5	.206	5.7
.30	6.5	.126	21.3	.207	5.8
.31	6.6	.128	22.1	.212	I_BIS.3
.32	6.7	.129	I.1	.291	I.2
.33	6.8	.132	I_BIS.1	.292	9.2
.34	7.1	.133	I_BIS.2	.293	9.1
.35	7.2	.134	I_BIS.5		
.36	7.3	.135	I_BIS.6		
.37	7.4	.136	I_BIS.7		
.38	7.5	.137	I_BIS.8		
.39	7.6	.152	13.8		
.40	7.7	.153	13.7		
.41	7.8	.154	13.6		
.90	10.1	.155	13.5		
.91	10.2	.156	13.4		
.92	10.3	.157	13.3		
.93	10.4	.158	13.2		
.94	10.5	.159	13.1		
.95	10.6	.164	4.1		
.96	10.7	.165	4.2		

msg = Message (40. … / 41. …).

Ev = Solenoid valve
The first number expresses: Solenoid valves bar (number of the board).
The second digit shows: the position of the solenoid valve .

LA04JS , LB04JS

msg	Ev						
.0	1.1	.103	11.8	.155	23.7	.211	5.4
.1	1.2	.104	15.1	.156	24.1	.212	I_BIS.3
.2	1.3	.105	11.3	.157	24.3	.217	25.2
.3	1.4	.106	2.5	.158	4.2	.218	25.1
.4	1.5	.107	11.4	.159	23.4	.219	27.2
.5	1.6	.108	15.7	.160	23.6	.220	27.1
.6	1.7	.109	15.8	.161	23.8	.221	29.2
.7	1.8	.110	16.1	.162	24.2	.222	29.1
.8	2.1	.111	16.2	.163	24.4	.223	2.6
.9	5.8	.112	16.3	.164	4.3	.224	15.6
.10	13.6	.113	16.4	.165	25.3	.225	10.2
.11	6.5	.114	16.5	.166	25.5	.226	10.1
.12	13.4	.115	16.6	.167	25.7	.227	7.7
.16	15.3	.116	16.7	.168	26.1	.228	7.8
.17	2.3	.117	16.8	.169	26.3	.229	6.7
.18	7.6	.118	8.1	.170	4.4	.230	6.8
.19	13.8	.119	8.2	.171	25.4	.231	11.2
.20	12.5	.120	8.3	.172	25.6	.232	11.1
.21	12.6	.121	8.4	.173	25.8	.233	15.5
.22	12.4	.122	12.1	.174	26.2	.240	13.3
.23	5.7	.123	12.2	.175	26.4	.241	13.2
.24	5.6	.124	10.4	.176	4.5	.291	I.2
.25	12.3	.125	10.3	.177	27.3		
.26	6.1	.126	21.3	.178	27.5		
.27	6.2	.128	22.1	.179	27.7		
.28	6.3	.129	I.1	.180	28.1		
.29	6.4	.132	I_BIS.1	.181	28.3		
.30	9.4	.133	I_BIS.2	.182	4.6		
.31	9.3	.134	I_BIS.5	.183	27.4		
.32	8.7	.135	I_BIS.6	.184	27.6		
.33	8.8	.136	I_BIS.7	.185	27.8		
.34	7.1	.137	I_BIS.8	.186	28.2		
.35	7.2	.138	13.7	.187	28.4		
.36	7.3	.139	13.5	.188	4.7		
.37	7.4	.140	6.6	.189	29.3		
.38	9.6	.142	13.1	.190	29.5		
.39	9.5	.143	2.2	.191	29.7		
.92	9.7	.144	15.2	.192	30.1		
.93	9.8	.145	15.4	.193	30.3		
.94	10.5	.146	12.8	.194	4.8		
.95	10.6	.147	2.8	.195	29.4		
.96	10.7	.148	2.7	.196	29.6		
.97	10.8	.149	12.7	.197	29.8		
.98	9.1	.150	8.5	.198	30.2		
.99	9.2	.151	8.6	.199	30.4		
.100	11.5	.152	4.1	.208	5.1		
.101	11.6	.153	23.3	.209	5.2		
.102	11.7	.154	23.5	.210	5.3		

msg = Message (40. … / 41. …).

Ev = Solenoid valve
The first number expresses: Solenoid valves bar (number of the board).
The second digit shows: the position of the solenoid valve .

LA04M7 , LB04M7

msg	Ev	msg	Ev	msg	Ev	msg	Ev
.0	1.1	.103	11.8	.158	4.2	.292	13.2
.1	1.2	.104	15.1	.159	23.4	.293	13.3
.2	1.3	.105	11.3	.160	23.6		
.3	1.4	.106	2.5	.161	23.8		
.4	1.5	.107	11.4	.162	24.2		
.5	1.6	.108	15.7	.163	24.4		
.6	1.7	.109	15.8	.164	4.3		
.7	1.8	.110	16.1	.165	25.3		
.8	2.1	.111	16.2	.166	25.5		
.9	5.8	.112	16.3	.167	25.7		
.10	13.6	.113	16.4	.168	26.1		
.11	6.5	.114	16.5	.169	26.3		
.12	13.4	.115	16.6	.170	4.4		
.16	15.3	.116	16.7	.171	25.4		
.17	2.3	.117	16.8	.172	25.6		
.18	7.6	.118	8.1	.173	25.8		
.19	13.8	.119	8.2	.174	26.2		
.20	12.5	.120	8.3	.175	26.4		
.21	12.6	.121	8.4	.176	4.5		
.22	12.4	.122	12.1	.177	27.3		
.23	5.7	.123	12.2	.178	27.5		
.24	5.6	.124	10.4	.179	27.7		
.25	12.3	.125	10.3	.180	28.1		
.26	6.1	.126	21.3	.181	28.3		
.27	6.2	.128	22.1	.182	4.6		
.28	6.3	.129	I.1	.183	27.4		
.29	6.4	.132	I_BIS.1	.184	27.6		
.30	9.4	.133	I_BIS.2	.185	27.8		
.31	9.3	.134	I_BIS.5	.186	28.2		
.32	8.7	.135	I_BIS.6	.187	28.4		
.33	8.8	.136	I_BIS.7	.188	4.7		
.34	7.1	.137	I_BIS.8	.189	29.3		
.35	7.2	.142	13.1	.190	29.5		
.36	7.3	.143	2.2	.191	29.7		
.37	7.4	.144	15.2	.192	30.1		
.38	9.6	.145	15.4	.193	30.3		
.39	9.5	.146	12.8	.194	4.8		
.92	9.7	.147	2.8	.195	29.4		
.93	9.8	.148	2.7	.196	29.6		
.94	10.5	.149	12.7	.197	29.8		
.95	10.6	.150	8.5	.198	30.2		
.96	10.7	.151	8.6	.199	30.4		
.97	10.8	.152	4.1	.208	5.1		
.98	9.1	.153	23.3	.209	5.2		
.99	9.2	.154	23.5	.210	5.3		
.100	11.5	.155	23.7	.211	5.4		
.101	11.6	.156	24.1	.212	I_BIS.3		
.102	11.7	.157	24.3	.291	I.2		

msg = Message (40. … / 41. …).

Ev = Solenoid valve
The first number expresses: Solenoid valves bar (number of the board).
The second digit shows: the position of the solenoid valve .

LA04MJ , LB04MJ

msg	Ev	msg	Ev	msg	Ev	msg	Ev
.0	1.1	.103	11.8	.156	24.1	.212	I_bis.3
.1	1.2	.104	15.1	.157	24.3	.217	25.2
.2	1.3	.105	11.3	.158	4.2	.218	25.1
.3	1.4	.106	2.5	.159	23.4	.219	27.2
.4	1.5	.107	11.4	.160	23.6	.220	27.1
.5	1.6	.108	15.7	.161	23.8	.221	29.2
.6	1.7	.109	15.8	.162	24.2	.222	29.1
.7	1.8	.110	16.1	.163	24.4	.223	2.6
.8	2.1	.111	16.2	.164	4.3	.224	15.6
.9	5.8	.112	16.3	.165	25.3	.225	10.2
.10	13.6	.113	16.4	.166	25.5	.226	10.1
.11	6.5	.114	16.5	.167	25.7	.227	7.7
.12	13.4	.115	16.6	.168	26.1	.228	7.8
.16	15.3	.116	16.7	.169	26.3	.229	6.7
.17	2.3	.117	16.8	.170	4.4	.230	6.8
.18	7.6	.118	8.1	.171	25.4	.231	11.2
.19	13.8	.119	8.2	.172	25.6	.232	11.1
.20	12.5	.120	8.3	.173	25.8	.233	15.5
.21	12.6	.121	8.4	.174	26.2	.291	I.2
.22	12.4	.122	12.1	.175	26.4	.292	13.3
.23	5.7	.123	12.2	.176	4.5	.293	13.2
.24	5.6	.124	10.4	.177	27.3		
.25	12.3	.125	10.3	.178	27.5		
.26	6.1	.126	21.3	.179	27.7		
.27	6.2	.128	22.1	.180	28.1		
.28	6.3	.129	I.1	.181	28.3		
.29	6.4	.132	I_bis.1	.182	4.6		
.30	9.4	.133	I_bis.2	.183	27.4		
.31	9.3	.134	I_bis.5	.184	27.6		
.32	8.7	.135	I_bis.6	.185	27.8		
.33	8.8	.136	I_bis.7	.186	28.2		
.34	7.1	.137	I_bis.8	.187	28.4		
.35	7.2	.139	13.5	.188	4.7		
.36	7.3	.140	6.6	.189	29.3		
.37	7.4	.142	13.1	.190	29.5		
.38	9.6	.143	2.2	.191	29.7		
.39	9.5	.144	15.2	.192	30.1		
.92	9.7	.145	15.4	.193	30.3		
.93	9.8	.146	12.8	.194	4.8		
.94	10.5	.147	2.8	.195	29.4		
.95	10.6	.148	2.7	.196	29.6		
.96	10.7	.149	12.7	.197	29.8		
.97	10.8	.150	8.5	.198	30.2		
.98	9.1	.151	8.6	.199	30.4		
.99	9.2	.152	4.1	.208	5.1		
.100	11.5	.153	23.3	.209	5.2		
.101	11.6	.154	23.5	.210	5.3		
.102	11.7	.155	23.7	.211	5.4		

msg = Message (40. … / 41. …).

Ev = Solenoid valve
The first number expresses: Solenoid valves bar (number of the board).
The second digit shows: the position of the solenoid valve .

LA08MJ , LB08MJ , LB08MJ-T

msg	Ev	msg	Ev	msg	Ev	msg	Ev
.0	1.1	.103	11.8	.158	4.2	.218	25.1
.1	1.2	.104	15.1	.159	23.4	.219	27.2
.2	1.3	.105	11.3	.160	23.6	.220	27.1
.3	1.4	.106	2.5	.161	23.8	.221	29.2
.4	1.5	.107	11.4	.162	24.2	.222	29.1
.5	1.6	.108	15.7	.163	24.4	.225	10.2
.6	1.7	.109	15.8	.164	4.3	.226	10.1
.7	1.8	.110	16.1	.165	25.3	.227	7.7
.8	2.1	.111	16.2	.166	25.5	.228	7.8
.9	5.8	.112	16.3	.167	25.7	.229	6.7
.10	13.6	.113	16.4	.168	26.1	.230	6.8
.11	6.5	.114	16.5	.169	26.3	.231	11.2
.12	13.4	.115	16.6	.170	4.4	.232	11.1
.16	15.3	.116	16.7	.171	25.4	.233	15.5
.17	2.3	.117	16.8	.172	25.6	.240	13.5
.18	7.6	.118	8.1	.173	25.8	.291	I.2
.19	13.8	.119	8.2	.174	26.2	.292	13.3
.20	12.5	.120	8.3	.175	26.4	.293	13.2
.21	12.6	.121	8.4	.176	4.5	.361	3.1
.22	12.4	.122	12.1	.177	27.3	.362	3.3
.23	5.7	.123	12.2	.178	27.5	.363	3.5
.24	5.6	.124	10.4	.179	27.7	.364	3.7
.25	12.3	.125	10.3	.180	28.1	.365	3.2
.26	6.1	.126	21.3	.181	28.3	.366	3.4
.27	6.2	.128	22.1	.182	4.6	.367	3.6
.28	6.3	.129	I.1	.183	27.4	.368	3.8
.29	6.4	.132	I_bis.1	.184	27.6		
.30	9.4	.133	I_bis.2	.185	27.8		
.31	9.3	.134	I_bis.5	.186	28.2		
.32	8.7	.135	I_bis.6	.187	28.4		
.33	8.8	.136	I_bis.7	.188	4.7		
.34	7.1	.137	I_bis.8	.189	29.3		
.35	7.2	.142	13.1	.190	29.5		
.36	7.3	.143	2.2	.191	29.7		
.37	7.4	.144	15.2	.192	30.1		
.38	9.6	.145	15.4	.193	30.3		
.39	9.5	.146	12.8	.194	4.8		
.92	9.7	.147	2.8	.195	29.4		
.93	9.8	.148	2.7	.196	29.6		
.94	10.5	.149	12.7	.197	29.8		
.95	10.6	.150	8.5	.198	30.2		
.96	10.7	.151	8.6	.199	30.4		
.97	10.8	.152	4.1	.208	5.1		
.98	9.1	.153	23.3	.209	5.2		
.99	9.2	.154	23.5	.210	5.3		
.100	11.5	.155	23.7	.211	5.4		
.101	11.6	.156	24.1	.212	I_bis.3		
.102	11.7	.157	24.3	.217	25.2		

msg = Message (40. … / 41. …).

Ev = Solenoid valve
The first number expresses: Solenoid valves bar (number of the board).
The second digit shows: the position of the solenoid valve .

LA10

msg	Ev						
.0	1.1	.50	17.3	.98	11.3	.166	4.3
.1	1.2	.51	17.4	.99	11.4	.167	4.4
.2	1.3	.52	17.5	.100	11.5	.168	4.5
.3	1.4	.53	17.6	.101	11.6	.169	4.6
.4	1.5	.54	17.7	.102	11.7	.170	4.7
.5	1.6	.55	17.8	.103	11.8	.171	4.8
.6	1.7	.56	18.1	.104	15.1	.176	3.1
.7	1.8	.57	18.2	.105	15.3	.177	3.2
.8	2.1	.58	19.3	.106	15.4	.178	3.3
.9	2.2	.59	19.4	.107	15.6	.179	3.4
.10	2.3	.60	19.5	.108	15.7	.180	3.5
.11	2.4	.61	19.6	.109	15.8	.181	3.6
.12	2.5	.62	19.7	.110	16.1	.182	3.7
.13	2.6	.63	19.8	.111	16.2	.183	3.8
.16	2.7	.64	20.1	.112	16.3	.188	14.8
.17	2.8	.65	20.2	.113	16.4	.189	14.7
.18	17.1	.66	9.1	.114	16.5	.190	14.6
.19	17.2	.67	9.2	.115	16.6	.191	14.5
.20	5.3	.68	9.3	.116	16.7	.192	14.4
.21	5.4	.69	9.4	.117	16.8	.193	14.3
.22	5.5	.70	9.5	.118	8.1	.194	14.2
.23	5.6	.71	9.6	.119	8.2	.195	14.1
.24	5.7	.72	9.7	.120	8.3	.200	8.5
.25	5.8	.73	9.8	.121	8.4	.201	8.6
.26	6.1	.74	18.3	.122	11.1	.202	8.7
.27	6.2	.75	18.4	.123	11.2	.203	8.8
.28	6.3	.76	18.5	.124	15.2	.212	I_bis.3
.29	6.4	.77	18.6	.125	15.5	.291	I.2
.30	21.7	.78	18.7	.126	21.3		
.31	21.8	.79	18.8	.127	21.4		
.32	6.7	.80	19.1	.128	22.1		
.33	6.8	.81	19.2	.129	I.1		
.34	21.5	.82	20.3	.132	I_bis.1		
.35	21.6	.83	20.4	.133	I_bis.2		
.36	7.3	.84	20.5	.134	I_bis.5		
.37	7.4	.85	20.6	.135	I_bis.6		
.38	7.5	.86	20.7	.136	I_bis.7		
.39	7.6	.87	20.8	.137	I_bis.8		
.40	7.7	.88	21.1	.152	13.8		
.41	7.8	.89	21.2	.153	13.7		
.42	12.1	.90	10.1	.154	13.6		
.43	12.2	.91	10.2	.155	13.5		
.44	12.3	.92	10.3	.156	13.4		
.45	12.4	.93	10.4	.157	13.3		
.46	12.5	.94	10.5	.158	13.2		
.47	12.6	.95	10.6	.159	13.1		
.48	12.7	.96	10.7	.164	4.1		
.49	12.8	.97	10.8	.165	4.2		

msg = Message (40. … / 41. …).

Ev = Solenoid valve
The first number expresses: Solenoid valves bar (number of the board).
The second digit shows: the position of the solenoid valve .

LA12-LA12J

msg	Ev							
.0	1.1	.50	11.1	.98	15.3	.166	4.3
.1	1.2	.51	11.2	.99	15.4	.167	4.4
.2	1.3	.52	11.3	.100	15.5	.168	4.5
.3	1.4	.53	11.4	.101	15.6	.169	4.6
.4	1.5	.54	11.5	.102	15.7	.170	4.7
.5	1.6	.55	11.6	.103	15.8	.171	4.8
.6	1.7	.56	11.7	.104	18.1	.176	3.1
.7	1.8	.57	11.8	.105	18.3	.177	3.2
.8	2.1	.58	13.1	.106	18.4	.178	3.3
.9	2.2	.59	13.2	.107	18.6	.179	3.4
.10	2.3	.60	13.3	.108	18.7	.180	3.5
.11	2.4	.61	13.4	.109	18.8	.181	3.6
.12	2.5	.62	13.5	.110	19.1	.182	3.7
.13	2.6	.63	13.6	.111	19.2	.183	3.8
.16	2.7	.64	13.7	.112	19.3	.188	17.8
.17	2.8	.65	13.8	.113	19.4	.189	17.7
.18	5.1	.66	10.1	.114	19.5	.190	17.6
.19	5.2	.67	10.2	.115	19.6	.191	17.5
.20	5.3	.68	10.3	.116	19.7	.192	17.4
.21	5.4	.69	10.4	.117	19.8	.193	17.3
.22	5.5	.70	10.5	.118	20.1	.194	17.2
.23	5.6	.71	10.6	.119	20.2	.195	17.1
.24	5.7	.72	10.7	.120	20.3	.200	15.1
.25	5.8	.73	10.8	.121	20.4	.201	15.2
.26	6.1	.74	9.1	.122	20.5	.202	18.2
.27	6.2	.75	9.2	.123	20.6	.203	18.5
.28	6.3	.76	9.3	.124	20.7	.212	I_bis.3
.29	6.4	.77	9.4	.125	20.8	.291	I.2
.30	6.5	.78	9.5	.126	21.3		
.31	6.6	.79	9.6	.127	21.4		
.32	6.7	.80	9.7	.128	22.1		
.33	6.8	.81	9.8	.129	I.1		
.34	7.1	.82	8.1	.132	I_bis.1		
.35	7.2	.83	8.2	.133	I_bis.2		
.36	7.3	.84	8.3	.134	I_bis.5		
.37	7.4	.85	8.4	.135	I_bis.6		
.38	7.5	.86	8.5	.136	I_bis.7		
.39	7.6	.87	8.6	.137	I_bis.8		
.40	7.7	.88	8.7	.152	16.8		
.41	7.8	.89	8.8	.153	16.7		
.42	12.1	.90	14.1	.154	16.6		
.43	12.2	.91	14.2	.155	16.5		
.44	12.3	.92	14.3	.156	16.4		
.45	12.4	.93	14.4	.157	16.3		
.46	12.5	.94	14.5	.158	16.2		
.47	12.6	.95	14.6	.159	16.1		
.48	12.7	.96	14.7	.164	4.1		
.49	12.8	.97	14.8	.165	4.2		

msg = Message (40. … / 41. …).

Ev = Solenoid valve
The first number expresses: Solenoid valves bar (number of the board).
The second digit shows: the position of the solenoid valve .

LA24 , LB24

msg	Ev				
.0	1.1	.97	10.8	.166	4.3
.1	1.2	.98	11.3	.167	4.4
.2	1.3	.99	11.4	.168	4.5
.3	1.4	.100	11.5	.169	4.6
.4	1.5	.101	11.6	.170	4.7
.5	1.6	.102	11.7	.171	4.8
.6	1.7	.103	11.8	.176	3.1
.7	1.8	.104	15.1	.177	3.2
.8	2.1	.105	15.3	.178	3.3
.9	2.2	.106	15.4	.179	3.4
.10	12.1	.107	15.6	.180	3.5
.11	2.4	.108	15.7	.181	3.6
.12	2.5	.109	15.8	.182	3.7
.14	12.7	.110	16.1	.183	3.8
.15	12.8	.111	16.2	.188	14.8
.16	2.7	.112	16.3	.189	14.7
.17	2.8	.113	16.4	.190	14.6
.18	2.3	.114	16.5	.191	14.5
.19	2.6	.115	16.6	.192	14.4
.20	12.5	.116	16.7	.193	14.3
.21	12.6	.117	16.8	.194	14.2
.22	12.4	.118	8.1	.195	14.1
.23	11.2	.119	8.2	.200	5.1
.24	12.2	.120	8.3	.201	5.2
.25	12.3	.121	8.4	.202	5.3
.26	6.1	.122	8.6	.203	5.4
.27	6.2	.123	8.5	.204	5.5
.28	6.3	.124	15.2	.205	5.6
.29	6.4	.125	15.5	.206	5.7
.30	6.5	.126	21.3	.207	5.8
.31	6.6	.128	22.1	.212	I_bis.3
.32	6.7	.129	I.1	.291	I.2
.33	6.8	.132	I_bis.1	.292	9.2
.34	7.1	.133	I_bis.2	.293	9.1
.35	7.2	.134	I_bis.5		
.36	7.3	.135	I_bis.6		
.37	7.4	.136	I_bis.7		
.38	7.5	.137	I_bis.8		
.39	7.6	.152	13.8		
.40	7.7	.153	13.7		
.41	7.8	.154	13.6		
.90	10.1	.155	13.5		
.91	10.2	.156	13.4		
.92	10.3	.157	13.3		
.93	10.4	.158	13.2		
.94	10.5	.159	13.1		
.95	10.6	.164	4.1		
.96	10.7	.165	4.2		

msg = Message (40. … / 41. …).

Ev = Solenoid valve
The first number expresses: Solenoid valves bar (number of the board).
The second digit shows: the position of the solenoid valve .

LA45-5P7

msg	Ev	msg	Ev	msg	Ev	msg	Ev
.0	1.1	.52	11.3	.102	15.7	.176	3.1
.1	1.2	.53	11.4	.103	15.8	.177	3.2
.2	1.3	.54	11.5	.104	18.1	.178	3.3
.3	1.4	.55	11.6	.105	18.3	.179	3.4
.4	1.5	.56	11.7	.106	18.4	.180	3.5
.5	1.6	.57	11.8	.107	18.6	.181	3.6
.6	1.7	.58	13.1	.108	18.7	.182	3.7
.7	1.8	.59	13.2	.109	18.8	.183	3.8
.8	2.1	.60	13.3	.110	19.1	.188	17.8
.9	2.2	.61	13.4	.111	19.2	.189	17.7
.10	2.3	.62	13.5	.114	19.5	.190	17.6
.11	2.4	.63	13.6	.115	19.6	.191	17.5
.12	2.5	.64	13.7	.116	19.7	.192	17.4
.13	2.6	.65	13.8	.117	19.8	.193	17.3
.16	2.7	.66	10.1	.118	20.1	.194	17.2
.17	2.8	.67	10.2	.119	20.2	.195	17.1
.18	5.1	.68	10.3	.120	20.3	.200	15.1
.19	5.2	.69	10.4	.121	20.4	.201	15.2
.20	5.3	.70	10.5	.122	20.5	.202	18.2
.21	5.4	.71	10.6	.123	20.6	.203	18.5
.22	5.5	.72	10.7	.124	20.7	.212	I_bis.3
.23	5.6	.73	10.8	.125	20.8	.291	I.2
.24	5.7	.74	9.1	.126	21.3	.292	14.4
.25	5.8	.75	9.2	.128	22.1	.293	14.3
.26	6.1	.76	9.3	.129	I.1		
.27	6.2	.77	9.4	.132	I_bis.1		
.28	6.3	.78	9.5	.133	I_bis.2		
.29	6.4	.79	9.6	.134	I_bis.5		
.32	6.7	.80	9.7	.135	I_bis.6		
.33	6.8	.81	9.8	.136	I_bis.7		
.34	7.1	.82	8.1	.137	I_bis.8		
.35	7.2	.83	8.2	.138	19.4		
.36	7.3	.84	8.3	.152	16.8		
.37	7.4	.85	8.4	.153	16.7		
.38	7.5	.86	8.5	.154	16.6		
.39	7.6	.87	8.6	.155	16.5		
.40	7.7	.88	8.7	.156	16.4		
.41	7.8	.89	8.8	.157	16.3		
.42	12.1	.90	14.1	.158	16.2		
.43	12.2	.91	14.2	.159	16.1		
.44	12.3	.94	14.5	.164	4.1		
.45	12.4	.95	14.6	.165	4.2		
.46	12.5	.96	14.7	.166	4.3		
.47	12.6	.97	14.8	.167	4.4		
.48	12.7	.98	15.3	.168	4.5		
.49	12.8	.99	15.4	.169	4.6		
.50	11.1	.100	15.5	.170	4.7		
.51	11.2	.101	15.6	.171	4.8		

msg = Message (40. … / 41. …).

Ev = Solenoid valve
The first number expresses: Solenoid valves bar (number of the board).
The second digit shows: the position of the solenoid valve .

LA45-5T , LB45-5T

msg	Ev	msg	Ev	msg	Ev	msg	Ev
.0	1.1	.59	13.2	.117	19.8	.194	17.2
.1	1.2	.60	13.3	.122	15.1	.195	17.1
.2	1.3	.61	13.4	.123	15.2	.212	I_bis.3
.3	1.4	.62	13.5	.124	18.2	.213	11.6
.4	1.5	.63	13.6	.125	18.5	.214	11.5
.5	1.6	.64	13.7	.126	21.3	.215	11.4
.6	1.7	.65	13.8	.128	22.1	.216	11.2
.7	1.8	.66	10.1	.129	I.1	.291	I.2
.8	2.1	.67	10.2	.132	I_bis.1	.292	19.4
.9	2.2	.68	10.3	.133	I_bis.2	.293	19.3
.10	2.3	.69	10.4	.134	I_bis.5		
.11	2.4	.70	10.5	.135	I_bis.6		
.12	2.5	.71	10.6	.136	I_bis.7		
.16	2.7	.72	10.7	.137	I_bis.8		
.17	2.8	.73	10.8	.138	11.8		
.18	5.1	.82	8.1	.139	11.1		
.19	5.2	.83	8.2	.140	11.3		
.20	5.3	.84	8.3	.142	11.7		
.21	5.4	.85	8.4	.152	16.8		
.22	5.5	.86	8.5	.153	16.7		
.23	5.6	.87	8.6	.154	16.6		
.24	5.7	.88	8.7	.155	16.5		
.25	5.8	.89	8.8	.156	16.4		
.26	6.1	.90	14.1	.157	16.3		
.27	6.2	.91	14.2	.158	16.2		
.28	6.3	.92	14.3	.159	16.1		
.29	6.4	.93	14.4	.164	4.1		
.30	6.5	.94	14.5	.165	4.2		
.31	6.6	.95	14.6	.166	4.3		
.32	6.7	.96	14.7	.167	4.4		
.33	6.8	.97	14.8	.168	4.5		
.34	7.1	.98	15.3	.169	4.6		
.35	7.2	.99	15.4	.170	4.7		
.36	7.3	.100	15.5	.171	4.8		
.37	7.4	.101	15.6	.176	3.1		
.38	7.5	.102	15.7	.177	3.2		
.39	7.6	.103	15.8	.178	3.3		
.40	7.7	.104	18.1	.179	3.4		
.41	7.8	.105	18.3	.180	3.5		
.42	12.1	.106	18.4	.181	3.6		
.43	12.2	.107	18.6	.182	3.7		
.44	12.3	.108	18.7	.183	3.8		
.45	12.4	.109	18.8	.188	17.8		
.46	12.5	.110	19.1	.189	17.7		
.47	12.6	.111	19.2	.190	17.6		
.48	12.7	.114	19.5	.191	17.5		
.49	12.8	.115	19.6	.192	17.4		
.58	13.1	.116	19.7	.193	17.3		

msg = Message (40. … / 41. …).

Ev = Solenoid valve
The first number expresses: Solenoid valves bar (number of the board).
The second digit shows: the position of the solenoid valve .

LA45E7 , LB45E7

msg	Ev				
.0	1.1	.97	10.8	.159	13.1
.1	1.2	.98	11.3	.164	4.1
.2	1.3	.99	11.4	.165	4.2
.3	1.4	.100	11.5	.166	4.3
.4	1.5	.101	11.6	.167	4.4
.5	1.6	.102	11.7	.168	4.5
.6	1.7	.103	11.8	.169	4.6
.7	1.8	.104	15.1	.170	4.7
.8	2.1	.105	15.3	.171	4.8
.9	2.2	.106	15.4	.176	3.1
.10	12.1	.107	15.6	.177	3.2
.11	2.4	.108	15.7	.178	3.3
.12	2.5	.109	15.8	.179	3.4
.14	12.7	.110	16.1	.180	3.5
.15	12.8	.111	16.2	.181	3.6
.16	2.7	.112	16.3	.182	3.7
.17	2.8	.113	16.4	.183	3.8
.18	2.3	.114	16.5	.188	14.8
.19	2.6	.115	16.6	.189	14.7
.20	12.5	.116	16.7	.190	14.6
.21	12.6	.117	16.8	.191	14.5
.22	12.4	.118	8.1	.192	14.4
.23	11.2	.119	8.2	.193	14.3
.24	12.2	.120	8.3	.194	14.2
.25	12.3	.121	8.4	.195	14.1
.26	6.1	.122	8.6	.200	5.1
.27	6.2	.123	8.5	.201	5.2
.28	6.3	.124	15.2	.202	5.3
.29	6.4	.125	15.5	.203	5.4
.30	6.5	.126	21.3	.204	5.5
.31	6.6	.128	22.1	.205	5.6
.32	6.7	.129	I.1	.206	5.7
.33	6.8	.132	I_bis.1	.207	5.8
.34	7.1	.133	I_bis.2	.212	I_bis.3
.35	7.2	.134	I_bis.5	.291	I.2
.36	7.3	.135	I_bis.6	.292	9.2
.37	7.4	.136	I_bis.7	.293	9.1
.38	7.5	.137	I_bis.8		
.39	7.6	.138	11.1		
.40	7.7	.139	9.8		
.41	7.8	.140	9.7		
.90	10.1	.152	13.8		
.91	10.2	.153	13.7		
.92	10.3	.154	13.6		
.93	10.4	.155	13.5		
.94	10.5	.156	13.4		
.95	10.6	.157	13.3		
.96	10.7	.158	13.2		

msg = Message (40. … / 41. …).

Ev = Solenoid valve
The first number expresses: Solenoid valves bar (number of the board).
The second digit shows: the position of the solenoid valve .

LA4TS , LB4TS , LB4TS-T

msg	Ev	msg	Ev	msg	Ev	msg	Ev
.0	1.1	.64	10.7	.132	I_bis.1	.210	3.3
.1	1.2	.65	10.8	.133	I_bis.2	.211	3.4
.2	1.3	.66	6.1	.134	I_bis.5	.212	I_bis.3
.3	1.4	.67	6.2	.135	I_bis.6	.213	9.8
.4	1.5	.68	6.3	.136	I_bis.7	.214	9.7
.5	1.6	.69	6.4	.137	I_bis.8	.215	9.6
.6	1.7	.70	6.5	.138	14.7	.216	9.5
.7	1.8	.71	6.6	.139	14.5	.241	14.2
.8	15.2	.72	6.7	.140	4.8	.242	9.4
.9	3.8	.73	6.8	.142	14.1	.243	9.3
.10	14.6	.82	7.1	.146	13.8	.244	9.2
.11	4.7	.83	7.2	.148	13.7	.245	9.1
.12	14.4	.84	7.3	.152	2.1	.246	16.5
.16	15.3	.85	7.4	.154	23.5	.247	16.6
.17	15.4	.86	7.5	.155	23.7	.291	I.2
.18	4.6	.87	7.6	.157	24.3	.292	16.4
.19	14.8	.88	7.7	.158	2.2	.293	16.3
.20	13.5	.89	7.8	.160	23.6		
.21	13.6	.90	5.4	.161	23.8		
.22	13.4	.91	5.1	.163	24.4		
.23	3.7	.92	12.1	.164	2.3		
.24	3.6	.96	12.4	.166	25.5		
.25	13.3	.97	12.5	.167	25.7		
.26	4.1	.98	12.2	.168	26.1		
.27	4.2	.100	12.6	.169	26.3		
.31	5.5	.102	12.7	.170	2.4		
.32	8.7	.103	12.8	.172	25.6		
.33	8.8	.104	15.1	.173	25.8		
.34	4.3	.105	13.1	.175	26.4		
.35	4.4	.106	15.5	.176	2.5		
.37	4.5	.107	13.2	.178	27.5		
.39	5.6	.108	15.7	.179	27.7		
.40	5.2	.109	15.8	.181	28.3		
.41	5.3	.110	16.1	.182	2.6		
.42	11.1	.111	16.2	.184	27.6		
.43	11.2	.116	16.7	.185	27.8		
.44	11.3	.117	16.8	.187	28.4		
.45	11.4	.118	8.1	.188	2.7		
.46	11.5	.119	8.2	.190	29.5		
.47	11.6	.120	8.3	.191	29.7		
.48	11.7	.121	8.4	.192	30.1		
.49	11.8	.122	8.6	.193	30.3		
.58	10.1	.123	8.5	.194	2.8		
.59	10.2	.124	5.7	.196	29.6		
.60	10.3	.125	5.8	.197	29.8		
.61	10.4	.126	21.3	.199	30.4		
.62	10.5	.128	22.1	.208	3.1		
.63	10.6	.129	I.1	.209	3.2		

msg = Message (40. … / 41. …).

Ev = Solenoid valve
The first number expresses: Solenoid valves bar (number of the board).
The second digit shows: the position of the solenoid valve .

LB10

msg	Ev	msg	Ev	msg	Ev	msg	Ev
.0	1.1	.50	17.3	.98	11.3	.166	4.3
.1	1.2	.51	17.4	.99	11.4	.167	4.4
.2	1.3	.52	17.5	.100	11.5	.168	4.5
.3	1.4	.53	17.6	.101	11.6	.169	4.6
.4	1.5	.54	17.7	.102	11.7	.170	4.7
.5	1.6	.55	17.8	.103	11.8	.171	4.8
.6	1.7	.56	18.1	.104	15.1	.176	3.1
.7	1.8	.57	18.2	.105	15.3	.177	3.2
.8	2.1	.58	19.3	.106	15.4	.178	3.3
.9	2.2	.59	19.4	.107	15.6	.179	3.4
.10	2.3	.60	19.5	.108	15.7	.180	3.5
.11	2.4	.61	19.6	.109	15.8	.181	3.6
.12	2.5	.62	19.7	.110	16.1	.182	3.7
.13	2.6	.63	19.8	.111	16.2	.183	3.8
.16	2.7	.64	20.1	.112	16.3	.188	14.8
.17	2.8	.65	20.2	.113	16.4	.189	14.7
.18	17.1	.66	9.1	.114	16.5	.190	14.6
.19	17.2	.67	9.2	.115	16.6	.191	14.5
.20	5.3	.68	9.3	.116	16.7	.192	14.4
.21	5.4	.69	9.4	.117	16.8	.193	14.3
.22	5.5	.70	9.5	.118	8.1	.194	14.2
.23	5.6	.71	9.6	.119	8.2	.195	14.1
.24	5.7	.72	9.7	.120	8.3	.212	I_bis.3
.25	5.8	.73	9.8	.121	8.4	.291	I.2
.26	6.1	.74	18.3	.122	11.1		
.27	6.2	.75	18.4	.123	11.2		
.28	6.3	.76	18.5	.124	15.2		
.29	6.4	.77	18.6	.125	15.5		
.30	21.7	.78	18.7	.126	21.3		
.31	21.8	.79	18.8	.127	21.4		
.32	6.7	.80	19.1	.128	22.1		
.33	6.8	.81	19.2	.129	I.1		
.34	21.5	.82	20.3	.132	I_bis.1		
.35	21.6	.83	20.4	.133	I_bis.2		
.36	7.3	.84	20.5	.134	I_bis.5		
.37	7.4	.85	20.6	.135	I_bis.6		
.38	7.5	.86	20.7	.136	I_bis.7		
.39	7.6	.87	20.8	.137	I_bis.8		
.40	7.7	.88	21.1	.152	13.8		
.41	7.8	.89	21.2	.153	13.7		
.42	12.1	.90	10.1	.154	13.6		
.43	12.2	.91	10.2	.155	13.5		
.44	12.3	.92	10.3	.156	13.4		
.45	12.4	.93	10.4	.157	13.3		
.46	12.5	.94	10.5	.158	13.2		
.47	12.6	.95	10.6	.159	13.1		
.48	12.7	.96	10.7	.164	4.1		
.49	12.8	.97	10.8	.165	4.2		

msg = Message (40. … / 41. …).

