

LABEL APPLICATOR ASSEMBLY

Problem Observed	Alarm	Possible Cause	Solutions
Label not printing	Printer Offline	1: Printer not connected	Label not printing
			2: Check printer status
			3: Restart printer
	No Label Roll	2: Label roll finished	1: Load new label roll properly
	Ribbon Error	3: Ribbon empty/damaged	1: Replace ribbon
	Communication Fault	4: No data from PLC	1: Check SCADA data signal
			2: Check cable connection
Print Head Error	5: Print head issue	1: Clean print head	
		2: Restart printer	
Label not applying	Applicator Fault	1: Cylinder not actuating	1: Check SCADA output
			2: Check solenoid valve
	Low Air Pressure	2: Insufficient air	1: Check regulator pressure
	Sensor Fault	3: Carton not detected	1: Check sensor in SCADA
			2: Adjust alignment
	Label Jam	4: Label stuck in applicator	1: Stop machine
2: Clear jam manually			
Timing Error	5: Delay mismatch	1: Adjust timing in SCADA	
Label misaligned	Position Error	1: Applicator head misaligned	1: Adjust applicator position
	Speed Mismatch	2: Conveyor speed variation	1: Match conveyor speed
	Wrong Recipe	3: Incorrect label position setting	1: Check SCADA recipe
Label skipping / missing	Sensor Delay	1: Sensor response delay	1: Adjust sensor timing
	Product Gap Issue	2: Irregular carton flow	1: Adjust upstream flow
	Encoder Issue	3: Speed tracking issue	1: Check encoder signal
Machine stops during labeling	Label Error	1: Label roll finished	1: Replace roll
	Printer Fault	2: Printer stopped	1: Restart printer
	Communication Fault	3: Data not received	1: Check PLC communication
Label peeling issue	Peeling Fault	1: Peel plate dirty	1: Clean peel plate
	Adhesive issue	2: Poor label quality	1: Check label material
	Tension issue	3: Improper roll tension	1: Adjust tension