

DISPACK CWA



Operating Instructions

LOGISTIC SYSTEMS & SOFTWARE





A. Control panel





Emergency stop

1

2

3

4

The machine is equipped with EMERGENCY STOP buttons. When an EMERGENCY STOP button is

pressed, the machine will stop immediately and the safety relay will cut the power to all actuators. **Start button**

The machine is automatic when the green light is on.

Accept button

When making a cold start, the light will come on and wait for the user to accept .

Stop button

Makes a controlled stop of the machine once the motion has stopped and the light comes on.



B. General

Operation

This machinery is intended for use in the packaging of single items in postal dispatch boxes Its use in other applications is prohibited.





1

Packaging machine infeed separation switch

The packaging machine infeed separation switch is located o the left door of the control unit. The packaging machine infeed separation switch supplies power To the packaging machine and gluing unit. Always turn the switch to the 0 position when performing maintenance tasks inside the machine. The switch is equipped with a separate lock-out facility; always use the lock-out when performing maintenance inside the machine.

3

Emergency stop

The machine is equipped with EMERGENCY STOP buttons. When an EMERGENCY STOP button is pressed, the machine will stop immediately and the safety relay will cut the power to all actuators.



4

Door limits

The machine is equipped with safety limits. When a door is opened, a safety relay is triggered, thus cutting power to actuators.





Alarm beacon

The machine is equipped with a safety beacon, which has a red, yellow and green alarm indicator light.

The red light is on when the machine is stopped, doors are closed and emergency stop is not active. The red light flashes when cold starting the machine.

The yellow light comes on when the door circuit relay or emergency stop relay has been triggered and flashes when the alarm is active.

The green light is on when the machine is running.







C. Cold start

When the machinery power supply has been cut or a reset command was given on the display, a cold start is carried out as follows:



Remove any box blanks and products from inside the machine. Ensure that there is nothing inside the machine to interfere with its start up.



Using the instructions provided in this Operating Instructions and machine adjustment folder, set the packaging machine for the correct product and choose the correct product on the display screen.



If necessary, place the correct type of blanks into the blank cassettes.



If necessary, ensure that the compressed air hand valve is open. If necessary, check the machine's compressed air pressure (6 bar). The packaging machine compressed air service unit and pressure gauge are located behind a door at the bottom of the operating panel.



Turn the infeed separation switches (on side of control unit) to position 1 (ON).



Close all doors and guards.



Pull all EMERGENCY STOP buttons out.



Press the OK button to reset the safety relay.



10

Press the green Start button (START)

The Start button light will come on and the Stop light will begin to flash to signal the start of a cold start.

The main valve will open slowly and actuators will be moved to their home positions.

The machine will run all actuators into their home positions.

When the motions have been run to the home positions, the OK light will remain on to indicate that all actuators are in their home positions and the machine can now begin normal packaging operation by pressing the OK button.



D. Packaging functions

4.1 Start with I button



Check the display to ensure that there are no alarm lock-outs activated. If there are, press the OK button to reset.



Press the I button on the machine. The machine Start light (green button) will begin to flash to indicate that the machine is starting.



The Start light stops flashing and remains on to signal the start of automatic operation .

Products can now be placed in the packaging machine. Grouping and boxing is done automatically according to the programme selection.

4.2 Stop with 0 button



When the 0 button is pressed, the machine and its conveyors will stop but the valve will remain open (actuators pressurised). Some incomplete motions will continue to completion. The suction holding an open

The machine can be stopped at any time by pressing the 0 button.

blank is not released.

The red light on the display and alarm beacon will come on to indicate STOP mode.



When the machine is stopped with the 0 button and the doors are o the machine is de-energised. When the machine is de-energised, it started until all doors are closed.



If the machine stopped with the STOP button, packaging operations can be resumed at the point where they left off by pressing the START button.



If the machine is stopped with the STOP button and doors are oper operations can be resumed by pressing the OK button to reset the relay and then the START button to resume where the operations left

NOTE!

EXERCISE EXTREME CAUTION IN THE EVENT OF A MALFUNCTION: MOTIONS THAT APPEAR TO BE "STUCK" MAY SUDDENLY RESUME MOTION DUE TO STORED POTENTIAL ENERGY.