Ev = Solenoid valve
The first number expresses: Solenoid valves bar (number of the board).
The second digit shows: the position of the solenoid valve .

LB12-LB12J

msg	Ev	msg	Ev	msg	Ev	msg	Ev
.0	1.1	.50	11.1	.98	15.3	.166	4.3
.1	1.2	.51	11.2	.99	15.4	.167	4.4
.2	1.3	.52	11.3	.100	15.5	.168	4.5
.3	1.4	.53	11.4	.101	15.6	.169	4.6
.4	1.5	.54	11.5	.102	15.7	.170	4.7
.5	1.6	.55	11.6	.103	15.8	.171	4.8
.6	1.7	.56	11.7	.104	18.1	.176	3.1
.7	1.8	.57	11.8	.105	18.3	.177	3.2
.8	2.1	.58	13.1	.106	18.4	.178	3.3
.9	2.2	.59	13.2	.107	18.6	.179	3.4
.10	2.3	.60	13.3	.108	18.7	.180	3.5
.11	2.4	.61	13.4	.109	18.8	.181	3.6
.12	2.5	.62	13.5	.110	19.1	.182	3.7
.13	2.6	.63	13.6	.111	19.2	.183	3.8
.16	2.7	.64	13.7	.112	19.3	.188	17.8
.17	2.8	.65	13.8	.113	19.4	.189	17.7
.18	5.1	.66	10.1	.114	19.5	.190	17.6
.19	5.2	.67	10.2	.115	19.6	.191	17.5
.20	5.3	.68	10.3	.116	19.7	.192	17.4
.21	5.4	.69	10.4	.117	19.8	.193	17.3
.22	5.5	.70	10.5	.118	20.1	.194	17.2
.23	5.6	.71	10.6	.119	20.2	.195	17.1
.24	5.7	.72	10.7	.120	20.3	.212	I_bis.3
.25	5.8	.73	10.8	.121	20.4	.291	I.2
.26	6.1	.74	9.1	.122	15.1		
.27	6.2	.75	9.2	.123	15.2		
.28	6.3	.76	9.3	.124	20.7		
.29	6.4	.77	9.4	.125	20.8		
.30	6.5	.78	9.5	.126	21.3		
.31	6.6	.79	9.6	.127	21.4		
.32	6.7	.80	9.7	.128	22.1		
.33	6.8	.81	9.8	.129	I.1		
.34	7.1	.82	8.1	.132	I_bis.1		
.35	7.2	.83	8.2	.133	I_bis.2		
.36	7.3	.84	8.3	.134	I_bis.5		
.37	7.4	.85	8.4	.135	I_bis.6		
.38	7.5	.86	8.5	.136	I_bis.7		
.39	7.6	.87	8.6	.137	I_bis.8		
.40	7.7	.88	8.7	.152	16.8		
.41	7.8	.89	8.8	.153	16.7		
.42	12.1	.90	14.1	.154	16.6		
.43	12.2	.91	14.2	.155	16.5		
.44	12.3	.92	14.3	.156	16.4		
.45	12.4	.93	14.4	.157	16.3		
.46	12.5	.94	14.5	.158	16.2		
.47	12.6	.95	14.6	.159	16.1		
.48	12.7	.96	14.7	.164	4.1		
.49	12.8	.97	14.8	.165	4.2		

msg = Message (40. … / 41. …).

Ev = Solenoid valve
The first number expresses: Solenoid valves bar (number of the board).
The second digit shows: the position of the solenoid valve .

LB40ME , LB45ME , LB50ME

msg	Ev	msg	Ev	msg	Ev	msg	Ev
.1	1.2	.121	8.4	.191	30.5	.282	30.2
.2	1.3	.124	15.2	.192	30.4	.283	30.1
.3	16.2	.125	2.2	.193	30.3	.284	29.1
.4	1.5	.126	21.3	.194	29.8	.291	I.2
.5	1.6	.128	22.1	.195	29.7	.292	10.4
.6	1.7	.129	I.1	.196	29.6	.293	10.3
.7	1.8	.132	I_bis.1	.197	29.5		
.9	12.8	.133	I_bis.2	.198	29.4		
.10	2.4	.134	I_bis.5	.199	29.3		
.11	13.5	.135	I_bis.6	.212	I_bis.3		
.12	13.4	.136	I_bis.7	.225	10.2		
.16	13.2	.137	I_bis.8	.226	10.1		
.17	13.1	.138	11.3	.227	7.7		
.18	13.6	.143	12.7	.228	7.8		
.19	13.3	.144	12.6	.229	6.7		
.20	12.5	.152	24.8	.230	6.8		
.22	12.4	.153	24.7	.247	16.6		
.23	16.3	.154	24.6	.248	5.7		
.24	16.4	.155	24.5	.249	5.8		
.25	12.3	.156	24.4	.250	2.5		
.26	6.1	.157	24.3	.251	2.6		
.27	6.2	.158	23.8	.252	14.8		
.28	6.3	.160	23.6	.253	14.7		
.29	6.4	.162	23.4	.254	14.6		
.32	14.5	.163	23.3	.255	14.3		
.33	14.4	.164	26.8	.256	15.6		
.34	7.1	.165	26.7	.257	15.5		
.35	7.2	.166	26.6	.258	2.8		
.36	7.3	.167	26.5	.259	2.7		
.37	7.4	.168	26.4	.260	5.1		
.94	10.5	.169	26.3	.261	5.3		
.95	10.6	.170	25.8	.262	5.2		
.97	10.8	.172	25.6	.263	1.4		
.100	11.5	.174	25.4	.264	5.4		
.101	11.6	.175	25.3	.265	5.5		
.103	11.8	.176	28.8	.266	3.1		
.105	15.3	.177	28.7	.267	3.2		
.106	15.4	.178	28.6	.268	3.7		
.107	2.3	.179	28.5	.269	3.8		
.108	15.7	.180	28.4	.270	3.5		
.110	16.1	.181	28.3	.271	3.6		
.112	16.8	.182	27.8	.272	3.3		
.113	1.1	.184	27.6	.273	3.4		
.116	16.7	.186	27.4	.277	3_bis.5		
.117	16.5	.187	27.3	.278	3_bis.6		
.118	8.1	.188	30.8	.279	3_bis.7		
.119	8.2	.189	30.7	.280	3_bis.8		
.120	8.3	.190	30.6	.281	6.6		

msg = Message (40. … / 41. …).

Ev = Solenoid valve . The first number expresses: Solenoid valves bar (number of the board). The second digit shows: the position of the solenoid valve .

On this model: **The 3rd bar is for bistable solenoid valves.** See end of section.

LB41TV

msg	Ev	msg	Ev	msg	Ev	msg	Ev
.1	1.2	.115	16.6	.178	28.6	.269	3.8
.2	1.3	.116	16.7	.179	28.5	.270	3.5
.3	16.2	.117	16.5	.180	28.4	.271	3.6
.4	1.5	.118	8.1	.181	28.3	.272	3.3
.5	1.6	.119	8.2	.182	27.8	.273	3.4
.6	1.7	.120	8.3	.184	27.6	.277	3_bis.5
.7	1.8	.121	8.4	.186	27.4	.278	3_bis.6
.9	12.8	.122	15.1	.187	27.3	.279	3_bis.7
.10	2.4	.123	2.1	.188	30.8	.280	3_bis.8
.11	13.5	.124	15.2	.189	30.7	.281	6.6
.12	13.4	.125	2.2	.190	30.6	.282	30.2
.16	13.2	.126	21.3	.191	30.5	.283	30.1
.17	13.1	.128	22.1	.192	30.4	.284	29.1
.18	13.6	.129	I.1	.193	30.3	.287	5.4
.19	13.3	.132	I_bis.1	.194	29.8	.288	5.5
.20	12.5	.133	I_bis.2	.195	29.7	.289	14.2
.22	12.4	.134	I_bis.5	.196	29.6	.291	I.2
.23	16.3	.135	I_bis.6	.197	29.5	.292	10.4
.24	16.4	.136	I_bis.7	.198	29.4	.293	10.3
.25	12.3	.137	I_bis.8	.199	29.3		
.26	6.1	.138	11.3	.212	I_bis.3		
.27	6.2	.142	5.6	.225	10.2		
.28	6.3	.143	12.7	.226	10.1		
.29	6.4	.144	12.6	.227	7.7		
.32	14.5	.150	11.2	.228	7.8		
.33	14.4	.151	11.1	.229	6.7		
.34	7.1	.152	24.8	.230	6.8		
.35	7.2	.153	24.7	.248	5.7		
.36	7.3	.154	24.6	.249	5.8		
.37	7.4	.155	24.5	.250	2.5		
.40	13.8	.156	24.4	.251	2.6		
.41	13.7	.157	24.3	.252	14.8		
.90	12.1	.158	23.8	.253	14.7		
.91	12.2	.160	23.6	.254	14.6		
.94	10.5	.162	23.4	.255	14.3		
.95	10.6	.163	23.3	.256	15.6		
.97	10.8	.164	26.8	.257	15.5		
.100	11.5	.165	26.7	.258	2.8		
.101	11.6	.166	26.6	.259	2.7		
.103	11.8	.167	26.5	.260	5.1		
.105	15.3	.168	26.4	.261	5.3		
.106	15.4	.169	26.3	.262	5.2		
.107	2.3	.170	25.8	.263	1.4		
.108	15.7	.172	25.6	.264	7.5		
.109	15.8	.174	25.4	.265	7.6		
.110	16.1	.175	25.3	.266	3.1		
.112	16.8	.176	28.8	.267	3.2		
.113	1.1	.177	28.7	.268	3.7		

msg = Message (40. … / 41. …).

Ev = Solenoid valve . The first number expresses: Solenoid valves bar (number of the board). The second digit shows: the position of the solenoid valve .

On this model: **The 3rd bar is for bistable solenoid valves.** See end of section.

LB45-5P7

msg	Ev	msg	Ev	msg	Ev	msg	Ev
.0	1.1	.52	10.3	.102	14.7	.176	3.1
.1	1.2	.53	10.4	.103	14.8	.177	3.2
.2	1.3	.54	10.5	.104	17.1	.178	3.3
.3	1.4	.55	10.6	.105	17.3	.179	3.4
.4	1.5	.56	10.7	.106	17.4	.180	3.5
.5	1.6	.57	10.8	.107	17.6	.181	3.6
.6	1.7	.58	12.1	.108	17.7	.182	3.7
.7	1.8	.59	12.2	.109	17.8	.183	3.8
.8	2.1	.60	12.3	.110	18.1	.188	16.8
.9	2.2	.61	12.4	.111	18.2	.189	16.7
.10	2.3	.62	12.5	.114	18.5	.190	16.6
.11	2.4	.63	12.6	.115	18.6	.191	16.5
.12	2.5	.64	12.7	.116	18.7	.192	16.4
.13	2.6	.65	12.8	.117	18.8	.193	16.3
.16	2.7	.66	9.1	.118	19.1	.194	16.2
.17	2.8	.67	9.2	.119	19.2	.195	16.1
.18	4.1	.68	9.3	.120	19.3	.212	I_bis.3
.19	4.2	.69	9.4	.121	19.4	.291	I.2
.20	4.3	.70	9.5	.122	14.1	.292	13.4
.21	4.4	.71	9.6	.123	14.2	.293	13.3
.22	4.5	.72	9.7	.124	19.7		
.23	4.6	.73	9.8	.125	19.8		
.24	4.7	.74	8.1	.126	20.3		
.25	4.8	.75	8.2	.128	21.1		
.26	5.1	.76	8.3	.129	I.1		
.27	5.2	.77	8.4	.132	I_bis.1		
.28	5.3	.78	8.5	.133	I_bis.2		
.29	5.4	.79	8.6	.134	I_bis.5		
.32	5.7	.80	8.7	.135	I_bis.6		
.33	5.8	.81	8.8	.136	I_bis.7		
.34	6.1	.82	7.1	.137	I_bis.8		
.35	6.2	.83	7.2	.138	18.4		
.36	6.3	.84	7.3	.152	15.8		
.37	6.4	.85	7.4	.153	15.7		
.38	6.5	.86	7.5	.154	15.6		
.39	6.6	.87	7.6	.155	15.5		
.40	6.7	.88	7.7	.156	15.4		
.41	6.8	.89	7.8	.157	15.3		
.42	11.1	.90	13.1	.158	15.2		
.43	11.2	.91	13.2	.159	15.1		
.44	11.3	.94	13.5	.164	3_bis.1		
.45	11.4	.95	13.6	.165	3_bis.2		
.46	11.5	.96	13.7	.166	3_bis.3		
.47	11.6	.97	13.8	.167	3_bis.4		
.48	11.7	.98	14.3	.168	3_bis.5		
.49	11.8	.99	14.4	.169	3_bis.6		
.50	10.1	.100	14.5	.170	3_bis.7		
.51	10.2	.101	14.6	.171	3_bis.8		

msg = Message (40. … / 41. …).

Ev = Solenoid valve
The first number expresses: Solenoid valves bar (number of the board).
The second digit shows: the position of the solenoid valve .

LB55ME , LB60ME

msg	Ev		msg	Ev		msg	Ev		msg	Ev
.1	1.2		.121	8.4		.191	30.5		.282	30.2
.2	1.3		.124	15.2		.192	30.4		.283	30.1
.3	16.2		.125	2.2		.193	30.3		.284	29.1
.4	1.5		.126	21.3		.194	29.8		.291	I.2
.5	1.6		.128	22.1		.195	29.7		.292	10.4
.6	1.7		.129	I.1		.196	29.6		.293	10.3
.7	1.8		.132	I_bis.1		.197	29.5			
.9	12.8		.133	I_bis.2		.198	29.4			
.10	2.4		.134	I_bis.5		.199	29.3			
.11	13.5		.135	I_bis.6		.212	I_bis.3			
.12	13.4		.136	I_bis.7		.225	10.2			
.16	13.2		.137	I_bis.8		.226	10.1			
.17	13.1		.138	11.3		.227	7.7			
.18	13.6		.143	12.7		.228	7.8			
.19	13.3		.144	12.6		.229	6.7			
.20	12.5		.152	24.8		.230	6.8			
.22	12.4		.153	24.7		.247	16.6			
.23	16.3		.154	24.6		.248	5.7			
.24	16.4		.155	24.5		.249	5.8			
.25	12.3		.156	24.4		.250	2.5			
.26	6.1		.157	24.3		.251	2.6			
.27	6.2		.158	23.8		.252	14.8			
.28	6.3		.160	23.6		.253	14.7			
.29	6.4		.162	23.4		.254	14.6			
.32	14.5		.163	23.3		.255	14.3			
.33	14.4		.164	26.8		.256	15.6			
.34	7.1		.165	26.7		.257	15.5			
.35	7.2		.166	26.6		.258	2.8			
.36	7.3		.167	26.5		.259	2.7			
.37	7.4		.168	26.4		.260	5.1			
.94	10.5		.169	26.3		.261	5.3			
.95	10.6		.170	25.8		.262	5.2			
.97	10.8		.172	25.6		.263	1.4			
.100	11.5		.174	25.4		.264	5.4			
.101	11.6		.175	25.3		.265	5.5			
.103	11.8		.176	28.8		.266	3.1			
.105	15.3		.177	28.7		.267	3.2			
.106	15.4		.178	28.6		.268	3.7			
.107	2.3		.179	28.5		.269	3.8			
.108	15.7		.180	28.4		.270	3.5			
.110	16.1		.181	28.3		.271	3.6			
.112	16.8		.182	27.8		.272	3.3			
.113	1.1		.184	27.6		.273	3.4			
.116	16.7		.186	27.4		.277	3_bis.5			
.117	16.5		.187	27.3		.278	3_bis.6			
.118	8.1		.188	30.8		.279	3_bis.7			
.119	8.2		.189	30.7		.280	3_bis.8			
.120	8.3		.190	30.6		.281	6.6			

msg = Message (40. … / 41. …).

Ev = Solenoid valve . The first number expresses: Solenoid valves bar (number of the board). The second digit shows: the position of the solenoid valve .

On this model: **The 3rd bar is for bistable solenoid valves.** See end of section.

LBOP

msg	Ev	msg	Ev	msg	Ev	msg	Ev
.0	1.1	.112	16.3	.166	25.5	.254	3.5
.1	1.2	.113	16.4	.167	25.7	.259	13.7
.2	1.3	.114	16.5	.168	26.1	.274	3.6
.3	1.4	.115	16.6	.169	26.3	.276	3.8
.4	1.5	.116	16.7	.170	4.4	.281	6.6
.5	1.6	.117	16.8	.171	25.4	.285	2.6
.6	1.7	.118	8.1	.172	25.6	.286	3.7
.7	1.8	.119	8.2	.173	25.8	.290	7.5
.8	2.1	.120	8.3	.174	26.2	.291	I.2
.9	5.8	.121	8.4	.175	26.4	.292	13.2
.10	13.6	.122	12.1	.176	4.5	.293	13.3
.11	6.5	.123	12.2	.177	27.3		
.12	13.4	.124	10.4	.178	27.5		
.16	15.3	.125	10.3	.179	27.7		
.17	2.3	.126	21.3	.180	28.1		
.18	7.6	.128	22.1	.181	28.3		
.19	13.8	.129	I.1	.182	4.6		
.20	12.5	.132	I_bis.1	.183	27.4		
.21	12.6	.133	I_bis.2	.184	27.6		
.22	12.4	.134	I_bis.5	.185	27.8		
.23	5.7	.135	I_bis.6	.186	28.2		
.24	5.6	.136	I_bis.7	.187	28.4		
.25	12.3	.137	I_bis.8	.188	4.7		
.26	6.1	.138	2.4	.189	29.3		
.27	6.2	.142	13.1	.190	29.5		
.28	6.3	.143	2.2	.191	29.7		
.29	6.4	.144	15.2	.192	30.1		
.32	8.7	.145	15.4	.193	30.3		
.33	8.8	.146	12.8	.194	4.8		
.34	7.1	.147	2.8	.195	29.4		
.35	7.2	.148	2.7	.196	29.6		
.36	7.3	.149	12.7	.197	29.8		
.37	7.4	.150	8.5	.198	30.2		
.94	10.5	.151	8.6	.199	30.4		
.95	10.6	.152	4.1	.208	5.1		
.96	10.7	.153	23.3	.209	5.2		
.97	10.8	.154	23.5	.210	5.3		
.100	11.5	.155	23.7	.211	5.4		
.101	11.6	.156	24.1	.212	I_bis.3		
.102	11.7	.157	24.3	.233	15.5		
.103	11.8	.158	4.2	.242	14.1		
.104	15.1	.159	23.4	.243	14.2		
.105	11.3	.160	23.6	.244	14.3		
.106	2.5	.161	23.8	.245	14.4		
.107	11.4	.162	24.2	.250	3.1		
.108	15.7	.163	24.4	.251	3.2		
.110	16.1	.164	4.3	.252	3.3		
.111	16.2	.165	25.3	.253	3.4		

msg = Message (40. … / 41. …).

Ev = Solenoid valve
The first number expresses: Solenoid valves bar (number of the board).
The second digit shows: the position of the solenoid valve .

LB10Y

msg	Ev		msg	Ev
.0	1.1		.142	4.8
.1	1.2		.212	I_bis.3
.2	1.3		.291	I.2
.3	1.4		.292	3.5
.4	1.5		.293	3.6
.5	1.6			
.6	1.7			
.7	1.8			
.8	8.3			
.9	2.8			
.10	7.6			
.11	7.2			
.12	7.1			
.21	2.5			
.22	2.7			
.23	2.6			
.24	2.3			
.32	7.7			
.33	7.8			
.104	8.4			
.105	3.4			
.106	7.5			
.107	3.2			
.108	2.2			
.109	2.1			
.110	8.1			
.111	8.2			
.114	8.5			
.115	8.6			
.116	8.7			
.117	8.8			
.118	4.1			
.119	4.2			
.120	4.3			
.121	4.4			
.122	3.7			
.123	3.8			
.124	3.1			
.125	3.3			
.126	21.3			
.128	22.1			
.129	I.1			
.132	I_bis.1			
.133	I_bis.2			
.134	I_bis.5			
.135	I_bis.6			
.136	I_bis.7			
.137	I_bis.8			

msg = Message (40. … / 41. …).

Ev = Solenoid valve
The first number expresses: Solenoid valves bar (number of the board).
The second digit shows: the position of the solenoid valve .

LB12Y

msg	Ev		msg	Ev
.0	1.1		.135	I_bis.6
.1	1.2		.136	I_bis.7
.2	1.3		.137	I_bis.8
.3	1.4		.142	4.8
.4	1.5		.212	I_bis.3
.5	1.6		.291	I.2
.6	1.7		.292	3.5
.7	1.8		.293	3.6
.8	8.3			
.9	2.8			
.10	7.6			
.11	7.2			
.12	7.1			
.13	6.1			
.18	7.3			
.19	7.4			
.21	2.5			
.22	2.7			
.23	2.6			
.24	2.3			
.32	7.7			
.33	7.8			
.104	8.4			
.105	3.4			
.106	7.5			
.107	3.2			
.108	2.2			
.109	2.1			
.110	8.1			
.111	8.2			
.114	8.5			
.115	8.6			
.116	8.7			
.117	8.8			
.118	4.1			
.119	4.2			
.120	4.3			
.121	4.4			
.122	3.7			
.123	3.8			
.124	3.1			
.125	3.3			
.126	21.3			
.128	22.1			
.129	I.1			
.132	I_bis.1			
.133	I_bis.2			
.134	I_bis.5			

msg = Message (40. … / 41. …).

Ev = Solenoid valve
The first number expresses: Solenoid valves bar (number of the board).
The second digit shows: the position of the solenoid valve .

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msg	Ev				
.2	1.3	.117	16.5	.225	10.2
.3	16.2	.118	8.1	.226	10.1
.4	1.5	.119	8.2	.227	7.7
.5	1.6	.120	8.3	.228	7.8
.6	1.7	.121	8.4	.229	6.7
.7	1.8	.122	15.1	.230	6.8
.9	12.8	.123	2.1	.248	5.7
.10	2.4	.124	15.2	.249	5.8
.11	13.5	.125	2.2	.250	2.5
.12	13.4	.126	21.3	.251	2.6
.16	13.2	.128	22.1	.252	14.8
.17	13.1	.129	I.1	.253	14.7
.18	13.6	.132	I_bis.1	.254	14.6
.19	13.3	.133	I_bis.2	.255	14.3
.20	12.5	.134	I_bis.5	.256	15.6
.22	12.4	.135	I_bis.6	.257	15.5
.23	16.3	.136	I_bis.7	.258	2.8
.24	16.4	.137	I_bis.8	.259	2.7
.25	12.3	.138	11.3	.263	1.4
.26	6.1	.139	5.1	.265	7.6
.27	6.2	.140	5.3	.266	3.1
.28	6.3	.142	5.6	.267	3.2
.29	6.4	.143	12.7	.268	3.7
.32	14.5	.144	12.6	.269	3.8
.33	14.4	.152	24.8	.270	3.5
.34	7.1	.153	24.7	.271	3.6
.35	7.2	.154	24.6	.272	3.3
.36	7.3	.156	24.4	.273	3.4
.37	7.4	.157	24.3	.277	3_bis.5
.40	13.8	.158	23.8	.278	3_bis.6
.41	13.7	.164	26.8	.279	3_bis.7
.90	12.1	.165	26.7	.280	3_bis.8
.91	12.2	.166	26.6	.283	30.1
.94	10.5	.169	26.3	.287	5.4
.95	10.6	.170	25.8	.288	5.5
.97	10.8	.176	28.8	.289	14.2
.100	11.5	.177	28.7	.291	I.2
.101	11.6	.178	28.6	.292	10.4
.103	11.8	.181	28.3	.293	10.3
.105	15.3	.182	27.8		
.106	15.4	.188	30.8		
.107	2.3	.189	30.7		
.108	15.7	.190	30.6		
.109	15.8	.191	30.5		
.110	16.1	.194	29.8		
.112	16.8	.197	29.5		
.113	1.1	.212	I_bis.3		
.115	16.6	.223	5.2		

msg = Message (40. … / 41. …).

Ev = Solenoid valve . The first number expresses: Solenoid valves bar (number of the board). The second digit shows: the position of the solenoid valve .

On this model: **The 3rd bar is for bistable solenoid valves.** See end of section.

Bar for bistable solenoid valves

On this model: **The 3rd bar is for bistable solenoid valves.** See end of section.

The 3rd bar is for bistable solenoid valves.
For hardware/software architecture reasons, only 8 commands per "bar" can be managed.
Therefore:
The bar is divided virtually into two: bar n and bar n-bis.
The first 4 solenoid valves belong to the "bis" bar.
(The numbering takes place starting from the unfixed end of the support.)
[The I bar (I and I_Bis) is not a support for bistable EVs, but an internal board for 16 outputs.]

Signal input

The sensor is a switch that is opened (or closed) by a physical parameter.
[For further information see also: Wikipedia.org].
The sensor provides the software a signal. [Input   ].
Namely … The sensors transmit electrical signals to the processor to stop the machine in case of failure.
[Therefore: The input (and/or sensor) is also called "stop".]
In practice: Input sensors detect that the operation progresses correctly and safely for the operator.

If a signal does not comply with the safety conditions, a specific error will appear.
Concerning this see the menu: **Autotest of inputs**

By false error is meant a defect signal not generated by an actually dangerous situation but only electric disturbances and/or hardware defects.

Position of machine inputs

The section indicates the position of the inputs.
Furthermore …
There is indicated the signal value with sensor NOT in reading.
Remember that:

Green Led = The sensor is "Normally Open" type.
When the sensor is reading, the input Autotest LED colour is … **Red** .

Red Led = The sensor is "Normally Closed" type.
When the sensor is reading, the input Autotest LED colour is … **Green** .

Concerning this see the menu: **Autotest of inputs**

Command output

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 a sensor detects a movement, it is automatically associated with that output.
For the most important movements, the actuator is controlled by one/ two sensors.
A sensor detects the final position and another one the initial position.

Concerning this see the menu: **Manual commands menu**

See also the menu: **Step motors menu**

CTE models

Refer to the menu: **Linker Motor**

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. (I/O = Input / Output)
The board signals are coded and sent through a closed-loop circuit. The boards are placed in series along this loop.
The serial line circuit originates from the board Pcb 2010.
From here the serial line then reaches all the various Input and Output boards (located outside the electrical panel).
Main inputs board is the Pcb 4866.

Seaming Robot (CTE models)

The models equipped with the aforementioned device are equipped with a 3896 PCB board.
This board receives the input signals related to the device.

To solve the problem

Solve the real problem that has caused the error.
In particular … See the pages that follow.
If the control device has not intervened, proceed as follows.

In this case, refer to the section: **In the event of a false error …**   (Enclosure)

Table : Messages and software inputs correspondence

For all models	

Message		Input	
42.0	Lack of power 36 VDC	Pcb 2010, J36, p01	
42.1	Lack of power phase	Pcb 2010, J36, p02	
42.2	Caution: cylinder carter open	Pcb 2010, J41	
42.3	Lack of power 15 VDC positive	Pcb 2010, Internal	
42.4	Lack of power 15 VDC negative	Pcb 2010, Internal	
42.5	Lack of power 24 VDC serial line	i. 12	
42.6	Lack of power 24 VDC yarnfingers unit	i. 11	
42.7	Lack of power 24 VDC solenoid-valves unit	i. 10	
42.8	Lack of power 24 VDC external expansion board	i. 9	
42.9	Suction hood open	i. 36	
42.10	Lack of air pressure	i. 35	
42.11	Crank	**GL ≠ GK** …	(1)
42.12	Stop clean knife	i. 91	
42.13	Dial obstructed	i. 97	
42.14	Winders	i. 34	
42.15	Latches 1	i. 104	
42.16	Latches 2	i. 103	
42.17	Stop jack breakage 2	i. 98	
42.18	Stop needles during heel	i. 99	
42.19	Take-up	i. 100	
42.20	Stop jack breakage 1	i. 101	
42.21	Needles butt	*Values depending on the model* …	(1)
42.22	Stop elastic 1	**GL ≠ GK** …	(1)
42.23	Stop elastic 2	**GL ≠ GK** …	(1)
42.24	Bobbin End	i. 32	
42.25	Stop end reel structure	i. 30	
42.26	Yarn creel	i. 31	

Input : To this end, see table:
Matching software and hardware inputs (**Enclosure**)

i. : input (input code for the software = software input)

(1) See the pages that follow.

Message		Input	
42.27	Stop Yarnfingers plate lock	i. 38	*
42.28	Stop yarnfingers plate position	i. 27	
42.29	Right Dropper	i. 25	
42.30	Left Dropper	i. 26	
42.31	… 42.33 *Values depending on the model*	…	(1)
42.34	Lowering needles for elastic	i. 74	
42.35	… 42.43 *Values depending on the model*	…	(1)
42.44	Cam rise needles heel/toe return swing	i. 88	
42.45	… 42.46 *Values depending on the model*	…	(1)
42.47	Throat-plate 蝴蝶门	i. 89	
42.48	Stop Solis reverser pressure	i. 48	
42.49	Stop Solis reverser inspection	i. 49	
42.50	Sock ejection not detected (Sock passage 1)	i. 7	
42.51	Sock ejection not detected (Sock passage 2)	i. 8	
42.52	Yarn antibreak control	i. 6	
42.53	… 42.73 *Warnings relating to an operation (start, in progress, end).*	…	(1)
42.74	… 42.76 *Values depending on the model*	…	(1)
42.77	Stitch cam feed 3 position A	i. 77	
42.78	Stitch cam feed 3 position B	i. 85	
42.79	Stitch cam feed 4 position A	i. 80	
42.80	Stitch cam feed 4 position B	i. 82	
42.81	Stop jack breakage 3	i. 63	
42.82	Latches 3	i. 102	
42.83	Jacks exctraction feed 1	i. 65	
42.84	Jacks exctraction feed 2	i. 64	
42.85	Jacks exctraction feed 3	i. 96	
42.86	Jacks exctraction feed 4	i. 95	
42.87	Lowering needles color 2	i. 81	
42.88	Lowering needles color 3	i. 84	
42.89	Lowering needles color 4	i. 86	

Input :   To this end, see table:
                  Matching software and hardware inputs (**Enclosure**)

 i. :   input (input code for the software = software input)

 *****   This item is specific for the models equipped with: Raising dial motor
              Otherwise:
               i. 38 = Mechanical welt proximity switch = Input for upper mechanical dial

 (1)   See the pages that follow.

Message		Input
42.90	Sole reinforcement cam feed 2 pos. A	i. 74
42.91	Sole reinforcement cam feed 3 pos. A	i. 76
42.92	Sole reinforcement cam feed 4 pos. A	i. 79
42.93	Tuck cam feed 2	i. 88
42.94	Stop clean knife 2	i. 93
42.95	Stop clean knife 1	i. 91
42.96	Released for pattern	i. 87
42.97	Eliminate jacks feed 2	i. 96
42.98	Lowering needles color 5	i. 77
42.99	Lowering needles transfer cam	i. 79
42.100	Stop latch opening transfer select	i. 78
42.101	Clearing cam feed 2	*Values depending on the model* … (1)
42.102	Central cam	i. 70
42.103	Latches 4	i. 66
42.104	Stop jack breakage 4	i. 67
42.105	Lowering needles for elastic 2	i. 79
42.106	Lowering needles for elastic 2	*Input not currently used.* …
42.107	Lowering needles cam end of heel 2	*Input not currently used.* …
42.108	Eliminates elastic selectors 2	i. 95
42.109	Small jack-raising cam, colour3, feed1	i. 82
42.110	Small jack-raising cam, colour3, feed2	i. 87
42.111	Lowering needles color 2 feed 1	i. 57
42.112	Lowering needles color 2 feed 2	i. 86
42.113	Stop jack breakage 1	i. 41
42.114	Elastic selectors level	i. 73
42.115	Heel return small jack raiser	i. 85
42.116	Feed 1 selectors level	i. 83
42.117	Heel return needle leveller	i. 76
42.118	Remove heel return jacks OUT	i. 55
42.119	Remove heel return jacks IN	i. 43
42.120	Remove selector elastic OUT	i. 95
42.121	Remove selector elastic IN	i. 44
42.122	Selectors exclusion feed 1 OUT	i. 96
42.123	Selectors exclusion feed 1 IN	i. 45
42.124	Selector protection feed 1 OUT	i. 56
42.125	Selector protection feed 1 IN	i. 42
42.126	Pattern drum unit 9 retreat out	i. 54
42.127	Pattern drum unit 9 retreat in	i. 53

Input : To this end, see table:
Matching software and hardware inputs (**Enclosure**)

i. : input (input code for the software = software input)

(1) See the pages that follow.

For all models		

Message		Input	
42.128	Stop elastic 2	**GL ≠ GK**	... (2)
42.129	Sole renforcement cam 2		i. 85
42.130		*Warnings relating to an operation (start, in progress, end).*	... (1)
42.131	Clearing cam feed 1 for filet		i. 80
42.132	Clearing cam feed 2 for filet		i. 75
42.133	Small jack-raising cam, tuck, feed 1		i. 83

(1)   See the pages that follow.
(2)   See below on the page.

by model …		

GL ≠ GK

Message		Input

GL models

42.11	Crank	i. 37
42.22	Stop elastic 1	i. 90
42.23	Stop elastic 2	i. 92

GK models

42.11	Crank	(a)
42.22	Stop elastic 1	(b)
42.23	Stop elastic 2 (configuration : 2 Elastic 1 Motor)	(b)
42.128	Stop elastic 2 (configuration : 2 Elastic 2 Motor)	(c)

(a) connector on motor board (Sizing motor) ,
      CAN type RX board ;

(b) connector on motor board (elastic motor 1) ,
      CAN type RX board ;

(c) connector on motor board (elastic motor 2) ,
      CAN type RX board .

