

Timeout on V Blade Home or Out

How to solve a Timeout on V Blade Out or Home Error

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This means that the Inputs at the top or bottom stroke of the V notching cylinders are not being made within a set number of seconds of the Output Valve and being operated (timeout).

Input and Output references table

Message	V Notch Station	Input Reference	Valve Reference
Timeout on VI Blade Home	Front Infeed Side	VICTH	Y32 VICUT
Timeout on VI Blade Out	Front Infeed Side	VICTO	Y32 VICUT
Timeout on VO Blade Home	Front Outfeed Side	VOCTH	Y33 VOCUT
Timeout on VO Blade Out	Front Outfeed Side	VOCTO	Y33 VOCUT
Timeout on WI Blade Home	Rear Infeed Side	WICTH	Y36 WICUT
Timeout on WI Blade Out	Rear Infeed Side	WICTO	Y36 WICUT
Timeout on WO Blade Home	Rear Outfeed Side	WOCTH	Y37 WOCUT
Timeout on WO Blade Out	Rear Outfeed Side	WOCTO	Y37 WOCUT

Solution

Potential Root Causes

Movement is too slow because:

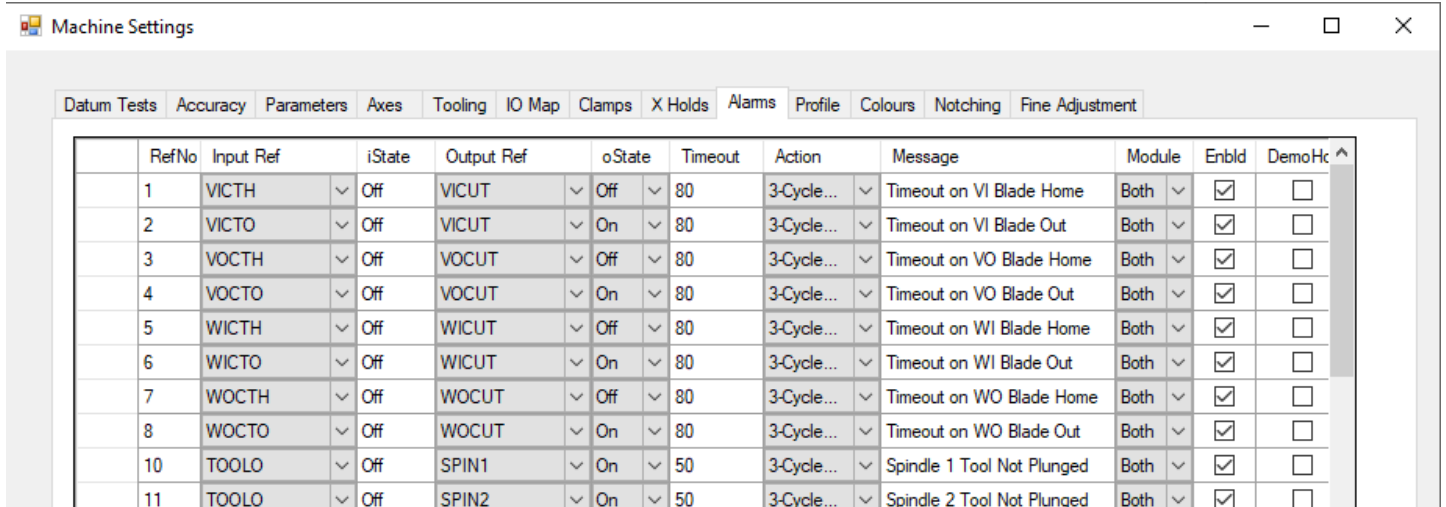
- Blades are really blunt
- Hydrocheck speed damper is not adjusted correctly or faulty.
- Faulty or sticky air valves (water damage) that are not switching on and have a delay

Movement is correct speed but input is not feeding back

- Faulty reed switch
- Faulty connection to reed switch
- Position of reed switch not correct on cylinder

1 Increase the timeout

In Settings -> Alarms tab



RefNo	Input Ref	iState	Output Ref	oState	Timeout	Action	Message	Module	Enblid	DemoHc
1	VICTH	Off	VICUT	Off	80	3-Cycle...	Timeout on VI Blade Home	Both	<input checked="" type="checkbox"/>	<input type="checkbox"/>
2	VICTO	Off	VICUT	On	80	3-Cycle...	Timeout on VI Blade Out	Both	<input checked="" type="checkbox"/>	<input type="checkbox"/>
3	VOCTH	Off	VOCUT	Off	80	3-Cycle...	Timeout on VO Blade Home	Both	<input checked="" type="checkbox"/>	<input type="checkbox"/>
4	VOCTO	Off	VOCUT	On	80	3-Cycle...	Timeout on VO Blade Out	Both	<input checked="" type="checkbox"/>	<input type="checkbox"/>
5	WICTH	Off	WICUT	Off	80	3-Cycle...	Timeout on WI Blade Home	Both	<input checked="" type="checkbox"/>	<input type="checkbox"/>
6	WICTO	Off	WICUT	On	80	3-Cycle...	Timeout on WI Blade Out	Both	<input checked="" type="checkbox"/>	<input type="checkbox"/>
7	WOCTH	Off	WOCUT	Off	80	3-Cycle...	Timeout on WO Blade Home	Both	<input checked="" type="checkbox"/>	<input type="checkbox"/>
8	WOCTO	Off	WOCUT	On	80	3-Cycle...	Timeout on WO Blade Out	Both	<input checked="" type="checkbox"/>	<input type="checkbox"/>
10	TOOLO	Off	SPIN1	On	50	3-Cycle...	Spindle 1 Tool Not Plunged	Both	<input checked="" type="checkbox"/>	<input type="checkbox"/>
11	TOOLO	Off	SPIN2	On	50	3-Cycle...	Spindle 2 Tool Not Plunged	Both	<input checked="" type="checkbox"/>	<input type="checkbox"/>

The diagram shows a timeout of 8 seconds (80). To increase by 2 seconds, make 80 into 100 on the Timeout column.

It is expected that 8 seconds should be ample for the v notch stroke to happen, so this will only mask the real root cause, possibly

2 Disable the alarm

If you are certain that the blade is operating correctly, you can disable the alarm by unticking the "Enblid" tick box for the alarm that keeps triggering.



...This is only going to prevent the alarm from interrupting production, it has not solved the root cause of the problem