STOPS MANAGEMENT AND TROUBLESHOOTING MANUAL

Models equipped with PCB 2009
Models equipped with PCB 2014

Version 0.7

ENGLISH

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

Attention

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

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STOPS MANAGEMENT AND TROUBLESHOOTING MANUAL

ENCLOSURE

The models to which this document relates

GOAL machines

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GL616DCTE	G616D
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GK523CTE	GK523
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GK544	GL544
GK544CTE	GL544
GL544	GL544
GL544CTE	GL544
GK615	GL615
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GL615	GL615
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GK616DF3	GL616DF3
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	LA04M7	LA04M7
LB02MJ	LA02MJ	LB04M7	LA04M7
LA04E7	LA04E7	LA04MJ	LA04MJ
LB04E7	LA04E7	LB04MJ	LA04MJ
LA04JS	LA04JS	LA08MJ	LA08MJ
LB04JS	LA04JS	LB08MJ	LA08MJ
LA10	LA10-12	LB41TV	LA41TV
LA12-LA12J	LA10-12	LA45-5P7	LA45-5P7
LB10	LA10-12	LB45-5P7	LA45-5P7
LB12-LB12J	LA10-12	LA45-5T	LA45-5T
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LB40ME	LA40ME	LB45E7	LA45E7
LB45ME	LA45ME	LB08MJ-T	LB08MJ-T
LA4TS	LA4TS	LB10Y	LB10Y
LB4TS	LA4TS	LB41TVE	LB41TVE
LB50ME	LA50ME	LB4TS-T	LB4TS-T
LB55ME	LA55ME	LBOP	LBOP
LB60ME	LA60ME		

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.
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
Work menu	Space-A
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Graduation menu	Space-A-B
Mod. stitch q.ty by cm/inch (Rest CM zones / Rest zones Inch)	Space-A-B-A
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Modify economizations	Space-A-E
Modify economizations on sigle zone	Space-A-E-ê
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Yarn sliding sensors identification	Space-A-F-A-B
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Parameters of sensors	Space-A-F-A-C
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***** = Hold down the button.

ê = Enter

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

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DONNA machines

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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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PID speed setting	Space-A-E-C-A-C-B
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PID speed setting crank	Space-A-E-C-A-C-D
Mechanical zero	Space-A-E-C-B
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DC88 machines

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Password level	**Key**
Management menu	**Space**
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ê = Enter
p1, p2, etc. = Page 1, Page 2, etc

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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

Dedicated devices setup	**Space-D-C-p1-A-B**
Rest setup	**Space-D-C-p1-A-C**
Rest enabling setup	Space-D-C-p1-A-C-A
All-sizes modification enabling setup	Space-D-C-p1-A-C-B
Offset motors	Space-D-C-p1-A-C-D
Sizing correction	Space-D-C-p1-A-C-E
Gradual movement	Space-D-C-p1-A-C-F
Typical data collection setup	**Space-D-C-p1-A-D**
Machine management setting	**Space-D-C-p1-A-E**
Warm up machine	Space-D-C-p1-A-E-p1-A
Inputs setup	Space-D-C-p1-A-E-p1-B
Setup stop chain [F1]	Space-D-C-p1-A-E-p1-E
Solenoid valves shake menu	Space-D-C-p1-A-E-p2-A
Lighting management	Space-D-C-p1-A-E-p2-B
Speed and rev limit control	Space-D-C-p1-A-E-p2-D
Warm up menu	Space-D-C-p1-A-E-p2-E
Medium speed [F6] light	Space-D-C-p1-A-E-p2-F
Emergency light out of run	Space-D-C-p1-A-E-p2-G
Setup elastic motors	**Space-D-C-p1-A-F**
Enable motors	Space-D-C-p1-A-F-A
Motor sense of rotation	Space-D-C-p1-A-F-B
Type of motors mounted	Space-D-C-p1-A-F-C
Yarn sensor Pyf Plus	Space-D-C-p1-A-F-D
All-sizes modification enabling setup	Space-D-C-p1-A-C-E
Outputs autoconfiguration	**Space-D-C-p1-B**
Motor setup menu	**Space-D-C-p1-C**
General parameters menu	Space-D-C-p1-C-A
Motor drive ramps setup	Space-D-C-p1-C-A-A
Motor drive speed setup	Space-D-C-p1-C-A-B
PID menu setting	Space-D-C-p1-C-A-C
PID current setting	Space-D-C-p1-C-A-C-A
PID speed setting	Space-D-C-p1-C-A-C-B
PID position setting	Space-D-C-p1-C-A-C-C
PID speed setting crank	Space-D-C-p1-C-A-C-D
Mechanical zero	Space-D-C-p1-C-B
Resolver timing	Space-D-C-p1-C-C

Setup IP address	**Space-D-C-p1-D**
Single-item-counter setting	**Space-D-C-p1-E**
Display setting	**Space-D-C-p1-F**
Languages	Space-D-C-p1-F-A
Energy saving	Space-D-C-p1-F-B
Change of display interface	Space-D-C-p1-F-D
Fan contactor setup	**Space-D-C-p1-G**
External closed toe setup menu	**Space-D-C-p1-H**
General setup external closed toe	Space-D-C-p1-H-A
Yarn carrier setup	**Space-D-C-p1-I**
Feed 1 general offset yarn carrier setup	Space-D-C-p1-I-p1-A
F1 yarn carrier 1 offset yarn carrier setup	Space-D-C-p1-I-p1-1
F1 yarn carrier 2 offset yarn carrier setup	Space-D-C-p1-I-p1-2
F1 yarn carrier 3 offset yarn carrier setup	Space-D-C-p1-I-p1-3
F1 yarn carrier 4 offset yarn carrier setup	Space-D-C-p1-I-p1-4
F1 yarn carrier 5 offset yarn carrier setup	Space-D-C-p1-I-p1-5
F1 yarn carrier 6 offset yarn carrier setup	Space-D-C-p1-I-p1-6
F1 yarn carrier 7 offset yarn carrier setup	Space-D-C-p1-I-p1-7
Fingers setup offset split feed 1	Space-D-C-p1-I-p1-S
Feed 2 yarn carrier 1 offset yarn carrier setup	Space-D-C-p1-I-p2-1
Feed 2 yarn carrier 2 offset setup	Space-D-C-p1-I-p2-2
F2 yarn carrier 3 offset yarn carrier setup	Space-D-C-p1-I-p2-3
Feed 2 general offset yarn carrier setup	Space-D-C-p1-I-p2-A
Fingers setup offset split feed 2	Space-D-C-p1-I-p2-S
Lubrication unit	**Space-D-C-p2-A**
Mono-Actuator setup menu	**Space-D-C-p2-B**
Mono-Actuator boards numbering	Space-D-C-p2-B-B
Mono-Actuators learning	Space-D-C-p2-B-C
Mono-Actuators general data setup	Space-D-C-p2-B-D
Setup Mono-Actuators currents	Space-D-C-p2-B-D-A
Setup enabling Mono-Actuators	Space-D-C-p2-B-D-B
Mono-Actuators speed table setup	Space-D-C-p2-B-D-C
Take-Down setup	**Space-D-C-p2-C**

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

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, …).]

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.
In practice the sensor provides the software a signal. [Input].

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".

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 and 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**

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

Informs that the operation cannot be performed under the current circumstances.
Do not currently managed.

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.

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.
Update the Graphitron software
Check the software version. The solution, depending on the case, is to update the machine software or the Graphitron.

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.

8. … Stitch-cams calibration

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

Refer to the menu: **Stitch-cams calibration**
See also the menu: **Autotest Stitch cam**

8.0: Cams calibration missing — Error

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).

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 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.

8.5: 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.

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 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.

9.4: Saving of piece-counter setup 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.

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

See in this regard as reported under the item: **8.9**
The machine needs to advance by a value (or the indication of a preference).
Machine run disabled until the software receives the reply.

General piece-counter menu

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.

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.

In the event of a false error ...

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.

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

Error

Message no longer menaged.

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.

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. The new setting will be activated immediately after saving.
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.
First …
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.

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.:

14.59: 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

Information

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

Information

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

Information

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

Alarm

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

Alarm

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)

Alarm

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

Information

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

Error

The stepper motor shown exceeded the time allowed for the operation.
The Timeout is activated via the reset command.
The user must turn off and then turn on the machine. If the problem persists, please contact the Technical Customer Service.

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: **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 a Zeroing ([F0]) to arrive at the End of Sock.
Therefore … 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: **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

Informs that the operation cannot be performed under the current circumstances. (This is for safety reasons.)
Lors du rallumage, la machine reprend à partir du point où elle s'était arrêtée.
This message informs the user that the machine cannot be Run.
Carry out n cylinder full turns by handle till the normal functioning is restored.

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".