Message		Input	Models
42.21	Needles butt	62	GK523, GK523CTE
		66	G_544, G_544CTE, G_625, G_625CTE
		102	GK616D3, G_615, G_616, G_616D, GK616D3S, G_615CTE, G_616CTE, G_616DCTE, G_616DF3CTE
42.31	Rise footlet medium jacks 1	73	GK523, GK523CTE
		77	G_615, G_615CTE, G_616, G_616CTE, G_616D, G_616DCTE
		82	G_625, G_625CTE
42.32	Rise footlet medium jacks 2	72	GK523, GK523CTE
		73	G_615, G_615CTE, G_616, G_616CTE, G_616D, G_616DCTE, G_625, G_625CTE
42.33	Rise footlet medium jacks 3	84	G_625, G_625CTE
		87	G_615, G_615CTE, G_616, G_616CTE, G_616D, G_616DCTE
42.35	Clearing cam feed 1	75	G_615, G_615CTE, G_616, G_616CTE, G_616D, G_616DCTE
		87	GK616D3, GK616D3S, G_616DF3CTE
42.36	Heel insertion needle raising cam	76	G_615, G_615CTE, G_616, G_616CTE, G_616D, G_616DCTE
		83	G_544, G_544CTE, G_625, G_625CTE
		86	GK616D3, GK616D3S, G_616DF3CTE
42.37	Stitch-cam heel return pos. A	57	G_625, G_625CTE
		71	GK523, GK523CTE, G_544, G_544CTE
		78	GK616D3, GK616D3S, G_616DF3CTE
		83	G_615, G_615CTE, G_616, G_616CTE, G_616D, G_616DCTE
42.38	Stitch-cam heel return pos. B	58	GK523, GK523CTE, G_544, G_544CTE
		78	G_615, G_615CTE, G_616, G_616CTE, G_616D, G_616DCTE
		81	G_625, G_625CTE
		84	GK616D3, GK616D3S, G_616DF3CTE
42.39	Sole renforcement cam	58	G_625, G_625CTE
		70	GK523, GK523CTE
		79	G_615, G_615CTE, G_616, G_616CTE, G_616D, G_616DCTE
		82	GK616D3, GK616D3S, G_616DF3CTE
42.40	Stitch cam feed 1 position A	60	G_544, G_544CTE
		69	GK523, GK523CTE
		71	G_625, G_625CTE
		80	GK616D3, GK616D3S, G_616DF3CTE
		82	G_615, G_615CTE, G_616, G_616CTE, G_616D, G_616DCTE
42.41	Stitch cam feed 1 position B	59	G_625, G_625CTE
		60	GK523, GK523CTE
		69	G_544, G_544CTE
		80	G_615, G_615CTE, G_616, G_616CTE, G_616D, G_616DCTE
		81	GK616D3, GK616D3S, G_616DF3CTE

G_ = GL / GK .

See also: **The models to which this document relates**

Message		Input	Models
42.42	Tuck cam feed 1	57	G_544, G_544CTE
		77	GK616D3, GK616D3S, G_616DF3CTE
		80	G_625, G_625CTE
		81	GK523, GK523CTE
		84	G_615, G_615CTE, G_616, G_616CTE, G_616D, G_616DCTE
42.43	Lowering needles cam end of heel	73	G_544, G_544CTE
		75	GK616D3, GK616D3S, G_616DF3CTE, G_625, G_625CTE
		78	GK523, GK523CTE
		86	G_615, G_615CTE, G_616, G_616CTE, G_616D, G_616DCTE
42.45	Eliminates elastic selectors	64	GK523, GK523CTE
		65	G_625, G_625CTE
		95	G_615, G_615CTE, G_616, G_616CTE, G_616D, G_616DCTE
42.46	Eliminate jacks feed 1	65	GK523, GK523CTE
		95	G_625, G_625CTE
		96	G_615, G_615CTE, G_616, G_616CTE, G_616D, G_616DCTE
42.74	Raise closed-toe knit	59	GK523CTE, G_544CTE
		72	G_625CTE
		79	G_616DF3CTE
		81	G_615CTE, G_616CTE, G_616DCTE
42.75	Stitch cam feed 2 position A	75	G_544, G_544CTE
		84	GK523, GK523CTE
		85	G_625, G_625CTE
42.76	Stitch cam feed 2 position B	76	G_625, G_625CTE
		77	GK523, GK523CTE
		87	G_544, G_544CTE
42.101	Clearing cam feed 2	76	GK523, GK523CTE
		86	G_625, G_625CTE

G_ = GL / GK .

See also: **The models to which this document relates**

Note for the models prepared with: Seaming Robot (CTE)

Refer to the menu: **Autotest of inputs**

In particular: **Input Autotest external closed toe**

For further information, refer to the brochure: **Position of machine inputs**

Furthermore …
See the description provided for the message: 48. …
When the robot stops, the machine stops at the sock pick-up point.

See the description provided for the message: 66. …
This type of message causes the Robot stop.
Furthermore: The machine stops.
Furthers informations are available in the chapter: **Classification of messages**

Warnings relating to an operation (start, in progress, end).

42.53	Zeroing accepted
42.54	MOTOR resetting
42.55	Zeroing completed
42.56	Stitch-cams autocalibration: starting positioning needles
42.57	Stitch-cams autocalibration: stitch-cams ready to be calibrated
42.58	Stitch-cams autocalibration: starting clearing needles
42.59	Stitch-cams autocalibration finished
42.60	Mechanical Reset: START
42.61	Mechanical Reset: Dial-jacks recovery
42.62	Mechanical Reset: END
42.63	TRACCIA1-Belant
42.64	TRACCIA2-Belant
42.65	TRACCIA3-Belant
42.66	Zeroing in welt zone
42.67	Zeroing in out-of-welt zone
42.68	Zeroing heel in welt
42.69	Zeroing heel out of welt
42.70	Zeroing in welt zone: dial-jacks recovery active
42.71	Zeroing: starting cam movements
42.72	Zeroing: end of cam movements
42.73	Zeroing in heel zone. Wait for synchronism
42.130	VPE valve in manual state. Normal functioning resumes with machine running

The Warnings (Notifications) appear in the low part of the display.
The Warnings inform about the machine status or the operation in progres.
Or … The message indicates the next operation.

─── **Notice** ───

i. 94 = Saw blade phase proximity
See the description provided for the message: 34. …

Lubrication unit

i. … =   For the position of the input refer to the instructions given in the message: **37.**

Goal machines

This message indicates the Short-Circuit (40._, 43._, 60._) or the Load not connected (41._, 44._, 61._) to an output machine.
The message specifies the position of the output.

The position of the solenoid valve depends on the model.
The value is shown in the tables on the following pages.
The boards controlling the pneumatic solenoid valves are called "bars".

There are three types of solenoid valves: Normally Closed (NC), Normally Open (NO) and Bistable.
The command provided to these solenoid valves corresponds to the presence of the 24 Vdc voltage on their poles.
NC = The air is present at the exit of the Solenoid valve when command is active.
NO = The air is present at the exit of the Solenoid valve when command is NOT active.
In the third case (Bistable) the Solenoid valve switches its output (Closed/ Open) only when arrives the specific command.
Bistable solenoid valves maintain the status in which they are when the electric power goes off.

The bars are specific for monostable and bistable solenoid valves.
The bistable solenoid valves have 3 pins and require the specific 3719 PCB board.
However …
It is possible to mount a bistable EV on a monostable bar, if the adjacent place is kept free.

First …
Here is the complete list of messages from this group.
After which …
The specific tables for each model will follow.
(The position of the solenoid valve depends on the model.)

Command output

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.

Concerning this see the menu: **Autotest menu**

In particular: **Manual commands menu**
In particular: **Autotest various outputs**

See also the menu: **Manual EV**

For further information, refer to the brochure: **Serial line repair.**

msg	Solenoid valve	msg	Solenoid valve
.0	Sock ejection	.20	Command stop latches 1
.1	Crank block	.21	Command stop latches 2
.2	Oiler	.22	Elastic binder 1
.3	Yarnfingers plate position	.23	Elastic binder 2
.4	Yarnfingers plate lock	.24	Lycra binder position A
.5	Halt saw device	.25	Lycra binder position B
.6	Bag 1 collection socks	.26	Lycra tensioner feed 1
.7	Bag 2 collection socks	.27	Lycra tensioner heel and toe
.8	Basket changeover 1	.28	Rubber piston 1
.9	Basket changeover 2	.29	Rubber piston 2
.10	Stop yarn antibreak control 1	.30	Air blowing for transfer
.11	Yarn sliding for DACSY or MDS	.31	Air blast clean sinkers
.12	End of cycle DACSY or MDS	.32	Heel Toe take-up 1
.13	Output for Nautilus	.33	Heel Toe take-up 2
.14	External stop lamp	.34	Heel Toe take-up 3
.15	Fictitious Output	.35	Heel Toe take-up 4
.16	Latch opener	.36	Heel Toe take-up 5
.17	Latch opener 2	.37	Heel Toe take-up 6
.18	Needles butt stop in the back	.38	Terry lever feed 1
.19	Stop toe jack	.39	Terry lever half cylinder feed 1
.40	Heel & toe terry lever	.60	Eliminate raising picker heel return
.41	Terry lever for rib feed 1	.61	Eliminate raising picker feed 1
.42	Heel Toe terry lever for rib	.62	Right Dropper
.43	Heel Toe terry lever half cylinder	.63	Left Dropper
.44	Elastic sinkers extraction	.64	Tucking cam feed 1 pos. A
.45	Elastic sinkers extraction position 2	.65	Tucking cam feed 1 pos. B
.46	Sinker cap piston	.66	Clearing cam pos. A
.47	Ducking stitch cam feed 1	.67	Clearing cam pos. B
.48	Ducking stitch cam feed 1 intermediate position	.68	Stitch cam feed 1 position A
.49	Throat-plate piston feed 1	.69	Stitch cam feed 1 position B
.50	Disable Throat-plate piston feed 1	.70	Stitch cam heel/toe position A
.51	Output User 1	.71	Stitch cam heel/toe position B
.52	Output User 2	.72	Lowering needles cam, elastic pos. A
.53	Output User 3	.73	Lowering needles cam, elastic pos. B
.54	Output User 4	.74	Raising long butt needles entering heel/toe
.55	Dial jacks enter 1	.75	Lowering needles cam end of heel
.56	Dial jacks enter 2	.76	Sole renforcement cam
.57	Dial jacks exit phase 1	.77	Cam rise needles heel return swing pos. A
.58	Dial jacks exit phase 2	.78	Cam rise needles heel return swing pos. B
.59	Dial partial return for pattern	.79	Raise medium jacks 1 for Sole Liner style
.80	Raise medium jacks 2 for Sole Liner style	.100	Second Position yarnfinger 8 feed 1
.81	Raise medium jacks 3 for Sole Liner style	.101	Second position Elastic yarnfinger feed 1
.82	Eliminate jacks feed 1 / Jacks exctraction drum 1	.102	Change position Elastic yarnfinger feed 1
.83	Eliminate jacks f. 1 / Jacks exctrac. drum 2	.103	Yarnfinger 1 elastic feed
.84	Yarnfinger 1 feed 1	.104	Yarnfinger 2 elastic feed
.85	Yarnfinger 2 feed 1	.105	Yarnfinger 1 color 1
.86	Yarnfinger 3 feed 1	.106	Yarnfinger 2 color 1
.87	Yarnfinger 4 feed 1	.107	Yarnfinger 2 color 1
.88	Yarnfinger 5 feed 1	.108	Yarnfinger 1 color 2
.89	Yarnfinger 6 feed 1	.109	Yarnfinger 2 color 2
.90	Yarnfinger 7 feed 1	.110	Yarnfinger 3 color 2
.91	Yarnfinger 8 feed 1	.111	Yarnfinger 1 color 3
.92	Elastic yarnfinger feed 1	.112	Yarnfinger 2 color 3
.93	Second Position yarnfinger 1 feed 1	.113	Yarnfinger 3 color 3
.94	Second Position yarnfinger 2 feed 1	.114	Yarnfinger 1 color 4
.95	Second Position yarnfinger 3 feed 1	.115	Yarnfinger 2 color 4
.96	Second Position yarnfinger 4 feed 1	.116	Yarnfinger 3 color 4
.97	Second Position yarnfinger 5 feed 1	.117	Yarnfinger 1 color 5
.98	Second Position yarnfinger 6 feed 1	.118	Yarnfinger 2 color 5
.99	Second Position yarnfinger 7 feed 1	.119	Yarnfinger 3 color 5

msg = Message (43. … / 44. …).

msg	Solenoid valve	msg	Solenoid valve
.120	Yarnfinger 1 feed 6	.140	Sewing rollerbackward
.121	Yarnfinger 2 feed 6	.141	Sewing roller forward
.122	Yarnfinger 3 feed 6	.142	Seaming device cutter
.123	External lighting	.143	Pin holder unit rot. lever.
.124	Dial lowering	.144	Pin holder support
.125	Yarnfinger adjustment elastic	.145	Pin holder knit pusher
.126	Close toe dial lowering	.146	Turning piston up - UP
.127	Raise fabric close toe	.147	Turning Piston up - DOWN
.128	Cylinder stop piston	.148	Sock stretching sector
.129	Turned sock pushing blow	.149	Tube stop cam t.dev.up rel.
.130	Internal tube position 1	.150	Tube stop cam t.dev.up stop
.131	Cylinder knit pusher pos. 1	.151	Stitching mach. insp. lamp
.132	Yarn ctrl. in sock extract.	.152	Elastic binder
.133	Tung.dev. stop piston low	.153	Cam press jacks
.134	Knit transfer piston up	.154	Lowering needles color 2 Lowering needles exit heel/toe
.135	Knit transfer piston down	.155	Ducking stitch cam feed 4
.136	Sock-in-work presence control rod	.156	Stitch cam feed 4 position A
.137	Cylinder knit pusher	.157	Stitch cam feed 4 position B
.138	Pickup piston out	.158	Ducking stitch cam feed 4 position 2
.139	Pickup piston in	.159	Sole splicing cam feed 4 position A
.160	Sole splicing cam feed 4 position B	.180	Stitch cam feed 3 position B
.161	Lycra binder 1	.181	Stitch cam lock, feed 3 or position 3
.162	Lycra binder 2	.182	Lowering needles color 3
.163	Lycra binder 3	.183	Lowering needles color 4
.164	Lycra binder 4	.184	Ducking stitch cam feed 2
.165	Lycra tensioner feed 4	.185	Stitch cam feed 2 position B
.166	Lycra tensioner feed 3	.186	Stitch cam feed 2 position A
.167	Lycra tensioner feed 2	.187	Position tucking cam feed 2 position B
.168	Ducking stitch cam feed 3 position 2	.188	Position tucking cam feed 2 position A
.169	Sole splicing cam feed 3 position B	.189	Terry lever half cylinder feed 4
.170	Sole splicing cam feed 3 position A	.190	Terry lever feed 4 or Sinkers extraction
.171	Ducking stitch cam feed 2 position 2	.191	Terry lever for rib feed 4
.172	Sole splicing cam feed 2 position B	.192	Change position Elastic yarnfinger feed 4
.173	Sole splicing cam feed 2 position A	.193	Command stop latches 3
.174	Jacks exctraction feed 4	.194	Terry lever for rib feed 3
.175	Jacks exctraction feed 3	.195	Terry lever feed 3 or Sinkers extraction
.176	Jacks exctraction feed 2	.196	Terry lever half cylinder feed 3
.177	Jacks exctraction feed 1	.197	Change position Elastic yarnfinger feed 3
.178	Ducking stitch cam feed 3	.198	Terry lever for rib feed 2
.179	Stitch cam feed 3 position A	.199	Terry lever feed 2 or Sinkers extraction
.200	Terry lever half cylinder feed 2	.220	Second Position yarnfinger 7 feed 2
.201	Exclusion knife feed 2 position 2	.221	Change position Elastic yarnfinger feed 2
.202	Exclusion knife feed 2	.222	Yarnfinger 1 feed 3
.203	Exclusion knife feed 1 position 2	.223	Yarnfinger 2 feed 3
.204	Exclusion knife feed 1	.224	Yarnfinger 3 feed 3
.205	Air blast clean cutter	.225	Yarnfinger 4 feed 3
.206	Regulation 2 finger 4 feed 1	.226	Yarnfinger 5 feed 3
.207	Yarnfinger 1 feed 2	.227	Yarnfinger 6 feed 3
.208	Yarnfinger 2 feed 2	.228	Yarnfinger 7 feed 3
.209	Yarnfinger 3 feed 2	.229	Second Position yarnfinger 1 feed 3
.210	Yarnfinger 4 feed 2	.230	Second Position yarnfinger 2 feed 3
.211	Yarnfinger 5 feed 2	.231	Second Position yarnfinger 3 feed 3
.212	Yarnfinger 6 feed 2	.232	Second Position yarnfinger 4 feed 3
.213	Yarnfinger 7 feed 2	.233	Second Position yarnfinger 5 feed 3
.214	Second Position yarnfinger 1 feed 2	.234	Second Position yarnfinger 6 feed 3
.215	Second Position yarnfinger 2 feed 2	.235	Second Position yarnfinger 7 feed 3
.216	Second Position yarnfinger 3 feed 2	.236	Yarnfinger 1 feed 4
.217	Second Position yarnfinger 4 feed 2	.237	Yarnfinger 2 feed 4
.218	Second Position yarnfinger 5 feed 2	.238	Yarnfinger 3 feed 4
.219	Second Position yarnfinger 6 feed 2	.239	Yarnfinger 4 feed 4

msg = Message (43. …   / 44. …   ).

msg   Solenoid valve

.240 Yarnfinger 5 feed 4
.241 Yarnfinger 6 feed 4
.242 Yarnfinger 7 feed 4
.243 Second Position yarnfinger 1 feed 4
.244 Second Position yarnfinger 2 feed 4
.245 Second Position yarnfinger 3 feed 4
.246 Second Position yarnfinger 4 feed 4
.247 Second Position yarnfinger 5 feed 4
.248 Second Position yarnfinger 6 feed 4
.249 Second Position yarnfinger 7 feed 4
.250 Elastic trapper3
.251 Auxiliary knife
.252 Stop toe jack 2
.253 Welt release needle lowering cam pos. A
.254 Welt release needle lowering cam pos. B
.255 Cam latch opener welt clearing pos. A
.256 Cam latch opener welt clearing pos. B
.257 Lower needles color 5
.258 Stitch cam lock, feed 2 or position 3
.259 Clearing cam feed 2 pos. A

.280 Yarnfinger 3 color 1 feed 1
.281 Yarnfinger 2 color 1 feed 1
.282 Yarnfinger 1 color 1 feed 1
.283 Yarnfinger 3 color 2 feed 1
.284 Yarnfinger 2 color 2 feed 1
.285 Yarnfinger 1 color 2 feed 1
.286 Yarnfinger 3 color 3 feed 1
.287 Yarnfinger 2 color 3 feed 1
.288 Yarnfinger 1 color 3 feed 1
.289 Yarnfinger 3 color 1 feed 2
.290 Yarnfinger 2 color 1 feed 2
.291 Yarnfinger 1 color 1 feed 2
.292 Yarnfinger 3 color 2 feed 2
.293 Yarnfinger 2 color 2 feed 2
.294 Yarnfinger 1 color 2 feed 2
.295 Yarnfinger 3 color 3 feed 2
.296 Yarnfinger 2 color 3 feed 2
.297 Yarnfinger 1 color 3 feed 2
.298 Second Position Finger 8 Feed 2
.299 Yarnfinger 8 feed 2

.320 Jack removal cam, elastic
.321 Jack removal cam, elastic 2
.322 Small jack-raising cam, colour3, feed2
.323 Sole splicing cam feed 2
.324 Command stop latches 4
.325 Double welt mesh-push blower
.326 seamer 2 inspection light
.327 Turning device pipe rotating piston
.328 Sock-presence photocamera
.329 Stop jack breakage 1
.330 Stop jack breakage 3
.331 Clearing cam, feed 1 for filet pos. A
.332 Clearing cam, feed 1 for filet pos. B
.333 Clearing cam, feed 2 for filet pos. A
.334 Clearing cam, feed 2 for filet pos. B
.335 Small jack-raising cam, tuck, feed 1 posn. A
.336 Small jack-raising cam, tuck, feed 1 posn. B
.337 Yarnfinger 1 elastic 1
.338 Yarnfinger 2 elastic 2
.339 Gear lubricator
.360 Third adjustment yarn finger 1 elastic 2
.361 Stitch cam feed 1

msg   Solenoid valve

.260 Clearing cam feed 2 pos. B
.261 Cam released for pattern pos. A
.262 Cam released for pattern pos. B
.263 Sinker extraction - feed 2, position 2
.264 Sinker extraction - feed 2
.265 Eliminate jacks feed 2
.266 Central cam
.267 Machine inspection lamp
.268 Air blast cuff
.269 Additional spandex tensioner 1
.270 Additional spandex tensioner 2
.271 Remove heel return jacks
.272 Heel return small jack raiser
.273 Feed 1 selectors level
.274 Elastic selectors level
.275 Selectors protection, feed 1
.276 Pattern drum unit 9 retreat
.277 Heel return needle leveller
.278 Heel return sinker extraction
.279 Yarnfinger adjustment, elastic 2

.300 Second position Elastic yarnfinger feed 2
.301 Elastic yarnfinger feed 2
.302 Spandex trapper 2, position A
.303 Spandex trapper 2, position B
.304 Trapper, elastic 2, pos. 2
.305 Heel return sinker extraction pos. 1
.306 Heel return sinker extraction pos. 2
.307 Trapper elastic 1, pos. 2
.308 Sinker extraction, elastic 2 pos. 1
.309 Sinker extraction, elastic 2 pos. 2
.310 Sinker extraction, elastic 1 pos. 1
.311 Sinker extraction, elastic 1, pos. 2
.312 Suction hood cleaning blower
.313 Raise medium jacks 4 for Sole Liner style
.314 Small jack-raising cam, colour 3, feed 1
.315 Lowering needles cam end of heel 2
.316 Lowering needles cam, elastic 2 pos. A
.317 Lowering needles cam, elastic 2 pos. B
.318 Lowering needles cam, colour 2, feed 1
.319 Lowering needles cam, colour 2, feed 2

.340 Second position yarnfinger 1 elastic 1
.341 Second position yarnfinger 1 elastic 2
.342 Heel Toe take-up 7
.343 Heel Toe take-up 8
.344 Heel Toe take-up 9
.345 Change position Elastic yarnfinger feed 2
.346 SHORT-CIRCUIT output %d bar %d Dream sock ejection assist
.347 Lowering needles color 6
.348 Cam rise needles color 6
.349 Selection pin cleaning blower
.350 Intermediate jack-raising cam, colour 1
.351 Intermediate heel return jack-raising cam
.352 Lowering needles color 1
.353 Intermediate heel forward jack-raising cam
.354 Heel forward needle-raising cam
.355 Heel return dipping stitch cam, position 2
.356 Heel return dipping stitch cam
.357 Heal return plaited sinker push lever
.358 Plaited sinker push lever, feed 1
.359 Third adjustment yarn finger 1 elastic 1
.362 Tube opening conveys the sock from the cylinder
.363 Internal tube position 0

msg = Message (43. …   / 44. …   ).

	GL544 , GK544						
msg	**Ev**	**msg**	**Ev**	**msg**	**Ev**	**msg**	**Ev**
.0	11.2	.20	15.6	.40	3.5	.60	4.6
.1	6.1	.21	14.6	.41	2.7	.61	6.4
.2	5.8	.22	16.2	.42	3.4	.62	5.2
.3	6.2	.23	1.4	.43	3.6	.63	12.5
.4	6.3	.26	9.8	.46	3.7	.64	4.8
.5	16.1	.27	1.8	.47	4.3	.65	5.1
.6	I_BIS.2	.28	15.8	.48	6.5	.68	4.1
.7	I_BIS.1	.29	15.7	.49	15.5	.69	4.2
.8	7.2	.30	11.1	.50	15.4	.70	4.4
.9	7.1	.31	14.7	.51	I_BIS.5	.71	4.5
.10	I.1	.32	2.1	.52	I_BIS.6	.74	5.7
.13	8.1	.33	2.2	.53	I_BIS.7	.75	3.8
.14	I_BIS.3	.34	2.3	.54	I_BIS.8	.84	26.8
.15	8.2	.35	2.4	.55	1.2	.85	26.6
.16	2.5	.36	10.2	.56	1.3	.86	26.4
.17	14.1	.37	10.1	.57	1.6	.87	26.2
.18	2.6	.38	2.8	.58	1.5	.88	25.8
.19	11.5	.39	3.1	.59	16.5	.89	25.6
.90	25.4	.154	5.3	.172	10.7	.190	13.5
.91	25.2	.155	5.4	.173	10.8	.191	13.6
.92	23.2	.156	5.5	.174	11.3	.192	13.7
.93	26.7	.157	5.6	.175	11.4	.193	13.8
.94	26.5	.158	6.6	.176	11.6	.194	14.2
.95	26.3	.159	6.7	.177	11.7	.195	14.3
.96	26.1	.160	6.8	.178	11.8	.196	14.4
.97	25.7	.161	7.3	.179	12.1	.197	14.5
.98	25.5	.162	7.4	.180	12.2	.198	14.8
.99	25.3	.163	7.5	.181	12.3	.199	15.1
.100	25.1	.164	7.6	.182	12.4	.200	15.2
.101	23.1	.165	9.5	.183	12.6	.201	16.3
.102	3.2	.166	9.6	.184	12.7	.202	16.4
.105	29.2	.167	9.7	.185	12.8	.203	16.6
.106	29.1	.168	10.3	.186	13.1	.204	16.7
.107	27.2	.169	10.4	.187	13.2	.205	16.8
.152	1.1	.170	10.5	.188	13.3	.206	3.3
.153	1.7	.171	10.6	.189	13.4	.207	24.8
.208	24.6	.227	29.6	.245	28.3		
.209	24.4	.228	29.4	.246	28.1		
.210	24.2	.229	30.7	.247	27.7		
.211	23.8	.230	30.5	.248	27.5		
.212	23.6	.231	30.3	.249	27.3		
.213	23.4	.232	30.1	.250	7.7		
.214	24.7	.233	29.7	.267	I.2		
.215	24.5	.234	29.5	.269	9.4		
.216	24.3	.235	29.3	.325	7.8		
.217	24.1	.236	28.8	.339	4.7		
.218	23.7	.237	28.6				
.219	23.5	.238	28.4				
.220	23.3	.239	28.2				
.221	15.3	.240	27.8				
.222	30.8	.241	27.6				
.223	30.6	.242	27.4				
.224	30.4	.243	28.7				
.225	30.2	.244	28.5				

msg = Message (43. … / 44. …).

Ev = Solenoid valve
The first number expresses: Solenoid valves bar (number of the board).
The second digit shows: the position of the solenoid valve .

GL544CTE , GK544CTE

msg	Ev	msg	Ev	msg	Ev	msg	Ev
.0	11.2	.20	15.6	.40	3.5	.60	4.8
.1	6.2	.21	14.6	.41	2.7	.61	6.8
.2	6.1	.22	16.2	.42	3.4	.62	5.3
.3	6.3	.23	1.4	.43	3.6	.63	12.5
.4	6.4	.26	9.8	.46	3.7	.64	5.1
.5	16.1	.27	1.8	.47	4.3	.65	5.2
.6	I_BIS.2	.28	15.8	.48	7.4	.68	4.1
.7	I_BIS.1	.29	15.7	.49	15.5	.69	4.2
.8	8.2	.30	11.1	.50	15.4	.70	4.6
.9	8.1	.31	14.7	.51	I_BIS.5	.71	4.7
.10	I.1	.32	2.1	.52	I_BIS.6	.74	5.8
.13	7.7	.33	2.2	.53	I_BIS.7	.75	3.8
.14	I_BIS.3	.34	2.3	.54	I_BIS.8	.84	26.8
.15	8.8	.35	2.4	.55	1.2	.85	26.6
.16	2.5	.36	10.2	.56	1.3	.86	26.4
.17	14.1	.37	10.1	.57	1.6	.87	26.2
.18	2.6	.38	2.8	.58	1.5	.88	25.8
.19	11.5	.39	3.1	.59	16.5	.89	25.6
.90	25.4	.128	6.6	.147	33.5	.166	9.6
.91	25.2	.129	6.7	.148	33.4	.167	9.7
.92	23.2	.130	6.5	.149	33.7	.168	10.3
.93	26.7	.131	31.5	.150	33.8	.169	10.4
.94	26.5	.133	33.6	.151	34.8	.170	10.5
.95	26.3	.134	31.8	.152	1.1	.171	10.6
.96	26.1	.135	32.1	.154	5.4	.172	10.7
.97	25.7	.136	32.2	.155	5.5	.173	10.8
.98	25.5	.137	32.3	.156	5.6	.174	11.3
.99	25.3	.138	32.4	.157	5.7	.175	11.4
.100	25.1	.139	32.5	.158	7.1	.176	11.6
.101	23.1	.140	32.6	.159	7.2	.177	11.7
.102	3.2	.141	32.7	.160	7.3	.178	11.8
.105	29.2	.142	32.8	.161	8.3	.179	12.1
.106	29.1	.143	33.1	.162	8.4	.180	12.2
.107	27.2	.144	33.2	.163	8.5	.181	12.3
.126	1.7	.145	33.3	.164	8.6	.182	12.4
.127	4.4	.146	31.1/2	.165	9.5	.183	12.6
.184	12.7	.202	16.4	.220	23.3	.238	28.4
.185	12.8	.203	16.6	.221	15.3	.239	28.2
.186	13.1	.204	16.7	.222	30.8	.240	27.8
.187	13.2	.205	16.8	.223	30.6	.241	27.6
.188	13.3	.206	3.3	.224	30.4	.242	27.4
.189	13.4	.207	24.8	.225	30.2	.243	28.7
.190	13.5	.208	24.6	.226	29.8	.244	28.5
.191	13.6	.209	24.4	.227	29.6	.245	28.3
.192	13.7	.210	24.2	.228	29.4	.246	28.1
.193	13.8	.211	23.8	.229	30.7	.247	27.7
.194	14.2	.212	23.6	.230	30.5	.248	27.5
.195	14.3	.213	23.4	.231	30.3	.249	27.3
.196	14.4	.214	24.7	.232	30.1	.250	8.7
.197	14.5	.215	24.5	.233	29.7	.266	4.5
.198	14.8	.216	24.3	.234	29.5	.267	I.2
.199	15.1	.217	24.1	.235	29.3	.268	31.3
.200	15.2	.218	23.7	.236	28.8	.269	9.4
.201	16.3	.219	23.5	.237	28.6	.325	7.8
.326	I.3	.327	31.6	.339	7.6	.346	9.3
						.363	31.4

msg = Message (43. … / 44. …).

Ev = Solenoid valve
The first number expresses: Solenoid valves bar (number of the board).
The second digit shows: the position of the solenoid valve .

GL615 , GK615							
msg	Ev	msg	Ev	msg	Ev	msg	Ev
.0	11.8	.20	15.4	.38	16.5	.56	19.7
.1	11.7	.21	14.2	.39	16.4	.57	19.6
.2	11.6	.22	19.2	.40	16.2	.58	19.5
.3	8.8	.23	18.1	.41	16.6	.59	19.4
.4	17.8	.24	18.8	.42	16.3	.60	13.5
.5	19.1	.25	18.7	.43	16.1	.61	15.5
.6	I_BIS.2	.26	18.4	.44	15.3	.62	12.6
.7	I_BIS.1	.27	17.3	.45	15.2	.63	13.4
.8	10.7	.28	18.6	.46	16.7	.64	12.8
.9	10.8	.29	18.5	.47	14.6	.65	12.7
.10	I.1	.30	19.3	.48	14.5	.66	13.1
.13	10.4	.31	14.1	.49	17.2	.67	12.4
.14	I_BIS.3	.32	17.7	.50	17.1	.68	14.8
.15	10.3	.33	17.6	.51	I_BIS.5	.69	14.7
.16	15.8	.34	17.5	.52	I_BIS.6	.70	13.7
.17	15.1	.35	17.4	.53	I_BIS.7	.71	13.6
.18	15.7	.36	18.3	.54	I_BIS.8	.72	13.3
.19	11.1	.37	18.2	.55	19.8	.73	13.2
.74	12.2	.92	28.6	.110	25.3		
.75	12.3	.93	28.8	.111	26.8		
.76	13.8	.94	28.3	.112	26.7		
.77	14.4	.95	27.4	.113	26.6		
.78	14.3	.96	27.5	.114	26.5		
.79	11.4	.97	27.6	.115	26.4		
.80	11.3	.98	28.1	.116	26.3		
.81	11.2	.99	27.2	.117	23.8		
.82	12.5	.100	25.1	.118	23.7		
.83	12.1	.101	28.4	.119	23.6		
.84	27.1	.102	15.6	.124	16.8		
.85	28.5	.103	23.3	.125	23.4		
.86	28.7	.104	23.5	.267	I.2		
.87	28.2	.105	25.8	.269	10.6		
.88	27.8	.106	25.7	.270	10.5		
.89	27.7	.107	25.6	.325	10.1		
.90	27.3	.108	25.5	.339	11.5		
.91	25.2	.109	25.4				

msg = Message (43. … / 44. …).

Ev = Solenoid valve
The first number expresses: Solenoid valves bar (number of the board).
The second digit shows: the position of the solenoid valve .

GL615CTE , GK615CTE

msg	Ev	msg	Ev	msg	Ev	msg	Ev
.0	10.5	.20	15.3	.38	16.7	.56	19.7
.1	10.7	.21	14.2	.39	16.6	.57	19.6
.2	10.6	.22	19.2	.40	16.4	.58	19.5
.3	11.1	.23	18.3	.41	16.8	.59	19.3
.4	17.2	.24	18.2	.42	16.5	.60	12.8
.5	19.1	.25	18.1	.43	16.3	.61	15.5
.6	I_BIS.2	.26	18.6	.44	15.2	.62	12.5
.7	I_BIS.1	.27	17.4	.45	15.1	.63	13.3
.8	11.6	.28	18.5	.46	16.2	.64	12.7
.9	11.7	.29	18.4	.47	14.6	.65	12.6
.10	I.1	.30	19.4	.48	14.5	.66	12.4
.13	9.6	.31	14.1	.49	17.1	.67	12.3
.14	I_BIS.3	.32	17.8	.50	15.4	.68	14.8
.15	9.5	.33	17.7	.51	I_BIS.5	.69	14.7
.16	15.8	.34	17.6	.52	I_BIS.6	.70	13.6
.17	14.3	.35	17.5	.53	I_BIS.7	.71	13.5
.18	15.7	.36	18.8	.54	I_BIS.8	.72	13.2
.19	10.1	.37	18.7	.55	19.8	.73	13.1
.74	12.1	.92	28.6	.110	25.3	.134	31.8
.75	12.2	.93	28.8	.111	26.8	.135	32.1
.76	13.8	.94	28.3	.112	26.7	.136	32.2
.77	14.4	.95	27.4	.113	26.6	.137	32.3
.78	13.4	.96	27.5	.114	26.5	.138	32.4
.79	11.5	.97	27.6	.115	26.4	.139	32.5
.80	11.4	.98	28.1	.116	26.3	.140	32.6
.81	11.3	.99	27.2	.117	23.8	.141	32.7
.82	10.8	.100	25.1	.118	23.7	.142	32.8
.83	11.2	.101	28.4	.119	23.6	.143	33.1
.84	27.1	.102	15.6	.125	23.4	.144	33.2
.85	28.5	.103	23.3	.126	17.3	.145	33.3
.86	28.7	.104	23.5	.127	13.7	.146	31.1/2
.87	28.2	.105	25.8	.128	10.3	.147	33.5
.88	27.8	.106	25.7	.129	10.2	.148	33.4
.89	27.7	.107	25.6	.130	10.4	.149	33.7
.90	27.3	.108	25.5	.131	31.5	.150	33.8
.91	25.2	.109	25.4	.133	33.6	.151	34.8
.267	I.2	.268	31.3	.269	9.8	.270	9.7
.325	9.1	.326	I.3	.327	31.6	.339	11.8
.346	9.4	.363	31.4				

msg = Message (43. … / 44. …).

Ev = Solenoid valve
The first number expresses: Solenoid valves bar (number of the board).
The second digit shows: the position of the solenoid valve .

