

Parameters & Messages HERMA 500

EN (US)

Quelltext — Deutsch	Übersetzung – Englisch (US)
helpParameter_10	Set the language on the display. If a text is not available in the language chosen, it will be output in English.
helpParameter_20	Rotate the display screen by 90°, 180° or 270°. The default orientation is 0°.
helpParameter_25	Brightness of the display between 10% and 100%, in steps of 1%. This value determines the brightness for an active display (not dimmed). See parameter 27.
helpParameter_26	Brightness of the display between 10% and 90%, in steps of 1%. This value determines the brightness of an inactive display (dimmed). See parameter 27.
helpParameter_27	Dim the display after the time set here to the brightness set in parameter 26. Dimming the display extends its service life.
helpParameter_30	Activate/deactivate the screen lock for the start screen (darken the screen after approx. 3 minutes of inactivity).
helpParameter_51	Determine which parameter is shown in field 1 of the start screen.
helpParameter_52	Determine which parameter is shown in field 2 of the start screen.
helpParameter_53	Determine which parameter is shown in field 3 of the start screen.
helpParameter_54	Determine which parameter is shown in field 4 of the start screen.
Metrisch/Zoll	Metric/inches
helpParameter_70	Display of units. Should metric units or imperial units (e.g. inches) be used?
Bediener Zugriff auf Format laden erlauben	Allow user to load formats
helpParameter_89	Is the user allowed to use the "Load format" function?
Session Timeout deaktivieren	Deactivate session timeout

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helpParameter_99	Deactivate the session timeout function. Service authorization required
helpParameter_100	<p data-bbox="616 371 1382 483">The delay between the start signal and actual start of label transfer. Thus, for example, the label's position on the product can be altered.</p> <p data-bbox="616 528 1382 719">Note: In conjunction with one of the transfer units of cross transfer or linear unit, this value is specified in milliseconds and defines the delay between product detection and starting the dispensing/transfer cycle. You can set this value with parameter 101.</p> <p data-bbox="616 763 1382 875">When multi-label application is active (parameter 205), there is a separate start delay for each label. See parameters 102 through 108.</p> <p data-bbox="616 920 1382 1032">Take note of the fact that, depending on what is entered as the maximum product speed (parameter 134), the range of values (minimum value) changes for this parameter.</p>
helpParameter_101	<p data-bbox="616 1066 1382 1133">Set the delay between product detection and start of the dispensing/transfer cycle.</p> <p data-bbox="616 1178 1382 1290">This parameter applies only if using a transfer unit (transverse removal unit, linear unit) and/or moving dispensing beak without master encoder.</p>
helpParameter_102	<p data-bbox="616 1323 1382 1480">Set the delay between start signal and actual start of label transport (2nd label when multi-label application is activated). This allows you to adjust the label's position on the product, for example.</p> <p data-bbox="616 1525 1015 1559"><== 205 Multi-label application</p>
helpParameter_103	<p data-bbox="616 1581 1382 1738">Set the delay between start signal and actual start of label transport (3rd label when multi-label application is activated). This allows you to adjust the label's position on the product, for example.</p> <p data-bbox="616 1783 1015 1816"><== 205 Multi-label application</p>
helpParameter_104	<p data-bbox="616 1839 1382 1995">Set the delay between start signal and actual start of label transport (4th label when multi-label application is activated). This allows you to adjust the label's position on the product, for example.</p> <p data-bbox="616 2040 1015 2074"><== 205 Multi-label application</p>

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helpParameter_105	<p>Set the delay between start signal and actual start of label transport (5th label when multi-label application is activated). This allows you to adjust the label's position on the product, for example.</p> <p><== 205 Multi-label application</p>
helpParameter_106	<p>Set the delay between start signal and actual start of label transport (6th label when multi-label application is activated). This allows you to adjust the label's position on the product, for example.</p> <p><== 205 Multi-label application</p>
helpParameter_107	<p>Set the delay between start signal and actual start of label transport (7th label when multi-label application is activated). This allows you to adjust the label's position on the product, for example.</p> <p><== 205 Multi-label application</p>
helpParameter_108	<p>Set the delay between start signal and actual start of label transport (8th label when multi-label application is activated). This allows you to adjust the label's position on the product, for example.</p> <p><== 205 Multi-label application</p>
helpParameter_110	<p>Determine how the start delay is controlled. The start delay can be controlled in two ways.</p> <p>Standard (parameter): Enter the start delay using the integrated display. This value cannot be below the speed-dependent minimum value for the start delay.</p> <p>Analog input (potentiometer): Determine the start delay using an analog value between 0V and 10V. 0V corresponds to the minimum value that can possibly be entered, 10V to the maximum value. These values are defined using parameters 111 and 112. The difference between the minimum and maximum values should not be too large, since otherwise small variations in voltage could considerably alter the start delay. With a difference between minimum and maximum of 200.0 mm, for example, a variation of 0.05V will result in a typical offset of 1 mm.</p>

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helpParameter_111	<p>The minimum value for the start delay at analog input = 0V.</p> <p><== 110 = "Analog input (potentiometer)"</p>
helpParameter_112	<p>The maximum value for the start delay at analog input = 10V.</p> <p><== 110 = "Analog input (potentiometer)"</p>
helpParameter_120	<p>Determines which input variable controls the applicator's speed. There are the following options:</p> <p>Standard (parameter): Permanently set by entry on the display or via the interface (higher-level controller)</p> <p>Analog input (potentiometer): Controlled by potentiometer or an analog PLC output</p> <p>Master encoder: Controlled by master encoder</p> <p>Master encoder vStart=0: Speed controlled via master encoder; the start, however, is initiated from standstill or a speed below 12 m/min. The start delay is max. 10.0 mm.</p> <p>Master encoder async: Speed is determined asynchronously via master encoder if the product speed is higher than the speed set in parameter 130 (max. product speed = 1,200 m/min).</p> <p>Master encoder type 132: Rotation speed compensation for machine type 132M</p> <p>Master encoder roll-fed: Customer specific</p>
helpParameter_130	<p>Read the product speed. For applications with a master encoder, this is the current product speed (display only). Fixed speed if the application type is transverse removal or blow box (<== 300 = "Transverse removal", "Blow Box" or "CAN: Transverse removal")</p>
helpParameter_132	<p>Read the current conveyor speed for application type "CAN: Type 152".</p> <p>In this case the product speed (parameter 130) refers to the speed of the application roller.</p>
helpParameter_134	<p>Enter the maximum speed for the encoder used to optimize parameters for the current application. Thus the minimum value for the start delay can be calculated.</p> <p>This is required for all applications with master encoder and a connected transfer unit. The same applies to master encoder mode for synchronous/asynchronous labeling.</p> <p>Please note that the range for the labeling start delay (minimum value, parameter 100) changes according to what you enter here. If the value you enter is too high, the</p>

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	<p>minimum start delay will also be high.</p> <p><== 120 = "Master encoder"</p>
helpParameter_140	<p>Enter the direction of rotation for the master encoder used. This means you can change the direction of rotation of the master encoder if needed.</p>
helpParameter_141	<p>The number of pulses/increments per revolution of the master encoder are given (see the information on the master encoder's nameplate).</p> <p>Only incremental encoders without interpolating functions and with 2 phase-offset tracks can be used. The resolution of the master encoder is then calculated in x.xxxxx mm / signal edge in conjunction with the following parameter. The 2 phase-offset tracks result in four times the number of signal edges. The range should be between 0.001 mm to 0.05 mm / signal edge. Fine resolution makes it easier to achieve high labeling accuracy. The default resolution is 200 mm at 2000 pulses. This corresponds to a resolution of $200.0 \text{ mm} / (2000 \text{ pulses} * 4) = 0.025 \text{ mm} / \text{signal edge}$.</p> <p><== 120 = "Master encoder"</p>
helpParameter_142	<p>The distance of label web covered per revolution of the master encoder. With linear scales, this is therefore the distance for the specified number of pulses.</p> <p><== 120 = "Master encoder"</p>
helpParameter_143	<p>Enter the dead time of the start sensor to compensate for the resulting delay. This is for calculating an exact labeling process.</p> <p>This is important especially for labeling at high speeds of more than 60 meters/min. If, for example, this is not taken into account, a typical offset of 0.8 mm will result between a minimum speed of 30 meters/min and a maximum speed of 120 meters/min. Typical contactless sensors for triggering the start have a dead time of approx. 0.6 ms.</p>

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	<p><== 120 = "Master encoder" See also parameter 356.</p>
helpParameter_144	<p>Special options that cannot be optimally defined via the other master encoder settings. Option 321 (dispensing speed = start speed): Because a steep acceleration ramp is defined, labeling begins with a fixed start speed. During the rest of the dispensing process, the dispensing speed is adapted to the actual product speed.</p>
helpParameter_145	<p>Extra dead time compensation for the asynchronous range. If the product speed is greater than the speed programmed in quick menu parameter 030, this extra time compensates for the labeling delay in the asynchronous range (typically 0.0 to 1.0 ms)</p> <p><== 120 = "Asynch master encoder"</p>
helpParameter_146	<p>Compensation if using at a machine of type 132M. Enter the distance between dispensing beak and target attachment point on the product. This ensures that the label's point of attachment does not change for different starwheel rotation speeds. Without this compensation, there is a chance that the label will be dispensed between the product and application belt at slow rotational speeds. At high speeds, the label could meet the product too late or be applied folded in on itself.</p>
helpParameter_147	<p>The cutter distance / the distance from cut to cut (for roll-fed only). The control program uses this value to calculate the required speed profile for accurate foil feeding.</p>
helpParameter_148	<p>Position difference between start/stop operation and continuous passage. Usually the foil is stretched more in start/stop operation than in continuous operation due to the vacuum drum and the prolonged pulling time. The difference is entered here so that the cutting edge is always at the same position.</p>
helpParameter_160	<p>This parameter determines the type of product sensing. There are the following options:</p> <p>Rising edge (standard): The default value. Label transfer starts with detection of the rising edge of the product (product enters the detection zone of the start sensor). As soon as the signal is applied the</p>

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corresponding START symbol appears on the screen and labeling starts. Any further start trigger can be effected only if this symbol is inactive for approx. 3 ms.

Scan mark:

Label transfer is started as soon as a scan mark is detected. Use parameters 161 through 163 for specifying.

Start inhibit:

Like a standard setting, except that the start of the label transport is inhibited at a distance determined with parameter 165.

Falling edge:

Label transfer starts when the falling edge of the product is detected (product leaves the detection zone of the start sensor).

Automatic trigger:

A start signal is triggered automatically after an adjustable interval. Depending on whether a transfer unit is active and which one, the interval can be entered in xxx ms or xxx.x mm. See parameters 166 and 167 for setting.

The interval control can be finished with an active signal at the start input.