E. Adding blanks

1- When the number of blanks in the blank magazine falls to the alarm limit, the yellow Alarm light begins flashing and "NOT ENOUGH BLANKS" appears on the display. The machine will continue operating until there are no more blanks available, at which time the packaging machine will stop and "BLANK LOAD FAILURE".

2

2. Refill the stack feeding conveyor with cardboard blanks carefully. This will prevent unnecessary blank failures from occurring. You must always set the blanks as indicated on the picture, with their edges against the guides. You can use the elevator to raise the feeding conveyor. Always lower the conveyor before starting the machine. WARNING: The stop button of the hydraulic lift do not stop the packing machine

3. Once the magazine is fully loaded, the machine will convey the blanks into the magazine. Never try to reach the blanks which are already in the magazine. Always open a door if you want to reach into the machine! It is strictly forbidden to enter the machine in operation!



5.1 Refilling gluing unit tank

When the gluing unit glue level falls to the alarm limit:

a) WEARING SAFETY GLOVES, open the gluing unit tank cap.b) Fill the tank and replace the cap.

ALWAYS EXERCISE CAUTION when the guard is open BEWARE OF HOT GLUE AND GLUING UNIT PARTS when working in close proximity to the gluing unit or nozzles.

5.2 Opening guard, manual repair

If it is necessary to repair products or blanks manually during a run, do the following:

a) If possible, press the Stop button and wait until the machine comes to a complete stop. This will ensure a more controlled restart. Opening a door in the middle of a motion will cause the glue to dry before box closure, among other things. If this should occur, the box closure will fail due to the dried glue and be ejected with the flaps open.



b) After the machine is stopped, open the guard and perform the necessary actions.

ALWAYS EXERCISE CAUTION when the guard is open. REMEMBER to close the guard and press the Reset button to activate the relays before restarting.

5.3 Backup in subsequent system



If the subsequent system is unable to receive products for some reason, potential-free contact data (stoppage data) can be sent to the packaging machine.

5.4 Previous machine control

If the packaging machine is unable to receive products for some reason, potential-free contact data (stoppage data) can be sent to the previous machine.







F. Display and keypad

The graphical touch-screen display should be cleaned on a regular basis. Do not use solvent-based agents for cleaning the display. Treat the display with care - the touch-screen film is easily damaged.



6.0 Display and keypad

SAVOYE

This screen is the packaging machine main page, which lists the machine name (**DISPACK CWA**) at the top of the page. At the bottom of the page, in the "Active Product" field is the product recipe for the product currently being run. The time is listed in the adjacent field in hours and minutes (hh.mm). Below the Active Product field is the Alarm message field, in which alarms are listed in text form. A symbol for the alarm message is displayed in the lower left-hand corner of the page, where red balls indicate the source of the alarm in the machine.

The field in which "Cold start Machine running" appears shows the machine mode.

The display also has 7 function buttons:

- 1. Product selection
- 2. Reset
- 3. Bar code monitoring)
- 4. Counters
- 5. Alarm log
- 6. Testdrive
- 7. General paramters





G. Screen map





1.0 Main menu



Format running

This line shows the format currently running. To change product you must enter the format selection menu.

Menu selection

To enter a menu, just press gently with your finger on the key shown on the screen. Never use a pen or any other sharp object.



1

2

Alarm browsing

This line shows the current alarm related to the last event in the machine. Always seek for the reson of the alarm before trying to re-start the machine.



2.0 Format selection





2.1 Format editing





Format number

This is the number of the format which is currently edited

2

1

Saving changes

By pressing this key you can save all the changes you have done in this page



2.2 Format editing



Backflap offset

This allows you to set the distance between the back edge of the box, and the root of the back flap.

2

1

Sideflap bender in front

This allows you to set the point where the backflap bender comes to its front position. The distance is the distance between the back edge of the box, to the position where the flap bender comes 12 forward.



2.3 Format editing



Blank dimensions

1

2

This allows you to set the dimensions of the blank to be used. The height is the maximun height.

Retractable conveyor position

This allows you to set the points where the retractable conveyor will start its motion from, and the point where it will stop. This allows you to drop the products in different positions depending on the size q_{13}^f the box.