GL616 , GK616

msg	Ev	msg	Ev	msg	Ev	msg	Ev
.0	11.8	.20	15.4	.38	16.5	.56	19.7
.1	11.7	.21	14.2	.39	16.4	.57	19.6
.2	11.6	.22	19.2	.40	16.2	.58	19.5
.3	11.5	.23	18.1	.41	16.6	.59	19.4
.4	17.8	.24	18.8	.42	16.3	.60	13.5
.5	19.1	.25	18.7	.43	16.1	.61	15.5
.6	I_BIS.2	.26	18.4	.44	15.3	.62	12.6
.7	I_BIS.1	.27	17.3	.45	15.2	.63	13.4
.8	10.7	.28	18.6	.46	16.7	.64	12.8
.9	10.8	.29	18.5	.47	14.6	.65	12.7
.10	I.1	.30	19.3	.48	14.5	.66	13.1
.13	10.4	.31	14.1	.49	17.2	.67	12.4
.14	I_BIS.3	.32	17.7	.50	17.1	.68	14.8
.15	10.3	.33	17.6	.51	I_BIS.5	.69	14.7
.16	15.8	.34	17.5	.52	I_BIS.6	.70	13.7
.17	15.1	.35	17.4	.53	I_BIS.7	.71	13.6
.18	15.7	.36	18.3	.54	I_BIS.8	.72	13.3
.19	11.1	.37	18.2	.55	19.8	.73	13.2
.74	12.2	.92	28.6	.110	25.3	.325	10.1
.75	12.3	.93	28.8	.111	26.8	.339	10.2
.76	13.8	.94	28.3	.112	26.7		
.77	14.4	.95	27.4	.113	26.6		
.78	14.3	.96	27.5	.114	26.5		
.79	11.4	.97	27.6	.115	26.4		
.80	11.3	.98	28.1	.116	26.3		
.81	11.2	.99	27.2	.117	23.8		
.82	12.5	.100	25.1	.118	23.7		
.83	12.1	.101	28.4	.119	23.6		
.84	27.1	.102	15.6	.120	24.3		
.85	28.5	.103	23.3	.121	24.2		
.86	28.7	.104	23.5	.122	24.1		
.87	28.2	.105	25.8	.124	16.8		
.88	27.8	.106	25.7	.125	23.4		
.89	27.7	.107	25.6	.267	I.2		
.90	27.3	.108	25.5	.269	10.6		
.91	25.2	.109	25.4	.270	10.5		

msg = Message (43. … / 44. …).

Ev = Solenoid valve
The first number expresses: Solenoid valves bar (number of the board).
The second digit shows: the position of the solenoid valve .

msg	Ev	msg	Ev	msg	Ev	msg	Ev
				GL616CTE , GK616CTE			
.0	10.5	.20	15.3	.38	16.7	.56	19.7
.1	10.7	.21	14.2	.39	16.6	.57	19.6
.2	10.6	.22	19.2	.40	16.4	.58	19.5
.3	11.1	.23	18.3	.41	16.8	.59	19.3
.4	17.2	.24	18.2	.42	16.5	.60	12.8
.5	19.1	.25	18.1	.43	16.3	.61	15.5
.6	I_BIS.2	.26	18.6	.44	15.2	.62	12.5
.7	I_BIS.1	.27	17.4	.45	15.1	.63	13.3
.8	11.6	.28	18.5	.46	16.2	.64	12.7
.9	11.7	.29	18.4	.47	14.6	.65	12.6
.10	I.1	.30	19.4	.48	14.5	.66	12.4
.13	9.6	.31	14.1	.49	17.1	.67	12.3
.14	I_BIS.3	.32	17.8	.50	15.4	.68	14.8
.15	8.8	.33	17.7	.51	I_BIS.5	.69	14.7
.16	15.8	.34	17.6	.52	I_BIS.6	.70	13.6
.17	14.3	.35	17.5	.53	I_BIS.7	.71	13.5
.18	15.7	.36	18.8	.54	I_BIS.8	.72	13.2
.19	10.1	.37	18.7	.55	19.8	.73	13.1
.74	12.1	.92	28.6	.110	25.3	.130	10.4
.75	12.2	.93	28.8	.111	26.8	.131	31.5
.76	13.8	.94	28.3	.112	26.7	.133	33.6
.77	14.4	.95	27.4	.113	26.6	.134	31.8
.78	13.4	.96	27.5	.114	26.5	.135	32.1
.79	11.5	.97	27.6	.115	26.4	.136	32.2
.80	11.4	.98	28.1	.116	26.3	.137	32.3
.81	11.3	.99	27.2	.117	23.8	.138	32.4
.82	10.8	.100	25.1	.118	23.7	.139	32.5
.83	11.2	.101	28.4	.119	23.6	.140	32.6
.84	27.1	.102	15.6	.120	24.3	.141	32.7
.85	28.5	.103	23.3	.121	24.2	.142	32.8
.86	28.7	.104	23.5	.122	24.1	.143	33.1
.87	28.2	.105	25.8	.125	23.4	.144	33.2
.88	27.8	.106	25.7	.126	17.3	.145	33.3
.89	27.7	.107	25.6	.127	13.7	.146	31.1/2
.90	27.3	.108	25.5	.128	10.3	.147	33.5
.91	25.2	.109	25.4	.129	10.2	.148	33.4
.149	33.7	.268	31.3	.326	I.3	.363	31.4
.150	33.8	.269	9.8	.327	31.6		
.151	34.8	.270	9.7	.339	11.8		
.267	I.2	.325	9.1	.346	9.5		

msg = Message (43. … / 44. …).

Ev = Solenoid valve
The first number expresses: Solenoid valves bar (number of the board).
The second digit shows: the position of the solenoid valve .

GL616D , GK616D

msg	Ev	msg	Ev	msg	Ev	msg	Ev
_.0:	11.8	_.20:	15.4	_.44:	15.3	_.63:	13.4
_.1:	11.7	_.21:	14.2	_.45:	15.2	_.64:	12.8
_.2:	11.6	_.22:	19.2	_.47:	14.6	_.65:	12.7
_.3:	11.5	_.23:	18.1	_.48:	14.5	_.66:	13.1
_.4:	17.8	_.24:	18.8	_.49:	17.2	_.67:	12.4
_.5:	19.1	_.25:	18.7	_.50:	17.1	_.68:	14.8
_.6:	I_BIS.2	_.26:	18.4	_.51:	I_BIS.5	_.69:	14.7
_.7:	I_BIS.1	_.27:	17.3	_.52:	I_BIS.6	_.70:	13.7
_.8:	10.7	_.28:	18.6	_.53:	I_BIS.7	_.71:	13.6
_.9:	10.8	_.29:	18.5	_.54:	I_BIS.8	_.72:	13.3
_.10:	I.1	_.30:	19.3	_.55:	19.8	_.73:	13.2
_.13:	10.4	_.31:	14.1	_.56:	19.7	_.74:	12.2
_.14:	I_BIS.3	_.32:	17.7	_.57:	19.6	_.75:	12.3
_.15:	10.3	_.33:	17.6	_.58:	19.5	_.76:	13.8
_.16:	15.8	_.34:	17.5	_.59:	19.4	_.77:	14.4
_.17:	15.1	_.35:	17.4	_.60:	13.5	_.78:	14.3
_.18:	15.7	_.36:	18.3	_.61:	15.5	_.79:	11.4
_.19:	11.1	_.37:	18.2	_.62:	12.6	_.80:	11.3
_.81:	11.2	_.99:	27.2	_.117:	23.8		
_.82:	12.5	_.100:	25.1	_.118:	23.7		
_.83:	12.1	_.101:	28.4	_.119:	23.6		
_.84:	27.1	_.102:	15.6	_.120:	24.3		
_.85:	28.5	_.103:	23.3	_.121:	24.2		
_.86:	28.7	_.104:	23.5	_.122:	24.1		
_.87:	28.2	_.105:	25.8	_.125:	23.4		
_.88:	27.8	_.106:	25.7	_.267:	I.2		
_.89:	27.7	_.107:	25.6	_.269:	10.6		
_.90:	27.3	_.108:	25.5	_.270:	10.5		
_.91:	25.2	_.109:	25.4	_.325:	10.1		
_.92:	28.6	_.110:	25.3	_.339:	10.2		
_.93:	28.8	_.111:	26.8				
_.94:	28.3	_.112:	26.7				
_.95:	27.4	_.113:	26.6				
_.96:	27.5	_.114:	26.5				
_.97:	27.6	_.115:	26.4				
_.98:	28.1	_.116:	26.3				

msg = Message (43. … / 44. …).

Ev = Solenoid valve
The first number expresses: Solenoid valves bar (number of the board).
The second digit shows: the position of the solenoid valve .

GL616DCTE , GK616DCTE

msg	Ev	msg	Ev	msg	Ev	msg	Ev
_.0:	10.5	_.20:	15.3	_.44:	15.2	_.63:	13.3
_.1:	10.7	_.21:	14.2	_.45:	15.1	_.64:	12.7
_.2:	10.6	_.22:	19.2	_.47:	14.6	_.65:	12.6
_.3:	11.1	_.23:	18.3	_.48:	14.5	_.66:	12.4
_.4:	17.2	_.24:	18.2	_.49:	17.1	_.67:	12.3
_.5:	19.1	_.25:	18.1	_.50:	15.4	_.68:	14.8
_.6:	I_BIS.2	_.26:	18.6	_.51:	I_BIS.5	_.69:	14.7
_.7:	I_BIS.1	_.27:	17.4	_.52:	I_BIS.6	_.70:	13.6
_.8:	11.6	_.28:	18.5	_.53:	I_BIS.7	_.71:	13.5
_.9:	11.7	_.29:	18.4	_.54:	I_BIS.8	_.72:	13.2
_.10:	I.1	_.30:	19.4	_.55:	19.8	_.73:	13.1
_.13:	9.6	_.31:	14.1	_.56:	19.7	_.74:	12.1
_.14:	I_BIS.3	_.32:	17.8	_.57:	19.6	_.75:	12.2
_.15:	8.8	_.33:	17.7	_.58:	19.5	_.76:	13.8
_.16:	15.8	_.34:	17.6	_.59:	19.3	_.77:	14.4
_.17:	14.3	_.35:	17.5	_.60:	12.8	_.78:	13.4
_.18:	15.7	_.36:	18.8	_.61:	15.5	_.79:	11.5
_.19:	10.1	_.37:	18.7	_.62:	12.5	_.80:	11.4
_.81:	11.3	_.99:	27.2	_.117:	23.8	_.138:	32.4
_.82:	10.8	_.100:	25.1	_.118:	23.7	_.139:	32.5
_.83:	11.2	_.101:	28.4	_.119:	23.6	_.140:	32.6
_.84:	27.1	_.102:	15.6	_.120:	24.3	_.141:	32.7
_.85:	28.5	_.103:	23.3	_.121:	24.2	_.142:	32.8
_.86:	28.7	_.104:	23.5	_.122:	24.1	_.143:	33.1
_.87:	28.2	_.105:	25.8	_.125:	23.4	_.144:	33.2
_.88:	27.8	_.106:	25.7	_.126:	17.3	_.145:	33.3
_.89:	27.7	_.107:	25.6	_.127:	13.7	_.146:	31.1/2
_.90:	27.3	_.108:	25.5	_.128:	10.3	_.147:	33.5
_.91:	25.2	_.109:	25.4	_.129:	10.2	_.148:	33.4
_.92:	28.6	_.110:	25.3	_.130:	10.4	_.149:	33.7
_.93:	28.8	_.111:	26.8	_.131:	31.5	_.150:	33.8
_.94:	28.3	_.112:	26.7	_.133:	33.6	_.151:	34.8
_.95:	27.4	_.113:	26.6	_.134:	31.8	_.267:	I.2
_.96:	27.5	_.114:	26.5	_.135:	32.1	_.268:	31.3
_.97:	27.6	_.115:	26.4	_.136:	32.2	_.269:	9.8
_.98:	28.1	_.116:	26.3	_.137:	32.3	_.270:	9.7
_.325:	9.1	_.326:	I.3	_.327:	31.6	_.339:	11.8
_.346:	9.5	_.363:	31.4				

msg = Message (43. … / 44. …).

Ev = Solenoid valve
The first number expresses: Solenoid valves bar (number of the board).
The second digit shows: the position of the solenoid valve .

GL616DF3CTE , GK616DF3CTE

msg	Ev	msg	Ev	msg	Ev	msg	Ev
_.0:	11.6	_.20:	15.3	_.44:	15.2	_.65:	13.7
_.1:	11.8	_.21:	14.3	_.45:	15.1	_.66:	11.3
_.2:	11.7	_.22:	19.2	_.49:	16.3	_.67:	11.2
_.3:	11.5	_.23:	19.1	_.50:	16.2	_.68:	15.7
_.4:	16.7	_.24:	17.2	_.51:	I_BIS.5	_.69:	15.6
_.5:	16.8	_.25:	17.1	_.52:	I_BIS.6	_.70:	14.7
_.6:	I_BIS.2	_.26:	17.6	_.53:	I_BIS.7	_.71:	14.6
_.7:	I_BIS.1	_.27:	18.1	_.54:	I_BIS.8	_.72:	13.1
_.8:	10.7	_.28:	18.7	_.55:	19.8	_.73:	11.4
_.9:	10.8	_.29:	18.6	_.56:	19.7	_.74:	10.3
_.10:	I.1	_.30:	19.4	_.57:	19.6	_.75:	11.1
_.13:	9.1	_.31:	14.1	_.58:	19.5	_.76:	15.5
_.14:	I_BIS.3	_.32:	18.5	_.59:	19.3	_.77:	13.4
_.15:	8.7	_.33:	18.4	_.60:	14.5	_.78:	13.3
_.16:	16.6	_.34:	18.3	_.61:	15.8	_.82:	12.4
_.17:	14.4	_.35:	18.2	_.62:	13.5	_.83:	12_BIS.2
_.18:	16.5	_.36:	17.8	_.63:	13.2	_.84:	27.1
_.19:	10.2	_.37:	17.7	_.64:	13.8	_.85:	28.5
_.86:	28.7	_.104:	23.5	_.122:	24.1	_.143:	33.1
_.87:	28.2	_.105:	25.8	_.125:	16.1	_.144:	33.2
_.88:	27.8	_.106:	25.7	_.126:	18.8	_.145:	33.3
_.89:	27.7	_.107:	25.6	_.127:	14.8	_.146:	31.2
_.90:	27.3	_.108:	25.5	_.128:	10.5	_.147:	33.5
_.91:	25.2	_.109:	25.4	_.129:	10.6	_.148:	33.4
_.92:	28.6	_.110:	25.3	_.130:	10.4	_.149:	33.7
_.93:	28.8	_.111:	26.8	_.131:	31.5	_.150:	33.8
_.94:	28.3	_.112:	26.7	_.133:	33.6	_.151:	34.8
_.95:	27.4	_.113:	26.6	_.134:	31.8	_.252:	10.1
_.96:	27.5	_.114:	26.5	_.135:	32.1	_.267:	I.2
_.97:	27.6	_.115:	26.4	_.136:	32.2	_.268:	31.3
_.98:	28.1	_.116:	26.3	_.137:	32.3	_.269:	17.4
_.99:	27.2	_.117:	23.8	_.138:	32.4	_.270:	17.3
_.100:	25.1	_.118:	23.7	_.139:	32.5	_.271:	12.2
_.101:	28.4	_.119:	23.6	_.140:	32.6	_.272:	12.6
_.102:	16.4	_.120:	24.3	_.141:	32.7	_.273:	12.8
_.103:	23.3	_.121:	24.2	_.142:	32.8	_.274:	12_BIS.4
_.275:	12_BIS.6	_.276:	12_BIS.8	_.277:	13.6	_.278:	14.2
_.279:	15.4	_.325:	17.5	_.326:	I.3	_.327:	31.6
_.339:	9.2	_.346:	9.3	_.363:	31.4		

msg = Message (43. … / 44. …).

Ev = Solenoid valve
The first number expresses: Solenoid valves bar (number of the board).
The second digit shows: the position of the solenoid valve .

On this model: **The 12th bar is for bistable solenoid valves.**
Since the bistable electric valve requires two commands, its position is indicated only by even numbers.
Furthermore …
For hardware/software architecture reasons, only 8 commands per "bar" can be managed.
Therefore:
The bar is divided virtually into two: bar n and bar n-bis.
The first 4 solenoid valves belong to the "bis" bar.
(The numbering takes place starting from the unfixed end of the support.)
Therefore …
The first EV is indicated as 12_BIS.2.
The last EV is indicated as 12.8.
[The I bar (I and I_Bis) is not a support for bistable EVs, but an internal board for 16 outputs.]

GL625 , GK625

msg	Ev	msg	Ev	msg	Ev	msg	Ev
_.0:	10.4	_.20:	15.6	_.39:	4.2	_.57:	1.3
_.1:	10.3	_.21:	15.3	_.40:	4.4	_.58:	1.4
_.2:	6.4	_.22:	1.7	_.41:	3.8	_.59:	1.5
_.3:	10.5	_.24:	16.1	_.42:	4.3	_.60:	5.7
_.4:	3.2	_.25:	16.2	_.43:	4.5	_.61:	5.1
_.5:	1.8	_.26:	16.4	_.44:	15.5	_.62:	6.2
_.6:	I_BIS.2	_.27:	2.5	_.45:	15.4	_.63:	13.8
_.7:	I_BIS.1	_.28:	16.8	_.46:	3.7	_.64:	5.8
_.8:	10.1	_.29:	16.7	_.47:	5.2	_.65:	6.1
_.9:	10.2	_.30:	1.6	_.48:	5.3	_.68:	4.7
_.10:	I.1	_.31:	14.1	_.49:	15.7	_.69:	4.8
_.13:	7.1	_.32:	2.6	_.50:	15.8	_.70:	5.5
_.14:	I_BIS.3	_.33:	2.7	_.51:	I_BIS.5	_.71:	5.6
_.15:	17.7	_.34:	2.8	_.52:	I_BIS.6	_.72:	13.5
_.16:	3.4	_.35:	3.1	_.53:	I_BIS.7	_.73:	13.4
_.17:	14.3	_.36:	16.6	_.54:	I_BIS.8	_.74:	11.6
_.18:	3.5	_.37:	16.5	_.55:	1.1	_.75:	13.1
_.19:	10.7	_.38:	4.1	_.56:	1.2	_.76:	5.4
_.79:	4.6	_.97:	27.6	_.116:	26.3	_.208:	24.6
_.80:	11.3	_.98:	28.1	_.162:	2.3	_.209:	24.4
_.81:	11.2	_.99:	27.2	_.167:	16.3	_.210:	24.2
_.82:	6.3	_.100:	25.1	_.171:	12.3	_.211:	23.8
_.83:	10.8	_.101:	28.4	_.184:	12.4	_.212:	23.6
_.84:	27.1	_.102:	3.6	_.185:	12.5	_.214:	24.7
_.85:	28.5	_.104:	26.1	_.186:	12.6	_.215:	24.5
_.86:	28.7	_.105:	25.8	_.187:	13.6	_.216:	24.3
_.87:	28.2	_.106:	25.7	_.188:	13.7	_.217:	24.1
_.88:	27.8	_.107:	25.6	_.193:	14.2	_.218:	23.7
_.89:	27.7	_.108:	25.5	_.198:	14.4	_.219:	23.5
_.90:	27.3	_.109:	25.4	_.199:	14.5	_.221:	15.1
_.91:	25.2	_.110:	25.3	_.200:	14.6	_.251:	2.4
_.92:	28.6	_.111:	26.8	_.201:	15.2	_.252:	10.6
_.93:	28.8	_.112:	26.7	_.202:	3.3	_.253:	11.5
_.94:	28.3	_.113:	26.6	_.203:	2.2	_.254:	11.4
_.95:	27.4	_.114:	26.5	_.204:	2.1	_.255:	11.8
_.96:	27.5	_.115:	26.4	_.207:	24.8	_.256:	11.7
_.257:	12.1	_.258:	12.2	_.259:	12.8	_.260:	12.7
_.261:	13.3	_.262:	13.2	_.263:	14.7	_.264:	14.8
_.265:	11.1	_.267:	I.2	_.269:	6.5	_.270:	6.6
_.312:	7.8	_.325:	6.7	_.339:	6.8		

msg = Message (43. … / 44. …).

Ev = Solenoid valve
The first number expresses: Solenoid valves bar (number of the board).
The second digit shows: the position of the solenoid valve .

GL625CTE , GK625CTE

msg	Ev	msg	Ev	msg	Ev	msg	Ev
_.0:	10.5	_.20:	15.6	_.39:	4.3	_.57:	1.3
_.1:	10.4	_.21:	15.3	_.40:	4.5	_.58:	1.4
_.2:	6.8	_.22:	1.7	_.41:	4.1	_.59:	1.5
_.3:	10.6	_.24:	16.1	_.42:	4.4	_.60:	6.2
_.4:	3.3	_.25:	16.2	_.43:	4.6	_.61:	5.3
_.5:	1.8	_.26:	16.4	_.44:	15.5	_.62:	6.5
_.6:	I_BIS.2	_.27:	2.6	_.45:	15.4	_.63:	14.1
_.7:	I_BIS.1	_.28:	16.8	_.46:	3.8	_.64:	6.3
_.8:	7.2	_.29:	16.7	_.47:	5.4	_.65:	6.4
_.9:	7.1	_.30:	1.6	_.48:	5.5	_.68:	5.1
_.10:	I.1	_.31:	14.2	_.49:	15.7	_.69:	5.2
_.13:	7.5	_.32:	2.7	_.50:	15.8	_.70:	5.8
_.14:	I_BIS.3	_.33:	2.8	_.51:	I_BIS.5	_.71:	6.1
_.15:	17.7	_.34:	3.1	_.52:	I_BIS.6	_.72:	13.6
_.16:	3.5	_.35:	3.2	_.53:	I_BIS.7	_.73:	13.5
_.17:	14.4	_.36:	16.6	_.54:	I_BIS.8	_.74:	11.7
_.18:	3.6	_.37:	16.5	_.55:	1.1	_.75:	13.2
_.19:	10.8	_.38:	4.2	_.56:	1.2	_.76:	5.6
_.79:	4.8	_.97:	27.6	_.115:	26.4	_.143:	33.1
_.80:	11.4	_.98:	28.1	_.116:	26.3	_.144:	33.2
_.81:	11.3	_.99:	27.2	_.126:	2.3	_.145:	33.3
_.82:	6.6	_.100:	25.1	_.127:	5.7	_.146:	31.2
_.83:	11.1	_.101:	28.4	_.128:	10.1	_.147:	33.5
_.84:	27.1	_.102:	3.7	_.129:	10.3	_.148:	33.4
_.85:	28.5	_.103:	26.2	_.130:	10.2	_.149:	33.7
_.86:	28.7	_.104:	26.1	_.131:	31.5	_.150:	33.8
_.87:	28.2	_.105:	25.8	_.133:	33.6	_.151:	34.8
_.88:	27.8	_.106:	25.7	_.134:	31.8	_.162:	2.4
_.89:	27.7	_.107:	25.6	_.135:	32.1	_.167:	16.3
_.90:	27.3	_.108:	25.5	_.136:	32.2	_.171:	12.4
_.91:	25.2	_.109:	25.4	_.137:	32.3	_.184:	12.5
_.92:	28.6	_.110:	25.3	_.138:	32.4	_.185:	12.6
_.93:	28.8	_.111:	26.8	_.139:	32.5	_.186:	12.7
_.94:	28.3	_.112:	26.7	_.140:	32.6	_.187:	13.7
_.95:	27.4	_.113:	26.6	_.141:	32.7	_.188:	13.8
_.96:	27.5	_.114:	26.5	_.142:	32.8	_.193:	14.3
_.198:	14.5	_.219:	23.5	_.268:	31.3		
_.199:	14.6	_.221:	15.2	_.269:	7.3		
_.200:	14.7	_.251:	2.5	_.270:	7.4		
_.201:	4.7	_.252:	10.7	_.312:	7.8		
_.202:	3.4	_.253:	11.6	_.325:	6.7		
_.203:	2.2	_.254:	11.5	_.326:	I.3		
_.204:	2.1	_.255:	12.1	_.327:	31.6		
_.207:	24.8	_.256:	11.8	_.339:	7.7		
_.208:	24.6	_.257:	12.2	_.346:	7.6		
_.209:	24.4	_.258:	12.3	_.362:	8.8		
_.210:	24.2	_.259:	13.1	_.363:	31.4		
_.211:	23.8	_.260:	12.8				
_.212:	23.6	_.261:	13.4				
_.214:	24.7	_.262:	13.3				
_.215:	24.5	_.263:	14.8				
_.216:	24.3	_.264:	15.1				
_.217:	24.1	_.265:	11.2				
_.218:	23.7	_.267:	I.2				

msg = Message (43. … / 44. …).

Ev = Solenoid valve
The first number expresses: Solenoid valves bar (number of the board).
The second digit shows: the position of the solenoid valve .

msg	Ev	msg	Ev	msg	Ev	msg	Ev
_.0:	7.2	_.21:	15.5	_.39:	4.1	_.62:	4.7
_.1:	7.3	_.22:	16.8	_.40:	4.4	_.63:	14.1
_.2:	7.4	_.23:	1.5	_.41:	3.4	_.64:	6.1
_.3:	6.7	_.24:	2.5	_.42:	4.3	_.65:	6.2
_.4:	4.6	_.25:	2.6	_.43:	4.5	_.68:	5.3
_.5:	16.5	_.26:	2.3	_.49:	15.7	_.69:	5.4
_.6:	I_BIS.2	_.27:	3.8	_.50:	15.6	_.70:	5.6
_.7:	I_BIS.1	_.28:	16.4	_.51:	I_BIS.5	_.71:	5.7
_.8:	7.6	_.29:	16.3	_.52:	I_BIS.6	_.72:	13.2
_.9:	7.5	_.30:	6.8	_.53:	I_BIS.7	_.73:	13.1
_.10:	I.1	_.31:	14.6	_.54:	I_BIS.8	_.75:	13.6
_.13:	10.2	_.32:	1.7	_.55:	1.1	_.76:	5.5
_.14:	I_BIS.3	_.33:	1.8	_.56:	1.2	_.79:	13.5
_.15:	17.7	_.34:	3.6	_.57:	1.3	_.80:	10.5
_.16:	3.2	_.35:	3.7	_.58:	1.4	_.83:	11.4
_.17:	14.5	_.36:	2.1	_.59:	16.6	_.84:	25.1
_.18:	3.3	_.37:	2.2	_.60:	5.8	_.85:	26.5
_.20:	3.1	_.38:	3.5	_.61:	5.2	_.86:	26.7
_.87:	26.2	_.186:	12.1	_.218:	29.6	_.290:	28.7
_.88:	25.8	_.187:	13.3	_.219:	30.1	_.291:	28.8
_.89:	25.7	_.188:	13.4	_.220:	29.2	_.292:	28.3
_.90:	25.3	_.193:	14.4	_.259:	12.4	_.293:	28.4
_.91:	23.2	_.198:	14.7	_.260:	12.3	_.294:	28.5
_.92:	26.6	_.199:	14.8	_.265:	11.7	_.296:	28.1
_.93:	26.8	_.200:	15.3	_.267:	I.2	_.297:	28.2
_.94:	26.3	_.207:	29.1	_.269:	2.4	_.298:	27.1
_.95:	25.4	_.208:	30.5	_.270:	16.1	_.299:	27.2
_.96:	25.5	_.209:	30.7	_.280:	24.6	_.300:	30.4
_.97:	25.6	_.210:	30.2	_.281:	24.7	_.301:	30.6
_.98:	26.1	_.211:	29.8	_.282:	24.8	_.302:	15.2
_.99:	25.2	_.212:	29.7	_.283:	24.3	_.303:	15.1
_.100:	23.1	_.213:	29.3	_.284:	24.4	_.304:	1.6
_.101:	26.4	_.214:	30.8	_.285:	24.5	_.305:	10.4
_.102:	4.2	_.215:	30.3	_.287:	24.1	_.307:	16.7
_.167:	16.2	_.216:	29.4	_.288:	24.2	_.308:	4.8
_.185:	11.8	_.217:	29.5	_.289:	28.6	_.309:	5.1
_.310:	13.8	_.334:	12.6				
_.311:	13.7	_.335:	11.2				
_.312:	7.1	_.336:	11.1				
_.314:	10.6	_.337:	14.3				
_.316:	10.8	_.338:	15.8				
_.317:	10.7	_.339:	7.7				
_.318:	6.3	_.340:	27.8				
_.319:	12.5	_.341:	23.8				
_.320:	6.6	_.345:	15.4				
_.321:	11.5	_.346:	10.3				
_.322:	12.8	_.359:	2.7				
_.323:	12.2	_.360:	2.8				

msg = Message (43. … / 44. …).

Ev = Solenoid valve
The first number expresses: Solenoid valves bar (number of the board).
The second digit shows: the position of the solenoid valve .

msg	Ev	msg	Ev	msg	Ev	msg	Ev
_.0:	7.3	_.21:	15.5	_.39:	4.1	_.62:	4.7
_.1:	7.7	_.22:	16.8	_.40:	4.4	_.63:	13.8
_.2:	7.8	_.23:	1.5	_.41:	3.4	_.64:	6.2
_.3:	6.8	_.24:	2.5	_.42:	4.3	_.65:	6.3
_.4:	4.6	_.25:	2.6	_.43:	4.5	_.68:	5.3
_.5:	16.4	_.26:	2.3	_.49:	15.7	_.69:	5.4
_.6:	I_BIS.2	_.27:	3.8	_.50:	15.6	_.70:	5.7
_.7:	I_BIS.1	_.28:	16.3	_.51:	I_BIS.5	_.71:	5.8
_.8:	9.7	_.29:	16.2	_.52:	I_BIS.6	_.72:	13.1
_.9:	9.8	_.30:	7.1	_.53:	I_BIS.7	_.73:	12.8
_.10:	I.1	_.31:	14.5	_.54:	I_BIS.8	_.75:	13.5
_.13:	9.6	_.32:	1.7	_.55:	1.1	_.76:	5.5
_.14:	I_BIS.3	_.33:	1.8	_.56:	1.2	_.79:	13.4
_.15:	17.7	_.34:	3.6	_.57:	1.3	_.80:	10.4
_.16:	3.2	_.35:	3.7	_.58:	1.4	_.83:	11.3
_.17:	14.4	_.36:	2.1	_.59:	16.6	_.84:	25.1
_.18:	3.3	_.37:	2.2	_.60:	6.1	_.85:	26.5
_.20:	3.1	_.38:	3.5	_.61:	5.2	_.86:	26.7
_.87:	26.2	_.128:	7.6	_.147:	33.5	_.211:	29.8
_.88:	25.8	_.129:	7.4	_.148:	33.4	_.212:	29.7
_.89:	25.7	_.130:	7.5	_.149:	33.7	_.213:	29.3
_.90:	25.3	_.131:	31.5	_.150:	33.8	_.214:	30.8
_.91:	23.2	_.133:	33.6	_.151:	34.8	_.215:	30.3
_.92:	26.6	_.134:	31.8	_.167:	16.1	_.216:	29.4
_.93:	26.8	_.135:	32.1	_.185:	11.7	_.217:	29.5
_.94:	26.3	_.136:	32.2	_.186:	11.8	_.218:	29.6
_.95:	25.4	_.137:	32.3	_.187:	13.2	_.219:	30.1
_.96:	25.5	_.138:	32.4	_.188:	13.3	_.220:	29.2
_.97:	25.6	_.139:	32.5	_.193:	14.3	_.259:	12.3
_.98:	26.1	_.140:	32.6	_.198:	14.6	_.260:	12.2
_.99:	25.2	_.141:	32.7	_.199:	14.7	_.265:	11.6
_.100:	23.1	_.142:	32.8	_.200:	14.8	_.267:	I.2
_.101:	26.4	_.143:	33.1	_.207:	29.1	_.268:	31.3
_.102:	4.2	_.144:	33.2	_.208:	30.5	_.269:	2.4
_.126:	16.5	_.145:	33.3	_.209:	30.7	_.270:	15.3
_.127:	5.6	_.146:	31.2	_.210:	30.2	_.280:	24.6
_.281:	24.7	_.301:	30.6	_.322:	12.7	_.345:	15.4
_.282:	24.8	_.302:	15.2	_.323:	12.1	_.346:	9.5
_.283:	24.3	_.303:	15.1	_.324:	14.1	_.359:	2.7
_.284:	24.4	_.304:	1.6	_.326:	I.3	_.360:	2.8
_.285:	24.5	_.305:	10.3	_.327:	31.6	_.363:	31.4
_.287:	24.1	_.307:	16.7	_.329:	11.5		
_.288:	24.2	_.308:	4.8	_.330:	11.2		
_.289:	28.6	_.309:	5.1	_.331:	6.5		
_.290:	28.7	_.310:	13.7	_.332:	6.6		
_.291:	28.8	_.311:	13.6	_.333:	12.6		
_.292:	28.3	_.312:	7.2	_.334:	12.5		
_.293:	28.4	_.314:	10.5	_.335:	11.1		
_.294:	28.5	_.316:	10.7	_.336:	10.8		
_.296:	28.1	_.317:	10.6	_.337:	14.2		
_.297:	28.2	_.318:	6.4	_.338:	15.8		
_.298:	27.1	_.319:	12.4	_.339:	10.2		
_.299:	27.2	_.320:	6.7	_.340:	27.8		
_.300:	30.4	_.321:	11.4	_.341:	23.8		

msg = Message (43. … / 44. …).

Ev = Solenoid valve
The first number expresses: Solenoid valves bar (number of the board).
The second digit shows: the position of the solenoid valve .

GK616D3

msg	Ev	msg	Ev	msg	Ev	msg	Ev
_.0:	11.6	_.20:	15.3	_.44:	15.2	_.65:	13.7
_.1:	11.8	_.21:	14.3	_.45:	15.1	_.66:	11.3
_.2:	11.7	_.22:	19.2	_.49:	16.3	_.67:	11.2
_.3:	11.5	_.23:	19.1	_.50:	16.2	_.68:	15.7
_.4:	16.7	_.24:	17.2	_.51:	I_BIS.5	_.69:	15.6
_.5:	16.8	_.25:	17.1	_.52:	I_BIS.6	_.70:	14.7
_.6:	I_BIS.2	_.26:	17.6	_.53:	I_BIS.7	_.71:	14.6
_.7:	I_BIS.1	_.27:	18.1	_.54:	I_BIS.8	_.72:	13.1
_.8:	10.7	_.28:	18.7	_.55:	19.8	_.73:	11.4
_.9:	10.8	_.29:	18.6	_.56:	19.7	_.74:	10.3
_.10:	I.1	_.30:	19.4	_.57:	19.6	_.75:	11.1
_.13:	9.8	_.31:	14.1	_.58:	19.5	_.76:	15.5
_.14:	I_BIS.3	_.32:	18.5	_.59:	19.3	_.77:	13.4
_.15:	9.7	_.33:	18.4	_.60:	14.5	_.78:	13.3
_.16:	16.6	_.34:	18.3	_.61:	15.8	_.82:	12.4
_.17:	14.4	_.35:	18.2	_.62:	13.5	_.83:	12_BIS.2
_.18:	16.5	_.36:	17.8	_.63:	13.2	_.84:	27.1
_.19:	10.2	_.37:	17.7	_.64:	13.8	_.85:	28.5
_.86:	28.7	_.104:	23.5	_.122:	24.1		
_.87:	28.2	_.105:	25.8	_.125:	16.1		
_.88:	27.8	_.106:	25.7	_.252:	10.1		
_.89:	27.7	_.107:	25.6	_.267:	I.2		
_.90:	27.3	_.108:	25.5	_.269:	17.4		
_.91:	25.2	_.109:	25.4	_.270:	17.3		
_.92:	28.6	_.110:	25.3	_.271:	12.2		
_.93:	28.8	_.111:	26.8	_.272:	12.6		
_.94:	28.3	_.112:	26.7	_.273:	12.8		
_.95:	27.4	_.113:	26.6	_.274:	12_BIS.4		
_.96:	27.5	_.114:	26.5	_.275:	12_BIS.6		
_.97:	27.6	_.115:	26.4	_.276:	12_BIS.8		
_.98:	28.1	_.116:	26.3	_.277:	13.6		
_.99:	27.2	_.117:	23.8	_.278:	14.2		
_.100:	25.1	_.118:	23.7	_.279:	15.4		
_.101:	28.4	_.119:	23.6	_.325:	17.5		
_.102:	16.4	_.120:	24.3	_.339:	10.4		
_.103:	23.3	_.121:	24.2				

msg = Message (43. … / 44. …).

Ev = Solenoid valve
The first number expresses: Solenoid valves bar (number of the board).
The second digit shows: the position of the solenoid valve .

On this model: **The 12th bar is for bistable solenoid valves.**
Since the bistable electric valve requires two commands, its position is indicated only by even numbers.
Furthermore …
For hardware/software architecture reasons, only 8 commands per "bar" can be managed.
Therefore:
The bar is divided virtually into two: bar n and bar n-bis.
The first 4 solenoid valves belong to the "bis" bar.
(The numbering takes place starting from the unfixed end of the support.)
Therefore …
The first EV is indicated as 12_BIS.2.
The last EV is indicated as 12.8.
[The I bar (I and I_Bis) is not a support for bistable EVs, but an internal board for 16 outputs.]