14.109: Protection barrier

Error

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**

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

First refer to what specified for the previous entry.
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 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: **9.7**

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

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: Activate file.CS to make closed-toe calibration

Error

Or …

14.122: Article deactivated for missing closed-toe calibration

Error

Refer to the menu: **External closed toe setup menu**

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.

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 group N:
  0 ÷ 7, 9, 12, 15, 18 .
- the following messages belong to group N:
  10, 13, 16, 19, 39 ÷ 46 .
- the following messages belong to group N:
  27 ÷ 30, 55 ÷ 62 .
- the following messages belong to group N:
  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 corresponding to the family of the devices shown. Perform a new numbering.

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.

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.

15.25: The family boards %s are not numbered

Warning

Message no longer menaged.

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

Initial error

Message no longer menaged.

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**

16. … Lubrication

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. __
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

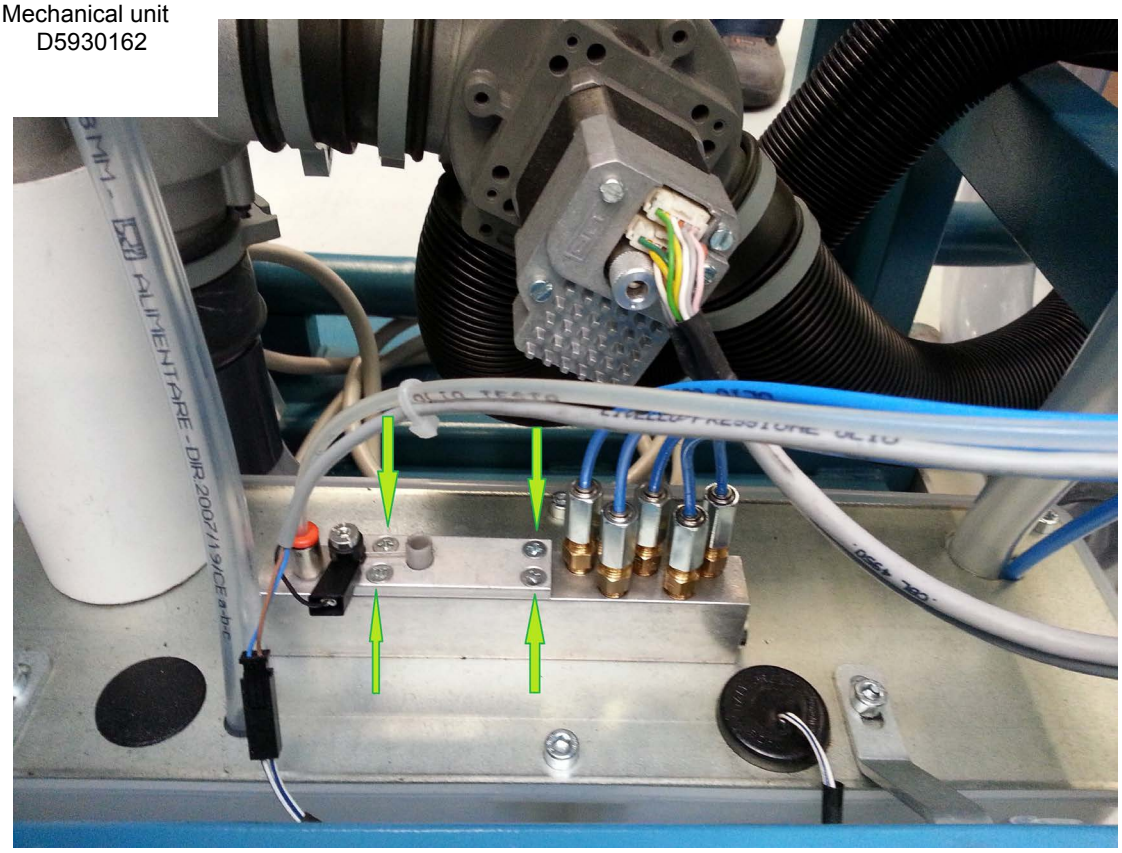
This error informs the user that the pressure (necessary for the effective lubrification) is not enough.
Failure can be caused by … Air bubbles near the sensor. Air bubbles may form when pouring oil.
In this case is neccessary … Create air vent.
See figure on next page. Loosen the screws indicated.
At 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. __
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

Data has been acquired (stored) successfully.

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

Error

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...

Warning

This message alerts the user that an upgrading of the specified board(s) is in progress.
Await the outcome of the operation. You need to wait a few seconds.
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

Warning

The operation was performed successfully.

17.12: Yarn sliding software update failed

Warning

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

Models equipped with PCB 2009
The models to which this document relates only accept the following devices: Sensors **Spyder 2S**

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.

18. … Saw

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

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 stop for high welt
Saw motion checking
Dial vertical piston/ Saw stop motion

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.
At this point, the running is again enabled.

18.1: Saw A control failed — Error

. . . in progress . . .

18.2: Saw B control failed — Error

. . . in progress . . .

18.3: Saw is not released — Error

. . . in progress . . .

18.4: Dial manually raised — Warning

. . . in progress . . .

18.5: Saw setup correctly saved — Warning

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

. . . in progress . . .

18.6: Saw setup saving error — Warning

. . . in progress . . .

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

Data has been acquired (stored) successfully.

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

Refer to the menu: **Fan contactor setup**

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

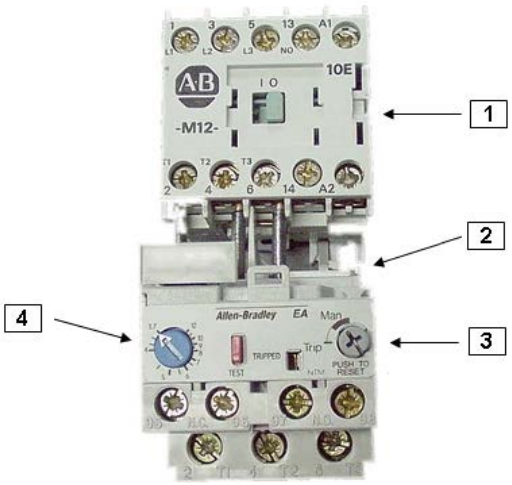
Warning

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. You need to wait a few seconds.
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 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

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.

The position of the part is out of tolerance. Specific calibration must be redone.
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

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.

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 impossible

Error - Movement

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] .

(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 → Enable Outputs)

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)
25.28 Drum 1a not connected (SK1-J2)
25.53 Drum 1r not connected (SK2-J4)
25.21 Drum 2 not connected (SK1-J2)
25.50 Drum 2 not connected (SK2-J1)
25.31 Drum 2 not connected (SK2-J3)
25.56 Drum 2a not connected (SK3-J3)
25.29 Drum 2a not connected (SK2-J1)
25.54 Drum 2r not connected (SK3-J1)

25.27 Drum 1a not connected (SK1-J1)
25.52 Drum 1r not connected (SK2-J3)
25.20 Drum 2 not connected (SK1-J1)
25.6 Drum 2 not connected (SK1-J3)
25.51 Drum 2 not connected (SK2-J2)
25.32 Drum 2 not connected (SK2-J4)
25.57 Drum 2a not connected (SK3-J4)
25.30 Drum 2a not connected (SK2-J2)
25.55 Drum 2r not connected (SK3-J2)

25.5 Drum 3 not connected (SK1-J2)
25.26 Drum 3 not connected (SK2-J4)
25.36 Drum 3 not connected (SK3-J4)
25.61 Drum 3 not connected (SK4-J4)
25.43 Drum 3 not connected (SK2-J2)
25.47 Drum 3a not connected (SK3-J4)
25.59 Drum 3a not connected (SK4-J2)
25.34 Drum 3a not connected (SK3-J2)
25.65 Drum 3r not connected (SK5-J4)

25.25 Drum 3 not connected (SK2-J3)
25.35 Drum 3 not connected (SK3-J3)
25.60 Drum 3 not connected (SK4-J3)
25.42 Drum 3 not connected (SK2-J1)
25.46 Drum 3a not connected (SK3-J3)
25.58 Drum 3a not connected (SK4-J1)
25.33 Drum 3a not connected (SK3-J1)
25.64 Drum 3r not connected (SK5-J3)

25.4 Drum 4 not connected (SK1-J1)
25.24 Drum 4 not connected (SK2-J2)
25.40 Drum 4 not connected (SK4-J4)
25.63 Drum 4 not connected (SK5-J2)
25.45 Drum 4 not connected (SK3-J2)
25.69 Drum 4a not connected (SK6-J4)
25.38 Drum 4a not connected (SK4-J2)
25.67 Drum 4r not connected (SK6-J2)

25.23 Drum 4 not connected (SK2-J1)
25.39 Drum 4 not connected (SK4-J3)
25.62 Drum 4 not connected (SK5-J1)
25.44 Drum 4 not connected (SK3-J1)
25.68 Drum 4a not connected (SK6-J3)
25.37 Drum 4a not connected (SK4-J1)
25.66 Drum 4r not connected (SK6-J1)

25.11 Drum 5 not connected (SK2-J4)
25.9 Drum 7 not connected (SK2-J2)
25.15 Drum 9 not connected (SK3-J4)
25.13 Drum 11 not connected (SK3-J2)
25.19 Drum 13 not connected (SK4-J4)
25.17 Drum 15 not connected (SK4-J2)

25.10 Drum 6 not connected (SK2-J3)
25.8 Drum 8 not connected (SK2-J1)
25.14 Drum 10 not connected (SK3-J3)
25.12 Drum 12 not connected (SK3-J1)
25.18 Drum 14 not connected (SK4-J3)
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.

