

TAPING MACHINE

Problem Observed	Alarm	Possible Cause	Solutions
Tapping machine not starting	Machine Not Ready	1: Power OFF	1: Check main supply
			2: Turn ON from panel
	Emergency Stop Active	2: E-Stop pressed	1: Release all E-Stops
			2: Reset from SCADA
	Safety Interlock Fault	3: Guard open	1: Close safety doors
			2: Reset safety
Conveyor Not Ready	4: Upstream not available	1: Check infeed conveyor status	
Communication Fault	5: PLC signal missing	1: Check SCADA communication	
		2: Restart system	
Carton not moving inside tapper	Conveyor Fault	1: Belt not running	1: Check motor status in SCADA
			2: Reset drive
	Carton Jam	2: Box stuck	1: Stop machine
			2: Remove jam manually
Guide Misalignment	3: Improper guide setting	1: Adjust width guides	
Sensor Blocked	4: Sensor continuously ON	1: Clean sensor	
		2: Remove obstruction	
Tape not applying properly	Tape Roll Empty	1: No tape	1: Replace tape roll
	Tape Break	2: Tape cut/broken	1: Reload tape properly
	Applicator Fault	3: Tape head not working	1: Check tape head movement
			2: Clean mechanism
	Pressure Issue	4: Tape not pressing	1: Adjust pressure rollers
Wrong Setting	5: Size mismatch	1: Adjust machine width/height	
Tape misaligned	Guide Error	1: Carton not centered	1: Adjust side guides
	Tape Head Misaligned	2: Improper head position	1: Align tape head
	Speed mismatch	3: Conveyor speed issue	1: Adjust speed in SCADA
Machine stops suddenly	Jam Detected	1: Carton stuck inside	1: Remove carton
			2: Reset alarm
	Motor Overload	2: High load	1: Reset overload relay
	Sensor Fault	3: False detection	1: Check sensor status
Drive Fault	4: Motor/drive error	1: Reset drive	