GK616D3S

msg	Ev	msg	Ev	msg	Ev	msg	Ev
_.0:	11.6	_.20:	15.3	_.44:	15.2	_.65:	13.7
_.1:	11.8	_.21:	14.3	_.45:	15.1	_.66:	11.3
_.2:	11.7	_.22:	19.2	_.49:	16.3	_.67:	11.2
_.3:	11.5	_.23:	19.1	_.50:	16.2	_.68:	15.7
_.4:	16.7	_.24:	17.2	_.51:	I_BIS.5	_.69:	15.6
_.5:	16.8	_.25:	17.1	_.52:	I_BIS.6	_.70:	14.7
_.6:	I_BIS.2	_.26:	17.6	_.53:	I_BIS.7	_.71:	14.6
_.7:	I_BIS.1	_.27:	18.1	_.54:	I_BIS.8	_.72:	13.1
_.8:	10.7	_.28:	18.7	_.55:	19.8	_.73:	11.4
_.9:	10.8	_.29:	18.6	_.56:	19.7	_.74:	10.3
_.10:	I.1	_.30:	19.4	_.57:	19.6	_.75:	11.1
_.13:	9.8	_.31:	14.1	_.58:	19.5	_.76:	15.5
_.14:	I_BIS.3	_.32:	18.5	_.59:	19.3	_.77:	13.4
_.15:	9.7	_.33:	18.4	_.60:	14.5	_.78:	13.3
_.16:	16.6	_.34:	18.3	_.61:	15.8	_.82:	12.4
_.17:	14.4	_.35:	18.2	_.62:	13.5	_.83:	12_BIS.2
_.18:	16.5	_.36:	17.8	_.63:	13.2	_.84:	27.2
_.19:	10.2	_.37:	17.7	_.64:	13.8	_.85:	28.6
_.86:	28.8	_.104:	23.6	_.122:	24.2	_.343:	10.5
_.87:	28.1	_.105:	25.7	_.125:	16.1	_.344:	10.4
_.88:	27.7	_.106:	25.8	_.252:	10.1		
_.89:	27.8	_.107:	25.5	_.267:	I.2		
_.90:	27.4	_.108:	25.6	_.269:	17.4		
_.91:	25.1	_.109:	25.3	_.270:	17.3		
_.92:	28.5	_.110:	25.4	_.271:	12.2		
_.93:	28.7	_.111:	26.7	_.272:	12.6		
_.94:	28.4	_.112:	26.8	_.273:	12.8		
_.95:	27.3	_.113:	26.5	_.274:	12_BIS.4		
_.96:	27.6	_.114:	26.6	_.275:	12_BIS.6		
_.97:	27.5	_.115:	26.3	_.276:	12_BIS.8		
_.98:	28.2	_.116:	26.4	_.277:	13.6		
_.99:	27.1	_.117:	23.7	_.278:	14.2		
_.100:	25.2	_.118:	23.8	_.279:	15.4		
_.101:	28.3	_.119:	23.5	_.325:	17.5		
_.102:	16.4	_.120:	24.4	_.339:	14.8		
_.103:	23.4	_.121:	24.1	_.342:	10.6		

msg = Message (43. … / 44. …).

Ev = Solenoid valve
The first number expresses: Solenoid valves bar (number of the board).
The second digit shows: the position of the solenoid valve .

On this model: **The 12th bar is for bistable solenoid valves.**
Since the bistable electric valve requires two commands, its position is indicated only by even numbers.
Furthermore …
For hardware/software architecture reasons, only 8 commands per "bar" can be managed.
Therefore:
The bar is divided virtually into two: bar n and bar n-bis.
The first 4 solenoid valves belong to the "bis" bar.
(The numbering takes place starting from the unfixed end of the support.)
Therefore …
The first EV is indicated as 12_BIS.2.
The last EV is indicated as 12.8.
[The I bar (I and I_Bis) is not a support for bistable EVs, but an internal board for 16 outputs.]

45.

Do not currently managed.

46.

Do not currently managed.

Refer to the Dinema instructions relating to the management of "NAUTILUS system for the production control".

48.   Messages dedicated to the Seaming Robot - GOAL machines , DC88 machines

The information provided applies to the following models:
Stitch-by-stitch models .

This type of message causes the Robot stop.
When the robot stops, the machine stops at the sock pick-up point.

For basic information, refer to:
42.   **Messages on Inputs - Goal machines**

Or:
62.   **Messages on Inputs - DC88 machines**

The software before enabling machine running and during work 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.
See the following page.

Reference —

For more information, refer to the manual: **GUIDE OF USER INTERFACE**
In particular, refer to: **27) Seaming Robot**
The subsection comes under section: **Main Window**

See also the menu: **Linker Motor**

For further information, refer to the brochure: Position of machine inputs

See also: Software parameter re-acquisition

Input external closed toe

Refer to the menu: **Input Autotest external closed toe**

See also the menu: **General setup external closed toe**

SensorSignal input	

Page   1

Cylinder stop piston	__ (1)
Internal knit raising tube	__
(A)	
Cylinder stitch-pusher high	__ (2)
Cylinder stitch-pusher low	108
Pickup piston in	109
Pickup piston out	110
Wheel pin holder unit lever	114
Pin unit rotation proximity switch	115
Pin holder	113
Pin holder stitch-pusher	116
Stop open bell CTE	117

Page   2

Sewing roller forwards	123
Sewing roller backwards	124
Seaming device cutter	__ (3)
Stop linker yarn	__ (4)
Turning device guard stop	130
Down turning device locking piston	__ (5)
Turning dev. up piston UP	133
Turning dev. up Piston DOWN	134
Turning device motor limit switch up	129
Knit transfer piston down	125
Knit transfer piston up	126

(1)   **Goal machines**   Input = 140 .

  DC88 machines   connector on motor board
                                      (CAN type RX board ; Motor : TAKE-DOWN TUBE).

(A)   **Goal machines**   Input = 139 .

  DC88 machines   Sensor   : absent .

Input :   To this end, see table: **Matching software and hardware inputs** (**Enclosure**)

(2)   **Goal machines**   Input = 107 .

GK models , **DC88 machines**   connector on motor board
(CAN type RX board ; Motor : VERTICAL PICKUP DEVICE ARM).

(3)   **GL models**   Input = 121 .

GK models , **DC88 machines**   connector on motor board
(CAN type RX board ; Motor : PIN FEED).

(4)   **GL models**   Input = 122 .

GK models , **DC88 machines**   connector on motor board
(CAN type RX board ; Motor : PIN FEED).

(5)   **GL models**   Input = 127 .

GK models , **DC88 machines**   input integrated on the motor board
(CAN type RX board ; Motor : TURNING DEVICE DOWN INCLINATION).

Page   3

(B)   **Goal machines**   Input = 143 .

DC88 machines   Sensor : absent .

(6)   **Goal machines**   Input = 144 (Do not currently managed.).

DC88 machines   Sensor : absent .

Goal machines

Page   4

DC88 machines

Page   4

(7)   Input = 106 (Do not currently managed.).

Output external closed toe

Refer to the menu: **Autotest outputs closed toe**

The first number expresses: Solenoid valves bar (number of the board).
The second digit shows: the position of the solenoid valve .

Function	Model	Command output
Page 1		
Eprc50 Cylinder stop piston	G_544CTE	6. 6
	GK523CTE	7. 6
	G_625CTE	10. 1
	G_615CTE	10. 3
	G_616DCTE	10. 3
	G_616CTE	10. 3
	G_616DF3CTE	10. 5
	DC88X …	10. 3

Function	Model	Command output
Eprc52 Turned sock pushing blow	G_544CTE	6. 7
	GK523CTE	7. 4
	G_615CTE	10. 2
	G_616DCTE	10. 2
	G_616CTE	10. 2
	G_625CTE	10. 3
	G_616DF3CTE	10. 6
	DC88X …	Not present
Eprc53 Close Toe dial lowering	G_544CTE	1. 7
	G_625CTE	2. 3
	GK523CTE	16. 5
	G_615CTE	17. 3
	G_616DCTE	17. 3
	G_616CTE	17. 3
	G_616DF3CTE	18. 8
	DC88X …	Not present
Eprc1 Pin holder unit rot. lever.	(*)	33. 1
Eprc2 Pin holder support	(*)	33. 2
Eprc3 Pin holder knit pusher	(*)	33. 3
Eprc4 Turning piston up - UP	(*)	31. 1/.2
Eprc5 Turning Piston up - DOWN	(*)	33. 5
Eprc6 Sock stretching sector	(*)	33. 4

Page   2

Function	Model	Command output
Eprc8 Tube stop cam t.dev.up stop	(*)	33. 8
Eprc7 Tube stop cam t.dev.up rel.	(*)	33. 7
Eprc24 Knit transfer piston up	(*)	31. 8
Eprc9 Knit transfer piston down	(*)	32. 1
Eprc10 Sock present control rod	(*)	32. 2
Eprc11 Cylinder knit pusher	(*)	32. 3
Eprc13 Pickup piston in	(*)	32. 5
Eprc12 Pickup piston out	(*)	32. 4
Eprc23 Tung.dev. stop piston low	(*)	33. 6

(*)   **For all models (G_ … CTE, DC88X …).**

Function	Model	Command output
Page 3		
Eprc14 Sewing roller backwards	(*)	32. 6
Eprc15 Sewing roller forwards	(*)	32. 7
Eprc16 Seaming device cutter	(*)	32. 8
Eprc25 Stitching mach. insp. lamp	(*)	34. 8
Eprc22 Yarn ctrl. in sock extract.	DC88X …	31. 6
Eprc22 Turning dev. pipe rot. Piston	G_ … CTE	31. 6
Stitching mach. insp.lamp2	(*)	I. 3
Eprc21 Cylinder knit pusher pos. 1	(*)	31. 5
Eprc19 Air blast cuff	(*)	31. 3
Knit pusher side shifting	DC88X …	31. 4
Eprc17 Toe pocket air blow	DC88X …	32. 7
E-Dream – Dream sock ejection assist	G_625CTE	7. 6
	G_544CTE	9. 3
	G_616DF3CTE	9. 3
	G_615CTE	9. 4
	G_616DCTE	9. 5
	G_616CTE	9. 5
	GK523CTE	9. 5

(*)   **For all models (G_ … CTE, DC88X …).**

48.1:	Cylinder angle position calibration	CTE - Error

The software ascertains that the value required to continue is missing.
The message indicates the need to repeat the procedure:　　　　Cylinder angle position calibration
In particular:　　　　　　　　　　　Normal toe

48.2:	Cylinder angle position calibration	CTE - Error

The software ascertains that the value required to continue is missing.
The message indicates the need to repeat the procedure:　　　　Cylinder angle position calibration
In particular:　　　　　　　　　Reversed toe

48.3:	Cylinder stop piston	CTE - Error

The device has not reached the rest position.
(Autotest inputs　:　Cylinder stop piston)
(Autotest outputs　:　Eprc50 Cylinder stop piston)

48.4:	Cylinder stop piston	CTE - Error

At first, view the contents of the previous message.
The device has not reached the working position.

48.5:	Cylinder stitch-pusher not high	CTE - Error

The device has not reached the rest position.
(Autotest inputs　:　Cylinder stitch-pusher high　/　Cylinder stitch-pusher low)
(Autotest outputs　:　Eprc11 Cylinder knit pusher)

48.6:	Cylinder stitch-pusher not low	CTE - Error

At first, view the contents of the previous message.
The device has not reached the working position.

48.7:	Pickup piston not in	CTE - Error

The device has not reached the rest position.
(Autotest inputs　:　Pickup piston in　/　Pickup piston out)
(Autotest outputs　:　Eprc13 Pickup piston in　/　Eprc12 Pickup piston out)

48.8:	Pickup piston not out	CTE - Error

At first, view the contents of the previous message.
The device has not reached the working position.

Goal machines

Internal knit raising tube position
The actuator can be pneumatic (solenoid valve) or electric (motor).

At first … To move the device we have used an electric valve.
([116] Internal tube position 1)   (*)

After which … To move the device, two solenoid valves were used.
([116] Internal tube position 1 + Eprc20 Internal tube low position)   (*)

At present … A motor is used to move the device. The motor does not have an encoder.

The message confirms that:
The device has not reached the rest position.

The motor must be disabled for the models in which the device is controlled pneumatically.
In particular, refer to item: **General setup external closed toe**
In particular, refer to item: **Motorized Internal knit raising tube management**

In this case is neccessary … Setting procedure.
Concerning this see the menu: **Linker Motor**
In particular: **Calibration menu**

In any case … To check the functionality of the device, access in the specific window.
Refer to the menu: **Linker Motor**
In particular: **Manual command menu**

For the location of the output, see what is reported for the message: 43.130
Or: 43.363

At first, view the contents of the previous message.
The device has not reached the working position.

(*)   Refer to the menu: **Autotest special functions**

48.11:	Knit transfer piston not in position. Not down	CTE - Error

The device has not reached the rest position.

48.12:	Knit transfer piston not in position. Not up	CTE - Error

The device has not reached the working position.

48.13:	Sock present control rod onboard machine not at zero	CTE - Error

The device has not reached the rest position.

48.14:	Sock not working presence control rod	CTE - Error

The device has not reached the working position.

48.15:	Sock stretching sector not in position. Not open	CTE - Error

The device has not reached the rest position.(Position 0)

48.16:	Sock stretching sector not in position. Not closed	CTE - Error

The device has not reached the working position.(Position 1)

48.17:	Up turning device tube locking cam not in position. Does not block	CTE - Error

The device has not reached the rest position.

48.18:	Up turning device tube locking cam not in position. Does not release	CTE - Error

The device has not reached the working position.

48.19:	Pin holder stitch-pusher not in position. Not high	CTE - Error

The device has not reached the rest position.

48.20:	Pin holder stitch-pusher not in position. Not low	CTE - Error

The device has not reached the working position.

| 48.21: | Pin holder unit rot. lever not in position. Not backward | CTE - Error |

The device has not reached the rest position.

| 48.22: | Pin holder unit rot. lever not in position. Not forward | CTE - Error |

The device has not reached the working position.

| 48.23: | Sewing device roller not in position. Not reversed | CTE - Error |

The device has not reached the rest position.

| 48.24: | Sewing device roller not in position. Not forward | CTE - Error |

The device has not reached the working position.

| 48.25: | Sewing device cutter not in position. Not open | CTE - Error |

The device has not reached the rest position.

| 48.26: | Sewing device cutter not in position. Not closed | CTE - Error |

The device has not reached the working position.

| 48.27: | Turning device up locking piston not in position. Not up | CTE - Error |

The device has not reached the rest position.

| 48.28: | Turning device up locking piston not in position. Not down | CTE - Error |

The device has not reached the working position.

| 48.29: | Down turning device locking piston not in position. Does not block | CTE - Error |

The device has not reached the rest position.

| 48.30: | Down turning device locking piston not in position. Does not release | CTE - Error |

The device has not reached the working position.

48.31:   Sock ejection not detected   CTE - Error

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 signal.
These programming codes are included in the specific "package".
(Sock extraction and seaming)
(Autotest of inputs : Sock passage 2)

48.32:   Seamer stop activated or in error   CTE - Error

When the robot stops, the machine stops at the sock pick-up point.
This message indicates that the current item cannot be picked up because the Seaming Robot is occupied.
Failure can be caused by:
● The device stop button, with a retainer, remains active (pressed).
  Press this key again to disable.

48.33:   Sewing device resetting active   CTE - Information

The message confirms 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.

48.34:   Manually lower the yarn finger plate   CTE - Information

To continue, bring the group to the low position.
The position indicated is the work position.
This message appears on completion of calibrations.
Furthermore: The message may be displayed following Resetting.
Therefore …
Press the operating command: [Stop] (Hold down the button.).
After which …
Refer to the menu: **Welt raier and dial manuals**

48.35:   Press the machine run button to continue   CTE - Information

The message indicates the next operation.
Press the operating command: (I) Machine Start Button .

48.36:   Press the sewing start button to continue   CTE - Information

The message indicates the next operation.
Press the operating command: Seaming device start button .

48.37:   Seaming device STOP button pressed   CTE - Error

The Robot was probably not switched on.
If everything is in order, you can restart the machine.
See the description provided for the message: 48.32

48.38:	Yarn control in sock extraction	CTE - Error

Do not currently managed.

48.39:	Prox. designates not TURNED OFF. Engine rotation group designates has not rotated correctly	CTE - Error

When the sensor detects the presence the LED comes on.
The sensor is in reading when it should be off.
(Input Autotest external closed toe : Pin holder)

48.40:	Prox. designates not running. Engine rotation group designates has not rotated correctly. CTE - Error

First refer to what specified for the previous entry.
The sensor is not in reading despite the motor has already completed the movement.

48.41:	Maximum number of turning movements exceeded	CTE - Error

Gripper movement transmission unit
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.

48.42:	Up turning device motor not in end-of-stoke position	CTE - Error

Message no longer menaged. Update the machine software .

Gripper movement transmission unit / lower sensor
The device has not reached the end position.
Command output: Motor TURNING DEVICE UP , CAN circuit
Sensor input: See table , Sensor code : U9840048 (Below)

48.43:	Up turning device motor not reached proximity zero	CTE - Error

Gripper movement transmission unit / Motor zero proximity
The device has not reached the rest position.
Command output: Motor TURNING DEVICE UP , CAN circuit
Sensor input: CAN circuit

GL models
Motor :   code G2920284
Sensor: code U9840048 (Up , connector on motor board)

GK models , DC88 machines
Motor :   code G2900813
Sensor: code G2920639 (Sensor integrated in the motor unit)

Lower turning device supporting frame / *Motor zero proximity*

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.

The message appears in the following circumstances:

- The sensor did not detect the change of status.
- The motor does not receive the command (the board not controls the motor).

Check that the movement of the device is not slowed down or blocked by mechanical obstacoles.

Check the mechanical functionality of the components linked to the motor movement.

Check the proper functioning of the Zero sensor. (Proceed to its adjustment and eventually replace it.).

Or …

Check the wiring that connect the sensor and the motor to the command board.

Replace the stepping motor indicated in the message.

Replace the CAN module (command board) associated with the motor indicated in the message.

Command output: Motor TURNING DEVICE DOWN INCLINATION , CAN circuit
Sensor input: CAN circuit

Design variant

Sensor code : G2900133 (Standard reset whith proximity ,
connector on motor board)

Or …

Sensor code : G2920639 (Rest whith proximity multiturn ,
Sensor integrated in the motor unit)

Goal machines

See also the menu: **Motor special management**

DC88 machines

See also the menu: **Rest setup**

Personalise this menu according to the machine actual outfit.

48.45: **Pin holder motor rotation incorrect** CTE - Error

The device has not reached the end position.
Refer to the next entry: Pin unit rotation proximity switch

48.46: **Motor %s is not in place** CTE - Error

%ls = Field showing the motor name. (or Mechanical unit) .

If the motor position differs from the software instruction, an error is displayed.

The indicated motor has not performed the movement correctly.

Where allowed, the movement can be repeated.

Press [Fn+R] to repeat the command. (The comand related to the motor.)

Namely …

The command is enabled wherever required and there is no hazards.

When the command is available, the related icon is displayed in the menu.

Otherwise:

Delete the message by pressing [FN+F8].

The software tries to recover the situation. (also in this case)

Namely … Try to restore the correct position using the control specified. (F8 / FN+F8)

Then, press the button: [Seaming device start button]

48.47: Remove the sock from the pickup devices manually

CTE - Error

The message may be displayed following Resetting.
The item could not be discharged due to robot stage.
Intervene manually: raise the sock to release the knit.

48.48: Cut up the seaming chain manually

CTE - Error

The message may be displayed following Resetting.
Lower the seamer needle using the side knob.
Intervene manually: raise the sock to release the knit.

48.49: Seamer motor blocked: sock seaming phase too long

CTE - Error

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.

48.50: Presence of sock photocell. Manually arranging the sock

CTE - Error

Gripper movement transmission unit
The sock is compressed at the base of the tube via repeated movements of the hands, until when the photocell is uncovered.
This message informs the user 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.

48.51: Turning tube position incorrect. Remove it manually

CTE - Error

The message appears in the following circumstances:
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.
The correct condition is:
When the Lower Turning Device descends, the photocell no longer needs to read the tube reflector.

Intervention

Take great care to avoid any damages.
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.

48.52:	No phase	CTE - Error

See the description provided for the message: **62.1**

48.53:	Blocked movement - angle pickup arm motor	CTE - Error

The arm disc is surrounded by a metal strip that goes in contact with the housing when it is hurt.
This message informs the user that:
The arm has encountered an obstacle during its movement.
The obstacle is probably due to a latch that has not released the yarn.

48.54:	Sewing device yarn broken	CTE - Error

This message informs the user that:
At least one of the Sewing Machine yarns is missing.
The yarn has broken or end of reel.

48.55:	Top turning device guards open	CTE - Error

Upper Turning unit (top)
This message informs the user that:
The unit guard has remained open.
Check that the two doors are secured using the locking clip.
Refer to the next entry: Turning device guard stop

48.56:	Protection barrier	CTE - Error

This message informs the user 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

Note
This input can be disabled.
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.
Concerning this see the menu: **General setup external closed toe**

48.57:	Sock present on machine	CTE - Error

The item refers to the device: Sock present control kit .
This is an optional device.
Select the actual equipment.

Refer to the menu: **General setup external closed toe**

This window shows the possible options for the model.

- Photocell (Goal machines / I/O Serial line)
- Photocamera (Goal machines / I/O Serial line)
- Infrared Wall barrier (Goal machines / CAN circuit)
- Videocamera (GK models and DC88 machines / _)

The device detect the extraction of the sock from the cylinder.
In this way … The cylinder can resume operation and immediately start the next item.
Namely … This device allows you to gain some seconds compared to the initial outfit.

Press the button: [FN+F8]
The menu shows the commands available.

See the description provided for the message: **48.83**
See also: **48.72**

| **48.58:** | **Stop open bell external closed toe** | CTE - 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 blocking the expulsion duct, prevent the closure of the device.
- Check that no cause prevent the correct closure of the device.
- Check the correct position of the Vacuum Valve.
  (Electronic stepping vacuum valve / Electronic shutter valve closed toe).

| **48.59:** | **No programming sequence of extraction functions** | CTE - Error |

Internal software failure . Contact the Technical Customer Service.
These programming codes are included in the specific "package".
(Sock extraction and seaming)

| **48.60:** | **Sewing device needs to be reset** | CTE - Information |

Press the button: FN+F0

| **48.61:** | **Seamer parameter setup backup completed** | Warning |

Data has been acquired (stored) successfully.
Refer to the menu: **External closed toe setup menu**

| **48.62:** | **Seamer parameter setup backup failed** | Warning |

First refer to what specified for the previous entry.
Informs that saving has failed. Go back to the menu and try again.
Or … Reboot the machine and repeat the operation.
If the problem persists, please contact the Technical Customer Service.

| **48.63:** | **Run disabled: seamer calibration in progress** | Information |

This message informs the user that the machine cannot be Run.
Informs that the operation cannot be performed under the current circumstances.

Some Robot positions need to be set (adjusted).
The robot and machine are independent. They operate in synchronisation during sock extraction.
Furthermore …
During the procedure (adjustment) it is not possible to start the machine.
(On display in the dedicated area, is shown the corresponding icon. :
Calibration in cours)

| **48.64:** | **Await end of seaming. Article change request activated** | Warning |

Informs that a new article has been enabled and the machine is ready to start production.
The machine will stop pending the completion of the seaming operation of the last sock produced.
Only at the end of the seaming, the new article will be really activated.

| **48.65:** | **Manually lower the yarn finger plate** | Error |

To continue, bring the group to the low position.
The position indicated is the work position.
This message appears on completion of calibrations.
Furthermore: The message may be displayed following Resetting.
Refer to the menu: **Welt raier and dial manuals**

| **48.66:** | **Operation not allowed manual command in progress sewing** | Information |

This message informs the user that the machine cannot be Run.
Informs that the operation cannot be performed under the current circumstances.
Wait for the item to be picked up.
Or …
The seaming robot is working.
Current phase: Sewing device resetting .
Wait for the message: **48.68**

| **48.67:** | **Awaiting end of seaming. Sock target achieved.** | Warning |

See the description provided for the message: **14.116**

48.68: Ready sewing
<div align="right">CTE - Information</div>

Delete the message by pressing [FN+F8].
Return to the Main window.

48.69: Activation sewing
<div align="right">CTE - Information</div>

The message appears in the following circumstances:
The seaming robot is working. (Working / Resetting)

48.70: Press the run button to reset the machine
<div align="right">CTE - Information</div>

The message indicates the next operation.
Press the operating command: (I) Machine Start Button .

48.71: Awaiting end of seaming. Basket target achieved.
<div align="right">Warning</div>

See the description provided for the message: **14.117**

48.72: Manually raise the yarn finger plate
<div align="right">CTE - Information</div>

The message is additional to the previous notification.
See the description provided for the message: **48.57**
To continue, bring the group to the top position.
The position indicated is NOT the work position.
Press the operating command: [Stop] (Hold down the button.).
After which …
Refer to the menu: **Welt raier and dial manuals**

48.73: Lack of air pressure
<div align="right">CTE - Error</div>

See the description provided for the message: **62.10**

48.74: Operation not allowed machine reset disable sewing
<div align="right">Information</div>

Informs that the operation cannot be performed under the current circumstances.
Wait for the item to be picked up.
You need to wait a few seconds.

48.75: Article activation not allowed. Calibration closed toe missing
<div align="right">Error</div>

The attempt to put the article into production was not successful.

Concerning this see the menu: **Calibration menu**
If the following condition is met, the operation will be successful.
Acquisition is required for all menu items.

See also: **14.81**

48.76:   **Kit for sock presence control disconnected**   CTE - Error

This device must be enabled on the machines equipped with it.

Concerning this see the menu: **General setup external closed toe**

Or …

Return to the Main window. (Linker Motor)

In particular, refer to item:

Kit for sock presence control disable

48.77:   **First pin value out of tolerance**   CTE - Error

Motor : *PIN FEED* / Motor zero proximity / First pin position calibration

Gennerally this message appears in response to the restoration (recovery) after a Black-out.

When switched on, the machine checks the zero position of the mechanical unit.

The motor position is controlled by an encoder.

Furthermore … The control is carried out through the signals given by the sensor: Motor zero proximity

If the motor position differs from the software instruction, an error is displayed.

The best solution is to run the zeroing to arrive at the End of Sock.

Press the button: FN+F0

If the problem persists: Check that the sensor switches in the presence of the mechanical unit.

Check the connection between the sensor and the board.

If the problem is not resolved …   Turn the machine off and on again.

If the problem persists, please contact the Technical Customer Service.

48.78:   **Adjusting the first pin value calibration necessary**   CTE - Error

Motor : *PIN FEED* / Motor zero proximity / First pin position calibration

When switched on, the machine checks the zero position of the mechanical unit.

The motor position is controlled by an encoder.

Furthermore … The control is carried out through the signals given by the sensor: Motor zero proximity

If the motor position differs from the software instruction, an error is displayed.

The data are removed from FLASH memory.

The procedure must be repeated. (First pin position calibration)

48.79:   **No USB memory stick**   CTE - Error

Message no longer menaged.

At present …   The menu can only be accessed after inserting the USB device.

48.80:   Error writing to USB key

Refer to the menu: **USB software management**

The changes have not been saved. This particular message is a symptom of a Hardware or Software problem.

● Replace the USB stick.

Go back to the menu and try again. Or … Reboot the machine and repeat the operation. If the problem persists, please contact the Technical Customer Service.

48.81:   Writing to USB correctly

CTE - Information

The operation was performed successfully.

Data has been acquired (stored) successfully.

48.82:   Operation in progress. Please wait…

CTE - Information

Refer to the menu: **USB software management**

In particular: **Export file log**

In the indicated menu, the [Fn+W] command has been pressed.

The message confirms that: It was decided to save data.

Informs that a procedure/operation is in progress and the machine is processing data.

Await the outcome of the operation.

48.83:   Check kit presence sock. Presence detected abnormal sock

CTE - Error

See the description provided for the message: **48.57**

This message has the same meaning as the one communicated.

The message is generated at another processing stage.

48.84:   Motor %s is not in place

CTE - Error

See the description provided for the message: **48.46**

48.85:   Machine in emergency

CTE - Error

See the description provided for the message: **14.23**

48.86: Pickup device in error

Delete the message by pressing [FN+F8].
Return to the Main window.
After which …
See in this regard as reported under the item: **69.**

48.87: Cylinder mesh-push extractor not at rest

The device has not reached the rest position.
The item refers to the device: **Knit pusher side shifting piston** .
This is an optional device.
Programming is effected by Graphitron.
Select the actual equipment.

Concerning this see the menu: **General setup external closed toe**
In particular, refer to item: **Cylinder knit pusher**

For the location of the output, see what is reported for the message: **60.198**

Sensor input: Watch beginning of section.
[Input Autotest external closed toe / Page 4]
Command output: Watch beginning of section.
[Autotest outputs external closed toe / Page 3]

48.88: Cylinder mesh-push extractor not working

First refer to what specified for the previous entry.
The device has not reached the working position.

48.89: Head not blocked

Message no longer menaged. Update the machine software .

48.90: Turning device pipe rotating piston not in position. Does not unlock

The device has not reached the rest position.
The item refers to the device: Turning device pipe rotating piston .
This is an optional device.
Programming is effected by Graphitron.

For the location of the output, see what is reported for the message: **43.327**

Sensor input: Watch beginning of section.
[Input external closed toe / Page 4]
Command output: Watch beginning of section.
[Autotest outputs external closed toe / Page 3]

48.91: Turning device pipe rotating piston not in position. Does not lock CTE - Error

First refer to what specified for the previous entry.
The device has not reached the working position.

48.92: Aborted sewing. Tolerance of pin-feed motor encoder: reset the sewing machine CTE - Error

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 Robot.
Press the button: FN+F0

48.93: Sewing mach.: device %s not ready CTE - Error

%ls = Field showing the motor name. (or Mechanical unit) .
The message appears in the following circumstances:
after the initialisation stage
(When the machine is switched on. / Moment preceding the item pick-up.) .
Press the key: [FN+F8] . Therefore … Press [F0].

48.94: Knit pusher side shifting piston not present. CTE - Error

For basic information, refer to: **48.87**

This message informs the user that:
The device has been (erroneously) enabled. However, it is not connected.
The machine, after enabling the device, performs a mechanical reset to verify its presence.

If a non-present device is enabled, the machine generates errors.
The devices present must be enabled and those missing must be disabled.
The disabled device is not handled even when it is connected.

48.95: Knit pusher side shifting piston not enabled, but required from program CTE - Error

For basic information, refer to: **48.87**

The message indicates that you want to activate a Sock Programme containing functions associated with
the use of the disabled device.

Enable under Setup the device recalled by the Sock Programme.
Or …
Correct the Sock Program by Graphitron.

48.96 ÷ 48.101

Do not currently managed.

| 48.102: | Loss of pin-feed motor steps returning to zero | CTE - Error |

See the description provided for the message: **31.13**

In particular … Please refer to point: **b)**

Remember that:
The board that manages the motor is located in the back of the Robot.
The board is called: Pcb 5776 .
The motor position is controlled by an encoder.

| 48.103: | Too much time awaiting Motor %s busyoff | CTE - Error |

The stepper motor shown exceeded the time allowed for the operation.
The software has not received a response.
Press [FN+F8] to repeat the command.

| 48.104: | Output either in load not connected or short circuit | CTE - Error |

Delete the message by pressing [FN+F8].

After which …

Refer to the section: **43. / 44.**
Or …
Refer to the section: **60. / 61.**

| 48.105: | Motor ENCODER tolerance: %ls (%d). Theoretical/actual values: Step %d-%d - Encoder %d-%d | CTE - Error |

In this regard, see the description provided for the message: **31.20**

| 48.106: | Approach to 0 impossible: %ls (%d). Proximity switch already covered. | CTE - Error |

In this regard, see the description provided for the message: **31.55**

| 48.107: | Approach to 0 impossible: %ls (%d). Proximity switch not found. | CTE - Error |

In this regard, see the description provided for the message: **31.57**

| 48.108: | Approach to end of stroke impossible: %ls (%d). Proximity switch already covered. CTE - Error |

In this regard, see the description provided for the message: **31.56**

| 48.109: | Approach to end of stroke impossible: %ls (%d).Proximity switch not found. | CTE - Error |

In this regard, see the description provided for the message: **31.58**

48.110:	Zeroing impossible: %ls (%d)	CTE - Error

See the description provided for the message: **31.22**

48.111:	Zeroing at end of stroke impossible: %ls (%d)	CTE - Error

See the description provided for the message: **31.48**

48.112:	Movement impossible: %ls (%d)	CTE - Error

See the description provided for the message: **31.22**

48.113:	Up turning device motor not in end-of-stoke position	CTE - Error

The sensor is not in reading despite the motor has already completed the movement.
Gripper movement transmission unit / lower sensor
The device has not reached the end position.

Command output: Motor TURNING DEVICE UP , CAN circuit
Sensor input: See table , Sensor code : U9840048 (Below)

48.114:	Cylinder knit pusher NOT in intermediate position	CTE - Error

The sensor is in reading when it should be off.
(Input Autotest external closed toe :   Cylinder stitch-pusher low) .
(Autotest outputs external closed toe :   Eprc21 Cylinder knit pusher pos. 1) .

48.115:	Barriers disable : mind the automatic movement after the errror cancel	CTE - Error

The message reminds that …
Optical barriers NOT ACTIVATED.

Delete the message by pressing [FN+F8].
Then, press the button: Seaming device start button .
This is for safety reasons.
In this regard, see the description provided for the message: **14.109**

48.116:	Hold pressed the sewing-machine start button to create chain; stop and start buttons for the cutter.	Information

This information only applies to the following models:
DC88 machines (double-cylinder models, for men's socks) .

Refer to the menu: **Manual command menu**
In particular, refer to item: Chain seaming

See the following page.

When you press the key indicated appears the message.
For the procedure, follow the information displayed.
The message shows the commands available.

48.117:	Sewing device stopped by machine error	CTE - Error

The message is visible in the dedicated window. (Linker Motor)
The message reminds that …
The device is stopped due to a malfunction of the machine.
The display shows the latter in the foreground.
Therefore: Solve the real problem that has caused the error.
After which …
Go to the dedicated menu. (Linker Motor)
Delete the message by pressing [FN+F8].

48.118:	Movement interrupted: %ls (%d)	CTE - Error

For the explanation/ solution, see what specified for the previous entry.
Furthermore …
See the description provided for the message: **14.118**

48.119:	First pin HOME value needs to be re-acquired	CTE - Error

The position of the part is out of tolerance.
The latter behaviour depends on the Setup.
Concerning this see the menu: **General setup external closed toe**
In particular, refer to item: **Pin feeder Special management**

The message indicates the need to repeat the procedure: **Calibrate the home position - Pin feeder**

(Ascertain the motor steps corresponding to the optimal condition and acquire the stored value.)

48.120:	Motor busy: %ls (%d)	CTE - Error

See the description provided for the message: 48.117

48.121:	Sock 2 passage on closed toe side obstructed or damaged	CTE - Error

See the description provided for the message: **9.14**

48.122:	Internal knit raising tube motor not in end course position	CTE - Error

See the description provided for the message: **48.10**

48.123:	Aborted sewing. Internal knit raising tube motor not in end course position: reset the sewing machine	CTE - Error

See the description provided for the message: **48.10**
The user must continue to Reset the Seaming Robot.
Press the button: FN+F0

48.124:	Photocell: reading fault	CTE - Error

The sensor is in reading when it should be off.
Or …
The sensor is off instead of being in the reading mode.

48.125:	…	CTE - Error

Do not currently managed.

48.126:	…	CTE - Error

Do not currently managed.

48.127:	Impossible approach to 0: %ls (%d)	CTE - Error

See the description provided for the message: **31.13**

48.128:	…	CTE - Error

Do not currently managed.

48.129:	…	CTE - Error

Do not currently managed.

48.130:	Forward by phases inserted	CTE - Error

The message confirms that:
The machine awaits the specific command to move the device forward.

For further information see also: **Linker motor Help**

Furthermore …
The icons indicate the status of the device and the related operations/ managements.
At each operating status, on display in the dedicated area, is shown the corresponding icon.