26. … Raising dial motor

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

Refer to the menu: **Rest enabling setup**
See also: **Dial raiser manuals**

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.
Press the button: **Lower dial manual** .
Touching the icon, the mechanical unit moves downwards.

Remember that: input integrated on the motor board

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.
Press the button: **Dial raising manual** .
Touching the icon, the mechanical unit moves upwards.

See also: **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
26.5:	**Edge Manuals rehabilitated. Complete the manual movement**	Information
26.6:	**Start disabled for manual dial raise not completed**	Information
26.7:	**Manual dial raising disabled**	Information

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

Informs that values below / above the standard allowed have been entered.
The value is expressed as motor steps.

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.

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.

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.

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.

31. … CAN Line messages

Refer to the menu: Menu numbering
See also … Step motors menu
The message contains two variables.
(%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

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.

31.0: Supply tension too high: %ls (%d) Alarm

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 presence of electrical noise on power Three-Phase Line of the machine.
- Check the power supply (voltage) of the CAN board relative the motor indicated in the message. Replace the board(s) if necessary.

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

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.

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**
See the pages that follow.

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_BAS-SOeALTO
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
RADIAL MOTOR 1-2-3-4	FOUR_STEP_MOT_RADIALE_1a4
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
PYF 8	REMOTE_STEPX_PYF_8

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
AIR VACUUM VALVE	REMOTE_STEP_VPE

31.5: Tx impossible: %ls (%d) Error

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.
Check the wiring that connect that connect the various boards.
In case of the occurrence of this message contact the Lonati technical staff.

31.6: Rx busy: %ls (%d) Error

See the description provided for the message: 31.5

31.7: Disabled module: %ls (%d) Error

Internal software failure . Contact the Technical Customer Service.

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

. . . in progress . . .

31.11: skCanMppSegnalazione 12: %ls (%d) Error

. . . in progress . . .

31.12: ADC reading wrong: %ls (%d) Error

. . . in progress . . .

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 (automatic) procedure.
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.

The most common causes that determine this problem are:

- Loss of "steps" due to mechanical factors (Obstructed movement).
- Loss of "steps" due to electrical factors (motor faulty or electrical control not coherent).
- Bad adjustment or malfunction of the sensor of Zero phase.

Software routine

Movement of zeroing of the motor. (during work)
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.**

To solve the problem

- 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.

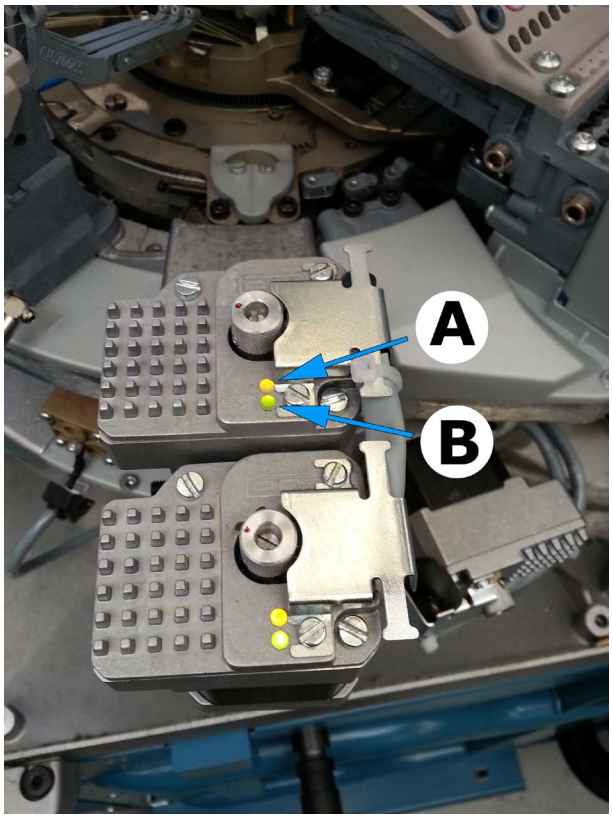
"Mpp CAN" board: Pcb 4887 , LED light meaning

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.

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.

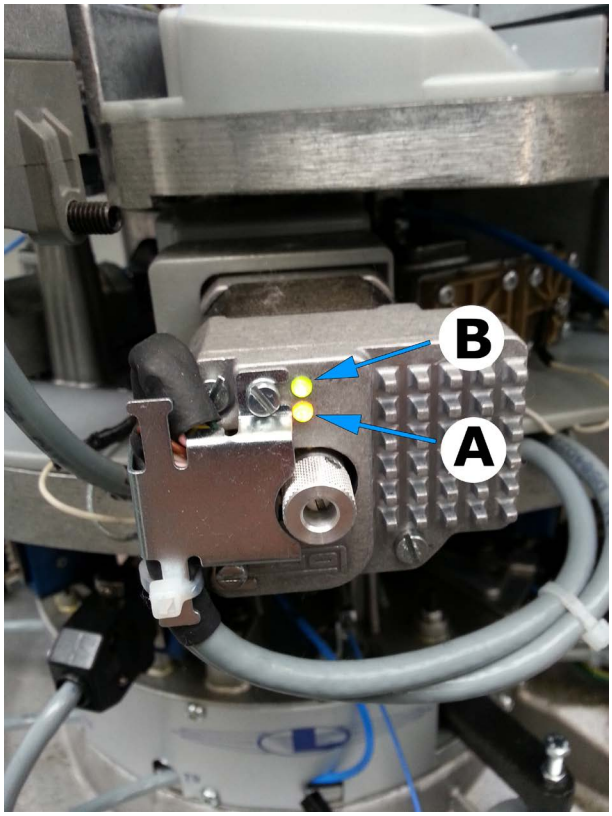
Attention
This type of error is recursive.
It is not cancel simply by pressing the [F8] key.
The best solution is to run a Zeroing ([F0]) to arrive at the End of Sock.
The machine can then return to its normal operation.
A turn off and turn on of the machine keeps the machine in the same point (if available, starts the black-out procedure).
A hardware Reset brings the machine to End of Cycle, but could cause subsequent mechanical damage.
If the problem is not resolved it will recur in the same point of the subsequent sock.



"Mpp CAN" board: Pcb 4899
LED light meaning
Sinkers cap / Sinker cap position

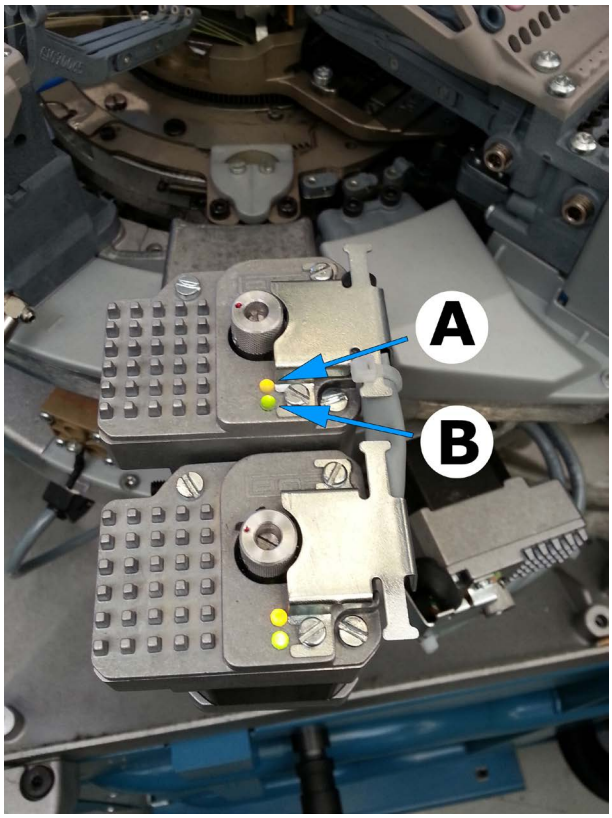
State	Function
LED light **A**	
ON - Orange	**Motor Zero**
LED light **B**	
Flashing - Green	**Communication OK**

