

INFEEED CONVEYOR ASSEMBLY

Problem Observed	Alarm	Possible Cause	Solutions
Conveyor not starting	Drive Fault	1: VFD fault	1: SCADA - Check drive status
			2: Reset drive
			3: Restart
	Motor Overload	2: Overcurrent	1: Reset overload relay
			2: Check motor load
	Emergency Stop	3: E-Stop active	1: Release E-Stop
			2: Reset in SCADA
	Safety Fault	4: Guard open	1: Close doors
			2: Reset safety
	Communication Fault	5: PLC signal loss	1: Check PLC status
2: Restart			
Conveyor stops during run	Sensor Blocked	1: Sensor ON continuously	1: Clean sensor
			2: Remove blockage
	Accumulation	2: Downstream full	1: Clear downstream
Drive Overheat	3: High temp	1: Check cooling	
Conveyor jerky	Speed Fault	1: Speed fluctuation	1: Adjust SCADA speed
	Mechanical issue	2: Loose belt	1: Tighten belt