If the barriers are disabled, the Robot moves from one setting to the other only on mode … Phase stop .
The opposing option will be disabled automatically.

48.131:   Turning device tube tampered, check the rotation   CTE - Error

The device has been moved when the machine was off.

This message can only appear on switching on.
It warns that the software failed to perform hibernation.

In this regard, see the description provided for the message: **14.52**

The message appears in the following circumstances:
At the end of the Reset procedure. (Seaming Robot)

Proceed as follows to solve the problem:
Refer to the menu: **Linker Motor**
In particular, refer to: **Manual command menu**
In particular: Pipe rotation coupling control

48.132:   Turning device tube rotation incomplete, manual reposition required   CTE - Error

There has been a power failure, while the device was moving/rotating.

This message can only appear on switching on.
It warns that the software failed to perform hibernation.

In this regard, see the description provided for the message: **14.52**

The message appears in the following circumstances:
At the end of the Reset procedure. (Seaming Robot)

Proceed as follows to solve the problem:
Refer to the menu: **Linker Motor**
In particular, refer to: **Manual command menu**
In particular: Pipe rotation coupling control

49.   Program not executable

The message appears when the Sock Programme is activated.

The message states that:

The software has detected a difference between the "Article type" entered under Setup and that identified in the Programme.

49.0:   Closed toe not possible see the program   Error - Movement impossible

An attempt was made to activate an aricle that is not compatible with the equipment and/ or model.

Or …

The equipment required by the article is disabled.

See the description provided for the message: **23.35**

Correct the Sock Program by Graphitron.

Or … Access to the machine Setup and set the correct value.

50.   Program not executable

The message appears when the Sock Programme is activated.

The message states that:

The software has detected a difference between the "Article type" entered under Setup and that identified in the Programme.

50.0:   Closed toe not possible see the program   Error - Movement impossible

An attempt was made to activate an aricle that is not compatible with the equipment and/ or model.

Or …

The equipment required by the article is disabled.

See the description provided for the message: **23.35**

Correct the Sock Program by Graphitron.

Or … Access to the machine Setup and set the correct value.

50.1:   Jacquard not executable see setup or program   Error - Movement impossible

Do not currently managed.

50.2:   Wide heel not possible see setup or program   Error - Movement impossible

Do not currently managed.

50.3 , 50.4

Do not currently managed.

50.5:   Program not executable. Stitch-cams not motorized   Error - Movement impossible

See the description provided for the message: **23.28**

50.6 ÷ 50.9

Do not currently managed.

Goal machines

This information only applies to the following models:
GOAL machines (single-cylinder models, for men's socks) .
More in particular:
Models equipped with the following device: **Raising dial motor**
The motor position is controlled by an encoder.
[Saw   + Dial   = Dial unit   ]

Reference

See also: **36.**

Description

Refer to the menu: **Modify raising dial zone**

This menu covers the Dial mechanical unit.
From this menu, it is possible to regulate the programmed values of the device.
Stop the machine at the desired step to adjust the value.
This menu can be used to modify the motor parameter in the relevant zone.

The mechanical unit is raised via a stepping motor.
The movements are controlled via the program through the specific code.
In performing the command, the machine moves the device up to the desired position.

The position (height) can be free (absolute) or preset (tabular).
When controlling an absolute position from the program, the height of the device must be specified. The value is expressed as motor steps.
When a tabular position is entered in the program, a number from 0 to 15 must be specified.
Each number is associated to an absolute position of the device thanks to an internal association table.
The preset heights for the device are called "tabellar" values.

The modification of a tabular value affects all the points of the article in which it is inserted.
Modification of an absolute value only involves the point in which it is inserted.

51.0:	Change position of welt raiser motor runout (min. %d - max. %d)	Warning

This message informs the user that the value placed aboard the machine in the active Sock Program is not permitted.
Informs that values below / above the standard allowed have been entered.
The message indicates the range of accepted values.
The value is expressed as motor steps.

51.1:	Welt raiser motor position backup performed correctly	Warning

The operation was performed successfully.

51.2:	Welt raiser motor positions reset correctly	Warning

Informs that the programmed values have been restored.

51.3:	Dial motor values encoding writing failure	Warning

The changes have not been saved. This particular message is a symptom of a Hardware or Software problem.
Go back to the menu and try again. Or … Reboot the machine and repeat the operation. If the problem persists, please contact the Technical Customer Service.

51.4:	Welt position changed. Confirm or cancel the change made	Information

The message appears in the following circumstances:
The machine stops at the exit of the area being modified: the value entered was neither confirmed nor cancelled.
Therefore:
Press [Return] / (OK) to confirm the settings.
Or …
Press the key: [Esc]
(Returns to the previous menu, cancelling any changes made.) .

51.5:	Operation not allowed. The change has not been confirmed not cancelled	Information

For the explanation/ solution, see what specified for the previous entry.

51.6:	Welt programming not admitted. Degree not appropriate	Alarm

Message no longer menaged. Update the Graphitron software .
Of course, in the case of Graphitron updating the sock program must be coded again.

52.   Messages on the manual commands

52.0:   Operation not allowed manual command in progress   Warning

Informs that the operation cannot be performed under the current circumstances.

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.

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.

[Gennerally … Press this key again to disable.

Or … Press the key: The dedicated command].

53. Cylinder angle position setting drum for terry - Goal machines

Goal machines

This information only applies to the following models:
GOAL machines (single-cylinder models, for men's socks) .

Reference

See the description provided for the message:	**23.23**
See also:	**23.27**
Refer to the menu:	**Cylinder angle position setting drum for terry**
For basic information, refer to:	**Mechanical Adjustments** (manual).
In particular:	Adjusting the terry pattern drum angle position

Forward = normal rotation of the cylinder .
Backward = reversed rotation of the cylinder .

53.0: **Cylinder angle position setting drum for terry missing**	Error

The software ascertains that the value required to continue is missing.
There are stations that require certain mechanical settings to continue without errors.
Acquisition is required for all menu items.

53.1: **Cylinder angle position setting drum for terry erase!**	Warning

Refer to the menu: **Setup menu drum for terry**
The operation was performed successfully.
The message confirms that: The Reset operation is completed properly.
The result of this operation is the restoration of the default, as defined in the Eprom.

53.2: **Save angular position drum terry not correctly performed**	Warning

Informs of the presence of saving problems or wrong data.
Go back to the menu and try again. Or … Reboot the machine and repeat the operation. If the problem persists, please contact the Technical Customer Service.

53.3:   **Save angular position drum terry correctly performed**   Warning

The operation was performed successfully.

53.4:   **Position for selection NEXT acquired!**   Warning

Forward = normal rotation of the cylinder .
The operation was performed successfully.

53.5:   **__raccordo__**   Warning

Position for selection BACK acquired!

Backward = reversed rotation of the cylinder .

54.

Do not currently managed.

55.

Do not currently managed.

56.

Do not currently managed.

57.

Do not currently managed.

58.

Do not currently managed.

59. Link change settings

Reference

Refer to the menu: **Link change settings**

See also the menu: **Link list**

59.0:	Concatenation data saving (file.cn) performed correctly	Warning

The operation was performed successfully.

59.1:	Concatenation data resetting (file.cn) performed correctly	Warning

Do not currently managed.

DC88 machines

This message indicates the Short-Circuit (40._, 43._, 60._) or the Load not connected (41._, 44._, 61._) to an output machine.
The message specifies the position of the output.

The position of the solenoid valve depends on the model.
The value is shown in the tables on the following pages.
The boards controlling the pneumatic solenoid valves are called "bars".

The first number expresses: Solenoid valves bar (number of the board).
The second digit shows: the position of the solenoid valve .

There are three types of solenoid valves: Normally Closed (NC), Normally Open (NO) and Bistable.
The command provided to these solenoid valves corresponds to the presence of the 24 Vdc voltage on their poles.
NC = The air is present at the exit of the Solenoid valve when command is active.
NO = The air is present at the exit of the Solenoid valve when command is NOT active.
In the third case (Bistable) the Solenoid valve switches its output (Closed/ Open) only when arrives the specific command.
Bistable solenoid valves maintain the status in which they are when the electric power goes off.

The bars are specific for monostable and bistable solenoid valves.
The bistable solenoid valves have 3 pins and require the specific 3719 PCB board.
However …
It is possible to mount a bistable EV on a monostable bar, if the adjacent place is kept free.

First …
Here is the complete list of messages from this group.
After which …
The specific tables for each model will follow.
(The position of the solenoid valve depends on the model.)

Command output

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.

Concerning this see the menu: **Autotest menu**

In particular: **Manual commands menu**
In particular: **Autotest various outputs**

See also the menu: **Manual EV**

For further information, refer to the brochure: **Serial line repair.**

Message	Solenoid valve	DC88X-1	DC88X-1J	DC880X-1	DC880X-1J	DC88X-2	DC880X-2S	DC880X-2
.20	Knit drop blower 2					9. 3	9. 3	9. 3
.21	Latch opener air blow	9. 3	9. 3	9. 3	9. 3			
.22	Latch opener feed 1 air blow					7. 6	7. 6	7. 6
.23	Latch opener feed 2 air blow					7. 7	7. 7	7. 7
.27	Sock extraction air blowing	10. 2	10. 2			10. 2	10. 2	10. 2
.28	Trapper air blow feed 1	10. 1	10. 1	10. 1	10. 1	7. 4	7. 4	7. 4
.29	Feed 2 cutter blower					10. 1	10. 1	10. 1
.30	Stop needles control	15. 7	15. 7	15. 7	15. 7			
.31	Feed 1 needles control pin					13. 8	13. 8	13. 8
.32	Feed 2 needles control pin					3. 1	3. 1	3. 1
.33	Stop sliders control	11. 8	11. 8	11. 8	11. 8	13. 7	13. 7	13. 7
.34	Needles control in heel/toe	15. 8	15. 8	15. 8	15. 8	19. 6	19. 6	19. 6
.35	Feed 2 knit pin					6. 7	6. 7	6. 7
.36	Feed 2 yarn finger unit working					12. 3		
.37	Feed 2 yarn finger unit out of work					12. 1		
.39	Heel ret. stich cam lock piston	12. 7	12. 7			12. 7		
.40	Feed 2 plain stitch cam locking piston					8. 1	8. 1	8. 1
.41	Extraction picker guard	12. 6	12. 6			12. 8		
.42	Cylinder stop piston	10. 3	10. 3			10. 3		
.44	Tail lengthening piston					15. 7	15. 7	15. 7
.45	Heel Toe take-up 1	23. 4	23. 4	23. 4	23. 4	23. 4	23. 4	23. 4
.46	Heel Toe take-up 2	23. 3	23. 3	23. 3	23. 3	23. 3	23. 3	23. 3
.47	Heel Toe take-up 3	23. 2	23. 2	23. 2	23. 2	23. 2	23. 2	23. 2
.48	Heel Toe take-up 4	23. 1	23. 1	23. 1	23. 1	23. 1	23. 1	23. 1
.49	Heel Toe take-up 5	28. 8	28. 8	28. 8	28. 8	28. 8	28. 8	28. 8
.50	Heel Toe take-up 6	28. 7	28. 7	28. 7	28. 7	28. 7	28. 7	28. 7
.51	Trapper Finger 1 Feed 1	11. 1	11. 1	11. 1	11. 1	8. 8	8. 8	8. 8
.52	Trapper Finger 2 Feed 1	11. 2	11. 2	11. 2	11. 2	8. 7	8. 7	8. 7
.53	Trapper Finger 3 Feed 1	11. 3	11. 3	11. 3	11. 3	8. 6	8. 6	8. 6
.54	Trapper Finger 4 Feed 1	11. 4	11. 4	11. 4	11. 4	8. 5	8. 5	8. 5
.55	Trapper Finger 5 Feed 1	11. 5	11. 5	11. 5	11. 5	8. 4	8. 4	8. 4
.56	Trapper Finger 6 Feed 1	11. 6	11. 6	11. 6	11. 6	8. 3	8. 3	8. 3
.57	Trapper Finger 7 Feed 1	11. 7	11. 7	11. 7	11. 7	8. 2	8. 2	8. 2

Ev = Solenoid valve

The first number expresses: Solenoid valves bar (number of the board).

The second digit shows: the position of the solenoid valve .

		DC88X-1	DC88X-1J	DC880X-1	DC880X-1J	DC88X-2	DC880X-2S	DC880X-2
	Message / Solenoid valve							
.58	Trapper Finger 1 Feed 2					15. 6	15. 6	15. 6
.59	Trapper Finger 2 Feed 2					15. 5	15. 5	15. 5
.60	Trapper Finger 3 Feed 2					15. 4	15. 4	15. 4
.61	Enter Finger 1 Feed 1	26. 6	26. 6	26. 6	26. 6	26. 6	26. 6	26. 6
.62	Exit Finger 1 Feed 1	26. 5	26. 5	26. 5	26. 5	26. 5	26. 5	26. 5
.63	Positioning 1 Finger 1 Feed 1	26. 4	26. 4	26. 4	26. 4	26. 4	26. 4	26. 4
.64	Enter Finger 2 Feed 1	26. 2	26. 2	26. 2	26. 2	26. 2	26. 2	26. 2
.65	Exit Finger 2 Feed 1	26. 1	26. 1	26. 1	26. 1	26. 1	26. 1	26. 1
.66	Positioning 1 Finger 2 Feed 1	25. 8	25. 8	25. 8	25. 8	25. 8	25. 8	25. 8
.67	Positioning 2 Finger 2 Feed 1	25. 7	25. 7	25. 7	25. 7	25. 7	25. 7	25. 7
.68	Translation Finger 2 Feed 1	26. 3	26. 3	26. 3	26. 3	26. 3	26. 3	26. 3
.69	Enter Finger 3 Feed 1	25. 6	25. 6	25. 6	25. 6	25. 6	25. 6	25. 6
.70	Exit Finger 3 Feed 1	25. 5	25. 5	25. 5	25. 5	25. 5	25. 5	25. 5
.71	Positioning 1 Finger 3 Feed 1	25. 4	25. 4	25. 4	25. 4	25. 4	25. 4	25. 4
.72	Positioning 2 Finger 3 Feed 1	25. 3	25. 3	25. 3	25. 3	25. 3	25. 3	25. 3
.73	Translation Finger 3 Feed 1	25. 2	25. 2	25. 2	25. 2	25. 2	25. 2	25. 2
.74	Enter Finger 4 Feed 1	26. 8	26. 8	26. 8	26. 8	26. 8	26. 8	26. 8
.75	Exit Finger 4 Feed 1	24. 8	24. 8	24. 8	24. 8	24. 8	24. 8	24. 8
.76	Positioning 1 Finger 4 Feed 1	26. 7	26. 7	26. 7	26. 7	26. 7	26. 7	26. 7
.77	Positioning 2 Finger 4 Feed 1	24. 7	24. 7	24. 7	24. 7	24. 7	24. 7	24. 7
.78	Translation Finger 4 Feed 1	25. 1	25. 1	25. 1	25. 1	25. 1	25. 1	25. 1
.79	Enter Finger 5 Feed 1	24. 6	24. 6	24. 6	24. 6	24. 6	24. 6	24. 6
.80	Exit Finger 5 Feed 1	24. 5	24. 5	24. 5	24. 5	24. 5	24. 5	24. 5
.81	Positioning 1 Finger 5 Feed 1	24. 4	24. 4	24. 4	24. 4	24. 4	24. 4	24. 4
.82	Translation Finger 5 Feed 1	24. 3	24. 3	24. 3	24. 3	24. 3	24. 3	24. 3
.83	Enter Finger 6 Feed 1	24. 2	24. 2	24. 2	24. 2	24. 2	24. 2	24. 2
.84	Exit Finger 6 Feed 1	24. 1	24. 1	24. 1	24. 1	24. 1	24. 1	24. 1
.85	Positioning 1 Finger 6 Feed 1	23. 8	23. 8	23. 8	23. 8	23. 8	23. 8	23. 8
.86	Enter Finger 7 Feed 1	23. 6	23. 6	23. 6	23. 6	23. 6	23. 6	23. 6
.87	Exit Finger 7 Feed 1	23. 5	23. 5	23. 5	23. 5	23. 5	23. 5	23. 5
.88	Positioning 1 Finger 7 Feed 1	23. 7	23. 7	23. 7	23. 7	23. 7	23. 7	23. 7
.89	Enter Finger 1 Feed 2					16. 1	16. 1	16. 1
.90	Exit Finger 1 Feed 2					16. 2	16. 2	16. 2
.91	Positioning 1 Finger 1 Feed 2					16. 3	16. 3	16. 3
.92	Positioning 1 Finger 1 Feed 2					16. 4	16. 4	16. 4
.93	Enter Finger 2 Feed 2					16. 5	16. 5	16. 5
.94	Exit Finger 2 Feed 2					16. 6	16. 6	16. 6
.95	Positioning 1 Finger 2 Feed 2					16. 7	16. 7	16. 7
.96	Positioning 2 Finger 2 Feed 2					16. 8	16. 8	16. 8
.97	Enter Finger 3 Feed 2					15. 1	15. 1	15. 1
.98	Exit Finger 3 Feed 2					15. 2	15. 2	15. 2
.99	Positioning 1 Finger 3 Feed 2					15. 3	15. 3	15. 3
.100	B.8 Slider-Push. Transfer top cyl.	15. 5	15. 5	15. 5	15. 5			
.101	B.21 Intermediat transfer slider presser	13. 1	13. 1	13. 1	13. 1			
.102	Upper transfer slider presser					5. 1	5. 1	5. 1
.103	Lower transfer slider presser					15. 8	15. 8	15. 8
.104	L.23 Raising sliders for sewing	12. 3						
.105	B.24 Clearing cam feed 1	12. 2	12. 2					
.110	B.14 Central cam	12. 1	12. 1					
.111	Central Cam					12. 6		
.112	L.15 Floating going heel - long	12. 4						
.113	L.16 Floating going heel - short	12. 5						
.114	L.17 Recall heel - long	13. 5	13. 5	13. 5	13. 5			
.115	L.18 Exit heel cam - short	13. 6	13. 6	13. 6	13. 6			
.116	L.19 Bottom cyl. selection - long	13. 3	13. 3	13. 3	13. 3			
.117	L.20 Bottom cyl. Selection - short	13. 4	13. 4	13. 4	13. 4			
.118	B.22 Sliders deviation cam bot.cyl.	13. 2	13. 2	13. 2	13. 2			
.119	Latch guard cam raiser	15. 6	15. 6	15. 6	15. 6			

Ev = Solenoid valve

The first number expresses: Solenoid valves bar (number of the board).

The second digit shows: the position of the solenoid valve .

Message Solenoid valve	DC88X-1	DC88X-1J	DC880X-1	DC880X-1J	DC88X-2	DC880X-2S	DC880X-2
.120 Latch guard 1 cam raiser					5. 5	5. 5	5. 5
.121 Latch guard 2 cam raiser					5. 6	5. 6	5. 6
.122 L.1 Top cylinder feed lever - long	16. 1	16. 1	16. 1	16. 1			
.123 L.2 Top cylinder feed lever -short	16. 2	16. 2	16. 2	16. 2			
.124 L.3 Welt lever - long	16. 3	16. 3	16. 3	16. 3			
.125 L.4 Welt lever - short	16. 4	16. 4	16. 4	16. 4			
.126 L.5 Welt lever - all	16. 5	16. 5	16. 5	16. 5			
.127 L.6 Top cylinder selection - long	16. 6	16. 6	16. 6	16. 6			
.128 L.7 Top cylinder selection - short	16. 7	16. 7	16. 7	16. 7			
.129 B.9 Links mobile cam	16. 8	16. 8	16. 8	16. 8			
.130 Mobile links cam					4. 1	4. 1	4. 1
.131 Clearing cam					12. 5		
.132 Upper feed 1 long					4. 2	4. 2	4. 2
.133 Upper feed 1 short 2					4. 3	4. 3	4. 3
.134 Upper feed 1 short 1					4. 4	4. 4	4. 4
.135 Upper feed 2 long					3. 2	3. 2	3. 2
.136 Upper feed 2 short 2					3. 3	3. 3	3. 3
.137 Upper feed 2 short 1					3. 4	3. 4	3. 4
.138 Lower feed 2 long					14. 1	14. 1	14. 1
.139 Lower feed 2 short 2					14. 2	14. 2	14. 2
.140 Lower feed 2 short 1					14. 3	14. 3	14. 3
.141 Upper selection long					5. 2	5. 2	5. 2
.142 Upper selection short 2					5. 3	5. 3	5. 3
.143 Upper selection short 1					5. 4	5. 4	5. 4
.144 Lower selection long					14. 4	14. 4	14. 4
.145 Lower selection short 2					14. 5	14. 5	14. 5
.146 Lower selection short 1					14. 6	14. 6	14. 6
.147 Feed 1 floating long					13. 3	13. 3	13. 3
.148 Feed 1 floating short 2					13. 2	13. 2	13. 2
.149 Feed 1 floating short 1					13. 1	13. 1	13. 1
.150 Feed 1 welt long					4. 5	4. 5	4. 5
.151 Feed 1 welt short 2					4. 6	4. 6	4. 6
.152 Feed 1 welt short 1					4. 7	4. 7	4. 7
.153 Feed 1 welt 1000					4. 8	4. 8	4. 8
.154 Feed 2 welt long					3. 5	3. 5	3. 5
.155 Feed 2 welt short 2					3. 6	3. 6	3. 6
.156 Feed 2 welt short 1					3. 7	3. 7	3. 7
.157 Feed 2 welt 1000					3. 8	3. 8	3. 8
.158 Memory Cam feed 2, stage 1					14. 7	14. 7	14. 7
.159 Memory Cam feed 2, stage 2					14. 8	14. 8	14. 8
.160 Feed 2 leveller cam					12. 4		

Ev = Solenoid valve

The first number expresses: Solenoid valves bar (number of the board).

The second digit shows: the position of the solenoid valve .

Message / Solenoid valve	DC88X-1	DC88X-1J	DC880X-1	DC880X-1J	DC88X-2	DC880X-2S	DC880X-2
.162 Stop yarn antibreak control 1	I. 1	I. 1	I. 1	I. 1	I. 1	I. 1	I. 1
.163 External stop lamp	I_BIS. 3	I_BIS. 3	I_BIS. 3	I_BIS. 3	I_BIS. 3	I_BIS. 3	I_BIS. 3
.164 Free function 1	9. 1	9. 1	9. 1	9. 1	7. 3	7. 3	7. 3
.165 Free function 2	I_BIS. 7	I_BIS. 7	I_BIS. 7	I_BIS. 7	I_BIS. 7	I_BIS. 7	I_BIS. 7
.166 Free function 3	I_BIS. 6	I_BIS. 6	I_BIS. 6	I_BIS. 6	I_BIS. 6	I_BIS. 6	I_BIS. 6
.167 Free function 4	I_BIS. 5	I_BIS. 5	I_BIS. 5	I_BIS. 5	I_BIS. 5	I_BIS. 5	I_BIS. 5
.168 Bag 1 collection socks	I_BIS. 2	I_BIS. 2	I_BIS. 2	I_BIS. 2	I_BIS. 2	I_BIS. 2	I_BIS. 2
.169 Bag 2 collection socks	I_BIS. 1	I_BIS. 1	I_BIS. 1	I_BIS. 1	I_BIS. 1	I_BIS. 1	I_BIS. 1
.170 Lower sliders deviation cam					13. 4	13. 4	13. 4
.171 Enter latch for head locking	14. 6	14. 6	14. 6	14. 6	6. 5	6. 5	6. 5
.172 Exit latch for head locking	15. 4	15. 4	15. 4	15. 4	6. 6	6. 6	6. 6
.173 Pulley lock piston	14. 5	14. 5			6. 8		
.174 External lighting							
.175 Cylinder knit pusher pos. 1	31. 5	31. 5			31. 5		
.176 Yarn ctrl. in sock extract.	31. 6	31. 6			31. 6		
.177 Tung.dev. stop piston low	33. 6	33. 6			33. 6		
.178 Knit transfer piston up	31. 8	31. 8			31. 8		
.179 Knit transfer piston down	32. 1	32. 1			32. 1		
.180 Sock-in-work presence control rod	32. 2	32. 2			32. 2		
.181 Cylinder knit pusher	32. 3	32. 3			32. 3		
.182 Pickup piston out	32. 4	32. 4			32. 4		
.183 Pickup piston in	32. 5	32. 5			32. 5		
.184 Sewing rollerbackward	32. 6	32. 6			32. 6		
.185 Sewing roller forward	32. 7	32. 7			32. 7		
.186 Seaming device cutter	32. 8	32. 8			32. 8		
.187 Pin holder unit rot. lever.	33. 1	33. 1			33. 1		
.188 Pin holder support	33. 2	33. 2			33. 2		
.189 Pin holder knit pusher	33. 3	33. 3			33. 3		
.190 Turning piston up - UP	31. 1	31. 1			31. 1		
.191 Turning Piston up - DOWN	33. 5	33. 5			33. 5		
.192 Sock stretching sector	33. 4	33. 4			33. 4		
.193 Tube stop cam t.dev.up rel.	33. 7	33. 7			33. 7		
.194 Tube stop cam t.dev.up stop	33. 8	33. 8			33. 8		
.195 Stitching mach. insp. lamp	34. 8	34. 8			34. 8		
.196 Machine inspection lamp	I. 2	I. 2	I. 2	I. 2	I. 2	I. 2	I. 2
.197 Air blast cuff	31. 3	31. 3			31. 3		
.198 Knit pusher side shifting	31. 4	31. 4			31. 4		
.199 Toe pouch blower	31. 7	31. 7			31. 7		
.200 seamer 2 inspection light	I. 3	I. 3			I. 3		
.201 B.25 Feed 1 leveller cam		12. 3					
.202 Tails reduction blower					9. 1	9. 1	9. 1
.203 Tail knitting blower	9. 2	9. 2	9. 2	9. 2	9. 2	9. 2	9. 2
.204 Generic blower	10. 8	10. 8	10. 8	10. 8	10. 8	10. 8	10. 8
.205 Anti-pinhole piston EXIT					13. 5	13. 5	13. 5
.206 Anti-pinhole piston ENTER					13. 6	13. 6	13. 6
.207 Mechanical Take-Down	14. 4	14. 4	14. 4	14. 4	6. 2	6. 2	6. 2
.208 L.26 Double welt	15. 1	15. 1	15. 1	15. 1			
.209 Tails and Stitch clearing air blow	9. 5	9. 5	9. 5	9. 5	9. 5	9. 5	9. 5
.210 Stitch rising air blow	9. 6	9. 6			9. 6		
.211 Heel sack piston lowering							
.212 Heel sack piston raising							
.213 Mechanical Take-Down pressure 1							
.214 Mechanical Take-Down pressure 2							

Ev = Solenoid valve

The first number expresses: Solenoid valves bar (number of the board).

The second digit shows: the position of the solenoid valve .

Signal input

The sensor is a switch that is opened (or closed) by a physical parameter.
[For further information see also: Wikipedia.org].
The sensor provides the software a signal. [Input   ].
Namely … The sensors transmit electrical signals to the processor to stop the machine in case of failure.
[Therefore: The input (and/or sensor) is also called "stop".]
In practice: Input sensors detect that the operation progresses correctly and safely for the operator.

If a signal does not comply with the safety conditions, a specific error will appear.
Concerning this see the menu: **Autotest of inputs**

By false error is meant a defect signal not generated by an actually dangerous situation but only electric disturbances and/or hardware defects.

Position of machine inputs

The section indicates the position of the inputs.
Furthermore …
There is indicated the signal value with sensor NOT in reading.
Remember that:

Green Led = The sensor is "Normally Open" type.
When the sensor is reading, the input Autotest LED colour is … **Red** .

Red Led = The sensor is "Normally Closed" type.
When the sensor is reading, the input Autotest LED colour is … **Green** .

Concerning this see the menu: **Autotest of inputs**

Command output

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 a sensor detects a movement, it is automatically associated with that output.
For the most important movements, the actuator is controlled by one/ two sensors.
A sensor detects the final position and another one the initial position.

Concerning this see the menu: **Manual commands menu**
See also the menu: **Step motors menu**

CTE models

Refer to the menu: **Linker Motor**

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. (I/O = Input / Output)
The board signals are coded and sent through a closed-loop circuit. The boards are placed in series along this loop.
The serial line circuit originates from the board Pcb 2010.
From here the serial line then reaches all the various Input and Output boards (located outside the electrical panel).
Main inputs board is the Pcb 4866.

Seaming Robot (CTE models)

The models equipped with the aforementioned device are equipped with a 3896 PCB board.
This board receives the input signals related to the device.

To solve the problem

Solve the real problem that has caused the error.
In particular … See the pages that follow.
If the control device has not intervened, proceed as follows.

In this case, refer to the section: **In the event of a false error …**   (Enclosure)

Table : Messages and software inputs correspondence

For all models	

Message		Input
62.0	Lack of power 36 VDC	Pcb 2010, J36, p01
62.1	Lack of power phase	Pcb 2010, J36, p02
62.2	Caution: cylinder carter open	Pcb 2010, J41
62.3	Lack of power 15 VDC positive	Pcb 2010, Internal
62.4	Lack of power 15 VDC negative	Pcb 2010, Internal
62.5	Lack of power 24 VDC serial line	i. 12
62.6	Lack of power 24 VDC yarnfingers unit	i. 11
62.7	Lack of power 24 VDC solenoid-valves unit	i. 10
62.8	Lack of power 24 VDC external expansion board	i. 9
62.9	Suction hood open	i. 36
62.10	Lack of air pressure	i. 35
62.11	Crank	i. 64
62.12	Stop yarn sensors	i. 32
62.13	Winders	i. 34
62.14	Bobbin End (Input not currently used.)	/
62.15	Yarn creel	i. 31
62.16	Sock ejection not detected (Sock passage 1)	i. 7
62.17	Sock ejection not detected (Sock passage 2)	i. 8
62.18	Yarn antibreak control	i. 6
62.19	… 62.29	(1)
62.30	Stop elastic 1	_ (2)
62.31	Stop elastic 2	_ (2)

Input :   To this end, see table:
    Matching software and hardware inputs (**Enclosure**)

 i. :   input (input code for the software = software input)

(1)   See the pages that follow. [**Warnings relating to an operation (start, in progress, end).**]
(2)   See the pages that follow. [**Stop elastic**]

Message		Input	associated output
62.32	Stop heel take up	i. 60	/
62.33	Needles stop	i. 61	.30
62.34	Heel needle stop	i. 62	.34
62.35	Uncut yarn detector	i. 101	/
62.36	Stop sliders breaking	i. 104	.33
62.37	Stop sliders breaking 1	i. 103	/
62.38	Stop sliders breaking 2	i. 102	/
62.40	Needles stop feed 1	i. 100	.31
62.41	Needles stop feed 2	i. 68	.32
62.42	Feed 2 knit stop	i. 62	.35
62.43	L.1 Top cylinder feed lever - long	i. 65	.122
62.44	L.2 Top cylinder feed lever -short	i. 66	.123
62.45	L.3 Welt lever - long	i. 67	.124
62.46	L.4 Welt lever - short	i. 68	.125
62.47	L.5 Welt lever - all	i. 69	.126
62.48	L.6 Top cylinder selection - long	i. 70	.127
62.49	L.7 Top cylinder selection - short	i. 71	.128
62.54	B.14 Central cam B	i. 42	.111
62.55	L.15 Heel forward floating - long	i. 45	.112
62.56	L.16 Heel forward floating - short	i. 46	.113
62.57	L.17 Recall heel - long	i. 28	.114
62.58	L.18 Exit heel cam - short	i. 27	.115
62.59	L.19 Bottom cyl. selection - long	i. 26	.116
62.60	L.20 Bottom cyl. Selection - short	i. 25	.117
62.61	B.22 Intermediate slider deviation cam	i. 89	.118
62.62	L.23 Raising sliders for sewing	i. 47	.104
62.63	B.24 Clearing cam B	i. 48	.105
62.64	Pulley locking piston: out	i. 58	.173
62.65	Pulley locking piston: inserted	i. 59	.173

Input :   To this end, see table:
Matching software and hardware inputs (**Enclosure**)

i. :   input (input code for the software = software input)

associated output :   We indicate the message code to refer to.
    60. … = SHORT CIRCUIT ; 61. … = NOT CONNECTED

Message		Input	associated output
62.66	Head movement enabling bolt	i. 63	.172
62.67	Head bolt in pick-up position	i. 95	.171
62.68	Head bolt in sock production position	i. 96	.171
62.69	L.1 Upper selection short 2	i. 65	.142
62.70	L.2 Upper selection short 1	i. 66	.143
62.71	L.3 Upper selection long	i. 67	.141
62.72	L.4 Upper feed 1 short 2	i. 85	.133
62.73	L.5 Upper feed 1 short 1	i. 84	.134
62.74	L.6 Upper feed 1 long	i. 86	.132
62.75	L.7 Feed 1 welt 1000	i. 77	.153
62.76	L.8 Feed 1 welt short 2	i. 79	.151
62.77	L.9 Feed 1 welt short 1	i. 78	.152
62.78	L.10 Feed 1 welt long	i. 80	.150
62.79	L.11 Upper feed 2 short 2	i. 82	.136
62.80	L.12 Upper feed 2 short 1	i. 81	.137
62.81	L.13 Upper feed 2 long	i. 83	.135
62.82	L.14 Feed 2 welt 1000	i. 73	.157
62.83	L.15 Feed 2 welt short 2	i. 75	.155
62.84	L.16 Feed 2 welt short 1	i. 74	.156
62.85	L.17 Feed 2 welt long	i. 76	.154
62.86	L.18 Lower selection short 2	i. 25	.145
62.87	L.19 Lower selection short 1	i. 26	.146
62.88	L.20 Lower selection long	i. 27	.144
62.89	L.21 Lower feed 2 short 2	i. 28	.139
62.90	L.22 Lower feed 2 short 1	i. 29	.140
62.91	L.23 Lower feed 2 long	i. 30	.138
62.92	L.24 Feed 1 floating short 2	i. 91	.148
62.93	L.25 Feed 1 floating short 1	i. 92	.149
62.94	L.26 Feed 1 floating long	i. 93	.147
62.95	B.30 Sliders deviation cam	i. 89	.170
62.96	B.31 Clearing cam B	i. 43	.131
62.97	B.32 Central cam B	i. 42	.111
62.98	B.33 Anti-pinhole piston	i. 94	.43
62.99	B.34 Feed 2 leveller cam B	i. 44	.160
62.100	B.35 Feed 2 memory step 1	i. 37	.158
62.101	B.35 Feed 2 memory step 2	i. 38	.159
62.102	Fingers group feed 2 , pos. A	i. 45	.36
62.103	Fingers group feed 2 , pos. B	i. 46	.37

Input :   To this end, see table:
              Matching software and hardware inputs (**Enclosure**)

i. :   input (input code for the software = software input)

associated output :   We indicate the message code to refer to.
              60. … = SHORT CIRCUIT ; 61. … = NOT CONNECTED

Message	Input	associated output
62.105 … 62.108		(1)
62.109 B.31 Clearing cam A	i. 54	.131
62.110 B.32 Central cam A	i. 55	.111
62.111 B.34 Feed 2 leveller cam A	i. 53	.160
62.112 B.14 Central cam A	i. 55	.110
62.113 L.26 Double welt	i. 72	.208
62.114 B.24 Clearing cam A	i. 49	.105
62.115 B.25 Feed 1 leveller cam B	i. 50	.201
62.116 B.25 Feed 1 leveller cam A	i. 51	.201
62.117 Stop elastic 2	*See below on the page.*	

Input :   To this end, see table:
           Matching software and hardware inputs (**Enclosure**)

i. :   input (input code for the software = software input)

associated output :   We indicate the message code to refer to.
           60. … = SHORT CIRCUIT ; 61. … = NOT CONNECTED

(1) Note

Warnings relating to an operation (start, in progress, end).