GOAL machines



"Mpp CAN" board: Pcb 4899
LED light meaning
Data stitch cam

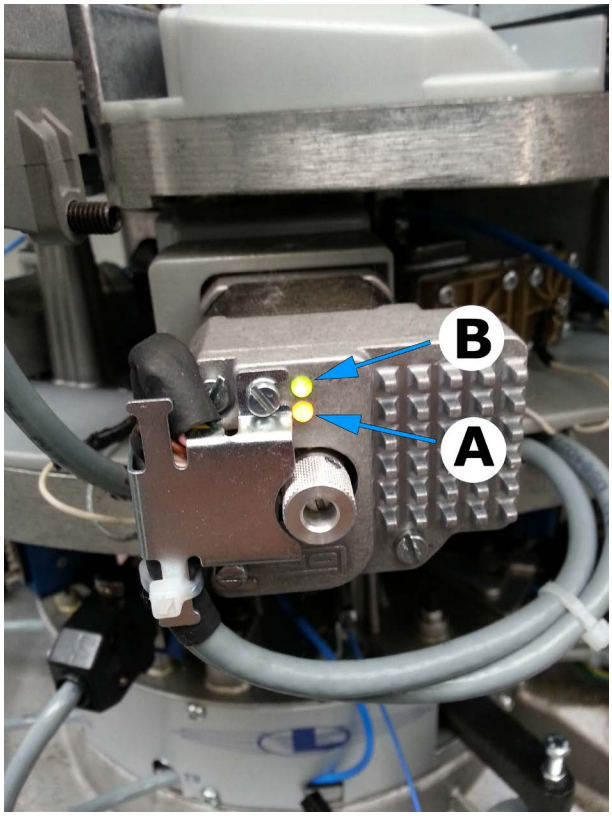
State	Function
LED light **A**	
ON - Orange	Motor Zero
Two-colour alternating light :	
Orange / Red	Software Upgrade
LED light **B**	
Flashing - Orange	**Out** (Solenoid valves de-energized)
Flashing - Green	**Intermediate position** (Stitch cam feed N, position A)
Flashing - Red	**In** (Stitch cam feed N, position B)



"Mpp CAN" board: Pcb 4899
LED light meaning

State	Function
LED light **A** ON - Orange	**Motor Zero**
LED light **B** Flashing - Green	**Communication OK**

DONNA machines



"Mpp CAN" board: Pcb 4899
LED light meaning

State	Function
LED light **A** ON - Orange	**Motor Zero**
LED light **B** Flashing - Green	**Communication OK**

31.14: Lost steps: %ls (%d) Error

. . . in progress . . .

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

31.20: Motor ENCODER tolerance: %ls (%d). Theoretical/actual values: Step %d-%d - Encoder %d-%d

Error - Movement impossible

. . . in progress . . .

31.21: Supply tension too low: %ls (%d)

Error

. . . in progress . . .

31.22: Zeroing impossible: %ls (%d)

Error

. . . in progress . . .

31.23: Bobbin end: %ls (%d)

Error

. . . in progress . . .

31.24: Broken Yarn: %ls (%d)

Error

. . . in progress . . .

31.25: Movement impossible: %ls (%d)

Error

. . . in progress . . .

31.26: Pulls piece %ls (%d)

Error

. . . in progress . . .

31.27: Sewing device needle and ratch.wheel pin not synchronized: %ls (%d) Press Fn + F0

Error

. . . in progress . . .

31.28: No answer from 3ENC board: %ls (%d)

Alarm

. . . in progress . . .

31.29: Acceleration limit: %ls (%d)

Warning

. . . in progress . . .

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
See previous page for more details.

32.2: Bus off: %ls (%d) Error

32.3: Wake up: %ls (%d) Error

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

See previous page for more details.

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 *

In this case … See the description provided for the message: 16. __

Refer to the documentation provided for ordering spare parts.

Outputs / Inputs

Stop oil filter clogs *	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
See also the menu: Autotest menu

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

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

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.

Signal input

The sensor is a switch that is opened (or closed) by a physical parameter.
In practice the sensor provides the software a signal. [Input].

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".

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

If a signal does not comply with the safety conditions, a specific error will appear.
Concerning this see the menu: **Autotest of inputs**

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**

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 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 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.

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	12
39.7	Lack of power 24 VDC yarnfingers unit	11
39.8	Lack of power 24 VDC solenoid-valves unit	10
39.9	Lack of power 24 VDC external expansion board	9
39.10	Sock ejection	36
39.11	Lack of air pressure	35
39.12	Crank - *See the pages that follow.*	LA ≠ LB *
39.13	Oil filter clogged	38
39.14	Position clearing cam feed 4	81
39.15	Position clearing cam feed 3	82
39.16	Position clearing cam feed 2	83
39.17	Position clearing cam feed 1	84
39.18	Position tucking cam feed 4	85
39.19	Position tucking cam feed 3	86
39.20	Position tucking cam feed 2	87
39.21	Position tucking cam feed 1	88
39.22	Elastic 1	93
39.23	Elastic 3	94
39.24	Knife 1 clogged	91
39.25	Knife 3 clogged	92
39.26	Needl Butt Detector	89
39.27	Saw motion checking	95
39.28	Bobbin End	32
39.29	Winders	34
39.30	Supplementary latch detector 2 feed 3	99
39.31	Supplementary latch detector 2 feed 1	100
39.32	Latches 4	101
39.33	Latches 3	102
39.34	Latches 2	103
39.35	Latches 1	104

Input : To this end, see table: Matching software and hardware inputs (**Enclosure**)

Message		Input
39.70	Position C needle stitch cam feed 4	80
39.71	Position C needle stitch cam feed 3	78
39.72	Position C needle stitch cam feed 2	76
39.73	Position C needle stitch cam feed 1	74
39.74	Position E needle stitch cam feed 4	79
39.75	Position E needle stitch cam feed 3	77
39.76	Position E needle stitch cam feed 2	75
39.77	Position E needle stitch cam feed 1	73
39.78	Heel/toe take-up	66
39.79	Needles protection feed 4	65
39.80	Cam heel entrance 4	68
39.81	Cam heel exit 4	67
39.82	Jack overturning feed 4	69
39.83	Jack overturning feed 3	70
39.84	Jack overturning feed 2	71
39.85	Jack overturning feed 1	72
39.86	Position C needle stitch cam heel return	80
39.87	Position E needle stitch cam heel return	79
39.88	Position extra cam feed 4	67
39.89	Position extra cam feed 3	62
39.90	Position extra cam feed 2	68
39.91	Position extra cam feed 1	61

LA ≠ LB (*)

In particular …

LA models

39.12	Crank	37

LB models

39.12	Crank	(a)

(a) connector on motor board (Sizing motor)

CAN type RX board

Furthermore …

i. 90 = 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:
i. 90 = Saw stop for high welt = Input for upper mechanical dial
See the description provided for the message: 18. …

i. nn = Lubrication unit
See the description provided for the message: 37. …

Message		Input
39.97	Elastic 2 - *Input not currently used.*	/
39.98	Knife 2 clogs - *Input not currently used.*	/
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)	

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**

Signal input

The sensor is a switch that is opened (or closed) by a physical parameter.
In practice the sensor provides the software a signal. [Input].

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".

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

If a signal does not comply with the safety conditions, a specific error will appear.

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

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 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 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.

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	12
42.6	Lack of power 24 VDC yarnfingers unit	11
42.7	Lack of power 24 VDC solenoid-valves unit	10
42.8	Lack of power 24 VDC external expansion board	9
42.9	Suction hood open	36
42.10	Lack of air pressure	35
42.11	Crank	*GL ≠ GK* (1)
42.12	Stop clean knife	91
42.13	Dial obstructed	97
42.14	Winders	34
42.15	Latches 1	104
42.16	Latches 2	103
42.17	Stop jack breakage 2	98
42.18	Stop needles during heel	99
42.19	Take-up	100
42.20	Stop jack breakage 1	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	32
42.25	Stop end reel structure	30
42.26	Yarn creel	31

(1) See the pages that follow.

