

LABEL CONVEYOR

Problem Observed	Alarm	Possible Cause	Solutions
Conveyor not running	Drive Fault	1: VFD fault	1: Check drive alarm 2: Reset
	Emergency Stop	2: E-Stop active	1: Reset E-Stop
	Overload	3: Motor overload	1: Reset relay
Carton not moving	Accumulation Fault	1: Downstream blockage	1: Clear blockage
	Sensor Fault	2: Sensor giving stop signal	1: Check SCADA input
	Belt Slip	3: Loose belt	1: Adjust belt tension
Carton misalignment	Guide Error	1: Improper guide setting	1: Adjust guides
	Uneven flow	2: Speed mismatch	1: Adjust speed