2.4 Format creation



New format

1

2

2

You can enter here the number of the new format

Template selection

This number shows the number of the format you want to use as a template

Target selection

This number shows the number of the format you want to update the recipe







Reset

This allows you to reset the all machine, and make a coldstart during the next start. This must be done after changing format.

2) |

Emptying

This function allows you to empty the machine. Press the key Emptying and the machine will run all the remaining products out.



4.0 Bar code



Bar code monitoring

1

Each window shows the barcode of the product that is in the station. Each barcode jumps to the next window as the product effectively moves to the next station.



5.0 Counters



Counts the total running time after installation

Partial running time

3

Counts the total running time after the last maintenance



6.0 Alarm log



Shows all defaults and alarms in chronological order.







8.0 General parameters



Language selection

1

You can change the language by pressing the corresponding flag.

SAVOYE 5.1 Alarms and Error reports

The machine is equipped with an alarm indicator light and touch-screen display for the issuing of alarms and error reports. If the alarm light begins to flash, investigate the cause of the disturbance before restarting packaging operations. Below is a list of alarms issued by the machine:

1.Emergency stop pressed 2.Door open, grouping unit 3.Door open, boxing unit 4. Emergency relay tripped 5.Door circuit relay tripped 6.Coldstart ready, press OK button to start automatic packaging 7.Case suction failure, repair/remove blank from erector and press OK 8.Row pusher failure 9. Motor protection tripped 10.Air pressure ok E1-B1 11.Mark envelope sensor has failed, XB1-B1 12.Row pusher back sensor has failed, XB1-B2 13.Row pusher middle sensor has failed, XB1-B3 14.Row pusher front sensor has failed, XB1-B4 15.Front stopper back sensor has failed, XB1-B5 16. Front stopper front sensor has failed, XB1-B6 17.Mark envelope checking failure, no mark envelope 18.Mark envelope checking failure, extra mark envelope 19. Pusher fork front sensor has failed, XB2-B1 20.Pusher fork back sensor has failed, XB2-B2 21.Pusher fork up sensor has failed, XB2-B3 22.Pusher fork down sensor has failed, XB2-B4 23.Stopper fork back sensor has failed, XB2-B5 24.Stopper fork down sensor has failed, XB2-B6 25.Stopper fork up sensor has failed, XB2-B7 26.Unadjustable supporting teeth open sensor has failed, XB2-B8 27. Adjustable supporting teeth closed sensor has failed, XB2-B9 28.Group pusher back sensor has failed, XB2-B10 29.Group pusher front sensor has failed, XB2-B11 30. Top side fork back sensor has failed, XB2-B12 31.Middle side fork back sensor has failed, XB2-B13 32.Bottom side fork back sensor has failed, XB2-B14 33.Intermediate cardboard blanks not enough, add more (XB2-B15) 34.Intermediate cardboard suction failure, repair/remove blank and press OK 35.Intermediate cardboard holder up sensor has failed XB3-B1 36.Intermediate cardboard holder down sensor has failed XB3-B2 37.Intermediate cardboard holder suction head up sensor has failed XB3-B3 38.Intermediate cardboard holder suction head down sensor has failed XB3-B4 39.Press manipulator pressed sensor has failed XB3-B7 40.Press manipulator open sensor has failed XB3-B8 41.Press manipulator front sensor has failed XB3-B9 42.Press manipulator back sensor has failed XB3-B10 43.Press manipulator middle XB3-B11 44.Press manipulator reference limit sensor has failed XB3-B12 45.Blank erector front sensor has failed XB4-B1 46.Blank erector back sensor has failed XB4-B2 47.Not enough blanks in blank magazine, add blanks (XB4-B4) 48.No more blanks in blank magazine, add blanks (XB4-B5) 49.Blank opener up sensor has failed XB4-B6

50.Blank opener front sensor has failed XB4-B7



5.1 Alarms and Error reports

51.Blank opener back sensor has failed XB4-B8

52.Right lower flap closer closed sensor has failed XB4-B10

53.Right lower flap closer open sensor has failed XB4-B11

54.Left lower flap closer closed sensor has failed XB4-B12

55.Left lower flap closer open sensor has failed XB4-B13

56.Small front flap closer closed sensor has failed XB4-B14

57.Small front flap closer open sensor has failed XB4-B15 58.Small back flap closer closed sensor has failed XB4-B16

59.Small back flap closer open sensor has failed XB5-B1

60.Box eject pusher front sensor has failed XB5-B2

61.Box eject pusher back sensor has failed XB5-B3

62.Backup on the ejector conveyor

63.Box not ejected, check pushers

64.Box pusher not down (XB6-B1)

65.One box eject pusher not back (XB6-B4)

66.DeviceNet error, unit not responding.