Input : To this end, see table: Matching software and hardware inputs (**Enclosure**)

For all models

Message		Input
42.27	Stop Yarnfingers plate lock	38 *
42.28	Stop yarnfingers plate position	27
42.29	Right Dropper	25
42.30	Left Dropper	26
42.31	… 42.33	*Values depending on the model* (1)
42.34	Lowering needles for elastic	74
42.35	… 42.43	*Values depending on the model* (1)
42.44	Cam rise needles heel/toe return swing	88
42.45	… 42.46	*Values depending on the model* (1)
42.47	Throat-plate	89
42.48	Stop Solis reverser pressure	48
42.49	Stop Solis reverser inspection	49
42.50	Sock ejection not detected	7
42.51	Sock ejection not detected	8
42.52	Yarn antibreak control	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	77
42.78	Stitch cam feed 3 position B	85
42.79	Stitch cam feed 4 position A	80
42.80	Stitch cam feed 4 position B	82
42.81	Stop jack breakage 3	63
42.82	Latches 3	102
42.83	Jacks exctraction feed 1	65
42.84	Jacks exctraction feed 2	64
42.85	Jacks exctraction feed 3	96
42.86	Jacks exctraction feed 4	95
42.87	Lowering needles color 2	81
42.88	Lowering needles color 3	84
42.89	Lowering needles color 4	86
42.90	Sole reinforcement cam feed 2 pos. A	74
42.91	Sole reinforcement cam feed 3 pos. A	76
42.92	Sole reinforcement cam feed 4 pos. A	79
42.93	Tuck cam feed 2	88
42.94	Stop clean knife 2	93
42.95	Stop clean knife 1	91
42.96	Released for pattern	87
42.97	Eliminate jacks feed 2	96
42.98	Lowering needles color 5	77
42.99	Lowering needles transfer cam	79
42.100	Stop latch opening transfer select	78
42.101		*Values depending on the model* (1)

(1) See the pages that follow.

* This item is specific for the models equipped with: Raising dial motor
Otherwise:
i. 38 = Mechanical welt proximity switch = Input for upper mechanical dial

For all models

Message		Input
42.102	Central cam	70
42.103	Latches 4	66
42.104	Stop jack breakage 4	67
42.105	Lowering needles for elastic 2	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	95
42.109	Small jack-raising cam, colour3, feed1	82
42.110	Small jack-raising cam, colour3, feed2	87
42.111	Lowering needles color 2 feed 1	57
42.112	Lowering needles color 2 feed 2	86
42.113	Stop jack breakage 1	41
42.114	Elastic selectors level	73
42.115	Heel return small jack raiser	85
42.116	Feed 1 selectors level	83
42.117	Heel return needle leveller	76
42.118	Remove heel return jacks OUT	55
42.119	Remove heel return jacks IN	43
42.120	Remove selector elastic OUT	95
42.121	Remove selector elastic IN	44
42.122	Selectors exclusion feed 1 OUT	96
42.123	Selectors exclusion feed 1 IN	45
42.124	Selector protection feed 1 OUT	56
42.125	Selector protection feed 1 IN	42
42.126	Pattern drum unit 9 retreat out	54
42.127	Pattern drum unit 9 retreat in	53
42.128	Stop elastic 2	GL ≠ GK (1)
42.129	Sole renforcement cam 2	85
42.130	*Warnings relating to an operation (start, in progress, end).*	(1)
42.131	Clearing cam feed 1 for filet	80
42.132	Clearing cam feed 2 for filet	75
42.133	Small jack-raising cam, tuck, feed 1	83

(1) See the pages that follow.

by model …

GL ≠ GK

In particular …

Message		Input
	GL models	
42.11	Crank	37
42.22	Stop elastic 1	90
42.23	Stop elastic 2	92
	GK	
42.11	Crank	(a)
42.22	Stop elastic 1	(b)
42.23	Stop elastic 2	(b)
	[configuration : 2 Elastic 1 Motor]	
42.128	Stop elastic 2	(c)
	[configuration : 2 Elastic 2 Motor]	

(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

by model …

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 .
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 .

G_ = GL / GK .

See also: **The models to which this document relates**

by model …

Message	Input	Models
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 .

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

Notice

i. 94 = Saw blade phase proximity
See the description provided for the message: 34. …

i. nn = Lubrication unit
See the description provided for the message: 37. …

43 / 44 Short circuit / Not connected

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.

msg	Solenoid valve
.0	Sock ejection
.1	Crank block
.2	Oiler
.3	Yarnfingers plate position
.4	Yarnfingers plate lock
.5	Halt saw device
.6	Bag 1 collection socks
.7	Bag 2 collection socks
.8	Basket changeover 1
.9	Basket changeover 2
.10	Stop yarn antibreak control 1
.11	Yarn sliding for DACSY or MDS
.12	End of cycle DACSY or MDS
.13	Output for Nautilus
.14	External stop lamp
.15	Fictitious Output
.16	Latch opener
.17	Latch opener 2
.18	Needles butt stop in the back
.19	Stop toe jack
.40	Heel & toe terry lever
.41	Terry lever for rib feed 1
.42	Heel Toe terry lever for rib
.43	Heel Toe terry lever half cylinder
.44	Elastic sinkers extraction
.45	Elastic sinkers extraction position 2
.46	Sinker cap piston
.47	Ducking stitch cam feed 1
.48	Ducking stitch cam feed 1 intermediate position
.49	Throat-plate piston feed 1
.50	Disable Throat-plate piston feed 1
.51	Output User 1
.52	Output User 2
.53	Output User 3
.54	Output User 4
.55	Dial jacks enter 1
.56	Dial jacks enter 2
.57	Dial jacks exit phase 1
.58	Dial jacks exit phase 2
.59	Dial partial return for pattern
.80	Raise medium jacks 2 for Sole Liner style
.81	Raise medium jacks 3 for Sole Liner style
.82	Eliminate jacks feed 1 / Jacks exctraction drum 1
.83	Eliminate jacks f. 1 / Jacks exctrac. drum 2
.84	Yarnfinger 1 feed 1
.85	Yarnfinger 2 feed 1
.86	Yarnfinger 3 feed 1
.87	Yarnfinger 4 feed 1
.88	Yarnfinger 5 feed 1
.89	Yarnfinger 6 feed 1
.90	Yarnfinger 7 feed 1
.91	Yarnfinger 8 feed 1
.92	Elastic yarnfinger feed 1
.93	Second Position yarnfinger 1 feed 1
.94	Second Position yarnfinger 2 feed 1
.95	Second Position yarnfinger 3 feed 1
.96	Second Position yarnfinger 4 feed 1
.97	Second Position yarnfinger 5 feed 1
.98	Second Position yarnfinger 6 feed 1
.99	Second Position yarnfinger 7 feed 1

msg	Solenoid valve
.20	Command stop latches 1
.21	Command stop latches 2
.22	Elastic binder 1
.23	Elastic binder 2
.24	Lycra binder position A
.25	Lycra binder position B
.26	Lycra tensioner feed 1
.27	Lycra tensioner heel and toe
.28	Rubber piston 1
.29	Rubber piston 2
.30	Air blowing for transfer
.31	Air blast clean sinkers
.32	Heel Toe take-up 1
.33	Heel Toe take-up 2
.34	Heel Toe take-up 3
.35	Heel Toe take-up 4
.36	Heel Toe take-up 5
.37	Heel Toe take-up 6
.38	Terry lever feed 1
.39	Terry lever half cylinder feed 1
.60	Eliminate raising picker heel return
.61	Eliminate raising picker feed 1
.62	Right Dropper
.63	Left Dropper
.64	Tucking cam feed 1 pos. A
.65	Tucking cam feed 1 pos. B
.66	Clearing cam pos. A
.67	Clearing cam pos. B
.68	Stitch cam feed 1 position A
.69	Stitch cam feed 1 position B
.70	Stitch cam heel/toe position A
.71	Stitch cam heel/toe position B
.72	Lowering needles cam, elastic pos. A
.73	Lowering needles cam, elastic pos. B
.74	Raising long butt needles entering heel/toe
.75	Lowering needles cam end of heel
.76	Sole renforcement cam
.77	Cam rise needles heel return swing pos. A
.78	Cam rise needles heel return swing pos. B
.79	Raise medium jacks 1 for Sole Liner style
.100	Second Position yarnfinger 8 feed 1
.101	Second position Elastic yarnfinger feed 1
.102	Change position Elastic yarnfinger feed 1
.103	Yarnfinger 1 elastic feed
.104	Yarnfinger 2 elastic feed
.105	Yarnfinger 1 color 1
.106	Yarnfinger 2 color 1
.107	Yarnfinger 2 color 1
.108	Yarnfinger 1 color 2
.109	Yarnfinger 2 color 2
.110	Yarnfinger 3 color 2
.111	Yarnfinger 1 color 3
.112	Yarnfinger 2 color 3
.113	Yarnfinger 3 color 3
.114	Yarnfinger 1 color 4
.115	Yarnfinger 2 color 4
.116	Yarnfinger 3 color 4
.117	Yarnfinger 1 color 5
.118	Yarnfinger 2 color 5
.119	Yarnfinger 3 color 5

msg = Message (43. … / 44. …).