A start signal will only be passed through if, when the start conditions are met, the "LOCK input" does not prevent a start trigger.

helpParameter_161

The length of scan mark field 1 (the distance in front of the actual scan mark). This is the minimum length of the so-called "white field" in front of the scan mark. The program will look for a scan mark only if this minimum distance has passed.

helpParameter_162

The length of scan mark field 2. This is the width of the actual scan mark ("dark field"). Further processing occurs only if a field of this width is detected. Detection must occur within the specified tolerance. (positive tolerance for scan mark field 2, parameter 164). If detection fails, the program looks for the white field of scan mark field 1.

helpParameter_163

Optional. The length of scan mark field 3 (the distance behind the actual scan mark). Here you have the option to enter the minimum length of scan mark field 3 ("white field"). If you enter "0", this third scan mark field will be ignored. The start

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	is triggered upon correct detection of scan mark field 2. This parameter can be used as an additional filter for detecting a specific pattern.
Tastmarke: 2 Plustoleranz	Scan mark 2: Positive tolerance
helpParameter_164	Additional tolerance for the 2nd scan mark field ("dark field"). The start trigger is inhibited if the tolerance is exceeded. The controller resumes searching for the 1st scan mark field.
helpParameter_165	The distance over which further start signals are to be inhibited after a start signal is detected. See also parameter 160. <== 160 = "Start inhibition"
Simulation, START-Auslösung in msec (Stillstand)	Simulation, START trigger in ms (standstill)
helpParameter_166	The distance from product to product required for triggering a start via "Automatic trigger". For labeling with transfer at standstill, enter in ms. <== 160 = "Automatic trigger"
Simulation, START-Auslösung in mm	Simulation, START trigger in mm
helpParameter_167	The distance from product to product required for triggering a start via "Automatic trigger". For labeling applications not including labeling at standstill, enter in xxx.x mm. <== 160 = "Automatic trigger"
helpParameter_170	The controller's behavior if the start sequence is too close and not every product can be labeled with proper label position. Off: No reaction. The product is not labeled On: An error is issued. (Error message SM163) There is no further labeling.
helpParameter_180	Indicates the number of the format currently loaded. The number is assigned by the user when a new format is created.
helpParameter_181	Activate a batch counter here, if necessary. To do so. enter a value higher than 0. This value will be decreased by 1 with every dispensing cycle that is triggered via the start input. When the counter reaches 0, a message is displayed and

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	production stops. Enter a batch size of '0' to deactivate the batch counter.
helpParameter_182	Indicates the current value of the forward counter
helpParameter_183	Indicates the current value of the backward counter
helpParameter_200	Also called "stop delay." Determines the stop position of the label at the dispensing beak. Note: If multiple labels are dispensed per dispensing cycle, this value might need to be decreased! If twin labeling is activated (parameter 205), there is a separate stop delay for each label (see parameter 202). In case of multi-label application with more than two labels, the stop delay is identical for all labels. Please note that the range of values (minimum value) for this parameter changes according to what is entered for the maximum applicator speed (parameter 234).
helpParameter_202	The stop delay for the 2nd label when twin labeling is activated (parameter 205; see also parameter 200). <== 205 = "Twin (different labels)"
helpParameter_204	Enter the number of labels to be dispensed per start signal if you previously set parameter 205 to "Multiple (identical labels)". In this case all labels must have the same feed length. <== 205 = "Multiple (identical labels)"
helpParameter_205	Number of labels that will be dispensed per start signal. Single (standard): One single label is dispensed for each start signal. Twin (different labels): Two labels are dispensed with each start signal. This allows you to use labels of two different lengths on the backing paper. There are separate parameters for start delay and stop delay for each label (parameters 100, 102–108, 202) to allow for customized application of labels, e.g. on the front and back of a product. Multiple (identical labels): Multiple labels are dispensed with each start signal. The number of labels is specified using parameter 204. Each label

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helpParameter_210	<p>has a separate parameter for the start delay to allow for customized application of labels. The stop delay that is set using the corresponding parameter is the same for all labels.</p> <p>Determine how the stop delay will be controlled. The stop delay can be controlled in two different ways.</p> <p>Standard (parameter):</p> <p>Enter the stop delay via the integrated display or via communication with an external/superordinate control.</p> <p>Analog input (pot):</p> <p>Determine the stop delay with an analog value between 0V and 10V. 0V stands for the minimum value that can possibly be entered, 10V for the possible maximum value. These will be determined with parameters 211 and 212. The difference between the minimum and maximum value should not be too high, otherwise the smallest variations in voltage could considerably alter the stop delay.</p>
helpParameter_211	<p>The minimum value for the stop delay at analog input = 0V. The minimum value, however, depends on the maximum speed selected (parameter 234) and may be corrected.</p> <p><== 210 = "Analog input (potentiometer)"</p>
helpParameter_212	<p>The maximum value for the stop delay at analog input = 10V.</p> <p><== 210 = "Analog input (potentiometer)"</p>
helpParameter_230	<p>This parameter is used to set the speed of the label web. Minimum and maximum speeds correspond to the performance data of the drive unit used. If a master encoder is used, this parameter is used to set the dispensing speed (after the dispense button is pressed). With analog speed adjustment (parameter 120 = "Analog input (potentiometer)"), this is the production and dispensing speed (read only; entries can be limited using parameters 233 and 234).</p>
helpParameter_233	<p>The minimum value for speed at analog input = 0V.</p> <p><== 120 = "Analog input (potentiometer)"</p>
helpParameter_234	<p>The maximum value for speed with analog input = 10V.</p> <p><== 120 = "Analog input (pot)"</p>

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	<p>This value limits the maximum value for parameter 120. For master encoder applications, this speed should not be exceeded in production. Exceeding this speed can lead to errors and malfunctions. The maximum value depends on the performance of the applicator type.</p> <p>This value will always influence the minimum stop delay. The minimum start delay will also be influenced when using a master encoder.</p>
helpParameter_235	Labeling performance in labels per minute
helpParameter_240	<p>Switch the mini loop on or off. This mini loop is formed after a delay (set using parameter 241) by accelerating the label web for a short time (set using parameter 242). The mini loop reduces the tension on the label web.</p> <p>With oval products or in product handling where there must be no tension between product and label, it may be useful to create a small loop after a configured transport distance. This can be achieved using the adjustable mini loop function.</p>
Masterencoder: Startverzögerung Minischlaufe	Master encoder: Mini loop start delay
helpParameter_241	<p>The label transport delay in mm after which the mini loop is created.</p> <p><= 120 = "Master encoder" and 240 = "On"</p>
Masterencoder. Größe der Minischlaufe	Master encoder. Mini loop size
helpParameter_242	<p>The distance in mm over which the mini loop is created after the start delay.</p> <p>Typical values are between 2 mm and 5 mm.</p> <p>If this value is too high, folding may occur when the distance between the product and dispensing beak is small.</p> <p><= 120 = "Master encoder" and 240 = "On"</p>
helpParameter_250	<p>With the help of this option, split labeling can be carried out. This is the case, e.g., with a L-labeling task.</p> <p>Here, an adjustable distance is fed with the given dispensing speed with a start signal at X19.4 . Usually the product is at</p>

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standstill in the labeling station.

Off:

Split labeling is deactivated.

On:

Split labeling can be carried out.

The first adjustable subsection will be fed with the given dispensing speed. The second subsection will be fed after activation of the start input from standstill with $v_{start} = 0$ synchronously to the product speed.

With activation of the pivot beak function, "around the corner" labeling can easily be realized.

On, start input only:

Split labeling can be carried out, with the start input only. The first part of the label is fed immediately after one cycle. The bending station is activated with the start signal and then the second part of the label fed synchronously to the product.

On, start input only + simulation:

As 02, where the product speed will be simulated. The acceleration ramp can be adapted with parameters for the actual acceleration.

≤ 120 = "Master encoder $v_{Start}=0$ "

helpParameter_251

The first subsection for split labeling.

The label is advanced by the specified distance upon receipt of the start trigger. Detection of the label gap generates a second start trigger, after which the remaining distance is dispensed in synchronization with the product speed. See the operating instructions for further details.

≤ 250 = On

helpParameter_252

The bending time for the first subsection in split labeling.

≤ 250 = On

helpParameter_253

The presumed acceleration time for split labeling if the speed is not determined by the master encoder.

It is assumed that bending is carried out at standstill while the conveyor is *not* stopped. The time entered here serves as an assumption for calculating when the product will reach the speed specified (after release of the stopped product).

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helpParameter_260

<=250 = On

The type of label gap detection (gap between the labels) for controlling the label feed. Generally the sensor must be adjusted such that the STOP symbol (submenu) appears when the label sensor is on a label. If this is not observed, full functioning cannot be guaranteed.

Upon detection of the stop signal, the web is dispensed according to the configured stop delay until the final stop position is reached.

Rising edge (standard):

Web transport is stopped upon detection of the label's rising edge.

Scan mark:

Web transport is stopped upon detection of a scan mark. Parameters 261 through 263 are used for further configuration.

Stop inhibition:

Stopping of web transport is inhibited over a distance specified by parameter 264. This function can be used to filter out interfering signals or to dispense multiple labels.

Hole inhibition:

For annulus labels, stopping of web transport within the hole can be inhibited over a distance (the hole size) specified in parameter 265.

No length control:

Normal stopping of label transport, but without teaching of the label length, i.e. transport stops with the next signal from the sensor or after 800 mm at the latest.

Falling edge:

Web transport is stopped upon detection of the label's falling edge. This type of sensing is extremely advantageous in the following applications:

- The sensor is positioned directly at the dispensing beak
- Label transfer is subsequently carried out using a transfer unit

helpParameter_261

The length of scan mark field 1 (the distance in front of the actual mark). This is the minimum length of the "white field"

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	<p>in front of the scan mark. The program looks for a scan mark only once this minimum distance has passed. If there is a level change within this distance, searching starts anew. If the parameter for scan mark field 2 is set to 0, the detected white field is evaluated as the synchronization edge. See the operating instructions for further details</p> <p><= 260 = "Scan mark"</p>
helpParameter_262	<p>The length of scan mark field 2. This is the width of the actual scan mark ("dark field"). Further processing occurs only if a field of this width is detected. If detection fails, the program looks for the white field of scan mark field 1. If the subsequent value for scan mark field 3 is set to 0, synchronization is ended upon detection of the transition from dark to light.</p> <p><= 260 = "Scan mark"</p>
helpParameter_263	<p>Optional. The length of scan mark field 3 (the distance behind the actual scan mark). Here you have the option to enter the minimum length of scan mark field 3 ("white field"). If you enter "0", this third scan mark field will be ignored. The start is triggered upon correct detection of scan mark field 2. If a value is entered for this parameter, the dark field must be followed by a white field that has the length specified here. Otherwise the synchronization process starts anew.</p> <p><= 260 = "Scan mark"</p>
helpParameter_264	<p>The distance on which a stop signal is to be inhibited (suppressed) after one stop signal was received. See also parameter 260.</p> <p><= 260 = "Stop inhibit"</p>
helpParameter_265	<p>The length of the hole in annulus labels over which stop signals are to be inhibited. It should be significantly different from the label gap width (> 3 mm).</p> <p><= 260 = "Hole inhibition"</p>
helpParameter_270	<p>Define the strictness for monitoring the quality of the label feed. The program monitors the distance to falling edge, the width of the gap and the total distance including stop delay distance. The tolerance can be defined using this additional parameter. If the tolerance is exceeded at a particular point, a specific error message is displayed. There are the following options:</p>

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Deactivated
No monitoring.