62.19   Zeroing accepted
62.20   MOTOR resetting
62.21   Zeroing completed
62.22   Mechanical Reset: START
62.23   Mechanical Reset: END
62.24   TRACCIA1-Belant
62.25   TRACCIA2-Belant
62.26   TRACCIA3-Belant
62.27   Zeroing: starting cam movements
62.28   Zeroing: end of cam movements
62.29   Zeroing in heel zone. Wait for synchronism
62.105   VPE valve in manual state. Normal functioning resumes with machine running
62.106   Start zeroing
62.107   Zeroing: stop chain [F1] can be inserted now
62.108   Zeroing: stop chain [F1] disabled

The Warnings (Notifications) appear in the low part of the display.
The Warnings inform about the machine status or the operation in progres.
Or … The message indicates the next operation.

(2) Note

Stop elastic

For all models		
Message	**Input**	**associated output**
62.30 Stop elastic 1	(a)	(b)
62.31 Stop elastic 2 [configuration : 2 Elastic 1 Motor]	(a)	(b)
62.117 Stop elastic 2 [configuration : 2 Elastic 2 Motor]	(c)	(d)

(a) connector on motor board (elastic motor 1) , CAN type RX board
(b) elastic motor 1
(c) connector on motor board (elastic motor 2) , CAN type RX board
(d) elastic motor 2

Note for the models prepared with: Seaming Robot (CTE)

Refer to the menu: **Autotest of inputs**
In particular: **Input Autotest external closed toe**

For further information, refer to the brochure: **Position of machine inputs**

Furthermore …
See the description provided for the message: 48. …
When the robot stops, the machine stops at the sock pick-up point.
See the description provided for the message: 66. …
This type of message causes the Robot stop.
Furthermore: The machine stops.

Furthers informations are available in the chapter: **Classification of messages**

62.0: **Lack of power 36 VDC**

Do not currently managed.

62.1: **Lack of power phase** Error - Movement impossible

Signal generation: Pcb 3787B/1
Signal path: Pcb 3787B/1, J3 - Pcb 3812, J6 - Pcb 2010, J36
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.

Check the presence of the Line Phases in entry to the electronic equipment (Main switch).
Check the "line phases" connecting cables between:
main switch - Fuse board (Pcb 5802) - power autotransformer (Pcb 5803) - Pcb 3787B/1 .
Check the integrity of the fuses.
Check the connection cables for this signal along the indicated path.
Eventually replace the cables and/or the boards concerned.

After 4 seconds with a "Missing Phase" the Pcb 3812 board sends the Pcb 2010 board the "Black-out" signal.
This signal causes the start of the Black-out Procedure.
See the description provided for the message: **14.49**

62.2: **Caution: cylinder carter open** Error - Movement impossible

Do not currently managed.

62.3: **Lack of power 15 VDC positive** Error - Movement impossible

Voltage +/-15 Vdc is directly created on Pcb 2008 board.
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 board.
(Leds ON = tension OK)
In case of error, the only solution is: Replace the board.

62.4: **Lack of power 15 VDC negative** Error - Movement impossible

For the explanation/ solution, see what specified for the previous entry.

62.5: **Lack of power 24 VDC serial line** Error - Movement impossible

Signal generation: Pcb 4866
Signal management: Pcb 4866
If the message appears replace the board.
The actual lack of this voltage (24 Vdc) would prevent the board from working.
The user can see this particular situation, when is displayed in contemporary an error on Load not connected or Short-circuit.
Or a priority error message may appear relating to one of the inputs managed via this board.

See the following page.

Special case

The 24 Vdc output voltage from the board is used by various devices, and therefore on the board there are some protection resistors against the short-circuit (PTC).

Before the PTC opens the circuit, the possible lowering of the 24 Vdc voltage could generate this message.

Cut out part of the circuit to find out the faulty element. If the error disappears, one of the cut-out elements is faulty.

Disconnect all devices/boards downstream.

After which … Operation must be controlled from the dedicated menu. (See the reference set forth below.).

Proceed as follows if the error persists: Replace the board. (Pcb 4866).

Otherwise:

Connect a device/board downstream. Proceed with the following operations: Outputs autoconfiguration
Repeat the procedure until the error appears.

Replace the board concerned. / Replace the cables.

For further information, refer to the brochure: **Serial line repair.**

Refer to the menu: **Outputs autoconfiguration**

62.6:   Lack of power 24 VDC yarnfingers unit   Error **-** Movement impossible

First refer to what specified for the previous entry.
Signal generation: Pcb 3803
YF Bars
This board manages the solenoid valves related to the Yarn finger Carrier.
The bars identified with the numbers from "23" to "30" correspond to the modules mounted on the external interface board.

Signal management: Pcb 4866
This message appears when the Pcb 4866 external board does not detect a "Check 24 Vdc" signal.
The absent signal should come from the board indicated above.
(Pcb 3803, J5 - Pcb 4866, J10).
Check for the presence of a short circuit along the path.
(Pcb 4866 - Pcb 3803 - Solenoid valves).
Replace the defective component. / Replace the cables.

62.7:   Lack of power 24 VDC solenoid-valves unit   Error **-** Movement impossible

First refer to what specified for the previous entry.
Signal generation: Pcb 5748 (bar) + bars support board (comb).
Rear SV-box bars
Approximately, the bars identified with the numbers from "1" to "22" correspond to solenoid valves Bar assembled on rear box.

Signal management: Pcb 4866
This message appears when the Pcb 4866 external board does not detect a "Check 24 Vdc" signal.
The absent signal should come from the board indicated above.
(bars support board, J9 - Pcb 4866, J9).
Check for the presence of a short circuit along the path.
(Pcb 4866 - bars support board - bar - Solenoid valves).
Replace the defective component. / Replace the cables.

62.8: Lack of power 24 VDC external expansion board   Error **-** Movement impossible

See the description provided for the message: 62.5

Signal generation: Pcb 3896

<u>External Closed Toe bars</u> (Seaming Robot)

The bars identified with the numbers from "31" to "34" correspond to the modules mounted on the external interface board Pcb 3896.

This board manages the inputs and outputs related to the aforementioned device / group.

Signal management: Pcb 4866

This message appears when the Pcb 4866 external board does not detect a "Check 24 Vdc" signal.

The absent signal should come from the board indicated above.

(bars support board, J8 - Pcb 4866, J8).

Check for the presence of a short circuit along the path.

(Pcb 4866 - bars support board - bar   - Solenoid valves).

Replace the defective component. / Replace the cables.

62.9: Suction hood open   Error

The closure of the sock ejecton device is maintained during the condition "Vacuum Valve in suction".

This error mainly indicates the lack of sufficient suction in the Sock construction Tube.

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.

This control must be enabled through the insertion of a Code into the steps chain of the Sock program.

Therefore this error may appear only in the part of the Sock Program between the programming of the 2 codes (Enable and Control).

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 blocking the expulsion duct, prevent the closure of the device.

- Check that no cause prevent the correct closure of the device.
- Check programming from Graphitron.
- Check the correct position of the Vacuum Valve.

62.10: Lack of air pressure

This error is caused by the insufficient compressed air pressure in the pneumatic circuit.
A wire is connected to the end-run of pointer of the pressure gauge place at the entry of compressed air.
When the pressure is lowered the pointer touches the end-run.
The wire trasmits the stop signal to the machine.

62.11: Crank
Error

To manually rotate the cylinder it is necessary to insert a ratchet wrench.
The insertion point is protected by a cover. The presence of the protective casing is verified by a sensor.
The movement of the protective casing causes the appearance of this message and the disabling of the start-up.
In this condition it is possible to insert the ratchet wrench safely.
Vice versa … The start-up is allowed only if the cover is closed.

62.12: Stop yarn sensors
Error

This message informs the user that: The yarn has broken or end of reel.
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.
At least one of the wires results absent.

62.13: Winders
Error

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 1707/1 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 1707/1 board.

62.14: Bobbin End
Error

Do not currently managed.

62.15: Yarn creel
Error

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.
At least one of the wires results absent.
Through a cable is trasmitted this stop signal to the machine.

| **62.16:** | **Sock ejection not detected** | Error |

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.

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 signal.

| **62.17:** | **Sock ejection not detected** | Error |

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.

The device is present for Closed Toe models only.

| **62.18:** | **Yarn antibreak control** | Error |

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 the 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.

A "Flat" cable connects all the sensors and therefore is connected to another cable (shielded) coming from the inputs board.

| **62.19:** | **Zeroing accepted** | Warning |

This message informs the user that:

The Zeroing of the machine after pressing the [F0] key is begun.

This key is used to reset the program (i.e. move the machine to the end-of-cycle position).

The machine will perform all the resets, after which it will start the next sock cycle, unless keys F1 or F3 are active.

Wait for the message: 62.21

| **62.20:** | **MOTOR resetting** | Warning |

The message refers to the procedure called: Resetting

For the explanation/ solution, see what specified for the previous entry.

| **62.21:** | **Zeroing completed** | Warning |

The operation was performed successfully.

See in this regard as reported under the item: 62.19

62.22:   **Mechanical Reset: START**   **Warning**

This message can only appear on switching on.
Start the machine.

Or …
Use the crank to perform N turns to the cylinder.
Then will be possible press the [RUN] button.
Wait for the message that indicates completion of the operation.
Wait for the message: 62.23

Note for the models prepared with: Seaming Robot (CTE)

62.23:   **Mechanical Reset: END**   Warning

The operation was performed successfully.
For the explanation/ solution, see what specified for the previous entry.

62.24:   **TRACCIA1-Belant**   Warning

Code for internal use.
Internal software failure . Contact the Technical Customer Service.

62.25:   **TRACCIA2-Belant**   Warning

For the explanation/ solution, see what specified for the previous entry.

62.26:   **TRACCIA3-Belant**   Warning

For the explanation/ solution, see what specified for the previous entry.

62.27:   **Zeroing: starting cam movements**   Warning

The message refers to the procedure called: Resetting
See in this regard as reported under the item: 62.19

62.28:   **Zeroing: end of cam movements**   Warning

For the explanation/ solution, see what specified for the previous entry.

**62.29:**   **Zeroing in heel zone. Wait for synchronism**   Warning

For the explanation/ solution, see what specified for the previous entry.

To solve the problem

Solve the real problem that has caused the error.
If the control device has not intervened, proceed as follows.

In this case, refer to the section: **In the event of a false error …**   (Enclosure)
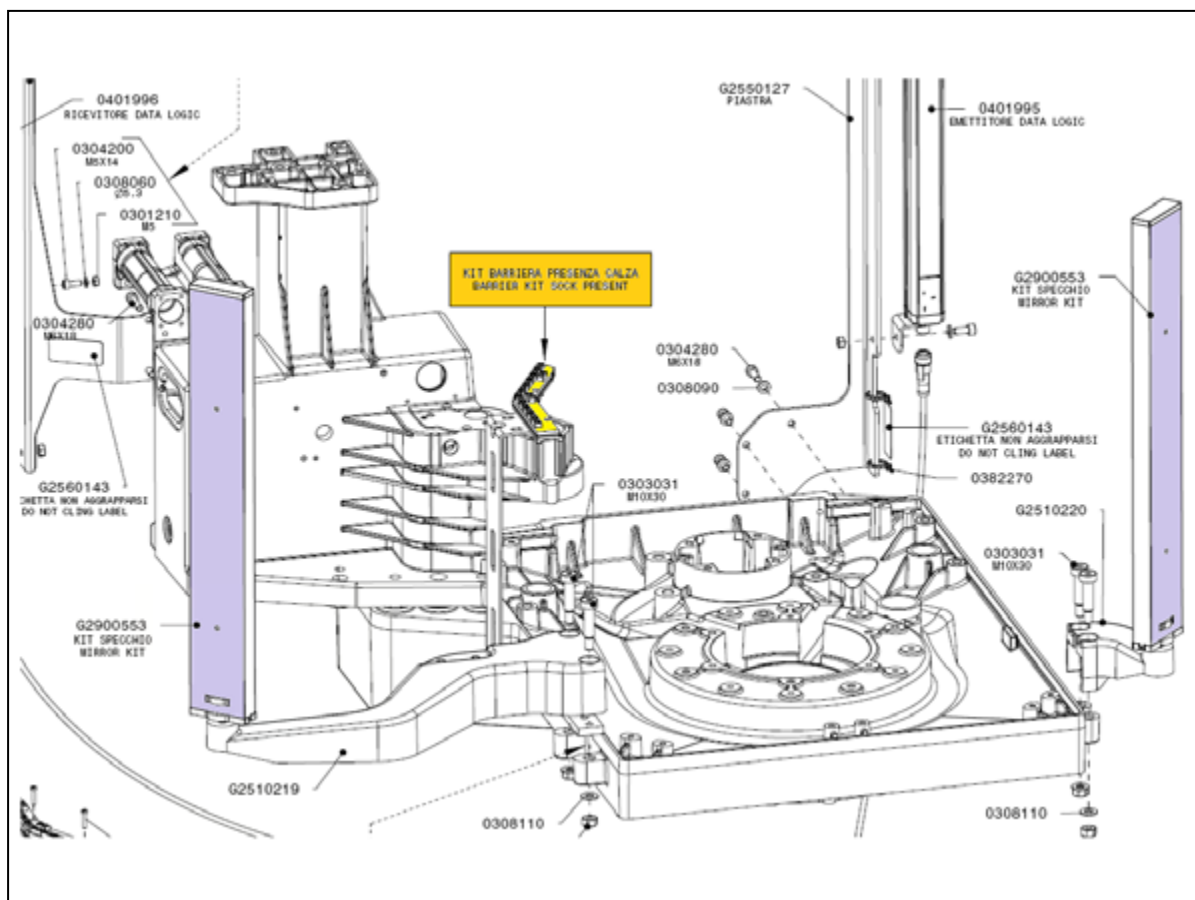
Reference

See the description provided for the message: **48.57**

Refer to the menu: **General setup external closed toe**
In particular, refer to item: **Sock present control kit**

See also the menu: **Menu versions**
In particular, refer to item: **Infrared barriers versions**

Temporarily disable

Concerning this see the menu: **Linker Motor**
In particular, refer to item: **Kit for sock presence control disable**

63.0:	**Tx impossible: %ls (%d)**	Error

See the description provided for the message: **31.5**

63.1:	**RX impossible: %ls (%d)**	Error

For the explanation/ solution, see what specified for the previous entry.

63.2:	**skCanIWSegnalazione 3: %ls (%d)**	Error

Do not currently managed.

63.3:	**CAN command syntax error: %ls (%d)**	Error

Internal software failure . Contact the Technical Customer Service.

63.4:	**FLASH writing in update: %ls (%d)**	Error

This mesage occurs during Updating of the CAN module (associated with the device indicated).
Repeat the Update operation, loading again the file "up" (software) in the FLASH memory and activate it.
If the problem persists: Replace the device.

64.   Mono-Actuators

Single-magnets are selection devices that cause the needles to move.
Some messages contain the term Needle instead of Pin because they are connected mechanically.
Indeed … **The device only operates on the Pins**

Reference

Refer to the menu: **Mono-Actuator setup menu**

See also the menu: **Mono-Actuator diagnostic menu**

See also: **Mono-Actuators board software version**

Legend

The message contains two variables.
In the message, the variable indicates:
%ls = This variable indicates: device number (Mono-Actuator) .
(%d) = This variable expresses the error via the code for internal use.

Each board can manage 4 devices.
Example : The device 7 will be on board 2.

64.0:   Reset: %ls (%d)   Alarm

Internal software failure . Contact the Technical Customer Service.
The message indicates that the software has detected the loss of the board operating parameters.
The card appears to have been reset.
Turn the machine off and on again.

Furthermore …
● Check the wiring that connect that connect the various boards.
Or …
● Replace the board concerned.

64.1:   Mono-Actuator: missing learning   Error

Concerning this see the menu: **Mono-Actuators learning**

In this window you can capture (learn) the angular position of the Mono-Actuators respect to the zero.
Perform calibration on completion of mechanical resetting. (Data acquisition.) .
Through the procedure the software compiles the table for the correct command of Mono-actuators.
The exit from the menu is performed the Mechanical Reset.

64.2:   Mono-Actuator: learning executed correctly   Warning

The operation was performed successfully.
Data has been acquired (stored) successfully.
The data are saved in the memory and therefore are an integral part of the machine.
The data are directly saved in the FLASH memory and become part of the "General Setup", and will not be lost.

64.3:	**Mono-Actuator: learning NOT executed correctly**	Warning

Message no longer menaged. Update the machine software .

The message has been replaced by more specific details

64. _ / a	**Messages related to the procedure called: Mono-Actuators learning**

Concerning this see the menu: **Mono-Actuators learning**

The Cylinder must be prepared for Self Learning.

Namely …

We must remove the 3 pins before and the 3 pins after the pin on the cylinder Zero (Pin/ Needle of zero-phase).

(= last three cylinder pins absent (-), pin 1 present (+), pins 2,3,4 absent (-)).

The message appears in the following circumstances:

During the Learning stage.

Therefore …

Stop the machine. Exit the menu.

The exit from the menu is performed the Mechanical Reset.

Go back to the menu and try again. Or … Reboot the machine and repeat the operation. If the problem persists, please contact the Technical Customer Service.

64.4:	**Mono-Actuator: TX CAN Mono-Actuator selection impossible**	Warning

Refer to the paragraph: **64. _ / a**

It seems that a board is not connected. At least one board does not communicate with the software.

See also the description provided for the message: **31.5**

64.5:	**Mono-Actuator: planned speed not reached**	Warning

The user must not intervene in any way during this phase.

The message appears if any irregularities occur during the procedure.

Wait for the message that indicates completion of the operation.

Have you probably forgotten to press the start button after the procedure start command?

Check if the motor movement has found mechanical obstacles or a very high resistance.

64.6:	**Mono-Actuator: learning timeout**	Warning

Refer to the paragraph: **64. _ / a**

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). At least one board does not communicate with the software.

64.7:	**Mono-Actuator: Acquired data processing timeout**	Warning

Refer to the paragraph: **64. _ / a**

A problem has been found during the data processing procedure.
The operation must be completed within a certain time, otherwise a message appears.

64.8:	**Mono-Actuator %ls not connected (%d)**	Error

Refer to the menu: **Setup enabling Mono-Actuators**

The message appears in the following circumstances:
When the machine is switched on.
The verification only occurs in this phase.

The enabled device is not connected.
The devices present must be enabled and those missing must be disabled.
Or …
● Check the wiring from the interface connector to the board.

Therefore …
The user must turn off the machine. (for verification   ) .

64.9:	**Current too high: %ls (%d)**	Alarm

The message indicates that the CAN board of the device indicated supplies more current than that allowed.
Check the power supply (voltage) of the board.
Check the wiring that connect that connect the various boards.

● Replace the board concerned.
● Replace the device.
● Check and if necessary replace all the hardware components linked to the Encoder counter.
● Replace the Encoder.

64.10:	**Excessive temperature: %ls (%d)**	Alarm

View the previous message.

64.11:	**Initialization failed %ls (%d)**	Alarm

The message appears in the following circumstances:
When the machine is switched on.
This message appears when there are not valid data (in the Setup area).
Turn the machine off and on again.
If the problem persists:
● Replace the board concerned.
If the problem persists, please contact the Technical Customer Service.

64.12:	**FLASH write update in progress %ls (%d)**	Alarm

In this regard, see the description provided for the message: **31.16**

64.13:	**Connection BUS %ls (%d)**	Alarm

The message states that:
The Single-magnet board and the Serializer board do not communicate each other.

Check the integrity of the connection "flat" cable between the two boards.
- Replace the board concerned.
- Check the wiring that connect that connect the various boards.
- Eventually replace the cables and/or the boards concerned.
- Replace the board Pcb 5755.
- Replace the board Pcb 2010.

64.14:	**Encoder counting %ls (%d)**	Alarm

Internal software failure . Contact the Technical Customer Service.

64.15:	**Signal not taken %ls (%d)**	Warning

See in this regard as reported under the item: **64. _ / a**

It seems that a board is not connected. At least one board does not communicate with the software.
- Check the wiring that connect that connect the various boards.
- Replace the device.
- Replace the board concerned.

64.16:	**Low level saturation signal %ls (%d)**	Warning

View the previous message.

64.17:	**High level saturation signal %ls (%d)**	Warning

View the previous message.

64.18:	**Cable connected in countrary way %ls (%d)**	Warning

View the previous message.
The device indicated has been connected with reversed polarity wires.

64.19:	**No one needle removed %ls (%d)**	Warning

Refer to the paragraph: **64. _ / a**

The Cylinder must be prepared for Self Learning.
Namely …
We must remove the 3 pins before and the 3 pins after the pin on the cylinder Zero (Pin/ Needle of zero-phase).

64.20:   **Mono-Actuator %ls number of missing needles %d first missing needle (%d)**   Warning

Message no longer menaged. Update the machine software .
See the next message.

64.20:   **Learning failed. Too many missing needles %d, first missing needle %d (%d)**   Warning

Refer to the paragraph: **64. _ / a**

Informs that the operation cannot be performed under the current circumstances.
In the message, the variable indicates … Watch beginning of section.   (**Legend**)

Furthermore …
%d = The first variable indicates: Number of pins not detected on the cylinder (in addition to the 6
needed)   [= qp] .
%d = The second variable indicates: first pin missing (after the 6 needed for the procedure)   [= 1p] .

The message states that:
Too many missing pins have been detected (compared to those needed).
In particular: qp > 8 .
[if … qp ≤ 8 then … See the description provided for the message: 64.38].

The machine stops upon completion of the process.
The undetected pin will be placed in front of the notch on the pin selection cam.
The part must be inserted or replaced.   [= 1p] .
After which … Repeat the procedure.

For more information, refer to the manual: **Mechanical Adjustments**

Or …
The message appears in the following circumstances:
The adjustment of the devices is incorrect.
Concerning this see the menu: **Mono-Actuators distance calibration**
In this case …
First …
Return the mechanical unit to the home position. [cylinder   ]

In case the problem remains:
Refer to the message: **64.15**

64.21:   **Removed less than needed needles %ls (%d)**   Warning

See in this regard as reported under the item: **64. _ / a**

The message states that:
Missing needles detected are less in number than those needed.

The Cylinder must be prepared for Self Learning.
Namely …
**We must remove the 3 pins before and the 3 pins after the pin on the cylinder Zero (Pin/ Needle
of zero-phase).**

In case the problem remains:
Refer to the message: **64.15**

64.22:	Isolated needle not found %ls (%d)	Warning

Message no longer menaged. Update the machine software .
See the next message.

64.22:	Learning failed. Isolated needle not found. Missing needles %d, first missing needle %d (%d)	Warning

First …
See the description provided for the message: **64.21**

Informs that the operation cannot be performed under the current circumstances.
The message states that:
Missing pins are correct in number but they arranged at random.

The machine stops upon completion of the process.
The undetected pin will be placed in front of the notch on the pin selection cam.
The part must be inserted or replaced.
After which … Repeat the procedure.

In case the problem remains:
Refer to the message: **64.15**

64.23:	Multiple isolated needles found %ls. Missing needles %d (%d)	Warning

First …
See the description provided for the message: **64.21**

The message confirms that:
More than one sequence isolating the pin has been detected.
%d = The second variable indicates: Total number of undetected needles on the cylinder, in addition to the first 3 .

Example

%d = 5 .
The message states that:
After the correct needle sequence (3 no - 1 yes - 3 no) the following sequence has been detected: 1 yes + 2 no.
In this situation it is not clear what is the needle ONE.

64.24:	Anomalous signal %ls (%d)	Warning

Refer to the message: **64.15**

64.25:	Mono-Actuator: Cylinder positioning failed	Warning

Refer to the paragraph: **64. _ / a**
Or: **64. _ / b**
(See the following page.)

Internal software failure . Contact the Technical Customer Service.

Proceed as follows to solve the problem:
See the description provided for the message: **33.2**

64. _ / b   Messages related to the procedure called: Mono-Actuators diagnostic

Concerning this see the menu: **Mono-Actuator diagnostic menu**

This message refers to the Testing program.
Therefore …
Stop the machine. Exit the menu.
The exit from the menu is performed the Mechanical Reset.
Go back to the menu and try again. Or … Reboot the machine and repeat the operation. If the problem persists, please contact the Technical Customer Service.

64.26:	Mono-Actuator: Missing pins searching finished	Warning

The operation was performed successfully.

64.27:	Mono-Actuator: Missing pins searching failed	Warning

Informs of the presence of saving problems or wrong data.
See in this regard as reported under the item: **64. _ / b**

64.28:	Mono-Actuator: Mono-Actuators distance calibration completed	Warning

The operation was performed successfully.

64.29:	MonoActuator: Mono-Actuators distance calibration failed	Warning

Informs of the presence of saving problems or wrong data.
See in this regard as reported under the item: **64. _ / b**

64.30:	Forced selection (ON) in progress.	Warning

Informs that the [ON] procedure has commenced.

Refer to the menu: **Manual EV**

In particular, refer to item: **Selection procedure forced "ON", only with F1.**

This function can be activated in the following cases:
- Links area knitting ,
- Links Jacquard area knitting .

The command is available at the following conditions:
- when is active the key F1 .

After which …

Operate the mechanical or electric handle (1 and 2) to rotate the cylinder a few turns.

At this point … All the needles will be in the low position (plain knit   ) .

In this way, it will be easier to identify the faulty part and replace it.

When maintenance is completed, proceed as follows:

Press this key again to deactivate this function.

When you press the key appears the message: 64.31

See also the menu: **Setup stop chain [F1]**

64.31:	Forced selection (ON) finished [remove stop chain F1]	Warning

View the previous message.

The message confirms that:

The procedure was completed.

64.32:	Mono-Actuator data reading, in progress.	Warning

Refer to the paragraph: **64. _ / b**

After which …

Concerning this see the menu: **Needles position**

Or …

See the menu: **Data acquiring**

In the first step the data is captured. [LOAD].

In the second step the data are stored in a file. [SAVE].

In this way is created a ".log" file that can be extracted from the machine through the USB utility.

Concerning this see the menu: **Export file log**

64.33:	Mono-Actuator %ls missing command (%d)	Error

The device failed to perform at least two consecutive commands.
At least two needles have not received the information.
Delete the message by pressing [F8].
If the problem persists, please contact the Technical Customer Service.

64.34:	Mono-Actuator %ls DEBUG %d (%d)	Error

Do not currently managed.

64.35:	Unexpected %ls Dinema internal (%d)	Warning

Internal software failure . Contact the Technical Customer Service.

64.36:	Inconsistent %ls Dinema internal (%d)	Warning

Refer to the paragraph: **64. _ / a**

The angle of the devices is known according to the model.
Therefore:
During the procedure … The software compare input data with those entered in the range.
This coherence control is the first evaluation: check that the parameters sent are not clearly erroneous.

Proceed as follows to solve the problem:
See also the description provided for the message: 64.15

For more information, refer to the manual: **Mechanical Adjustments**
In particular:
● Check the correct setting of the mechanical Zero.

64.37:	Forced %ls. XXX %d, XXX %d Dinema internal (%d)	Warning

Do not currently managed.

| 64.38: | Learning performed with possible further check required. Missing needles %d, first missing needle %d (%d) | Warning |

Refer to the paragraph: **64. _ / a**

The operation was performed successfully.
Data has been acquired (stored) successfully.
The data are saved in the memory and therefore are an integral part of the machine.
The data are directly saved in the FLASH memory and become part of the "General Setup", and will not be lost.

In the message, the variable indicates … Watch beginning of section.   (**Legend**)
Furthermore …
%d = The first variable indicates: Number of pins not detected on the cylinder (in addition to the 6 needed)   [= qp] .
%d = The second variable indicates: first pin missing (after the 6 needed for the procedure)   [= 1p] .

The message states that:
Too many missing pins have been detected (compared to those needed).
In particular: qp ≤ 8 .
[if … qp > 8 then … See the description provided for the message: 64.20].

The machine stops upon completion of the process.
The undetected pin will be placed in front of the notch on the pin selection cam.
The part must be inserted or replaced.   [= 1p] .
After which … Repeat the procedure.

For more information, refer to the manual: **Mechanical Adjustments**

Or …
The message appears in the following circumstances:
The adjustment of the devices is incorrect.
Concerning this see the menu: **Mono-Actuators distance calibration**
In this case …
First …
Return the mechanical unit to the home position. [cylinder]

In case the problem remains:
Refer to the message: **64.15**

| 64.39: | %ls management too slow (%d) | Error |

Internal software failure . Contact the Technical Customer Service.

| 64.40: | %ls management, needle is not sequent (%d) | Error |

Internal software failure . Contact the Technical Customer Service.

DC88 machines

This information only applies to the following models:
DC88 machines (double-cylinder models, for men's socks) .

Description

The main task of the Take down device is the tension of the sock and his recovery when has reached a certain length.

DC880X-2S models

Input
- Zero sensor (Heel sack-pusher piston)   i. 57   . *

for the other Models

The software verifies the movement of the device through an Encoder.
Input
- Encoder signal   Pcb 2010 , J26 .
- Zero sensor   (Take-Down)   i. 57   . *

Closed Toe

A motor is used to move the device.
Input
- Motor zero sensor   (Take-Down tube)   input integrated on the motor board .

Concerning this see the menu: **Step motors menu**

Reference

Refer to the message: **23.39**
See also: **Autotest various outputs**

Refer to the menu: **Take-Down setup**

See also the menu: **Manual EV**
In particular: **Manual tilt recovery commands**

i. :   input (input code for the software = software input)
Input :   To this end, see table:
                Matching software and hardware inputs (**Enclosure**)

To solve the problem

Solve the real problem that has caused the error.
If the control device has not intervened, proceed as follows.

In this case, refer to the section: **In the event of a false error …**   (Enclosure)

65.0: March disabled by Take-Down device   Information

Informs that the operation cannot be performed under the current circumstances.
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 operation is only possible on completion of the procedure.
On completion of the procedure, the operation will be enabled automatically.

65.1: Take-Down setup data correctly saved   Warning

The operation was performed successfully.
Data has been acquired (stored) successfully.

65.2: Take-Down setup saving error   Warning

Informs that saving has failed. Go back to the menu and try again.
Or … Reboot the machine and repeat the operation.
If the problem persists, please contact the Technical Customer Service.

65.3: The Take-Down didn't move from zero   Error

The message states that:
Despite the Hold-down has been release, the sensor continues to detect it in the standstill position.
Vice versa …
See the next message.
The software checks the correct status of the sensor throughout the Sock Cycle.

If the motor receives a command of displacement from the zero point, the software checks that after a set time the sensor has switched on or off.
Otherwise a message is displayed. Therefore: The message appears in the following circumstances:
● The motor does not receive the command (the board not controls the motor). Or …
● The sensor did not detect the change of status.

Proceed as follows to solve the problem:
See the description provided for the message: **31.13**

| 65.4: | **The Take-Down didn't get back to zero** | Error |

This message informs the user that:
The sensor does not detect the mechanical part despite it has been engaged.

For the explanation/ solution, see what specified for the previous entry.

| 65.5: | **The Take-Down reached end of course position** | Error |

Under normal operating conditions, the device must never reach this position. (end of stroke value) .
The check is performed through an analysis of encoder data (signal).
The message states that:
The device has reached the position too quickly.
After which …   The device remains locked.
To attempt the reset press the button [F9].

The causes of the alert can be the following:
● Insufficient mesh to withstand the device weight has been created.
● The mesh has collapsed (broken).

In the first case …
Correct the Sock Program by Graphitron.
There must be at least 4 cm mesh before activating the Release command.

In the second case …
Check for any mechanical irregularities.

Proceed as follows if the error persists:
● Check the operation of the solenoid valve/s related to the command.
● Check pressure regulation at the various actuators that move the device.
● Check and if necessary replace all the hardware components linked to the Encoder counter.
● Replace the Encoder.

| 65.6: | **Release Take-Down either too slow or still** | Error |

Refer to the menu: **Take-Down setup**
The message refers to the item: **Enable control "Take-Down too slow"**
Management has been enabled.

The message states that:
The device does not move forward enough and the mesh does not flow correctly into the tube.
This situation can cause mechanical breakages.

Proceed as follows to solve the problem:
See the description provided for the message: **65.5**

| **65.7:** | **Release Take-Down too fast toward end of course** | Error |

This message informs the user that:
After being released, the Hold-down device moves down more quickly than expected.
The device failed to lock the handle against the walls of the pipe.

When this condition occurs, the machine stops. After which …
The machine attempts a self-recovery.
["Retry" procedure (attempt) = Hooking   + Unhooking   ].
In case of failure, a message appears. After which …
The Hold-down device returns to the locked position.

Proceed as follows to solve the problem:
See the description provided for the message: **65.5**

| **65.8:** | **Take-Down timeout returning to zero** | Error |

At first, view the contents of the previous message.

The message appears in the following circumstances:
During the restoring (re-initialisation) phase, the zero sensor does not change status in good time.
(The device has not reached the rest position.)

Proceed as follows to solve the problem:
See the description provided for the message: **65.5**

Furthermore …
Check that the sensor is functioning and properly positioned. In the auto-test menu, check that the status of the input switches. Check the connection between the sensor and the board. Eventually replace these components. and/ or Replace the cables.

| **65.9:** | **Take-Down blocked** | Error |

The device has stuck along the way (neither at the start nor at end of stroke).
Gennerally this message appears in response to the restoration (recovery) after a Black-out.
Or …
The message appears after the mechanical Reset.

For the explanation/ solution, see what specified for the previous entry.
- Assess and resolve a possible textile problem.

65.10:	Take-Down recovery impossible	Error

For the explanation/ solution, see what specified for the previous entry.

65.11:	Take-Down Encoder non connected	Error

Proceed as follows to solve the problem:
See the description provided for the message: **65.5**

65.12:	Heel sack piston not lowered	Error

This information only applies to the following models:
DC880X-2S .
Watch beginning of section.

The sensor is in reading when it should be off.

Check that the sensor is functioning and properly positioned. In the auto-test menu, check that the status of the input switches. Check the connection between the sensor and the board. Eventually replace these components. and/ or Replace the cables.
● Check the operation of the solenoid valve/s related to the command.
● Check pressure regulation at the various actuators that move the device.

65.13:	Heel sack piston not raised (not at 0)	Error

For the explanation/ solution, see what specified for the previous entry.
The sensor is off instead of being in the reading mode.