msg	Solenoid valve
.120	Yarnfinger 1 feed 6
.121	Yarnfinger 2 feed 6
.122	Yarnfinger 3 feed 6
.123	External lighting
.124	Dial lowering
.125	Yarnfinger adjustment elastic
.126	Close toe dial lowering
.127	Raise fabric close toe
.128	Cylinder stop piston
.129	Turned sock pushing blow
.130	Internal tube position 1
.131	Cylinder knit pusher pos. 1
.132	Yarn ctrl. in sock extract.
.133	Tung.dev. stop piston low
.134	Knit transfer piston up
.135	Knit transfer piston down
.136	Sock-in-work presence control rod
.137	Cylinder knit pusher
.138	Pickup piston out
.139	Pickup piston in
.160	Sole splicing cam feed 4 position B
.161	Lycra binder 1
.162	Lycra binder 2
.163	Lycra binder 3
.164	Lycra binder 4
.165	Lycra tensioner feed 4
.166	Lycra tensioner feed 3
.167	Lycra tensioner feed 2
.168	Ducking stitch cam feed 3 position 2
.169	Sole splicing cam feed 3 position B
.170	Sole splicing cam feed 3 position A
.171	Ducking stitch cam feed 2 position 2
.172	Sole splicing cam feed 2 position B
.173	Sole splicing cam feed 2 position A
.174	Jacks exctraction feed 4
.175	Jacks exctraction feed 3
.176	Jacks exctraction feed 2
.177	Jacks exctraction feed 1
.178	Ducking stitch cam feed 3
.179	Stitch cam feed 3 position A
.200	Terry lever half cylinder feed 2
.201	Exclusion knife feed 2 position 2
.202	Exclusion knife feed 2
.203	Exclusion knife feed 1 position 2
.204	Exclusion knife feed 1
.205	Air blast clean cutter
.206	Regulation 2 finger 4 feed 1
.207	Yarnfinger 1 feed 2
.208	Yarnfinger 2 feed 2
.209	Yarnfinger 3 feed 2
.210	Yarnfinger 4 feed 2
.211	Yarnfinger 5 feed 2
.212	Yarnfinger 6 feed 2
.213	Yarnfinger 7 feed 2
.214	Second Position yarnfinger 1 feed 2
.215	Second Position yarnfinger 2 feed 2
.216	Second Position yarnfinger 3 feed 2
.217	Second Position yarnfinger 4 feed 2
.218	Second Position yarnfinger 5 feed 2
.219	Second Position yarnfinger 6 feed 2

msg	Solenoid valve
.140	Sewing rollerbackward
.141	Sewing roller forward
.142	Seaming device cutter
.143	Pin holder unit rot. lever.
.144	Pin holder support
.145	Pin holder knit pusher
.146	Turning piston up - UP
.147	Turning Piston up - DOWN
.148	Sock stretching sector
.149	Tube stop cam t.dev.up rel.
.150	Tube stop cam t.dev.up stop
.151	Stitching mach. insp. lamp
.152	Elastic binder
.153	Cam press jacks
.154	Lowering needles color 2 Lowering needles exit heel/toe
.155	Ducking stitch cam feed 4
.156	Stitch cam feed 4 position A
.157	Stitch cam feed 4 position B
.158	Ducking stitch cam feed 4 position 2
.159	Sole splicing cam feed 4 position A
.180	Stitch cam feed 3 position B
.181	Stitch cam lock, feed 3 or position 3
.182	Lowering needles color 3
.183	Lowering needles color 4
.184	Ducking stitch cam feed 2
.185	Stitch cam feed 2 position B
.186	Stitch cam feed 2 position A
.187	Position tucking cam feed 2 position B
.188	Position tucking cam feed 2 position A
.189	Terry lever half cylinder feed 4
.190	Terry lever feed 4 or Sinkers extraction
.191	Terry lever for rib feed 4
.192	Change position Elastic yarnfinger feed 4
.193	Command stop latches 3
.194	Terry lever for rib feed 3
.195	Terry lever feed 3 or Sinkers extraction
.196	Terry lever half cylinder feed 3
.197	Change position Elastic yarnfinger feed 3
.198	Terry lever for rib feed 2
.199	Terry lever feed 2 or Sinkers extraction
.220	Second Position yarnfinger 7 feed 2
.221	Change position Elastic yarnfinger feed 2
.222	Yarnfinger 1 feed 3
.223	Yarnfinger 2 feed 3
.224	Yarnfinger 3 feed 3
.225	Yarnfinger 4 feed 3
.226	Yarnfinger 5 feed 3
.227	Yarnfinger 6 feed 3
.228	Yarnfinger 7 feed 3
.229	Second Position yarnfinger 1 feed 3
.230	Second Position yarnfinger 2 feed 3
.231	Second Position yarnfinger 3 feed 3
.232	Second Position yarnfinger 4 feed 3
.233	Second Position yarnfinger 5 feed 3
.234	Second Position yarnfinger 6 feed 3
.235	Second Position yarnfinger 7 feed 3
.236	Yarnfinger 1 feed 4
.237	Yarnfinger 2 feed 4
.238	Yarnfinger 3 feed 4
.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
.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
.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
.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
.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 assist
.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
.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
.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-raisingcam
.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 .

GL616CTE , GK616CTE

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	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 .

GK523

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 .

GK523CTE

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.]

48. … Seaming Device dedicated messages - 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: **Messages on Inputs - GOAL machines**

Or: **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 .

(2) **Goal machines** Input = 107 .

GK , DC88 machines connector on motor board
(CAN type RX board ; Motor : VERTICAL PICKUP DEVICE ARM).

Input : To this end, see table: Matching software and hardware inputs (**Enclosure**)

(3)	**GL models**	Input = 121 .
	GK , DC88 machines	connector on motor board (CAN type RX board ; Motor : PIN FEED).
(4)	**GL models**	Input = 122 .
	GK , DC88 machines	connector on motor board (CAN type RX board ; Motor : PIN FEED).
(5)	**GL models**	Input = 127 .
	GK , DC88 machines	input integrated on the motor board (CAN type RX board ; Motor : TURNING DEVICE DOWN INCLINATION).

Page 3

Tube stop cam t.dev.up stop	131	
Tube stop cam t.dev.up rel.	132	
Presence of sock photocell	__	(B)
Angle pickup arm movement hindered	111	
Seaming device start button	137	
Seaming device halt button	138	
Sock stretching sector position 0	135	
Sock stretching sector position 1	136	
Sock-in-work presence control rod	141	
Sock working presence control rod	142	
Vertical pick-up arm position	__	(6)

(B)	**Goal machines**	Input = 143 .
	DC88 machines	Sensor : absent .
(6)	**Goal machines**	Input = 144 (Do not currently managed.).
	DC88 machines	Sensor : absent .

SensorSignal input	

Goal machines

Page 4

Stop barriers	16
Turning device pipe rotating piston	128
Stop Sock-presence photocamera	Pcb 2010, J43
Stop presence of sock photocell	112

DC88 machines

Page 4

Stop barriers	16
Yarn control in sock extraction	__ (7)
Knit pusher side shifting	144

(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

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

First refer to what specified for the previous entry.
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

First refer to what specified for the previous entry.
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

First refer to what specified for the previous entry.
The device has not reached the working position.

48.9: Internal knit raising tube. Not low

CTE - Error

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.
Refer to the menu: **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

48.10: Internal knit raising tube. Not up

CTE - Error

First refer to what specified for the previous entry.
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 Device 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

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 , DC88 machines
Motor : code G2900813
Sensor: code G2920639 (Sensor integrated in the motor unit)

48.44: Turning device tilt motor error

CTE - Error

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

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 [F8].

The software tries to recover the situation. (also in this case)

Namely … Try to restore the correct position using the control specified. (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.
Raise the sock manually 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.
Raise the sock manually 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 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: [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

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

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.
Therefore …
Press the operating command: [Stop] (Hold down the button.).
Refer to the menu: **Welt raier and dial manuals**

48.66: Operation not allowed manual command in progress sewing

Information

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

48.67: Awaiting end of seaming. Sock target achieved.

Warning

See the description provided for the message: **14.116**

48.68: Ready sewing

CTE - Information

Delete the message by pressing [F8].
Return to the Main window.

48.69: Activation sewing

CTE - Information

The message appears in the following circumstances:
The seaming robot is working. (Working / Resetting)

48.70: Press the run button to reset the machine

CTE - Information

The message indicates the next operation.
Press the operating command: **(I)** Machine Start Button

48.71: Awaiting end of seaming. Basket target achieved.

Warning

See the description provided for the message: **14.117**

48.72: Manually raise the yarn finger plate

CTE - Information

The message is additional to the previous notification.
Refer to 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

CTE - Error

See the description provided for the message: **62.10**

48.74: Operation not allowed machine reset disable sewing

Information

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

Error

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 a 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 persists: 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

CTE - Error

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 device.

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

CTE - Error

Delete the message by pressing [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

CTE - Error

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

CTE - Error

First refer to what specified for the previous entry.
The device has not reached the working position.

48.89: Head not blocked

CTE - Error

. . . in progress . . .

