

COLLATION UNIT

Problem Observed	Alarm	Possible Cause	Solutions
Product not collating	Sensor Fault	1: Sensor not detecting	1: Check SCADA input
			2: Clean sensor
	Flow Error	2: Irregular feed	1: Adjust upstream speed
	Accumulation	3: Product jam	1: Remove jam
	Timing Error	4: Delay mismatch	1: Adjust SCADA timing
Collation mismatch	Guide Error	1: Misalignment	1: Adjust guides
	Speed mismatch	2: Conveyor mismatch	1: Balance speed
Conveyor stop	Drive Fault	1: VFD issue	1: Reset drive