

Maintenance - Hydraulics & Electrics

Alarm 9093

Cooling block is already charged, row

Cause: The stated row of the cooling block is already charged with preforms (vacuum existing).

On throwing-off of the preforms it was detected that at least one preform of the current row is still in the cooling block.

Reaction: The advance transfer stroke is blocked if it is in the hand-over position (horizontal position).

Remedy check sensor are positioned correctly, check vacuum, check that perform is not distorted and therefore sticking in cooling block. Can up pressures on Calitec

Alarm 9094

Supervision of conveyor belt has responded

Cause: See alarm text

Reaction: Stop at end of cycle, cycle is blocked, 8-minute alarm, alarm system On

Remedy: Check the activation of the conveyor belts (incl. monitoring of power uptake)

Make sure there is no mechanical blockage anywhere

Alarm 9095

Supervision of vacuum/pressure pump of after-cooling station responded

Cause: See alarm text

Reaction: Stop at end of cycle, cycle is blocked, 8-minute alarm, alarm system On

Remedy: check the activation of the vacuum pump

Alarm 9096

Supervision of vacuum pump of after-cooling station responded

Cause: See alarm text

Reaction: Stop at end of cycle, cycle is blocked, 8-minute alarm, alarm system on

Remedy: check the activation of the vacuum pump

Alarm 9097

Transfer swivel unit is in undefined position

Cause: For the advance or return transfer stroke the transfer swivel unit must be in hand-over or take-over position. In the present case, however, it is in neither of these positions.

Reaction: The transfer stroke is blocked

Remedy: Move the transfer swivel unit to a defined position (hand-over or take-over position)

Alarm 9098

Vacuum loss in vacuum supply of cooling block

Cause: See alarm text

Reaction: Stop at end of cycle, cycle is blocked, 8-minute alarm, alarm system on

Remedy: Ensure that no untightnesses exist anywhere

Alarm 9099

Supervision of motor for lengthwise movement of cooling block responded

Cause: See alarm text

Reaction: The drive for the lengthwise movement is stopped

Remedy: Check the lengthwise movement for mechanical blockages

Check monitoring of power uptake

Alarm 9109

Cooling block offset is faulty

Cause: Program of cooling block not correct

Reaction: can't go to auto

Remedy: Check settings, check cooling block positions and C9005 and C9007