48.90: Turning device pipe rotating piston not in position. Does not unlock

CTE - Error

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 Device.
Press the button: FN+F0

48.93: Cucitrice: dispositivo %s non pronto

CTE - Error

. . . in progress . . .

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: Connection with photocamera

Error

The machine communicates with the device through the computer network.
The machine, or the photocamera, is not connected to the informatic network.
Concerning this see the menu: **Setup IP address**

48.97: Communication with photocamera

Error

. . . in progress . . .

48.98: Photocamera IP address already correct

Error

. . . in progress . . .

48.99: Communication error during changing of photocamera IP address

Error

. . . in progress . . .

48.100: IP address correctly modified

Warning

. . . in progress . . .

48.101: Machine IP address not set

Error

. . . in progress . . .

48.102: Loss of pin-feed motor steps returning to zero

CTE - Error

. . . in progress . . .

48.103: Too much time awaiting Motor %s busyoff

CTE - Error

. . . in progress . . .

48.104: Output either in load not connected or short circuit

CTE - Error

. . . in progress . . .

48.105: Motor ENCODER tolerance: %ls (%d). Theoretical/actual values: Step %d-%d - Encoder %d-%d

CTE - Error

. . . in progress . . .

48.106: Approach to 0 impossible: %ls (%d). Proximity switch already covered.

CTE - Error

. . . in progress . . .

48.107: Approach to 0 impossible: %ls (%d). Proximity switch not found.

CTE - Error

. . . in progress . . .

48.108: Approach to end of stroke impossible: %ls (%d). Proximity switch already covered.

CTE - Error

. . . in progress . . .

48.109: Approach to end of stroke impossible: %ls (%d).Proximity switch not found. CTE - Error

. . . in progress . . .

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

. . . in progress . . .

48.112: Movement impossible: %ls (%d) CTE - Error

. . . in progress . . .

48.113: Up turning device motor not in end-of-stoke position CTE - Error

. . . in progress . . .

48.114: Cylinder knit pusher NOT in intermediate position CTE - Error

. . . in progress . . .

48.115: Barriers disable : mind the automatic movement after the errror cancel CTE - Error

. . . in progress . . .

48.116: Hold pressed the sewing-machine start button to create chain; stop and start buttons for the cutter. Information

. . . in progress . . .

48.117: Sewing device stopped by machine error

CTE - Error

. . . in progress . . .

48.118: Movement interrupted: %ls (%d)

CTE - Error

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.

48.119: First pin HOME value needs to be re-acquired

CTE - Error

. . . in progress . . .

48.120: Motor busy: %ls (%d)

. . . in progress . . .

48.121: Sock 2 passage on closed toe side obstructed or damaged

CTE - Error

. . . in progress . . .

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

. . . in progress . . .

48.124: Photocell: reading fault

CTE - Error

. . . in progress . . .

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

. . . in progress . . .

48.128: …

CTE - Error

Do not currently managed.

48.129: …

CTE - Error

Do not currently managed.

48.130: Forward by phases inserted

CTE - Error

. . . in progress . . .

50. … Program not executable

. . . in progress . . .

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.

60 / 61 Short circuit / Not connected

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.

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 .

Message	Solenoid valve	DC88X-1	DC88X-1J	DC880X-1	DC880X-1J	DC88X-2	DC880X-2S	DC880X-2
.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.
In practice the sensor provides the software a signal. [Input].

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".

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

If a signal does not comply with the safety conditions, a specific error will appear.
Concerning this see the menu: **Autotest of inputs**

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**

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 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 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.

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		i. 7	
62.17	Sock ejection not detected		i. 8	
62.18	Yarn antibreak control		i. 6	
62.19	… 62.29	*Warnings relating to an operation (start, in progress, end).*		(1)
62.30	Stop elastic 1		_	(1)
62.31	Stop elastic 2		_	(1)

(1) See the pages that follow.

Input : To this end, see table:
Matching software and hardware inputs (**Enclosure**)

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

For all models

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 out locking piston	i. 58	.173
62.65	Pulley blocking piston inwards	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

For all models

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

For all models

Message		Input	associated output
62.105 … 62.108	*Warnings relating to an operation (start, in progress, end).*		(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.*	

(1)	See the pages that follow.
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

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

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

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

Error - Movement impossible

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

See previous page for more details.

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

External Closed Toe bars (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

Error - Movement impossible

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

See previous page for more details.

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 … Carry out n cylinder full turns by handle till the normal functioning is restored.
Carry out n cylinder full turns by handle till the normal functioning is restored.
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.
See previous page for more details.

62.24: TRACCIA1-Belant — Warning

Code for internal use.
Internal software failure . Contact the Technical Customer Service.

62.25: TRACCIA2-Belant — Warning

See previous page for more details.

62.26: TRACCIA3-Belant — Warning

See previous page for more details.

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

See previous page for more details.

62.29: Zeroing in heel zone. Wait for synchronism — Warning

See previous page for more details.

62.30 ÷ 62.136

To solve the problem

Solve the real problem that has caused the error.
If the control device has not intervened, proceed as follows.

To this end, please see paragraph: **In the event of a false error …**

66. … Seaming Device dedicated messages - 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: Cucitrice: dispositivo %s non pronto 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**

67. … Saw

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

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 stop for high welt
Saw motion checking
Dial vertical piston/ Saw stop motion

69. … Head out of position - DC88 machines

. . . in progress . . .

69.0: Manually reset the head

Error - Movement impossible

. . . in progress . . .

69.1: Manual head command not finished

Error - Movement impossible

. . . in progress . . .

69.2: Manual head command disabled from software

Information

. . . in progress . . .

69.3: Head setup data correctly saved

Warning

. . . in progress . . .

69.4: Head setup save error

Warning

. . . in progress . . .

69.5: Manual head command not finished

Information

. . . in progress . . .

69.6: The head is not in rest position

Error - Movement impossible

. . . in progress . . .

69.7: The head is not in the work position

Error - Movement impossible

. . . in progress . . .

69.8: Impossible to return the head in the rest position

Information

. . . in progress . . .

69.9: Machine movement prevented due to head manual command not completed

Information

. . . in progress . . .

69.10: Head at rest initialisation not completed

Information

. . . in progress . . .

69.11: Protection barrier interrupted — Information

. . . in progress . . .

69.12: Pulley not at rest — Error - Movement impossible

. . . in progress . . .

69.13: Pulley not in operation — Error - Movement impossible

. . . in progress . . .

69.14: Bolt not at rest — Error - Movement impossible

. . . in progress . . .

69.15: Bolt not at rest in — Error - Movement impossible

. . . in progress . . .

69.16: Bolt not at rest outwards — Error - Movement impossible

. . . in progress . . .

69.17: Bolt not in operation — Error - Movement impossible

. . . in progress . . .

69.18: Fingers group feed 2 not lowered — Error - Movement impossible

. . . in progress . . .

69.19: Feed 2 yarn finger unit not raised — Error - Movement impossible

. . . in progress . . .

69.20: Move the head manually outwards and lock the bolt in position — Warning

. . . in progress . . .

69.21: Move the head manually inwards and lock the bolt in position — Warning

. . . in progress . . .

69.22: Start up the machine — Warning

. . . in progress . . .

69.23: Machine ready for sinkers change, only use handle key — Warning

. . . in progress . . .

69.24: Head opening preparation, in progress — Warning

. . . in progress . . .

69.25: Procedure finishing, in progress — Warning

. . . in progress . . .

69.26: Procedure finished, either press ESC or repeat. — Warning

. . . in progress . . .

69.27: Move manually the head out (to the right) — Error - Movement impossible

. . . in progress . . .

69.28: Move manually the head in (to the left) — Error - Movement impossible

. . . in progress . . .

69.29: Latch not inserted (not descended). — Error - Movement impossible

. . . in progress . . .

69.30: Latch in unknown position — Error - Movement impossible

. . . in progress . . .

69.31: Head not in sock production position — Error - Movement impossible

. . . in progress . . .

69.32: Head not in sock extraction position — Error - Movement impossible

. . . in progress . . .

69.33: Sewing machine error, open sewing window — Error - Movement impossible

. . . in progress . . .

69.34: Pulley locking piston, not detected in rest position — Error - Movement impossible

. . . in progress . . .