High
With this setting, the values determined during “manual dispensing” with the dispense button are used as reference values. All deviations outside tolerance lead to standstill and display of the corresponding error message. In this case the stop delay cannot be changed.

Medium
In this case, slight deviations in the overfeed distance (stop delay distance) are accepted. The feed distances are compared to the average values, which are continuously recalculated.

Low
With this setting, an error is issued if multiple consecutive labeling operations are outside the tolerance. The feed distances are compared to the average values, which are continuously recalculated.

> 271

helpParameter_271

The maximum deviation tolerance when quality monitoring is activated. If this tolerance is exceeded, further labeling operations are stopped and an error is issued.

<= 270 is activated

helpParameter_273

The number of consecutive missing labels on the backing paper that will trigger an error message (SM148).

helpParameter_274

Define how to proceed after “incorrect label web transport”. Incorrect label web transport means that the level/status of the label sensor changes even though there was no label transport.

Off:
No reaction.

On:
Production is stopped immediately and error message SM141 is displayed.

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helpParameter_276

Determine if or under what conditions “missing labels” will be taken into account.

Off:

If a label is missing on the backing paper, the web is advanced to the next label available label (to a maximum of the number of label lengths defined in parameter 273; then an error message is issued).

On:

If a label is missing on the backing paper, the web is stopped just as if the label were present. An error message is issued after the maximum number of missing labels defined in parameter 273.

Coupled with printer:

The function depends on whether a printer is switched on (in which case this function is active) or switched off (in which case this function is not active).

helpParameter_277

Define when the No_Label output (X19.10) is activated, i.e., how the applicator reacts in case of missing labels.

At sensor (standard):

Immediate activation at the label sensor. The web is stopped at the correct position even though the label is missing. The “NO LABEL” signal is sent and remains pending until the next labeling cycle is started.

At dispensing beak:

Activation if the missing label is at the dispensing beak.

At dispensing beak + FEED:

Activation if the missing label is at the dispensing beak. Label feed is automatically triggered. This automatic “overfeeding” should only be activated if there is sufficient time or distance until the next start trigger. Otherwise further malfunctions may

occur. In some operating modes this option cannot be used and will automatically be deactivated by the control program.

At dispensing beak + FAULT:

Activation if the missing label is at the dispensing beak. Error message SM106, “Missing label at dispensing beak” is displayed.

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helpParameter_278	Specify the label at which the stop sensor (label sensor) is positioned, where the label directly at the dispensing beak is number "1". A correct entry is important for dealing with "missing labels" when these get to the dispensing beak. An incorrect entry will always lead to errors in the process
Etikettenlänge: Maximalwert	Label length: Maximum value
helpParameter_279	You can limit the maximum dispensing distance in a labeling cycle with this parameter. It is relevant if label detection does not function correctly because of a faulty label sensor. This is required if another module in the label feed process cannot handle the standard value of 800 mm.
helpParameter_295	Setting the dead time of the stop sensor (label sensor) in order to compensate for the resulting delay. Required for an exact orientation of the label with different dispensing speeds. This is important especially with labelings with a master encoder at different product speeds. A typical value for the FS03 sensor and the forked light barrier is approx. 0.6 ms. The ultrasonic sensor has a typical value of approx. 1.2 ms. If the value is too low the stop position of the label at high speed is too late. If the value is too high, the stop position at high speed is too early. See the operating instructions for further details.
helpParameter_300	This parameter defines the type of label transfer onto the product. Based on this selection, further parameters and parameter groups will be enabled. See the operating instructions for further details on all application types and their configuration options. Rigid beak: Using a "normal" rigid beak. Pivot beak: Using a pivot beak. With this application type, an additional distance-dependent output can be activated parallel to the label feed. In the simplest case, this is accomplished using a roller that rolls the label onto the product. Moving dispensing beak: Using a moving dispensing beak. An output is activated on a time-controlled basis and deactivated again after the label feed.

Transverse removal:

Using a transverse removal unit. With this application type, a label is dispensed onto the suction plate, transferred onto a product passing by perpendicularly and then rolled on. Start delay and activation distance can be entered using additional parameters.

Linear unit:

Using a transfer unit (linear unit). In this case a label is transferred onto the suction plate of a linear unit. When the output is activated, the label is transferred to the product and pressed on.

Blow box:

Using a "blow box" transfer unit. With this application type, the label is dispensed onto a vacuum chamber. The controllable output causes the label to be transferred onto the product with the help of compressed air nozzles. This type is suitable for high-speed labeling onto irregularly shaped products that allow a certain tolerance in positioning.

CAN: Type 211:

Using the functionality of the type 211 semi-automatic unit, with two drive units (one for the applicator, the other for the roller unit). This application can be used for universal labeling of horizontally positioned cylindrical products.

CAN: Moving dispensing beak:

Using a moving dispensing beak, connected via CAN bus. As described above, with the possibility of using additional sensors for end position detection.

CAN: Transverse removal:

Using a transverse removal unit, connected via CAN bus. As described above, with the possibility of using additional sensors for end position detection.

CAN: Linear unit:

Using a transfer unit (linear unit), connected via CAN bus. As described above, with the possibility of using additional sensors for end position detection and transfer monitoring with vacuum detection.

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CAN: Moving dispensing beak + linear unit:

Using a moving dispensing beak and transfer unit, connected via CAN bus. Combination of moving dispensing beak and linear unit for precision labeling at a standstill.

CAN: Dispensing beak + moving linear unit:

Using a dispensing beak and a moving transfer unit, connected via CAN bus. This application is intended for precision labeling on stationary products where labels are dispensed based on the detected actual position of the linear unit.

CAN: Type 152:

Use on a type 152C wrap-around applicator. For complete control of the drives and movements of a 152C type machine (vertical cylindrical products with labeling in a roller prism).

All applications with "CAN" require an additional I/O unit for the additional sensors and actuators. Transfer sequences can be optimized using additional optional connections and parameter settings.

helpParameter_310

The type of pivot beak activation.

Coupled with label:

The pivot beak is activated in conjunction with the label transfer.

Always on:

The pivot beak is always activated (in lower position) if the applicator is switched on and there is no malfunction.

Product related:

With this setting, controlling the output of the pivot beak does not depend on the labeling cycle. Start delay and activation time of the pivot beak can be adjusted individually (see parameters 311 and 312). The times are dependent on the product detection. In this way, for example, activation of the pivot beak can be effected after the start of labeling.

Label related:

Start and stop delay of the pivot beak can be adjusted individually (see parameters 313 and 314). The times are dependent on /start with the start and stop of label transfer. Negative values can also be used, which means that in this

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helpParameter_311	<p>case, the pivot beak can be lowered before label transfer starts and can be moved upwards before label transfer stops. It is important to “manually” dispense labels after each parameter change to be able to calculate the resulting parameters.</p> <p><= 300 = “Type 211”</p>
helpParameter_312	<p>If parameter 310 is set to “Product related”, this start delay indicates the distance in mm the product covers after detection until the pivot beak is activated.</p> <p>If parameter 310 is set to “Label related”, this start delay indicates the distance in mm the web is transported until the pivot beak is activated. Note: This parameter can also take a negative value (max. the value of parameter 200 set for the start delay of the label) and will in this case cause the pivot beak to be activated before the label transfer.</p> <p><= 310 = “Product related”</p>
helpParameter_313	<p>The distance in mm (in terms of label transport distance) over which the pivot beak remains activated after starting.</p> <p><= 310 = “Product dependent”</p>
helpParameter_314	<p>See parameter 311.</p> <p>This parameter is intended for the start of the label feed (label dependent). A negative value means that the output for the pivot beak is activated before the start of labeling.</p> <p><= 310 = “Label dependent”</p>
helpParameter_315	<p>The delay (distance covered in mm, in terms of label transport distance) after which the pivot beak is deactivated after the stop of the web transport. Note: This parameter can also take a negative value, in which case the pivot beak will be deactivated before label transport ends.</p> <p><= 310 = “Label dependent”</p>
helpParameter_320	<p>Switch the pivot beak on or off.</p> <p>Define the sensors for the moving dispensing beak (end-of-travel sensors). This is of great importance for the control process. Time-driven functions are thereby replaced by sensor-monitored positions.</p>

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None:

Operation is exclusively time driven.

Home position:

Sensor available. Further operation continues once the dispensing beak is actually back in the home position.

Work position:

Sensor available. The label feed starts only once the dispensing beak has reached its work position.

Home and work positions:

Sensors available: Control is exclusively sensor driven. All movements are monitored with maximum times. If the positions are not reached within these times, a corresponding error message is issued.

helpParameter_321

The delay from start of the moving dispensing beak until label transport is activated. To optimize the labeling process, you may want to start label transport even before the dispensing beak reaches its work position for certain applications. The dispensing beak, however, must have reached its work position before label transport is completed! However, this is valid only if the dispensing beak is operated without a sensor in the work position. In any case, the value must be high enough that:

- The dispensing beak has certainly left its home position after this time
- The dispensing beak is certainly in its work position before the label gap is beneath the label sensor Values above 80 ms have proven effective in practice. If the value is too low:
 - Error message 109 is triggered: "Dispensing beak does not leave home position"
 - Labeling will exhibit excessive deviations.

≤ 300 = "Moving dispensing beak" or "CAN: Moving dispensing beak", or "CAN: Moving dispensing beak + linear unit" + 320 = "None" or "Home position"

helpParameter_322

The time until the unit is in its work position.