66. Messages dedicated to the Seaming Robot - GOAL machines , DC88 machines

Refer to the menu: **Linker Motor**

66.0:	**Cylinder stop piston**	CTE - Error - Machine Stop
	See the description provided for the message:	**48.3**
66.1:	**Cylinder stop piston**	CTE - Error - Machine Stop
	See the description provided for the message:	**48.4**
66.2:	**Cylinder stitch-pusher not high**	CTE - Error - Machine Stop
	See the description provided for the message:	**48.5**
66.3:	**Cylinder stitch-pusher not low**	CTE - Error - Machine Stop
	See the description provided for the message:	**48.6**
66.4:	**Pickup piston not in**	CTE - Error - Machine Stop
	See the description provided for the message:	**48.7**
66.5:	**Pickup piston not out**	CTE - Error - Machine Stop
	See the description provided for the message:	**48.8**
66.6:	**Internal knit raising tube**	CTE - Error - Machine Stop
	See the description provided for the message:	**48.9**
66.7:	**Internal knit raising tube**	CTE - Error - Machine Stop
	See the description provided for the message:	**48.10**
66.8:	**Knit transfer piston not in position. Not down**	CTE - Error - Machine Stop
	See the description provided for the message:	**48.11**
66.9:	**Knit transfer piston not in position. Not up**	CTE - Error - Machine Stop
	See the description provided for the message:	**48.12**
66.10:	**Sock present control rod onboard machine not at zero**	CTE - Error - Machine Stop
	See the description provided for the message:	**48.13**

66.12:	Sock stretching sector not in position. Not open	CTE - Error - Machine Stop

See the description provided for the message: **48.15**

66.13:	Sock stretching sector not in position. Not closed	CTE - Error - Machine Stop

See the description provided for the message: **48.16**

66.14:	Up turning device tube locking cam not in position. Does not block	CTE - Error - Machine Stop

See the description provided for the message: **48.17**

66.15:	Up turning device tube locking cam not in position. Does not release	CTE - Error - Machine Stop

See the description provided for the message: **48.18**

66.16:	Pin holder stitch-pusher not in position. Not high	CTE - Error - Machine Stop

See the description provided for the message: **48.19**

66.17:	Pin holder stitch-pusher not in position. Not low	CTE - Error - Machine Stop

See the description provided for the message: **48.20**

66.18:	Pin holder unit rot. lever not in position. Not backward	CTE - Error - Machine Stop

See the description provided for the message: **48.21**

66.19:	Pin holder unit rot. lever not in position. Not forward	CTE - Error - Machine Stop

See the description provided for the message: **48.22**

66.20:	Sewing device roller not in position. Not reversed	CTE - Error - Machine Stop

See the description provided for the message: **48.23**

66.21:	Sewing device roller not in position. Not forward	CTE - Error - Machine Stop

See the description provided for the message: **48.24**

66.22:	Sewing device cutter not in position. Not open	CTE - Error - Machine Stop

See the description provided for the message: **48.25**

66.23:	Sewing device cutter not in position. Not closed	CTE - Error - Machine Stop

See the description provided for the message: **48.26**

66.24: Turning device up locking piston not in position. Not up CTE - Error - Machine Stop

See the description provided for the message: **48.27**

66.25: Turning device up locking piston not in position. Not down CTE - Error - Machine Stop

See the description provided for the message: **48.28**

66.26: Down turning device locking piston not in position. Does not block CTE - Error - Machine Stop

See the description provided for the message: **48.29**

66.27: Down turning device locking piston not in position. Does not release CTE - Error - Machine Stop

See the description provided for the message: **48.30**

66.28: Sock ejection not detected CTE - Error - Machine Stop

See the description provided for the message: **48.31**

66.29: Seamer stop activated or in error CTE - Error - Machine Stop

See the description provided for the message: **48.32**

66.30: Seaming device STOP button pressed CTE - Error - Machine Stop

See the description provided for the message: **48.37**

66.31: Yarn control in sock extraction CTE - Error - Machine Stop

See the description provided for the message: **48.38**

66.32: Prox. designates not TURNED OFF. Engine rotation group designates has not rotated correctly CTE - Error - Machine Stop

See the description provided for the message: **48.39**

66.33: Prox. designates not running. Engine rotation group designates has not rotated correctly.
CTE - Error - Machine Stop

See the description provided for the message: **48.40**

66.34: Maximum number of turning movements exceeded CTE - Error - Machine Stop

See the description provided for the message: **48.41**

66.35: Up turning device motor not in end-of-stoke position CTE - Error - Machine Stop

See the description provided for the message: **48.42**

66.36:	Up turning device motor not reached proximity zero	CTE - Error - Machine Stop

See the description provided for the message: **48.43**

66.37:	Turning device tilt motor error	CTE - Error - Machine Stop

See the description provided for the message: **48.44**

66.38:	Pin holder motor rotation incorrect	CTE - Error - Machine Stop

See the description provided for the message: **48.45**

66.39:	Motor %s is not in place	CTE - Error - Machine Stop

See the description provided for the message: **48.46**

66.40:	Remove the sock from the pickup devices manually	CTE - Error - Machine Stop

See the description provided for the message: **48.47**

66.41:	Seamer motor blocked: sock seaming phase too long	CTE - Error - Machine Stop

See the description provided for the message: **48.49**

66.42:	Presence of sock photocell. Manually arranging the sock	CTE - Error - Machine Stop

See the description provided for the message: **48.50**

66.43:	Turning tube position incorrect. Remove it manually	CTE - Error - Machine Stop

See the description provided for the message: **48.51**

66.44:	No phase	CTE - Error - Machine Stop

See the description provided for the message: **48.52**

66.45:	Blocked movement - angle pickup arm motor	CTE - Error - Machine Stop

See the description provided for the message: **48.53**

66.46:	Sewing device yarn broken	CTE - Error - Machine Stop

See the description provided for the message: **48.54**

66.47:	Top turning device guards open	CTE - Error - Machine Stop

See the description provided for the message: **48.55**

66.48:	Protection barrier	CTE - Error - Machine Stop
	See the description provided for the message:	**48.56**

66.49:	Sock present on machine	CTE - Error - Machine Stop
	See the description provided for the message:	**48.57**

66.50:	Stop open bell external closed toe	CTE - Error - Machine Stop
	See the description provided for the message:	**48.58**

66.51:	No programming sequence of extraction functions	CTE - Error - Machine Stop
	See the description provided for the message:	**48.59**

66.52:	Check kit presence sock. Presence detected abnormal sock	CTE - Error - Machine Stop
	See the description provided for the message:	**48.83**

66.53:	Machine in emergency	CTE - Error - Machine Stop
	See the description provided for the message:	**48.84**

66.54:	Motor %s is not in place	CTE - Error - Machine Stop
	See the description provided for the message:	**48.85**

66.55:	Kit for sock presence control disconnected	CTE - Error - Machine Stop
	See the description provided for the message:	**48.76**

66.56:	Motor %s is not in place Impossible approach to 0	CTE - Error
	See the description provided for the message:	**48.46**

66.57:	Motor %s is not in place ENCODER tolerance	CTE - Error
	This message appears if the expected position (Encoder quote) has not been reached within the time limit. See the description provided for the message:	**48.46**

66.58:	Motor %s is not in place Impossible approach to 0	CTE - Error - Machine Stop
	See the description provided for the message:	**66.56**

66.59:	Motor %s is not in place ENCODER tolerance	CTE - Error - Machine Stop
	See the description provided for the message:	**66.57**

66.60: **Extraction not executable. Welt motor proximity switch not covered.** CTE - Error

The message appears in the following circumstances: Moment preceding the item pick-up.
At this point the software checks that the motor Zero sensor is closed.
Otherwise a message is displayed.
The article will be considered a waste from the Robot waste counter.

66.61: **Extraction not executable. Welt motor proximity switch not covered.** CTE - Error - Machine Stop

See the description provided for the message: **66.60**

66.62: **Pickup device in error** CTE - Error - Machine Stop

See the description provided for the message: **48.86**

66.63: **Cylinder mesh-push extractor not at rest** CTE - Error - Machine Stop

See the description provided for the message: **48.87**

66.64: **Cylinder mesh-push extractor not working** CTE - Error - Machine Stop

See the description provided for the message: **48.88**

66.65: **Head not blocked** CTE - Error - Machine Stop

See the description provided for the message: **48.89**

66.66: **Turning device pipe rotating piston not in position. Does not unlock**   CTE - Error - Machine Stop

See the description provided for the message: **48.90**

66.67: **Turning device pipe rotating piston not in position. Does not lock**   CTE - Error - Machine Stop

See the description provided for the message: **48.91**

66.68: **Manually lower the yarn finger plate**   CTE - Error - Machine Stop

See the description provided for the message: **48.65**

66.69: **Aborted sewing. Tolerance of pin-feed motor encoder: reset the sewing machine**   CTE - Error - Machine Stop

See the description provided for the message: **48.92**

66.70: **Sewing mach.: device %s not ready**   CTE - Error - Machine Stop

See the description provided for the message: **48.93**

66.71: **Knit pusher side shifting piston not present.**   CTE - Error - Machine Stop

See the description provided for the message: **48.94**

66.72: **Knit pusher side shifting piston not enabled, but required from program**   CTE - Error - Machine Stop

See the description provided for the message: **48.95**

66.73: **Motor ENCODER tolerance: %ls (%d). Theoretical/actual values: Step %d-%d - Encoder %d-%d**   CTE - Error - Machine Stop

See the description provided for the message: **48.105**

66.74: **Approach to 0 impossible: %ls (%d). Proximity switch already covered.**   CTE - Error - Machine Stop

See the description provided for the message: **48.106**

66.75: **Approach to 0 impossible: %ls (%d). Proximity switch not found.**   CTE - Error - Machine Stop

See the description provided for the message: **48.107**

66.76: **Approach to end of stroke impossible: %ls (%d). Proximity switch already covered.**   CTE - Error - Machine Stop

See the description provided for the message: **48.108**

66.77: **Approach to end of stroke impossible: %ls (%d).Proximity switch not found.**   CTE - Error - Machine Stop

See the description provided for the message: **48.109**

66.78:	Zeroing impossible: %ls (%d)	CTE - Error - Machine Stop
	See the description provided for the message:	**48.110**

66.79:	Zeroing at end of stroke impossible: %ls (%d)	CTE - Error - Machine Stop
	See the description provided for the message:	**48.111**

66.80:	Movement impossible: %ls (%d)	CTE - Error - Machine Stop
	See the description provided for the message:	**48.112**

66.81:	Cylinder knit pusher NOT in intermediate position	CTE - Error - Machine Stop
	See the description provided for the message:	**48.114**

66.82:	Up turning device motor not in end-of-stoke position	CTE - Error - Machine Stop
	See the description provided for the message:	**48.113**

66.83:	Barriers disable : mind the automatic movement after the errror cancel	CTE - Error - Machine Stop
	See the description provided for the message:	**48.115**

66.84:	Sewing device stopped by machine error	CTE - Error - Machine Stop
	See the description provided for the message:	**48.117**

66.85:	Movement interrupted: %ls (%d)	CTE - Error - Machine Stop
	See the description provided for the message:	**48.118**

66.86:	Motor busy: %ls (%d)	CTE - Error - Machine Stop
	See the description provided for the message:	**48.120**

66.87:	Sock 2 passage on closed toe side obstructed or damaged	CTE - Error - Machine Stop
	See the description provided for the message:	**48.121**

66.88:	Internal knit raising tube motor not in end course position	CTE - Error - Machine Stop
	See the description provided for the message:	**48.122**

66.89:	Aborted sewing. Internal knit raising tube motor not in end course position: reset the sewing machine	CTE - Error - Machine Stop
	See the description provided for the message:	**48.123**

66.90:   **Photocell: reading fault**   CTE - Error - Machine Stop

See the description provided for the message: **48.124**

66.93:   **Impossible approach to 0: %ls (%d)**   CTE - Error - Machine Stop

See the description provided for the message: **48.127**

66.96:   **Forward by phases inserted**   CTE - Error - Machine Stop

See the description provided for the message: **48.130**

The cutter is a sharp disc that cuts off the yarns. (Saw + Knife) .
The device can be motorized.
[Saw + Dial = Dial unit]

Donna machines

This information only applies to the following models:
DONNA machines (single-cylinder models, for pantyhose) .

More in particular:
Models equipped with the following device: Saw blade motor
Therefore:
This section is specific for Medical (ME) machines.

Remember that:
The motors are controlled via the CAN Line.
For the device to work, you need to enter specific codes in the sock programme (Graphitron).

Reference

For basic information, refer to: **18.**

Description

For basic information, refer to: **18.**

Motorized Saw

The motorized Saw is used to adjust the length of cut yarns via the rotation speed.
The cut yarn length depends on the ratio between the cylinder and the cutter speeds.
The greater the cutter rotation compared to the cylinder the shorter the yarn is cut.

For the device to work, you need to enter specific codes in the sock programme (Graphitron).
It 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.
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.
In any case … In the programming software (Graphitron) there is a protection for which the start command of the Saw motor is not accepted if the Saw is mechanically hooked.

With motorized Saw, the machine can still be working as with the normal Saw: is sufficient not programming the start of the Saw motor.

Note

Models equipped with: Saw blade motor   .
No configuration menu is provided for the models shown. [Saw blade setup].
This menu has been deleted.
Therefore:
The device cannot be disabled. [Stop saw device].
This is for safety reasons.

67.0:	**Saw setup correctly saved**	Warning

Message no longer menaged. Update the machine software .

67.1:	**Saw setup saving error**	Warning

Message no longer menaged. Update the machine software .

67.2:	**Saw A control failed**	Error

With Saw hooked the Software must read in both the control points the correct status of the sensor.
Instead … The sensor is in reading when it should be off.

In case of error the first thing to check is the integrity of the phase sensor of the Saw.
Check that the sensor is functioning and properly positioned.
In the auto-test menu, check that the status of the input switches.
Use the [Handle] keys to rotate the cylinder.

Check the connection between the sensor and the board.
Eventually replace these components. and/ or Replace the cables.

Please refer also to paragraph: **In the event of a false error …**   (Enclosure)

67.3:	**Saw B control failed**	Error

With Saw hooked the Software must read in both the control points the correct status of the sensor.
Instead … The sensor is always off.
For the explanation/ solution, see what specified for the previous entry.

67.4:	**Saw C control failed**	Error

With Saw released by the cylinder rotation and Saw motor stopped the Saw must not move.
This message informs the user that the Saw is moving at a point at which the software expected it to be stopped.

Check the functionality of the command for the saw hook/ release.
In particular check the functioning of the solenoid valve and of the command board (bar), and the status of the pipe.

67.5:	**Saw D control failed**	Error

With Saw released from the cylinder rotation and Saw motor in rotation, the Saw should turn at the motor speed.
This message informs the user that the Saw is stopped at a point at which the software expected it in movement.
For the explanation/ solution, see what specified for the previous entry.

67.6:	**Machine running disabled by saw device**	Information

This message informs the user that the machine cannot be Run.
Movement is not allowed as the mechanical group (Dial) is not in the working position (it is not low).

Fully lower the mechanical group.
Operate the mechanical or electric handle (1 and 2) to rotate the cylinder a few turns.
At this point, the running is again enabled.

Therefore:
Use the crank to perform N turns to the cylinder. (N = 4)
Then will be possible press the [RUN] button.

67.7:	**Machine running disabled by saw device: carry out 4 cylinder full turns by handle till the normal functioning is restored**	Warning

This message is displayed when the software detects an attempt to start the machine.

First check the procedure adopted in the previous condition.
(For the explanation see what specified for the previous entry.)
The procedure was not completed. (N < 4)

68.

Do not currently managed.

DC88 machines

This information only applies to the following models:
DC88 machines (double-cylinder models, for men's socks) .

More in particular:
Models equipped with the following device: **Seaming Robot** .

The device picks up the item from the cylinder and transfers it to seaming.
When removing the sock (from the cylinder) the Head must move to the side.
(= **tilting** = angular movement).

Therefore …

Description

Head mechanical unit

The unit can take two positions:
- work position   (*In*) ,
- pick-up position (*Out*) .

A lock bolt fits into the holes and secures the positions.
The position is controlled by the software via the value read by three sensors.   (*)

    [Head bolt in sock production position   ]   (1)
    [Head bolt in pick-up position   ]   (2)
    [Head movement enabling bolt   ]   (3)

Use the cylinder motor to move the unit.
Typically …
The motor transmits the movement to a pulley via a belt.
(The pulley is integral with the cylinder.)

Instead …
If the pulley is blocked, the movement is transmitted to the entire unit.
The pulley is prevented from moving by inserting a pin.
    [Pulley lock piston   ] .

The position is controlled by the software via the value read by two sensors.   (*)
    [Pulley locking piston: out   (*rest position*)   ] ,
    [Pulley locking piston: inserted   (*Inserted*)   ] ,

(*)   This means that if one sensor is malfunctioning, this could generate a message.

(1)   low position - IN = Article in production.
(2)   low position - OUT = Sock extraction .
(3)   high position - JUMP = translation , tilting .

Reference

Software inputs

In this case, refer to the section:

62.   **Messages on Inputs - DC88 machines**

See also the menu: **Autotest of inputs**

Position of Pneumatic Outputs

In this case, refer to the section:

                                                                                    60.
/ 61.   **Short circuit   / Not connected   - DC88 machines**

See also the menu: **Autotest various outputs**

Settings

Refer to the menu:

                                              External closed toe setup menu
                                              General setup external closed toe
                                                          Head opening offset

Manual commands

Refer to the menu:

                                              Manual tilt recovery commands

To solve the problem

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

For the analysis and the solution of the problem refer to the section: **Checking the pneumatic system**

If the control device has not intervened, proceed as follows.

In this case, refer to the section: **In the event of a false error …**   (Enclosure)

69.0:   **Manually reset the head**   Error **-** Movement impossible

Do not currently managed.

69.1:   **Manual head command not finished**   Error **-** Movement impossible

Do not currently managed.

69.2:   **Manual head command disabled from software**   Information

Do not currently managed.

69.3:   **Head setup data correctly saved**   Warning

Do not currently managed.

69.4:   **Head setup save error**   Warning

Internal software failure . Contact the Technical Customer Service.

69.5:   **Manual head command not finished**   Information

Do not currently managed.

69.6:   **The head is not in rest position**   Error **-** Movement impossible

In this case, "rest" indicates the prevailing position.
(Namely … work position).

The device is not in the intended position.
The message appears in the following circumstances:
The position of the device is checked before moving it and after the move command has been sent.

It seems that the command is not completed or has not been completed previously.
Intervene manually: move to the end of stroke, in the correct position.

69.7:   **The head is not in the work position**   Error **-** Movement impossible

At first, view the contents of the previous message.

69.8:   **Impossible to return the head in the rest position**   Information

Do not currently managed.

69.9:   **Machine movement prevented due to head manual command not completed**   Information

Do not currently managed.

69.10:   **Head at rest initialisation not completed**   Information

Do not currently managed.

69.11:   **Protection barrier interrupted**   Information

Do not currently managed.

69.12:	Pulley not at rest	Error - Movement impossible

The device is not in the intended position.
The position is controlled by the software via the value read by two sensors.
(This means that if one sensor is malfunctioning, this could generate a message.).

The position is checked after the move command has been sent.
In particular …   `Pulley locking piston: out`
In this case, "piston out" means out of the hole, i.e. not inserted, hence not working.

It seems that the command is not completed or has not been completed previously.
Intervene manually: move to the end of stroke, in the correct position.
Refer to the menu: **Manual tilt recovery commands**

In this case, refer to the section: **Checking the pneumatic system**

69.13:	Pulley not in operation	Error - Movement impossible

The message is similar to the previous one.
At first, view the contents of the previous message.

The position is checked after the move command has been sent.
In particular …   `Pulley locking piston: inserted`

Furthermore …

The message appears in the following circumstances:
Head traverse positions calibration

Concerning this see the menu: **External closed toe setup menu**
In particular: Reset head rotation calibrations

See also the menu: **Head opening offset**

This adjustment is carried out manually (no dedicated menu available).
Adjustment consists of acquiring the motor steps corresponding to the mechanical condition.
After reset the procedure must be repeated.

─────────────────── **Procedure** ───────────────────

The software ascertains that the value required to continue is missing.
The following message appears: **14.122**

Activate a *.cs programme. The sock program is special and is already prepared by GRAPHITRON.
Activate the function F3. Deactivate function F1.
Press the operating command: (I) Machine Start Button .

The software ascertains that the value required to continue is missing.
When this condition occurs, the machine stops.
In that moment the relevant message now appears. (**69.13**).

Insert the ratchet wrench into the hex nut and perform the manual advancement of cylinders.
(The insertion point is protected by a cover.)
Continue until you hear the piston click. (Pulley lock piston).
Delete the message by pressing [F8].
The following message appears: 69.27

Hold the Head and move it outwards.
Continue until you hear the piston click. (Head bolt   ).
Delete the message by pressing [F8].
The following message appears: **66.84**

Delete the message by pressing [FN+F8].
The following message appears: **48.36**
Press the operating command: Seaming device start button .

The machine immediately resumes control of operations.
At "End of cycle" the machine will stop with the [F3] key active.
The following message appears: **14.18**

Press the operating command: [Fn+F3] .
The command deactivates the .cs file at end of cycle, and resumes the previously processed sock pro-
gramme (.co file).

69.14:	Bolt not at rest	Error **-** Movement impossible

In this case, "rest" indicates the prevailing position.
(The pin is "always" inserted, which makes the unit more stable.)

The device is not in the intended position.

The position is checked after the move command has been sent.
In particular …   **Enter latch for head locking**

It seems as if the command has not been activated.
Try to activate it through the dedicated commands and move it to the required position.
Refer to the menu: **Manual tilt recovery commands**

In this case, refer to the section: **Checking the pneumatic system**

69.15:	Bolt not at rest in	Error **-** Movement impossible

The message is similar to the previous one.
At first, view the contents of the previous message.

Furthermore …
In this case, "in" indicates the position specific for production.
   [**Head bolt in sock production position**   ] ,

The device is not in the intended position.

The position is checked before sending the move command.
In particular …   **Exit latch for head locking**

For the explanation/ solution, see what specified for the previous entry.

69.16:	Bolt not at rest outwards	Error **-** Movement impossible

The message is similar to the previous one.
At first, view the contents of the previous message.

Furthermore …
In this case, "out" indicate the position specific for extraction.
[`Head bolt in pick-up position`   ] .

The device is not in the intended position.
The position is checked before sending the move command.
In particular …   `Exit latch for head locking`

For the explanation/ solution, see what specified for the previous entry.

69.17:	Bolt not in operation	Error **-** Movement impossible

Here "work" indicates the position reached by the pin to allow the movement, i.e. "retracted".

The device is not in the intended position.

The position is checked after the move command has been sent.
In particular …   `Exit latch for head locking`

It seems as if the command has not been activated.
Try to activate it through the dedicated commands and move it to the required position.
Refer to the menu: **Manual tilt recovery commands**

Otherwise:
In this case, refer to the section: **Checking the pneumatic system**

69.18:	Fingers group feed 2 not lowered	Error **-** Movement impossible

Fingers group feed 2 - Feed 2

The unit can take two positions:
- work position   (*unit lowered*) ,
- pick-up position (*unit raised*) .

The device is not in the intended position.
The position is controlled by the software via the value read by two sensors.
[`Feed 2 yarn finger unit lowered`   ] ,
[`Feed 2 yarn finger unit raised`   ] .
(This means that if one sensor is malfunctioning, this could generate a message.).

The position is checked after the move command has been sent.
In particular …   `Move fingers group down`

It seems as if the command has not been activated.
Try to activate it through the dedicated commands and move it to the required position.
Refer to the menu: **Manual tilt recovery commands**

Otherwise:
In this case, refer to the section: **Checking the pneumatic system**

| **69.19:** | **Feed 2 yarn finger unit not raised** | Error **-** Movement impossible |

The message is similar to the previous one.
At first, view the contents of the previous message.

The position is checked after the move command has been sent.
In particular …   **Move fingers group up**

For the explanation/ solution, see what specified for the previous entry.

| **69.20:** | **Move the head manually outwards and lock the bolt in position** | Warning |

The message indicates the next operation.
Hold the Head and move it outwards.
After which …
Use the dedicated command. (Bolt Lock/Unlock).

The message appears in the following circumstances:
During the procedure … Maintenance procedure .
Concerning this see the menu: **Sinkers change**

| **69.21:** | **Move the head manually inwards and lock the bolt in position** | Warning |

The message is similar to the previous one.
For the explanation/ solution, see what specified for the previous entry.

| **69.22:** | **Start up the machine** | Warning |

Refer to the message: 69.20
Press the operating command: (I) Machine Start Button .
This allows the current routine to continue.

| **69.23:** | **Machine ready for sinkers change, only use handle key** | Warning |

The message is similar to the previous one.
For the explanation/ solution, see what specified for the previous entry.
Use the [Handle] keys to rotate the cylinder.

| **69.24:** | **Head opening preparation, in progress** | Warning |

The message simply indicates the processing stage/phase reached.
The device is performing a step of the procedure.
You need to wait a few seconds.
Refer to the message: 69.20

| **69.25:** | **Procedure finishing, in progress** | Warning |

For the explanation/ solution, see what specified for the previous entry.

| **69.26:** | **Procedure finished, either press ESC or repeat.** | Warning |

The operation was performed successfully.
To exit, press: [ESC] .

| **69.27:** | **Move manually the head out (to the right)** | Error **-** Movement impossible |

Hold the Head and move it outwards.
Continue until you hear the piston click. (Head bolt   ).
Delete the message by pressing [F8].

| **69.28:** | **Move manually the head in (to the left)** | Error **-** Movement impossible |

The message is similar to the previous one.
Hold the Head and move it over the cylinder.
Continue until you hear the piston click. (Head bolt   ).

| **69.29:** | **Latch not inserted (not descended).** | Error **-** Movement impossible |

Refer to the message: **69.14**
In this case …
The check is performed during the sock cycle.
The sensor signals do not reflect the processing stage.

| **69.30:** | **Latch in unknown position** | Error **-** Movement impossible |

The message is similar to the previous one.

In this case …
At least one sensor shows a signal not reflecting the processing phase.

| **69.31:** | **Head not in sock production position** | Error **-** Movement impossible |

The message is similar to the previous one.

In this case …
The signal of the relevant sensor does not comply with that requested in that phase.

| **69.32:** | **Head not in sock extraction position** | Error **-** Movement impossible |

The message is similar to the previous one.

In this case …
The check is performed during the sock extraction phase.
The signal of the relevant sensor does not comply with that requested in that phase.

| **69.33:** | **Sewing machine error, open sewing window** | Error **-** Movement impossible |

At each operating status, on display in the dedicated area, is shown the corresponding icon.
The device is stopped due to a malfunction. The message is visible in the dedicated window.
Go to the dedicated menu. (Linker Motor)
Press the operating command: [Fn+C] .

| **69.34:** | **Pulley locking piston, not detected in rest position** | Error **-** Movement impossible |

Refer to the message: **69.12**

In this case …
The check is performed during the sock cycle.
The signal of the relevant sensor does not comply with that requested in that phase.

Appendix

Control of electrostatic charges

First check of the board

Base elements

Control of electrostatic charges

This symbol indicates the presence of materials sensitive to electrostatic charges, and is found in the protected areas, on antistatic packing products, and on any material in any way related to electrostatic charges.

ESD=Electro Static Discharge

The electrical components are vulnerable to electrostatic charges and therefore also the boards and the machines are.
This must be kept in mind when repairing and maintenance is being made , and also when handling and storing the electrical spare parts.

Static electricity is usually created by friction between different non-conductive substances (e.g. yarn). The energy is in the form of charges (electrons) that accumulate in small amounts but at high voltage. This accumulation is discharged as soon as it finds a path (even air, with a spark), towards the ground. Even if the energy is low it can cause serious damage to the tiny transistors in electronic devices. This damage is sometimes noticeable only after some time.

Therefore use materials to dissipare the electrostatic charges and specific individual protections.

Precautions

- We recommend that you do not use polystyrene, cellophane bags, cardboard (unless the parts are not packed in antistatic bags), containers, or trays, boxed or drawers in plastic.
- It is essential to store and/or pack parts in special conductive bags and sheets of antistatic foam rubber.
- The operator assigned to repair the machine should ground himself using a special bracelet or heel clip. The bracelet connected to the ground is not dangerous from the point of view of electrocution because it incorporates a 1M ohm resistor in series that discharges exclusively electrostatic charges.
- Testing should be done on a bench equipped with antistatic kit.
- Replace the material in the special packing.
- Assembled electronic boards are much less sensitive than loose parts, because the parasite capacities and those of the filter of the various power supplies come into play.
- After the board is inserted in the machine, the risk is considerably reduced, but it is always a good idea to wear the bracelet or heel clip. Operators wearing a heel clip should not touch the boards if they are seated with their feet off the carpet (for example on a rung of the chair). The heel clip is practically useless on a bare floor.

The combination of various materials has enabled us to create highly valid systems for the protection from static electricity, that are effective, however, only if used according to certain rules:
- Connect all the protective parts (carpets, runners, bracelets, etc.), to the ground system of the mains. They are useless when resting on insulating material (tables, floors), because they do not discharge.
- Any personnel not equipped with antistatic apparel (and thus charged), should stay away from the protected area, as they can radiate charges even through the air; if their presence is really necessary, they must immediately put on the bracelet.

Materials for the control of electrostatic charges

All the parts of the various systems for the control of electrostatic charges are made with special materials that can be divided into four different categories: Antistatic, Conductive, Dissipative, Screening

Antistatic materials are special materials that do not produce electrostatic charges when rubbed or separated from other materials with which they come into contact (triboelectric effect). However, if they receive charges from the outside, they hold them (so though they do not produce them, they may contain charges received from outside).

Conductive materials are materials that distribute charges uniformly over their surface so that all the pins of the part have the same potential, thereby preventing discharges between points with different potential.

Dissipative substances are materials that have the property of expelling electrostatic charges outward (for example, from the inside of a bag). The charges expelled are transferred to the conductive materials around it or into the ground (if possible), in a time of approximately 1 second or less, depending on the amount of energy.

Screening materials have the same properties as the dissipative ones. In view of their particular structure, they perform a protective action according to the law of the FARADAY cage, which states that electric charges are always distributed on the outside of a closed conductive container. Therefore the charges on the inside move outward and those received from the outside remain on the outside. The screening also neutralizes the electrostatic fields induced by the environment; some highly sensitive components, indeed, are damaged even if they are only involved in an electrostatic field without receiving any actual discharge.

Static electricity is inversely proportional to the relative humidity of the air, thus:

HIGH HUMIDITY   ➔   LOW ELECTROSTATIC CHARGE

LOW HUMIDITY   ➔   HIGH ELECTROSTATIC CHARGE

First board check

At times, it is possible to identify a breakdown by observing the board and/or machine carefully. Here is a guide to some of the things to look for.

1. On the board, check for obvious short circuits between tracks or adjacent positions on the welded side. This could be due to bits of welding tin, filings, conductive dirt that in time has created a short-circuit. Exceptionally, it may be due to bent pins.

2. On the board, make sure there are no cold welds. These have a different appearance as they are not shiny and look "grainy".

3. Check the conditions of the electrolyte condensers. There should not be any oily liquid and the vent valve on the plate models should be in place (not raised). It is a good idea to check the correct polarity of all polarized condensers.

4. If any alterations have been made with wire, make sure they are not causing short circuits and that they are intact (wire welded).

5. Check the good condition of the fuses both on the boards and on the plates. The wire inside the fuses should be straight, not bowed so that it touches the glass. For ceramic types use the multimeter with scale base "200 ohm".

6. Make sure the boards and the connectors on them are correctly inserted, pushed all the way down. Make sure there are no contact pins partly emerging from the plastic body. The same applies, on the boards, to the jumper, integrators and modules on sockets.

◊   Valvola parzializzatrice elettrica (VPE) / Stepping vacuum valve

DE	EN	ES	FR	IT
Drosselventil VPE Wendevorrichtung unten 1	VPE graduation low 1	Parcialización VPE del volcador alto 1	Etranglement VRE retourneur bas 1	Parzializzazione VPE rovesciatore basso 1
Drosselventil VPE Wendevorrichtung oben 7	VPE graduation high 7	Parcialización VPE del volcador alto 7	Etranglement VRE retourneur haut 7	Parzializzazione VPE rovesciatore alto 7
Drosselventil VPE Wendevorrichtung oben 6	VPE graduation high 6	Parcialización VPE del volcador alto 6	Etranglement VRE retourneur haut 6	Parzializzazione VPE rovesciatore alto 6
Drosselventil VPE Wendevorrichtung oben 5	VPE graduation high 5	Parcialización VPE del volcador alto 5	Etranglement VRE retourneur haut 5	Parzializzazione VPE rovesciatore alto 5
Autotest VPE	Autotest VPE	Autotest VPE	Autotest CRE	Autotest VPE
Setup Motor VPE	Set AIR VACUUM VALVE motor	Setup motor VPE	Setup Moteur CRE	Setup motore VPE
Nullposition Drosselventil	Zero position AIR VACUUM VALVE	Posición de cero VPE	Position du zéro CRE	Posizione di zero VPE
Drosselventil VPE Wendevorrichtung unten 4	VPE graduation low 4	Parcialización VPE del volcador alto 4	Etranglement VRE retourneur bas 4	Parzializzazione VPE rovesciatore basso 4
Drosselventil VPE Wendevorrichtung unten 3	VPE graduation low 3	Parcialización VPE del volcador alto 3	Etranglement VRE retourneur bas 3	Parzializzazione VPE rovesciatore basso 3
Drosselventil VPE Wendevorrichtung unten 2	VPE graduation low 2	Parcialización VPE del volcador alto 2	Etranglement VRE retourneur bas 2	Parzializzazione VPE rovesciatore basso 2
Drosselv. Position 2 speziell	VPE position 2 special	VPE posición 2 especial	VPE position 2 spécial	VPE posizione 2 speciale
VPE position 1	VPE position 1	VPE posición 1	VPE position 1	VPE posizione 1
Drosselventil im manuellen Betrieb. Wiederherstellung der normalen Funktion mit Betrieb	VPE valve in manual state. Normal functioning resumes with machine running	Válvula VPE en maual. Restablecimiento funcionamiento normal con marcha	Soupape VPE en manuel. Rétablissement fonctionnement normal avec marche	Valvola VPE in manuale. Ripristino funzionamento normale con marcia
Elektronisches Drosselventil	Stepping vacuum valve	Valvula estranguladora eléctrica	Clapet de regulation	Valvola parzializzatrice elettrica
DROSSELVENTIL GESCH. SPITZE	SHUTTER VALVE EXTERNAL CLOSED	VÁLVULA PARCIAL. P. CERRADA	VANNE DE REGULATION P. FERMEE	VALVOLA PARZIAL. P. CHIUSA
EXTERN	TOE	EXTERNA	EXTERNE	ESTERNA
VPE	VPE	VPE	VPE	VPE
Drosselventil	VPE valve	VPE valvula	VPE soupape	VPE valvola
VPE position 2	VPE position 2	VPE posición 2	VPE position 2	VPE posizione 2

EN	PL	RU	TR	ZH
VPE graduation low 1	Przepustnica częściowo na dolną wywijarkę 1	Перекрытие регулировочного клапана опущенной выворотки 1	Alt ters çevirici VPE paylaştırma 1	低位 1 VPE自动翻转
VPE graduation high 7	Przepustnica częściowo na górną wywijarkę 7	Перекрытие регулировочного клапана поднятой выворотки 7	Üst ters çevirici VPE paylaştırma 7	高位 7 VPE自动翻转
VPE graduation high 6	Przepustnica częściowo na górną wywijarkę 6	Перекрытие регулировочного клапана поднятой выворотки 6	Üst ters çevirici VPE paylaştırma 6	高位 6 VPE自动翻转
VPE graduation high 5	Przepustnica częściowo na górną wywijarkę 5	Перекрытие регулировочного клапана поднятой выворотки 5	Üst ters çevirici VPE paylaştırma 5	高位 5 VPE自动翻转
Autotest VPE	Autotest Przepustnicy	Автотестирование VPE	Ototest VPE	VPE换风阀马达自动测试
Set AIR VACUUM VALVE motor	Setup silnika przepustnicy	Настройка двигатель VPE	VPE motoru setup	设置吸风阀门零位
Zero position AIR VACUUM VALVE	Pozycja zera Przepustnicy	Нулевое положение VPE	VPE sıfır pozisyonu	吸风阀门零位
VPE graduation low 4	Przepustnica częściowo na dolną wywijarkę 4	Перекрытие регулировочного клапана опущенной выворотки 4	Alt ters çevirici VPE paylaştırma 4	低位 4 VPE自动翻转
VPE graduation low 3	Przepustnica częściowo na dolną wywijarkę 3	Перекрытие регулировочного клапана опущенной выворотки 3	Alt ters çevirici VPE paylaştırma 3	低位 3 VPE自动翻转
VPE graduation low 2	Przepustnica częściowo na dolną wywijarkę 2	Перекрытие регулировочного клапана опущенной выворотки 2	Alt ters çevirici VPE paylaştırma 2	低位 2 VPE自动翻转
VPE position 2 special	VPE pozycja 2 specjalny	VPE положение 2 специаль.	VPE pozisyonda 2 Spec.	VPE换风阀2位 - 特殊
VPE position 1	VPE pozycja 1	VPE положение 1	VPE pozisyonda 1	VPE位置 1
VPE valve in manual state. Normal functioning resumes with machine running	Przepustnica w ręcznym działaniu. Przywrócenie normalnego działania w biegu	Клапан VPE в руч.режиме, восстанов.нормального функционир.и хода	VPE valfi manüelde. Marşta normal fonksiyon resetleme	VPE风阀处于手动状态 - 机器运转时正常恢复
Stepping vacuum valve	Przepustnicy elektronicznej	Клапан регулиров.подачи электронный	Elektrikli kısmi valf	电子式步进真空阀
SHUTTER VALVE EXTERNAL CLOSED TOE	PRZEPUSTNICA MASZYNA ZE ZSZYWARKĄ ZEW.	РЕГУЛИРОВОЧНЫЙ КЛАПАН ВНЕШНЕГО ШВЕЙНОГО МЕХАНИЗМА	ORANSAL VALF DIŞ KAPALI BURUN	附加缝头-裁剪风阀
VPE	VPE	VPE	VPE	VPE
VPE valve	VPE zawór	VPE клап.	VPE valf	VPE换风阀
VPE position 2	VPE pozycja 2	VPE положение 2	VPE pozisyonda 2	VPE位置 2