Enclosure

Matching software and hardware inputs

Table

Machine inputs

i.	= software inputs (inputs for the software)
B / C / P	= Board, Connector, Pin

i.	B / C / P
6	Pcb 4866, J14, pin 03
7	Pcb 4866, J13, pin 03
8	Pcb 4866, J15, pin 03
13	Pcb 4866, J7, pin 04
14	Pcb 4866, J7, pin 03
15	Pcb 4866, J7, pin 02
16	Pcb 4866, J7, pin 01
17	Pcb 4866, J6, pin 08
18	Pcb 4866, J6, pin 07
19	Pcb 4866, J6, pin 06
20	Pcb 4866, J6, pin 05
21	Pcb 4866, J6, pin 04
22	Pcb 4866, J6, pin 03
23	Pcb 4866, J6, pin 02
24	Pcb 4866, J6, pin 01
25	Pcb 4866, J5, pin 01
26	Pcb 4866, J5, pin 03
27	Pcb 4866, J5, pin 05
28	Pcb 4866, J5, pin 07
29	Pcb 4866, J5, pin 09
30	Pcb 4866, J5, pin 11
31	Pcb 4866, J5, pin 13
32	Pcb 4866, J5, pin 15
33	Pcb 4866, J5, pin 16
34	Pcb 4866, J5, pin 14
35	Pcb 4866, J5, pin 12
36	Pcb 4866, J5, pin 10
37	Pcb 4866, J5, pin 08
38	Pcb 4866, J5, pin 06
39	Pcb 4866, J5, pin 04
40	Pcb 4866, J5, pin 02
41	Pcb 4866, J4, pin 01
42	Pcb 4866, J4, pin 03
43	Pcb 4866, J4, pin 05
44	Pcb 4866, J4, pin 07
45	Pcb 4866, J4, pin 09
46	Pcb 4866, J4, pin 11
47	Pcb 4866, J4, pin 13
48	Pcb 4866, J4, pin 15
49	Pcb 4866, J4, pin 16
50	Pcb 4866, J4, pin 14
51	Pcb 4866, J4, pin 12
52	Pcb 4866, J4, pin 10
53	Pcb 4866, J4, pin 08
54	Pcb 4866, J4, pin 06
55	Pcb 4866, J4, pin 04
56	Pcb 4866, J4, pin 02

i.	B / C / P
57	Pcb 4866, J3, pin 01
58	Pcb 4866, J3, pin 03
59	Pcb 4866, J3, pin 05
60	Pcb 4866, J3, pin 07
61	Pcb 4866, J3, pin 09
62	Pcb 4866, J3, pin 11
63	Pcb 4866, J3, pin 13
64	Pcb 4866, J3, pin 15
65	Pcb 4866, J3, pin 16
66	Pcb 4866, J3, pin 14
67	Pcb 4866, J3, pin 12
68	Pcb 4866, J3, pin 10
69	Pcb 4866, J3, pin 08
70	Pcb 4866, J3, pin 06
71	Pcb 4866, J3, pin 04
72	Pcb 4866, J3, pin 02
73	Pcb 4866, J2, pin 01
74	Pcb 4866, J2, pin 03
75	Pcb 4866, J2, pin 05
76	Pcb 4866, J2, pin 07
77	Pcb 4866, J2, pin 09
78	Pcb 4866, J2, pin 11
79	Pcb 4866, J2, pin 13
80	Pcb 4866, J2, pin 15
81	Pcb 4866, J2, pin 16
82	Pcb 4866, J2, pin 14
83	Pcb 4866, J2, pin 12
84	Pcb 4866, J2, pin 10
85	Pcb 4866, J2, pin 08
86	Pcb 4866, J2, pin 06
87	Pcb 4866, J2, pin 04
88	Pcb 4866, J2, pin 02
89	Pcb 4866, J1, pin 01
90	Pcb 4866, J1, pin 03
91	Pcb 4866, J1, pin 05
92	Pcb 4866, J1, pin 07
93	Pcb 4866, J1, pin 09
94	Pcb 4866, J1, pin 11
95	Pcb 4866, J1, pin 13
96	Pcb 4866, J1, pin 15
97	Pcb 4866, J1, pin 16
98	Pcb 4866, J1, pin 14
99	Pcb 4866, J1, pin 12
100	Pcb 4866, J1, pin 10
101	Pcb 4866, J1, pin 08
102	Pcb 4866, J1, pin 06
103	Pcb 4866, J1, pin 04
104	Pcb 4866, J1, pin 02

i.	B / C / P
105	Pcb 3896, J1, pin 05
106	Pcb 3896, J1, pin 06
107	Pcb 3896, J1, pin 07
108	Pcb 3896, J1, pin 08
109	Pcb 3896, J1, pin 09
110	Pcb 3896, J1, pin 10
111	Pcb 3896, J1, pin 11
112	Pcb 3896, J1, pin 12
113	Pcb 3896, J2, pin 05
114	Pcb 3896, J2, pin 06
115	Pcb 3896, J2, pin 07
116	Pcb 3896, J2, pin 08
117	Pcb 3896, J2, pin 09
118	Pcb 3896, J2, pin 10
119	Pcb 3896, J2, pin 11
120	Pcb 3896, J2, pin 12
121	Pcb 3896, J3, pin 11
122	Pcb 3896, J3, pin 12
123	Pcb 3896, J3, pin 13
124	Pcb 3896, J3, pin 14
125	Pcb 3896, J3, pin 15
126	Pcb 3896, J3, pin 16
127	Pcb 3896, J3, pin 01
128	Pcb 3896, J3, pin 02
129	Pcb 3896, J5, pin 05
130	Pcb 3896, J5, pin 06
131	Pcb 3896, J5, pin 07
132	Pcb 3896, J5, pin 08
133	Pcb 3896, J5, pin 09
134	Pcb 3896, J5, pin 10
135	Pcb 3896, J5, pin 11
136	Pcb 3896, J5, pin 12
137	Pcb 3896, J4, pin 05
138	Pcb 3896, J4, pin 06
139	Pcb 3896, J4, pin 07
140	Pcb 3896, J4, pin 08
141	Pcb 3896, J4, pin 09
142	Pcb 3896, J4, pin 10
143	Pcb 3896, J4, pin 11
144	Pcb 3896, J4, pin 12

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

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.

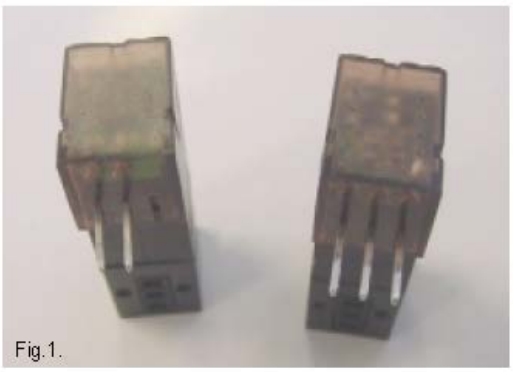


Fig.1.

Fig.1. Ev monostable on the left and bistable on the right.
Fig.2. Electrovalve bar:support with electrovalve.

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.

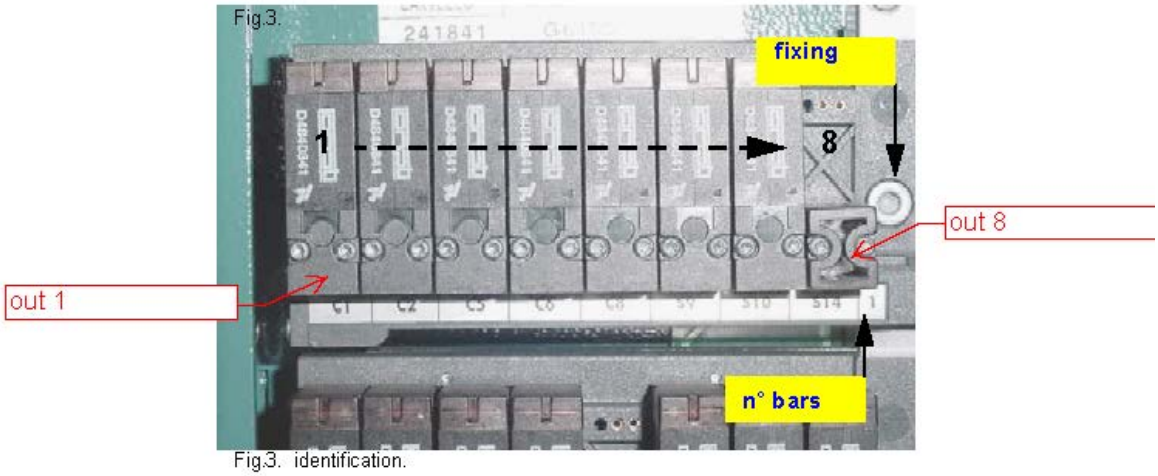


Fig.3. identification.

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 dvided 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.

Dedicated items and message

◊ 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 EXTERN	SHUTTER VALVE EXTERNAL CLOSED TOE	VÁLVULA PARCIAL. P. CERRADA EXTERNA	VANNE DE REGULATION P. FERMEE EXTERNE	VALVOLA PARZIAL. P. CHIUSA ESTERNA
VPE	VPE	VPE	VPE	VPE
Drosselventil	VPE valve	VPE válvula	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	设置吸风马达
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 valfı 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 kismi 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	附加缝头装置风阀
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