≤ 300 = "Moving beak" or "CAN: Moving beak", or "CAN: Moving beak + Linear unit" + 320 = "None" or "Home position"

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helpParameter_323	<p>The maximum time for the dispensing beak to move from home position to work position if there is a sensor for the work position. If the time is exceeded, an error message is displayed.</p> <p><= 300 = "Moving dispensing beak" or "CAN: Moving dispensing beak", or "CAN: Moving dispensing beak + linear unit" + 320 = "Work position" or "Home and work positions"</p>
helpParameter_324	<p>The time for the dispensing beak to reach its home position. If there is an end-of-travel sensor, this is the maximum time before an error message is triggered.</p> <p><= 300 = "Moving dispensing beak" or "CAN: Moving dispensing beak", or "CAN: Moving dispensing beak + linear unit" + 320 = "Home position" or "Home and work positions"</p>
helpParameter_325	<p>The maximum time for the dispensing beak to move from work position to home position if there is a sensor for the home position. If the time is exceeded, an error message is displayed.</p> <p><= 300 = "Moving dispensing beak" or "CAN: Moving dispensing beak", or "CAN: Moving dispensing beak + linear unit" + 320 = "None" or "Work position"</p>
Bewegliche Ablösekanet: Verweildauer in Arbeitsstellung	Moving dispensing beak: Dwell time in work position
helpParameter_326	<p>The time the dispensing beak remains activated before it is switched off (return stroke started). A short delay may be required to allow a take-up cylinder (short-stroke cylinder on the transfer unit) to complete its cycle. This is required to give the vacuum a little time to fix the label to the suction plate with a high vacuum before the dispensing beak is started again.</p> <p><= 300 = "Moving dispensing beak" or "CAN: Moving dispensing beak", or "CAN: Moving dispensing beak + linear unit"</p>
helpParameter_327	<p>This parameter activates options for controlling the moving dispensing beak.</p> <p>None: No option active.</p>

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	<p>Vacuum switch-off:</p> <p>The output for vacuum activation gets deactivated when the dispensing beak is activated. This minimizes the force needed to position the label beneath the suction plate. After label feed the output for vacuum generation is activated automatically.</p> <p><= 300 = "CAN: Moving dispensing beak", or "CAN: Moving dispensing beak + linear unit"</p>
helpParameter_328	<p>Additional functions for supporting the transfer process can be activated with the help of this parameter.</p> <p>None:</p> <p>No option at output 6.2.</p> <p>Web stopper:</p> <p>A web stopper is connected to output 6.2. This makes sure the web is in fixed position during forward movement of the moving beak. The output will be activated directly after label transfer and be deactivated only a short time before the next label feed.</p> <p>Pick-up cylinder:</p> <p>A short-stroke cylinder is connected to output 6.2. This makes sure in certain applications that the label be transferred properly to the suction stamp.</p>
helpParameter_330	<p>This parameter is used to define the sensor assignments for the transfer unit.</p> <p>None:</p> <p>If the transfer unit is operated without sensors, all movements are time driven only. Users have to take care that there are no collisions due to times that are too short.</p> <p>Home position:</p> <p>With this option, the program will only proceed if the transfer unit is certainly in its home position.</p> <p><= 300 = "CAN: Linear unit", or "CAN: Moving dispensing beak + linear unit"</p>
helpParameter_331	<p>The time for the transfer unit to reach its work position. If there is an end-of-travel sensor this is the maximum time until triggering an error message.</p>

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	<p>With the help of this parameter the time (simulation time) is entered which the transfer unit needs to get from home to work position. This time is an estimation depending on the length of the transfer distance and throttling. After this time the control continues.</p> <p><= 300 = "Transverse unit", "Linear unit", "CAN: Transverse unit", "CAN: Transverse unit", "CAN: Moving beak + Linear unit" or "CAN: Dispensing beak + moving linear unit"</p>
helpParameter_332	<p>The time during which the transfer unit remains activated before it is switched off (return stroke started). A short delay before the return stroke may be required to ensure that label transfer is completely successfully, or to have sufficient time for any blowing off.</p> <p><= 300 = "Transverse removal", "Linear unit", "CAN: Transverse removal", "CAN: Linear unit", "CAN: Moving dispensing beak + linear unit" or "CAN: Dispensing beak + moving linear unit"</p>
helpParameter_333	<p>The time for return travel.</p> <p>Home position reached: For application types except "Blow box": The time for the transfer unit to reach its home position. If there is an end-of-travel sensor, this is the maximum time before an error message is triggered.</p> <p>After blow-off: For the "Blow box" application type: The time required after a blow-off procedure before the unit is ready again for the next cycle.</p> <p>Values that are too low may cause malfunctions. Values that are too high will reduce performance.</p> <p><= 300 = "Transverse removal", "Linear unit", "CAN: Transverse removal", "CAN: Linear unit", "CAN: Moving dispensing beak + linear unit" or "CAN: Dispensing beak + moving linear unit" + 330 = "None"</p>
helpParameter_334	<p>The maximum time for return travel. If the home position is not reached during this time, an error message is displayed.</p>

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	<p><= 300 = "Transverse removal", "Linear unit", "CAN: Transverse removal", "CAN: Linear unit", "CAN: Moving dispensing beak + linear unit" or "CAN: Dispensing beak + moving linear unit" + 330 = "Home position"</p>
helpParameter_335	<p>This parameter determines the control sequence.</p> <p>START: Dispensing -> transfer: Dispensing first, then transfer. With this option the label is dispensed onto the suction plate after the start signal is received. Then the label is transferred onto the product by means of the transfer unit. Advantage: Vacuum generation is switched off between cycles.</p> <p>START: Transfer -> dispensing: Transfer first, then dispensing. With this option, transfer to the product occurs immediately after the start signal. Then the label is fed onto the suction plate. Advantage: Fast process because a label is already dispensed onto the suction plate between cycles. Disadvantage: The vacuum must remain permanently activated.</p> <p>FEED: Dispensing // START: Transfer: FEED input: Dispensing // START input: Transfer This setting combines the other two settings and eliminates the disadvantage of constant vacuum generation.</p> <p><= 300 = "Transverse removal", "Linear unit", "CAN: Transverse removal", "CAN: Linear unit", "CAN: Moving dispensing beak + linear unit" or "CAN: Dispensing beak + moving linear unit"</p>
helpParameter_340	<p>Activate or deactivate missing label monitoring (directly via sensor or indirectly via vacuum monitoring). This allows you to detect whether:</p> <ul style="list-style-type: none">- There is a label on the suction plate after dispensing- There is still a label on the suction plate after transfer <p><= 300 = "CAN: Linear unit", "CAN: Moving dispensing beak + linear unit" or "CAN: Dispensing beak + moving linear unit"</p>
helpParameter_341	<p>Determines the procedure to follow if after dispensing no label can be detected on the suction plate.</p> <p>None: The cycle is continued normally irrespective of the result of the missing label check.</p>

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	<p>Issue error message: The cycle is stopped and an error message is displayed.</p> <p>Repeat dispensing: Dispensing is repeated. After a second failure an error message is displayed.</p> <p><= 280 = "On"</p>
helpParameter_342	<p>Determines the procedure to follow if, after label transfer, a label can still be detected on the suction plate.</p> <p>None: The cycle is continued normally irrespective of the result of the missing label check.</p> <p>Issue error message: The cycle is stopped and an error message is displayed.</p> <p>Repeat transfer: Transfer is repeated. After a second failure an error message is displayed.</p> <p><= 280 = "On"</p>
helpParameter_343	<p>The time given to any label control unit (e.g. a vacuum monitor) to become operational. Wait a little after each action to get stable signals. Depending on the size of the vacuum chamber and the cross section of the hose, times for reacting may be approx. 40 through 200 msec. The best value can only be determined by trial and error.</p> <p><= 280 = "On"</p>
helpParameter_345	<p>Determine the type of "READY output". This is especially important for applications in which a transfer unit is used. For applications where transfer is not performed at a standstill, this setting cannot be changed.</p> <p>Always on: The "READY" signal is always present, provided the applicator is "active"</p> <p>Off during total cycle: The "READY" signal is revoked during the entire cycle of</p>

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	<p>dispensing and transferring</p> <p>Off during transfer:</p> <p>The "READY" signal is revoked as long as the transfer unit is active</p> <p><= 300 = "Moving dispensing beak", "Transverse removal", "Linear unit", "Blow box", "CAN: Moving dispensing beak", "CAN: Transverse removal", "CAN: Linear unit", "CAN: Moving dispensing beak + linear unit" or "CAN: Dispensing beak + moving linear unit"</p>
helpParameter_346	<p>The time available for blowing off. This time starts at the same time as the dwell time in parameter 332.</p> <p>In principle, this parameter can be used to activate an output that is usually is used for "blowing off labels" and determine the activation time. If a value of 0 is entered, the output remains inactive. Activation of the output starts when the work position is reached and ends when the transfer unit has reached its home position again, at the latest.</p> <p><= 300 = "Blow box", "CAN: Linear unit", "CAN: Moving dispensing beak + linear unit" or "CAN: Dispensing beak + moving linear unit"</p>
helpParameter_349	<p>Set the time required until the subsequent label can be fed after a label is blown off.</p> <p><= 300 = "Blow box"</p>
helpParameter_350	<p>The desired speed difference between the applicator and the type 152 application roller. A negative value makes the applicator slower than the application roller by the speed entered. A positive value makes it faster.</p> <p>The controller automatically determines the speed of the application roller by reading pulses.</p> <p><= 300 = "CAN: Type 152"</p>
Anrollmotor: Stoppverzögerung	Roller motor: Stop delay
helpParameter_351	<p>The distance in mm over which the roller motor and pivot beak remain activated after label web transport stops. This value usually does not have to be modified.</p> <p><= 300 = "CAN: Type 211"</p>

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Anrollmotor: Startverzögerung	Roller motor: Start delay
helpParameter_352	<p>The time in ms that elapses between product insertion and start of labeling. This delay is required if labeling is started by product detection, e.g. via a light sensor.</p> <p>With a negative value, the roller motor starts after activation of the pivot beak. With a positive value, the drive is activated before the pivot beak is activated.</p> <p><= 300 = "CAN: Type 211"</p>
helpParameter_354	<p>If you know the dead time, you can enter it directly here. Otherwise it can be measured automatically with parameter 355.</p>
Ausmessen Totzeit Übergabe	Measure transfer dead time
helpParameter_355	<p>This parameter serves as a wizard for determining the real dead time of the transfer unit. Sequence to follow: Low measurement speed > High measurement speed > Dead time calculation > Production</p> <p>Production: Standard. Starting compensation is activated (normal production).</p> <p>Low measurement speed: Select this setting and label a product at slow test speed (starting compensation deactivated!).</p> <p>High measurement speed: Select this setting and label the same product at high test speed (starting compensation deactivated!).</p> <p>Dead time calculation: In parameter 356, enter the "Difference of label positions" from the previous "Low measurement speed" and "High measurement speed" steps. Then select "Production" to return to production mode (reactivate starting compensation).</p> <p>The values "Low measurement speed" to "Dead time calculation" help to determine the dead time compensation.</p> <p><= 120 = "Master encoder" and 300 = with transfer unit</p>