67. Previous machine stopped

68. Spare

69. Spare

70. Upper small flap closers not closed (XB6-B5, -B7)

71. Upper small flap closers not open (XB6-B6, -B8)

72. Upper side flap closers not closed (XB6-B9, -B11)

73. Upper side flap closers not open (XB6-B10, -B12)

74. Horizontal intermediate cardboard holder not front (XB7-B1)

75. Horizontal intermediate cardboard holder not back (XB7-B2)

76. Horizontal intermediate cardboard holder cannot find upper limit (XB7-B3)

77. Horizontal intermediate cardboard holder rotate not down (XB7-B4)

78. Horizontal intermediate cardboard holder blank error

79. Horizontal intermediate cardboard holder rotate not up (XB7-B5)

80. Gluing unit not ready

81. Glue level low

82. Automatic temperature reduction on

83. Horizontal intermediate cardboard blanks low, add blanks (XB7-B7)





SAVOYE SA Site de Dijon 18, Boulevard des BP 21898 21018 Dijon cedex FRANCE Tel :	Gorgets +33 (0)3-80-54-40-00	PRODEX Siège Social 134, Rue Julian G 94405 Vitry sur S FRANCE Tel : Fax :	Grimau Jeine +33 (0)1-45-73-38-60 +33 (0)1-45-73-38-03
Fax :	+33 (0)3-80-54-40-01		
SAVOYE SA Site de Ladoix Ser 27, Rue de Serrigr 21550 Ladoix-Serr FRANCE Tel : Fax :	rigny ny rigny +33 (0)3-80-26-74-00 +33 (0)3-80-26-74-01	PRODEX Route de Chavag 35310 Mordelles FRANCE Tel : Fax :	ne +33 (0)2 99 85 11 40 +33 (0)2 99 85 11 41
SAVOYE SA Site de Genlis ZI du Layer Rue Ampère 21110 Genlis FRANCE Tel : Fax :	+33 (0)3-80-47-99-47 +33 (0)3-80-47-99-48	SAVOYE Gm Lüpertzender Str 41061 Mönchengl DEUTSCHLAND Tel : Fax :	bH (SAVOYE NE) :6 ladbach +49 (0) 2161 56791 0 +49 (0) 2161 56791 10
a-SIS Site de Saint-Etier 8 rue de la Richela 42100 Saint-Etient FRANCE Tel : Fax :	me mdière ne +33 (0)4-77-49-47-00 +33 (0)4-77-49-47-10	SAVOYE Ltd SAVOYE Ltd Cartwright Way Forest Business P Bardon Hill COALVILLE LE67 1UB UNITED KINGD Tel : Fax :	(SAVOYE UK) Park POM +44 (0)1530 455 000 +44 (0)1530 455 338
a-SIS Site de Tourcoing 50, Rue des Peigneurs BP 484 59338 Tourcoing Cedex FRANCE Tel : +33 (0)3-20-11-35-35 Fax : +33 (0)3-20-11-35-45		SAVOYE Inc (SAVOYE USA) 132 Franklin Corner Road PO Box 5459 Trenton New Jersey 08638 USA Tel : +1 609 512 7096 Fax : +1 609 512 7099	
a-SIS Site de Lyon Immeuble Le Brit	annia		

 Immeuble Le Britannia

 20 bd Eugène Deruelle

 69432 Lyon Cedex 03

 FRANCE

 Tel :
 +33 (0)4-72-68-20-90

 Fax :
 +33 (0)4-72-68-20-99

SAVOYE A DIVISION OF GROUPE EGRIS INDUSTRIES