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Totzeit Übergabe, Differenz Etikettenpositionen	Transfer dead time: Difference of label positions
helpParameter_356	<p>Serves to calculate the hold-back distance for different product speeds. Enter the difference in label position between the labels dispensed at high measurement speed and low measurement speed. The control program then uses this value to determine the parameters for the hold-back distance for different product speeds.</p> <p><= 355 = "Dead time calculation"</p>
Prisma-Ansteuerung	Prism control
helpParameter_360	<p>Determine the type of wrap-around labeling with the prism.</p> <p>Standard: The prism is activated after product recognition and a configurable start delay (parameter 364). Upon expiry of the start delay in the quick menu, the labeling process is started. After the labeling cycle has finished, the prism is opened after a configurable stop delay (parameter 365). This setting is suitable for positioned labeling with scan mark detection. If no scan mark is detected within a configurable distance, the prism opens so that there is no production stop.</p> <p>Mark: start monitoring: This operating mode is intended for positioned labeling, where the products always exit the prism at the same interval. The prism is activated after product recognition and a configurable start delay (parameter 364). Following a configurable start delay (parameter 366), the actual product detection starts, e.g. the detection of a scan mark. At the same, the activation time for the prism is started. If no product is detected within the configurable start monitoring time (parameter 361), the start trigger is blocked and the prism opened again after the set activation time.</p> <p>Mark: = start monitoring + error: As above, except that the machine is stopped and an error message issued if a synchronization mark (e.g. sensor mark) is not detected.</p> <p>Mark: = start monitoring + direction: As above, except that the activation time depends on the start of the labeling process. As a result, the products leave</p>

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helpParameter_361	<p>the prism station aligned by the label position.</p> <p><= 300 = "CAN: Type 152"</p> <p>Distance limit for parameter 366 (to avoid an endless search if the scan mark cannot be detected). If the limit is exceeded, the system proceeds as defined in parameter 360.</p> <p><= 300 = "CAN: Type 152", 360 = "Mark: Start monitoring" or "Mark: Start monitoring + error" or "Mark: Start monitoring + direction" and 260 = "Scan mark"</p>
helpParameter_362	<p>The sensor for detecting an outfeed jam must remain covered for the period specified here in order for a jam to be signaled. If this sensor remains covered for more than the time defined here, the process for handling outfeed jams starts (separator is stopped).</p> <p><= 300 = "CAN: Type 152"</p>
helpParameter_363	<p>Specify how long the machine continues to run (in order to empty itself) after deactivation (pressing of the "Automatic" button). Set this time such that all products behind the separator roller have been labeled and have left the labeling area.</p> <p><= 300 = "CAN: Type 152"</p>
helpParameter_364	<p>Delay between product detection and closing of the roller prism in order to securely grasp the product. This corresponds to the distance between light barrier and prism. This parameter must be adapted to each individual product and speed.</p> <p><= 300 = "CAN: Type 152"</p>
helpParameter_365	<p>Delay from successful labeling to opening of the roller prism to ensure that the label is fully applied</p> <p><= 300 = "CAN: Type 152"</p>
helpParameter_366	<p>In the case of positioned labeling (aligned to a scan mark), this is the time from activation of the prism until the start of the scan mark search and the start of labeling at 360 = "Standard" (prism extension time plus a buffer).</p> <p><= 300 = "CAN: Type 152"</p>

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helpParameter_367	<p>An additional output can be activated on the CAN module for special applications, e.g. a retaining device or a bending station. To enable universal use of this output, the trigger can be controlled by different events.</p> <p>Standard: Triggering via product recognition.</p> <p>Prism start: Triggering via prism activation.</p> <p>Prism stop: Triggering via prism deactivation.</p> <p>Label start: Triggering with start of labeling.</p> <p>Label stop: Triggering with end of labeling cycle.</p> <p><= 300 = "CAN: Type 152"</p>
helpParameter_368	<p>Start delay until activation of the auxiliary output.</p> <p><= 300 = "CAN: Type 152"</p>
helpParameter_369	<p>Activation duration of the auxiliary output. Caution: This value must not be 0!</p> <p><= 300 = "CAN: Type 152"</p>
helpParameter_400	<p>Switch the printer on or off.</p> <p><= 756 Take note of access authorization</p>
helpParameter_401	
helpParameter_410	<p>Mode for printer activation.</p> <p>Standstill, last label: Printing is triggered when the label web is stationary. For single labeling, each label is printed; for multi-label application, the last label of each series is printed. See parameters 415 and 416 for the configurable start delay and the print time.</p> <p>In motion, every label: Printing is triggered during label web transport. Every label is</p>

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	<p>printed. See parameters 417 and 418 for the configurable start delay and the print time.</p> <p>Standstill, every nth label: Printing is triggered when the label web is stationary. Every nth label is printed (n is defined in parameter 411).</p> <p>In motion, every nth label: Printing is triggered during label web transport. Every nth label is printed onto (n is determined in parameter 411).</p>
helpParameter_411	<p>The number for "n" in the corresponding printer mode.</p> <p>A value of 1 means there is a print pulse for each label. A value of 5 means there is a print pulse for every 5th label</p> <p><= 400 = "On", 410 = "Standstill, every nth label" or "In motion, every nth label"</p>
helpParameter_415	<p>The start delay until the printer output is activated. For printing at a standstill.</p> <p><= 410 = "Standstill, last label"</p>
helpParameter_416	<p>The activation time for the printer output. For printing at a standstill.</p> <p><= 410 = "Standstill, last label"</p>
helpParameter_417	<p>The start delay until the printer output is activated. For printing in motion.</p> <p><= 410 = "In motion, every label"</p>
helpParameter_418	<p>The activation time for the printer output. For printing in motion.</p> <p><= 410 = "In motion, every label"</p>
helpParameter_425	<p>How to evaluate the status signal (busy and error) of a printer.</p> <p>No print monitoring: No print monitoring.</p> <p>Only monitor for print malfunctions via error input: Print malfunctions are only evaluated via the error input.</p>

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	<p>Monitor print sequence and malfunctions via error input:</p> <p>This is selected when the error and busy signal from the printer is transferred via cable.</p> <p>Only monitor print sequence via busy input:</p> <p>The print sequence is only evaluated after the start pulse is triggered.</p> <p>Monitor print sequence and malfunctions via both inputs:</p> <p>The print sequence on a start pulse is evaluated by the busy input. The error signal is evaluated via the error input.</p>
helpParameter_510	-
helpParameter_511	<p>Enter the diameter of the unwinder disc here to optimize detection of diminishing reel and end of reel. Sensitivity of the end-of-reel control is controlled indirectly with this setting.</p> <p>300 mm / 12": Sensitive</p> <p>400 mm / 16": Less sensitive</p> <p>500 mm / 20": Moderate</p> <p>600 mm / 24": Insensitive</p>
helpParameter_512	<p>Define how error messages should be handled when end of reel is detected.</p> <p>Off: Only fault output is activated.</p> <p>On: Fault output and error output are activated, and error message SM107 is displayed.</p>
Ermittlung Bandende und Vorwarnung Bandende	Determine end of reel and diminishing reel

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helpParameter_513	<p>Setting for detecting end of reel.</p> <p>00: End of reel detection deactivated</p> <p>01: End of reel detected by applicator sensors</p> <p>02: End of reel detected by pulse reading</p> <p>03: End of reel detected by internal winder calculations and CAN query</p> <p>04: End of reel detected by winder sensors and CAN query</p>
helpParameter_514	<p>Setting for detecting diminishing reel.</p> <p>00: Diminishing reel detection deactivated</p> <p>01: Diminishing reel detected by applicator sensors</p> <p>02: Diminishing reel detected by pulse reading</p> <p>03: Diminishing reel detected by internal winder calculations and CAN query</p> <p>04: Diminishing reel detected by winder sensors and CAN query</p>
helpParameter_520	<p>Define the diameter for triggering diminishing reel. Only for unwinder with pulse reading or electrical unwinder. This value can also influence the response to an acknowledgment.</p> <p>Odd value, e.g. 97.7 mm "Diminishing reel" output (X10.5 DIM) is activated when the measured value falls below this value. An acknowledgment resets the output.</p> <p>Even value, e.g. 98.0 mm</p>

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helpParameter_521

“Diminishing reel” output (X10.5 DIM) is activated when the measured value falls below this value. The output remains activated until the diameter is redetermined via this value (approx 3 meters after inserting a new roll, at the earliest).

Further specify the conditions of use for the unwinder. This allows you to optimally adjust the unwinder characteristics to the current application conditions.

Standard:

This is the normal mode of the unwinder with pendulum control.

Inert:

This mode can be used with short labels and long intervals (> 1 sec) between the label feeds. The unwinder is gently accelerated and gently decelerated.

In most cases the tension spring effect of the pendulum is also set to a minimum to provide gentle handling, especially for sensitive adhesive materials (pendulum has a floating bearing).

For applications with an average unwinding speed of <= 10 m/min

Roll-fed:

This mode is conceived for continuous high-speed labeling (customer specific). A double pendulum is recommended.

Fixed: Shaft + end of reel:

With this mode there is no pendulum to control the unwinding. Unwinding of the adhesive material is controlled by a light barrier that detects the loop in a loop shaft.

This control mode is intended for stiff label materials for which deflecting the material over the pendulum roller will inevitably detach the labels.

If the loop falls below a second light barrier, end of reel is triggered. This is required since adhesive materials may be used which are not easily detached from the roll and wrapped (dancing roller required).

Acceleration and deceleration of the drive can be set with a second parameter. The setting for this parameter must be adapted to the production process.

Practical experience has shown that for an optimal configuration, a fixed setting for drive behavior is preferable to automatic determination.

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Fixed: Shaft + MAX/MIN sensor:

Same as "Fixed: Shaft + end of reel", except the second light barrier is used for increasing the unwinding speed and not for end-of-reel detection.

Shaft + end of reel:

Same as "Fixed: Shaft + end of reel", except here acceleration and deceleration are adapted automatically by the program.

Shaft + MAX/MIN sensor:

Same as "Fixed: Shaft + MAX/MIN sensors", except here acceleration and deceleration are adapted automatically by the program.

helpParameter_522

This parameter makes the performance request to the unwinder. The parameter can be used for optimal adaption to production conditions.

There are the following options:

00: Automatic (automatic adaption to applicator speed)

01: 100 % torque, aggressive control

02: 95 % torque, less aggressive control

03: 90 % torque

04: 85 % torque

05: 80 % torque

06: 75 % torque

07: 70 % torque, gentle, speed limited

08: 65 % torque, only suitable for operation without a pendulum

09: 60 % torque, only suitable for operation without a pendulum

10: 55 % torque, only suitable for operation without a pendulum

11: 50 % torque, only suitable for operation without a pendulum

12: 45 % torque, only suitable for operation without a pendulum

13: 40% torque, only suitable for operation without a pendulum

14: 35 % torque, only suitable for operation without a pendulum

15: 30 % torque, only suitable for operation without a pendulum

helpParameter_523

Determine the operating mode of the unwinder.

Normal:

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	<p>Integrated in production mode</p> <p>Passive: All functions available but no status and error messages</p> <p>Off: No functions</p>
helpParameter_524	<p>Adjust the sensitivity of unwinding monitoring using the motion of the pendulum. Normally the pendulum does not remain in the same position over a certain distance but rather swivels about its work position. We take advantage of this fact here. If the pendulum remains in the same position over a distance that is too long, it may be blocked. An error message is issued.</p> <p>Off: Off</p> <p>Tolerant: Tolerant (longer unwinding distance possible)</p> <p>Normal: Normal behavior</p> <p>Strict: Strict (short unwinding distance)</p> <p>This parameter may have to be adapted to the production conditions.</p>
helpParameter_525	<p>Adjust the sensitivity of unwinding monitoring using the length of web taken up by the applicator. We can assume that there is a malfunction at the unwinder if the amount of web unrolled is much higher than the web feed at the applicator.</p> <p>Off: Switched off</p> <p>Tolerant: Tolerant (longer unwinding distance possible)</p> <p>Normal: Normal behavior</p>

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	<p>Strict:</p> <p>Strict (short unwinding distance)</p> <p>This parameter may have to be adapted to the production conditions. Monitoring must be switched off if, for example, an independent printer unit creates a loop. In that case label feed is synchronized with unwinding.</p>
helpParameter_530	-
helpParameter_541	<p>There are two parameters for setting the characteristic of the loop unwinder because, in extreme cases, large label feeds at high speed, or small labels with occasional transport must be dealt with.</p> <p>Enter the mode of the loop unwinder as follows:</p> <p>Standard:</p> <p>With the standard setting, the loop unwinder is set and optimized automatically. After switching on or after pausing for an extended period of time, the control is set to its highest dynamics, i.e., even with small label feeds and little output the drive will run roughly in the beginning. On the other hand, however, after a long phase of little output and sudden high performance, the loop may not be able to be built up in time.</p> <p>Automatic:</p> <p>Based on the operating mode and the set maximum speed of the applicator, the loop unwinder is preset with respect to acceleration and maximum speed. The loop unwinder will optimize itself automatically based on the current process during operation.</p> <p>Fast:</p> <p>With respect to final speed and acceleration, the drive is set to high discharging speed. During operation the drive will optimize itself for the actual requirement.</p> <p>Medium:</p> <p>Like "Fast", but for the middle-speed range.</p> <p>Slow:</p> <p>Like "Fast", but for the low-speed range.</p> <p>"Fix" settings:</p> <p>Here the drive is constantly operated with the same preset</p>

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acceleration. The final speed must be determined with the help of parameter 542.

Example setting 05: Here the drive is set to highest dynamic. This setting will always be maintained.

Example setting 13: Here the drive has a slow setting. This setting will always be maintained.

05 Fix: *****:

06 Fix: *****:

07 Fix: *****:

08 Fix: *****:

09 Fix: *****:

10 Fix: *****:

11 Fix: *****:

12 Fix: *****:

13 Fix: *****:

Recommendation: Initially, the characteristics and performance of the loop unwinder should be set to "Automatic". For optimized settings, "Fix settings" should be selected. These do not have an inert, adaptive control and always behave in the same way. See the operating instructions for further details.

helpParameter_542

This parameter is used to further configure the characteristics of the drive. Most notably, the maximum drive speed is defined.

Automatic:

With this option, the settings for acceleration and final drive speed are based on the applicator settings.

100%: With this option, the unit operates with maximum dynamics and maximum final drive speed.

95%:

90%:

85%:

80%:

75%:

70%:

65%:

Reduces acceleration and final speed. This enables gentle handling of the backing system.

60%:

Example settings:

For label lengths over 200 mm and a dispensing speed over

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40 meters/min, a relatively strong, fixed setting should always be used. The reason for this is the quite small loop supply of approx. 250 mm. If a slow/inert setting is used here, blocking may easily result.

For the highest dynamics at the highest speed, the following parameter settings must be chosen:

Parameter 535 with 05 Fixed: *****, parameter 536 with 01 100%.

For small label feeds at moderate speed and a sensitive backing system, the following parameter settings may deliver good results:

Parameter 535 with 09 Fixed: *****, parameter 536 with 06 75%.

Recommendation: Initially the characteristics and performance of the loop unwinder should be set to "Automatic". The "Fixed" settings should be selected for optimized configurations. These do not have inert, adaptive control and always behave in the same way.

See the operating instructions for further details.

helpParameter_543

Define the operating behavior of the loop unwinder.

Normal:

Integrated in production mode

Passive:

All functions available but no status and error messages

Off:

No functions

helpParameter_560

-

helpParameter_561

Enter the diameter of the rewinder disc in order to optimize detection of the "rewinder full" and "rewinder almost full" states. Sensitivity is controlled indirectly with this setting.

300 mm / 12":

Sensitive

400 mm / 16":

Less sensitive

500 mm / 20":

Moderate

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	600 mm / 24": Insensitive
helpParameter_562	Define how error messages should be handled when "Rewinder full" is detected. Off: Only fault output is activated. On: Fault output and error output are activated and an error message is displayed.
helpParameter_572	Define the characteristics of the rewinder. This can be used to optimize the rewinding behavior. Automatic: Adapted to the applicator speed 100 % aggressive 95 % 90 % 85 % 80 % 75 % 70 % 65 % 60 % gentle
helpParameter_573	Define the operating behavior of the rewinder. Normal: Integrated in production mode Passive: All functions available but no status and error messages Off: No functions
helpParameter_610	Display/change the device IP address
helpParameter_611	Port for web front end
helpParameter_612	Subnet mask
helpParameter_613	Default gateway

Quelltext — Deutsch	Übersetzung – Englisch (US)
helpParameter_614	DNS server
OPC UA Freischaltung	Activate OPC UA
helpParameter_619	-
helpParameter_620	Activate OPC UA server in device
helpParameter_621	Port for the OPC UA server
OPC UA Updaterate	OPC UA update rate
helpParameter_622	The update rate for the OPC UA server
helpParameter_630	Define the type of the CANopen module used. This is especially important for control. When the system is started up, it checks whether the required module is in use and available.
helpParameter_631	Define the basic address for all CAN participants in the applicator. This is required for machine type 211, for example, in which two applicator units work on the same CAN bus Required only if multiple applicators are connected via CAN bus.
helpParameter_650	Select the fieldbus protocol. The selection options depend on the device settings enabled.
Feldbus aktivierten/deaktivieren	Activate/deactivate fieldbus
helpParameter_651	Activate/deactivate fieldbus
helpParameter_652	Fieldbus IP address
helpParameter_653	-
helpParameter_701	User 1 PIN in encrypted form
helpParameter_702	User 2 PIN in encrypted form
helpParameter_703	Technician PIN in encrypted form
helpParameter_704	Service customer PIN in encrypted form
Funktion Ausgang X19.3, Ausgabe Motorpulse (jede 0.1mm)	Function of output X19.3, output motor pulses (every 0.1 mm)
helpParameter_721	Define the function of output X19.3 00: Signal edge changes per 0.1 mm transport of the label

Quelltext — Deutsch	Übersetzung – Englisch (US)
	<p>01: For special service purposes</p> <p>02: For special service purposes</p>
Funktion Eingang X19.7: Masterencoder virtuell	Function of input X19.7: Virtual master encoder
helpParameter_722	<p>Define the function of input X19.7.</p> <p>None (standard): Input X19.7 without function</p> <p>Manual speed at START: Automatic dispensing with manual speed at next START. This function is used with master encoder applications where, in some situations, normal manual dispensing is not permitted and no distance information is provided by the master encoder. Here, the master encoder signals are generated by the control program itself, with the speed specified for dispensing. After approx. 100 ms, a labeling cycle under production conditions can be triggered with the start signal. Simulation of the speed stops once the signal at X19.7 falls to the low level again.</p> <p>Manual speed immediately: Automatic dispensing with manual speed immediately. Here, the same description as above applies with the difference that no start signal must be applied. Start is generated automatically. For a new cycle, the signal must be set to low for a short while.</p>
helpParameter_723	<p>Enable special functions and special parameters. By assigning defined values, special functions can be enabled that are not needed in normal applications. These include:</p> <ul style="list-style-type: none">- Enable quality monitoring for the labeling process- Define maximum label feed in a cycle <p>The parameter is available only after undergoing the authorization process.</p>
helpParameter_724	It can be used to start special programs.
helpParameter_726	This parameter defines the behavior of the applicator when it is switched on.

Quelltext — Deutsch	Übersetzung – Englisch (US)
	<p>00: Always on if power is applied</p> <p>01: Resumes the operating state directly before the power was disconnected.</p>
helpParameter_750	This parameter assigns authorization for error acknowledgment.
Zugriff auf Format	Access to format
helpParameter_751	Lock parameters against changes on HMI 00: Unrestricted 01: Locked
	For example, for audit-trail applications, parameter changes can be completely locked on the internal HMI (external and internal). The menu structure is nevertheless available with no restrictions; however, the system will not accept any parameter changes.
helpParameter_756	This parameter controls the access to the printer settings. Definition and implementation must be clarified with L&R.
helpParameter_758	This parameter controls the switch-on authorization for manual operation. It is differentiated between
	00: Only PLC or input ON 01: Only via internal HMI 02: Only via external HMI
helpParameter_759	This parameter controls the dispensing authorization. It is differentiated between
	00: Only PLC or feed input 01: PLC + external HMI (dispense button deactivated) 02: PLC + dispense button (hidden on external device) 03: PLC master: External + button signal are passed through 04: PLC master: Only button signal is passed through (hidden on external device) 05: PLC master: External signal is passed through, dispense button deactivated
helpParameter_850	Define the constructional variant of the applicator.
helpParameter_851	Current error. For communication via fieldbus, OPC, etc.

Quelltext — Deutsch	Übersetzung – Englisch (US)
helpParameter_852	32 bit = 32 flags for different functions: for example, OPC error acknowledgment, printer ON/OFF
helpParameter_853	This parameter indicates which user group is currently logged in.
helpParameter_861	Controller settings
helpParameter_862	Specified acceleration to top speed
helpParameter_863	Specified deceleration to standstill
helpParameter_864	Controller options when temperature limit exceeded
Maximal zulässige Dauerlast	Maximum continuous load permitted
helpParameter_865	Maximum continuous load permitted
helpParameter_870	<p>This parameter is provided for test purposes. It is used to automatically generate start and stop signals.</p> <p>00: Switched off</p> <p>01: Simulate label gap</p> <p>04: Clock generator (autom. label start trigger)</p> <p>05: Combination of 01 and 04 Others not documented here.</p>
helpParameter_871	<p>Simulated distance to next label gap for label feed Total distance = this value + stop delay</p>
helpParameter_872	<p>Activate single-step triggering. Parameter is reset to 00 after a restart. With single-step triggering activated, pressing the dispense button will advance one step at a time.</p>
Dauerlauf	Permanent run mode
helpParameter_873	Activate permanent run mode
helpParameter_1000	-
Fehlendes Etikettan Ablösekannte	Missing label at dispensing beak

Quelltext — Deutsch	Übersetzung – Englisch (US)
alarm_106	There is no label at the dispensing beak and this fact is to be indicated with an error message (to be configured using parameter 277 "Stop sensor: NoLabel").
Etikettenbandende	End of label web
alarm_107	The label reel is used up. However, this error message may have other causes as well, e.g. defective light barrier, light barrier/reflector misadjusted, web break.
Ablöseeinheit erreicht nicht Grundstellung	Dispensing unit does not reach home position
alarm_108	Various sensors check the positions of this component. If one of these positions is not reached or left in time, a corresponding message will appear. These problems usually have some mechanical cause which you can easily detect.
Ablöseeinheit verlässt nicht Grundstellung	Dispensing unit does not leave home position
alarm_109	Various sensors check the positions of this component. If one of these positions is not reached or left in time, a corresponding message will appear. These problems usually have some mechanical cause which you can easily detect.
Ablöseeinheit erreicht nicht Arbeitsstellung	Dispensing unit does not reach work position
alarm_110	Various sensors check the positions of this component. If one of these positions is not reached or left in time, a corresponding message will appear. These problems usually have some mechanical cause which you can easily detect.
Ablöseeinheit verlässt nicht Arbeitsstellung	Dispensing unit does not leave work position
alarm_111	Various sensors check the positions of this component. If one of these positions is not reached or left in time, a corresponding message will appear. These problems usually have some mechanical cause which you can easily detect.
Übergabeeinheit erreicht nicht Grundstellung	Transfer unit does not reach home position
alarm_113	Various sensors check the positions of this component. If one of these positions is not reached or left in time, a corresponding message will appear. These problems usually have some mechanical cause which you can easily detect.
Übergabeeinheit verlässt nicht Grundstellung	Transfer unit does not leave home position

Quelltext — Deutsch	Übersetzung – Englisch (US)
alarm_114	Various sensors check the positions of this component. If one of these positions is not reached or left in time, a corresponding message will appear. These problems usually have some mechanical cause which you can easily detect.
Übergabeeinheit erreicht nicht Arbeitsstellung	Transfer unit does not reach work position
alarm_115	Various sensors check the positions of this component. If one of these positions is not reached or left in time, a corresponding message will appear. These problems usually have some mechanical cause which you can easily detect.
Übergabeeinheit verlässt nicht Arbeitsstellung	Transfer unit does not leave work position
alarm_116	Various sensors check the positions of this component. If one of these positions is not reached or left in time, a corresponding message will appear. These problems usually have some mechanical cause which you can easily detect.
Etikettenkontrolle Fehler nach Vorspenden	Label check: Error after dispensing
alarm_119	After a label is dispensed, there must be a label on the suction stamp, which is detected by the integrated vacuum monitor. In this case the monitor does not detect a vacuum, which probably means that there is no label on the suction stamp. The reason for this may be a web break or a missing label on the backing paper. Perform a visual inspection.
Etikettenkontrolle Fehler nach Übergabe	Label check: Error after label transfer
alarm_120	After a label is transferred, there must be no label on the suction stamp, which is detected by the integrated vacuum monitor. In this case the monitor still detects a vacuum, which probably means that there is still a label on the suction stamp. Perform a visual inspection to determine the cause. There may also be a problem with the material to be labeled (the label could not stick to the product).
Prismaansteuerung Pressluft zu gering	Prism control: Air pressure too low
alarm_130	Type 152: At the beginning there is a check whether the prism leaves its home position. As the case may be check the sensor for the home position You may have to activate or increase the compressed air supply.
Drucker Störung	Printer error

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alarm_134	There is a malfunction in the printer. There may be a fault in the electrical connection, e.g. a plug is loose or the foil is used up. Perform a visual inspection.
Undefinierter Bandeinzug	Incorrect label web transport
alarm_141	The label sensor signaled a level change although there was no label feed. If the web was not moved manually, the following may be the cause: Label sensor misadjusted Label protrudes too far beyond the dispensing beak when at rest Paper brakes have no effect Remedy: Readjust label sensor: Check switching point of label sensor Label sensor should be positioned at least 2 mm behind the rising edge of the label gap Label should not protrude more than approx. 1 mm beyond the dispensing beak (else the product may catch the label when passing the labeling station).
Fehlendes Etikett Serienfehler (Bandriss?)	The label sensor could not detect three consecutive labels (or as many as set in the corresponding parameter, if any). Check the sensor (adjustment) or your label material.
alarm_148	The label sensor could not detect three consecutive labels (or as many as set in the corresponding parameter, if any). Check the sensor (adjustment) or your label material.
Etikettensteg größer als Etikettenlänge	Label gap larger than label length
alarm_150	The label sensor might have been taught inverted information.
Mehrfach-Etikettierung Startfolge zu kurz	Start sequence for multi-label application too short
alarm_153	When multi-label application is activated (parameter 205), the different labels are too close to each other. You may have to increase the respective start delays.
Eingestellte Chargengröße wurde erreicht.	The batch size entered is reached.
alarm_154	The entered batch is completed.
Startverzögerung zu klein oder vMax überschritten	Start delay too low or vMax was exceeded.

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alarm_162	The value for the start delay was too low and/or the maximum product speed was exceeded. Increase parameter 100 "Start delay" or check parameter 234 "Maximum speed (10V)".
Startfolge zu eng	Start sequence too close
alarm_163	The products are fed with too small a distance between each other, i.e., the sensor for the start of labeling gets covered before the previous labeling process is completed. Increase the distance between the products or check the parameters for speed (234), start delay (100) or, if applicable, print time (416).
Startsignal Tastmarke nicht erkannt	Start signal Sensor mark not detected
alarm_164	Parameter 160 is set to "Scan mark" but this mark could not be detected within a certain time. Check the alignment of the mark reader.
Anrollmotor Kommunikationsfehler	Roller unit Communication error
alarm_165	With using a subordinate basic unit, e.g. the roller motor for type 211, a connection to this unit could not be established. Check the connection via X18 and be aware that this connection must be interrupted before updating the software or initializing the unit for the first time.
Etikettierer Kommunikationsfehler	Applicator communication error
alarm_166	When using a superordinate basic unit, e.g. the applicator for type 211, a connection to this unit could not be established. Check the connection via X18 and be aware that this connection must be interrupted before updating the software or initializing the unit for the first time.
Anrollmotor Fehler	Roller motor error
alarm_167	There is an error in the roller motor (roller prism, type 211). There may be a blockage. After remedying the problem, acknowledge the error first on the roller unit's display and then on the main display.
CAN-Verbindung getrennt.	CAN connection interrupted.
alarm_168	The CAN connection must be disconnected (at X18). Check the CAN bus connection (X18). Disconnect. Switch the power off (min. 10 s) and switch on

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	again. After at least another 10 s switched off, reconnect the CAN and switch on the power.
Firmware-Update erforderlich!	Firmware update required!
alarm_169	You have to update the firmware (e.g. via the Config software) because the firmware of the CAN I/O and the firmware of the drive unit do not match, e.g. because one of the units was replaced.
alarm_170	Firmware of DSP and ARM not compatible. Update firmware.
Falsches CAN-Modul im Einsatz	Incorrect CAN module used
alarm_175	Select the right CAN module for the application.
Drucker nicht fertig	Printer not ready
alarm_180	A start signal for label transfer was given, the start delay has expired, the printer, however, is still "busy" (input X7.5). Check input X7.5 and, as the case may be, the parameter for the print time (416).
Fehler Freischaltoptionen	Error: activation options
alarm_181	There was a problem with the activation code. If this malfunction occurs repeatedly, please contact our technical service department or your HERMA contact person.
alarm_182	System update in progress. Do not switch off the applicator or disconnect the voltage.
Firmware-Update Winder erforderlich	Winder firmware update required
alarm_185	You have to update the firmware in the winder systems in order to fully use all of their options.
Etikettsensor Pegel prüfen	Check level of label sensor
alarm_186	Label sensor possibly misadjusted. Imbalance of gap width to label length. Solution: Change from paper label to metalized label
Qualitätssicherung Serienfehler	Quality assurance: series fault
alarm_187	Series fault: inadmissible deviations.

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	Solution: Increase tolerance for deviation. Dispense labels again.
Qualitätssicherung Stoppverzögerung	Quality assurance: stop delay
alarm_188	Overfeed distance changed without permission. Solution: Teach label length using manual dispensing.
Qualitätssicherung Abmessung falsch	Quality assurance: dimension wrong
alarm_189	Label distance is too long: Solution: Teach label length using manual dispensing. Increase tolerance
alarm_190	Label distance is too short Solution: Teach label length using manual dispensing. Increase tolerance
Qualitätssicherung Laufstrecke zu lang	Quality assurance: distance too long
alarm_191	Label distance is too long. Teach label length using manual dispensing. Increase tolerance.
Qualitätssicherung Laufstrecke zu kurz	Quality assurance: distance too short
alarm_192	Label distance is too short. Teach label length using manual dispensing. Increase tolerance.
alarm_193	Teach label length using manual dispensing. Increase tolerance.
CAN-Kommunikation Kein CAN-Modul gefunden	CAN communication: no CAN module detected
alarm_199	There is no connection to the required CAN module. Check the cabling.
Datenbank	Database
alarm_200	Reserved for direct user messages from ARM
Dateisystem	File system

Quelltext — Deutsch	Übersetzung – Englisch (US)
alarm_201	Reserved for direct user messages from ARM
Frontend	Front end
alarm_202	Reserved for direct user messages from ARM
Reserviert für direkte Benutzermeldungen von ARM	Reserved for direct user messages from ARM
alarm_203	Reserved for direct user messages from ARM
alarm_204	Reserved for direct user messages from ARM
alarm_205	Reserved for direct user messages from ARM
alarm_206	Reserved for direct user messages from ARM
alarm_210	Reserved for direct user messages from ARM
Nicht bereit. Etikettierer nicht aktiv.	Not ready. Applicator not active.
alarm_300	Not ready. Applicator not active.
Nicht bereit. CAN Modul	Not ready. CAN module
alarm_301	No response from the CAN module
Nicht bereit. Übergabezustand	Not ready. Transfer status
alarm_302	Transfer status requires removal of the READY signal
Nicht bereit. Abwickler	Not ready. Unwinder
alarm_303	Not ready. Unwinder
Nicht bereit. Aufwickler	Not ready. Rewinder
alarm_304	Not ready. Rewinder
Nicht bereit. Schlaufenvorroller	Not ready. Loop unwinder
alarm_305	Not ready. Loop unwinder
Nicht bereit. Initialisierung.	Not ready. Initializing.
alarm_306	Initialization with higher-level controller is not finished and/or approval has not been granted.
Nicht bereit. READY fehlt	Not ready. No READY signal
alarm_307	Configured Ready approval from PLC not yet received
Abwickler Abwickelsicherung aktiv	Unwinder monitor active

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alarm_804	Response time to switching operation too long. Solution: -
Abwickler TEACH-Vorgang	Unwinder failure: TEACH process
alarm_805	An error occurred while teaching the pendulum range. The measurement segment is too small (<90°).
Abwickler nicht belegt	Unwinder not occupied
alarm_806	Unwinder not occupied
alarm_807	Unwinder not occupied
Abwickler zu langsam	Unwinder too slow
alarm_808	The pendulum remains in the clamping position too long. The unwinder does not reach the required unwinding speed.
Abwickler ZK-Unterspannung	Unwinder DC link voltage too low
alarm_809	The operating voltage is too low. The internal power supply may be faulty.
Abwickler Störung	Unwinder failure
alarm_810	The unit was overloaded for an extended period of time. The rotating disc may not turn smoothly, the labeling performance may be too high, a double pendulum may be required.
Abwickler Übertemperatur	Unwinder: high temperature
alarm_811	The unit's operating temperature is too high due to an overload. Reduce the ambient temperature. Reduce the load.
Abwickler Bandende	Unwinder: end of reel
alarm_812	The pendulum is in its home position even though the label web was unwound.
Abwickler Durchmesserbestimmung	Unwinder: diameter determination
alarm_813	Determination of the winding diameter failed. The label reel may be slipping.
Abwickler Power-Stufe	Unwinder: power stage
alarm_814	Control error in power output stage

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	Solution: -
alarm_815	Unwinder not occupied
Schlaufenvorroller TEACH-Vorgang	Loop unwinder: TEACH process
alarm_825	An error occurred while teaching the unit's function. This message is unlikely to occur. If this error occurs repeatedly, please contact HERMA.
Schlaufenvorroller nicht belegt	Loop unwinder not occupied
alarm_826	Loop unwinder not occupied
Schlaufenvorroller Wickelfehler	Winding error in loop unwinder
alarm_827	Transported distance greatly exceeds distance removed from loop Solution: Check for slippage, blocked backing paper
Schlaufenvorroller zu langsam	Loop unwinder too slow
alarm_828	The sensor for maximum loop size remained uncovered too long. The label web may be slipping, the labeling performance may be too high, or the operating parameters may be incorrect for the unit.
Schlaufenvorroller ZK-Unterspannung	Loop unwinder DC link voltage too low
alarm_829	The operating voltage is too low. The internal power supply may be faulty.
Schlaufenvorroller Überlastung	Loop unwinder overload
alarm_830	The unit was overloaded for an extended period of time. The rotating disc may not turn smoothly, the labeling performance may be too high, a double pendulum may be required.
Schlaufenvorroller Übertemperatur	Loop unwinder: high temperature

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alarm_831	The unit's operating temperature is too high due to an overload. Reduce the ambient temperature. Reduce the load.
Schlaufe konnte nicht mehr gefüllt werden	Loop cannot be filled
alarm_832	This message appears if the loop can no longer be formed.
Schlaufenvorroller Störung nicht belegt	Loop unwinder error: not occupied
alarm_833	Loop unwinder error: not occupied
Ansteuerungsfehler der Leistungsendstufe	Control error in power output stage
alarm_834	Control error in power output stage Solution: -
Schlaufenvorroller Störung	Loop unwinder failure
alarm_835	Loop unwinder failure
Beim Einlernen des Pendelbereiches ist ein Fehler aufgetreten	An error occurred while teaching the pendulum range
alarm_845	An error occurred while teaching the pendulum range. The measurement segment is too small (<90°).
Aufwickler Störung nicht belegt	Rewinder failure: not occupied
alarm_846	Rewinder failure: not occupied
alarm_847	Rewinder failure: not occupied
Pendel befindet sich zu lange in Entspannposition	Pendulum in untensioned position too long
alarm_848	The pendulum was in the untensioned position for too long. Web break or the rewinder does not reach the required rewinding speed.
Aufwickler Störung ZK-Unterspannung	Rewinder failure: DC link voltage too low
alarm_849	The operating voltage is too low. The internal power supply may be faulty.

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Aufwickler Störung Überlastung	Rewinder failure: overload
alarm_850	The unit was overloaded for an extended period of time. The rotating disc may not turn smoothly, the labeling performance may be too high, a double pendulum may be required.
Aufwickler Störung Übertemperatur	Rewinder failure: high temperature
alarm_851	The unit's operating temperature is too high due to an overload. Reduce the ambient temperature. Reduce the load.
Aufwickler voll	Rewinder is full
alarm_852	Rewinder failure: not occupied
Aufwickler voll Vorwarnung	Warning: Rewinder is full
alarm_853	Rewinder failure: not occupied
Aufwickler Störung Power- Stufe	Rewinder failure: power stage
alarm_854	Control error in power output stage Solution: -
alarm_855	Rewinder failure: not occupied
Schlaufenfüller Störung	Loop filler failure
alarm_865	A malfunction occurred in the motorized loop unwinder of the winder system in an external looping unit. The exact malfunction is indicated by a flashing code on the illuminated button on the unit.
alarm_866	Loop filler failure
alarm_867	Loop filler failure
alarm_868	Loop filler failure
alarm_869	Loop filler failure
alarm_870	Loop filler failure
alarm_871	Simulated distance to next label gap for label feed Total distance = this value + stop delay
alarm_872	Activate single-step triggering. Parameter is reset to 00 after a restart.

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	With single-step triggering activated, pressing the dispense button will advance one step at a time.
alarm_873	Loop filler failure
alarm_874	Loop filler failure
alarm_875	Loop filler failure
Antriebsstörung Unterspannung	Drive failure: low voltage
alarm_910	Low voltage (voltage drop in AD converter DC link) detected. Check the power from the power supply. Replace the drive unit. If this malfunction occurs repeatedly, please contact our technical service department or your HERMA contact person.
Antriebsstörung Überspannung	Drive failure: high voltage
alarm_911	High voltage in DC link detected by AD converter. Check the power from the power supply. Replace the drive unit. If this malfunction occurs repeatedly, please contact our technical service department or your HERMA contact person.
Antriebsstörung Übertemperatur	Drive failure: high temperature
alarm_912	Excessive temperature was detected at one of the internal thermal sensors. Check the load from the label web, the winder systems and the drive mechanisms (roller and toothed belt). If this malfunction occurs repeatedly, please contact our technical service department or your HERMA contact person.
Antriebsstörung Überlast (Dauer)	Drive failure: overload (period)
alarm_913	This message appears if the peak current was required for more than 3 seconds. Check the mechanical components of the drive roller and toothed belt. Replace the drive unit. If this malfunction occurs repeatedly, please contact our technical service department or your HERMA contact person.
Antriebsstörung Motorencoder	Drive error: motor encoder
alarm_914	The encoder signals from the applicator drive during operation could not be evaluated.

Quelltext — Deutsch	Übersetzung – Englisch (US)
	Try again, or replace the drive unit. If this malfunction occurs repeatedly, please contact our technical service department or your HERMA contact person.
IPM Fehler Powermodul defekt	IPM error: power module faulty
alarm_915	The IPM board may be malfunctioning. If you cannot acknowledge the error, replace the base unit. If this malfunction occurs repeatedly, please contact our Technical Service or your HERMA partner.
Antriebsstörung Reglerstrecke	Drive error: controller distance
alarm_916	The current measurement offset is outside of the acceptable range. The following causes are possible: The engine plug is not plugged in to the IPM board; broken cable; defective current measurement. If this malfunction occurs repeatedly, please contact our Technical Service or your HERMA partner.
Antriebsstörung Powerfail	Drive failure: power fail
alarm_917	Power supply of the DC link falls below the critical level. Check the power from the power supply. If drive firmware is older than V02.01.29, please upgrade the firmware to reduce the sensitivity of SM910 and SM917. Replace the drive unit. If this malfunction occurs repeatedly, please contact our technical service department or your HERMA contact person.
Antriebsstörung Encoderfehler	Drive failure: encoder error
alarm_918	During initialization, a connection to the motor encoder could not be established. Try again, or replace the drive unit. If this malfunction occurs repeatedly, please contact our technical service department or your HERMA contact person.
Antriebsstörung Unterspannung (peak)	Drive failure: low voltage (peak)
alarm_919	A short-term voltage drop occurred in the DC link. Check the power from the power supply. If drive firmware is older than V02.01.29, please upgrade the firmware to reduce the sensitivity of SM910 and SM917. Replace the drive unit. If this malfunction occurs repeatedly, please contact our technical service department or your HERMA contact person.
Antriebsstörung Überlast (peak)	Drive failure: overload (peak)

Quelltext — Deutsch	Übersetzung – Englisch (US)
alarm_920	<p>This message appears if the maximum peak current was exceeded. It may be caused by the following: Web transport required more torque than could be delivered by the drive. If necessary, reduce the brake force of the label web brake. A sharp load increase occurred during web transport. The pendulum hit the label web or ran into a mechanical stop. The loop unwinder did not create a loop.</p> <p>At high dispensing speeds (> 90 meters/min), this error message may be triggered by the first labeling cycle after the applicator is switched on. The reason is that the exact rotor position is not known after the applicator is switched on. In such cases, manually dispense a label first. If this malfunction occurs repeatedly, please contact our technical service department or your HERMA contact person. The drive unit may need to be replaced.</p>
Antriebsstörung Endstufe	Drive error: output stage
alarm_921	<p>During initialization, power transistors could not be controlled. Restart the drive. If the problem persists: Replace the drive unit. If this malfunction occurs repeatedly, please contact our technical service department or your HERMA contact person.</p>
Antriebsstörung Referrenzspannung	Drive error: reference voltage
alarm_922	<p>The reference voltage is outside the specification. Restart the drive. If the problem persists: Replace the drive unit. If this malfunction occurs repeatedly, please contact our technical service department or your HERMA contact person.</p>
Antriebsstörung Motorposition	Drive error: motor position
alarm_923	<p>The difference between target and actual position is too large. May indicate an overload. Restart the drive. If the problem persists: Replace the drive unit. If this malfunction occurs repeatedly, please contact our technical service department or your HERMA contact person.</p>
Antriebsstörung Überlast	Drive failure: overload

Quelltext — Deutsch	Übersetzung – Englisch (US)
alarm_924	<p>A drive failure occurred with subsequent shutdown of the PWM amplifier.</p> <p>Inspect the mechanical components of the drive roller and toothed belt. Replace the drive unit.</p> <p>If this malfunction occurs repeatedly, please contact our technical service department or your HERMA contact person.</p>
Keine Verbindung zur Rangierplatine	No connection to distribution board
alarm_925	<p>There is a failure in the connection to the CAN I/O board. Check the CAN bus connections (drive unit -> I/O board -> external CAN devices), external CAN I/O board connected to X18</p> <p>If this malfunction occurs repeatedly, please contact our technical service department or your HERMA contact person.</p>
Antriebsstörung: Überlast (vMax überschritten!)	Drive failure: overload (vMax exceeded!)
alarm_926	<p>This message only appears during the deceleration phase of a labeling cycle. The braking current exceeds the maximum admissible value when trying to achieve the calculated overfeed distance.</p> <p>This will occur only if, for example, the maximum speed entered is much lower than the actual speed when decelerating to a stop with use of a master encoder.</p> <p>In this case, vMax must be increased if the maximum applicator speed was exceeded and therefore caused an overload in the drive.</p> <p>Check parameter 234 "Maximum speed (10V)".</p> <p>If this malfunction occurs repeatedly, please contact our technical service department or your HERMA contact person.</p> <p>The drive unit may need to be replaced.</p>