

ALARM LIST	CAUSE	SOLUTION
[D2800.0] U01: INITIALT_OVER ERROR	UNIT 01 INITIALIZATION RETURN TIME ERROR	UNIT 01 INITIALIZATION RETURN TIME ERROR
[D2800.C] MOLDING PART OUTSIDE MATERIAL REMAIN CHECK	OUTER FABRIC LOW ON MATERIAL	PREPARE OUTER FABRIC REPLACEMENT ROLL
[D2800.D] MOLDING PART FILTER MATERIAL REMAIN CHECK	FILTER FABRIC LOW ON MATERIAL	PREPARE FILTER FABRIC REPLACEMENT ROLL
[D2800.E] MOLDING PART LINING MATERIAL REMAIN CHECK	LINING(INNER) FABRIC LOW ON MATERIAL	PREPARE LINING(INNER) FABRIC REPLACEMENT ROLL
[D2801.1] RETRIEVE#1CYL' BWD ERROR	RETRIEVE#1 FABRIC DISCARDING CYLINDER SENSOR ERROR	Check back of equipment (Discarded Fabric Roller #1) for problems with discarding roller cylinder/sensor.
[D2801.3] RETRIEVE#2CYL' BWD ERROR	RETRIEVE#2 FABRIC DISCARDING CYLINDER SENSOR ERROR	Check back of equipment (Discarded Fabric Roller #2) for problems with discarding roller cylinder/sensor.
[D2809.D] U01: AutoStepCycle TimeOver	ERROR IN PROGRAM LOGIC IN AUTO CYCLE PROCESS	Restart and initialize equipment.
[D2809.F] U01: HomeStepCycle TimeOver	ERROR IN PROGRAM LOGIC IN AUTO CYCLE PROCESS	Restart and initialize equipment.
[D2810.0] U02: INITIALT_OVER ERROR	UNIT 02 INITIALIZATION RETURN TIME ERROR	Initialize equipment and check for green light on U02 on main screen.
[D2819.D] U02: AutoStepCycle TimeOver	ERROR IN PROGRAM LOGIC IN AUTO CYCLE PROCESS	Restart and initialize equipment.
[D2819.F] U02: HomeStepCycle TimeOver	ERROR IN PROGRAM INITIALIZATION PROCESS	Restart and initialize equipment.
[D2820.0] U03: INITIALT_OVER ERROR	UNIT 03 INITIALIZATION RETRUN TIME ERROR	Initialize equipment and check for green light on U03 on main screen.
[D2829.D] U03: AutoStepCycle TimeOver	ERROR IN PROGRAM LOGIC IN AUTO CYCLE PROCESS	Restart and initialize equipment.
[D2829.F] U03: HomeStepCycle TimeOver	ERROR IN PROGRAM INITIALIZATION PROCESS	Restart and initialize equipment.
[D2830.0] U04: INITIALT_OVER ERROR	UNIT 04 INITIALIZATION RETRUN TIME ERROR	Initialize equipment and check for green light on U04 on main screen.
[D2839.D] U04: AutoStepCycle TimeOver	ERROR IN PROGRAM LOGIC IN AUTO CYCLE PROCESS	Restart and initialize equipment.
[D2839.F] U04: HomeStepCycle TimeOver	ERROR IN PROGRAM INITIALIZATION PROCESS	Restart and initialize equipment.
[D2840.0] U05: INITIALT_OVER ERROR	UNIT 05 INITIALIZATION RETRUN TIME ERROR	Initialize equipment and check for green light on U05 on main screen.
[D2840.1] #1 UPPER LOOP S/NDETECT ERROR	EAR #1 LOOP UPPER LIMIT SENSOR DETECTION	Check for knots in the ear loop #1 string and the 4DN UB420-R detection sensor for any obstructions.
[D2840.2] #2 UPPER LOOP S/NDETECT ERROR	EAR #2 LOOP UPPER LIMIT SENSOR DETECTION	Check for knots in the ear loop #2 string and the 4DN UB420-R detection sensor for any obstructions.
[D2840.3] #3 UPPER LOOP S/NDETECT ERROR	EAR #3 LOOP UPPER LIMIT SENSOR DETECTION	Check for knots in the ear loop #3 string and the 4DN UB420-R detection sensor for any obstructions.
[D2840.4] #4 UPPER LOOP S/NDETECT ERROR	EAR #4 LOOP UPPER LIMIT SENSOR DETECTION	Check for knots in the ear loop #4 string and the 4DN UB420-R detection sensor for any obstructions.
[D2840.5] EAR부 MOVING 길이 센서 감지 이상	CONSECUTIVE DETECTION FAILURE IN X122A/X123A MID-CYLINDER SENSOR	Adjust the cylinder turn knob for ear loop length settings (Monitor the Length BWD Setting during adjustments). Check for faulty sensor/cylinder.
[D2849.D] U05: AutoStepCycle TimeOver	ERROR IN PROGRAM LOGIC IN AUTO CYCLE PROCESS	Restart and initialize equipment.
[D2849.E] U05: SUBStepCycle TimeOver	ERROR IN PROGRAM LOGIC IN STEP CYCLE PROCESS	Restart and initialize equipment.
[D2849.F] U05: HomeStepCycle TimeOver	ERROR IN PROGRAM INITIALIZATION PROCESS	Restart and initialize equipment.
[D2850.0] U06: INITIALT_OVER ERROR	UNIT 06 INITIALIZATION RETRUN TIME ERROR	Initialize equipment and check for green light on U05 on main screen.
[D2859.D] U06: AutoStepCycle TimeOver	ERROR IN PROGRAM LOGIC IN AUTO CYCLE PROCESS	Restart and initialize equipment.
[D2859.F] U06: HomeStepCycle TimeOver	ERROR IN PROGRAM INITIALIZATION PROCESS	Restart and initialize equipment.
[D2900.0] DURING AUTO RUN MOLDING PART CYCLE STOP SENSOR NOT DETECTED	ERROR IN NOSE WIRE CUT STOP SENSOR	Check the X110D sensor above the nose wire cam (back of the drive compartment) for faulty function.
[D2900.1] CUT START SENSOR NOT DETECTED ERROR	ERROR IN NOSE WIRE CUT STOP SENSOR	Check the X110C sensor below the nose wire cam (back of the drive compartment) for faulty function.
[D2900.2] MOLDING PART NOSE WIRE EMPTY ERROR	ERROR IN NOSE WIRE DETECTION SENSOR	Replace nose wire roll. Check for nose wire alignment and faulty sensor.
[D2900.3] MOLDING PART NOSE WIRE CUTTING ERROR CONSECUTIVE	CONSECUTIVE FAULTY DETECTION IN NOSE WIRE SENSOR	Check for faulty sensor on the nose wire compartment (X110D/X110C).
[D2900.4] 1st ULTRASONIC CYL' UP ERROR	ERROR IN 1st ULTRASONIC CYL' UP SENSOR	Check for faulty sensor X1110/X1111 or cylinder.
[D2900.5] 1st ULTRASONIC CYL'DOWN ERROR	ERROR IN 1st ULTRASONIC CYL' DOWN SENSOR	Check for faulty sensor X1110/X1111 or cylinder.
[D2900.6] 2nd ULTRASONIC CYL' UP ERROR	ERROR IN 2nd ULTRASONIC CYL' UP SENSOR	Check for faulty sensor X1112/X1113 or cylinder.
[D2900.7] 2nd ULTRASONIC CYL'DOWN ERROR	ERROR IN 2nd ULTRASONIC CYL' DOWN SENSOR	Check for faulty sensor X1112/X1113 or cylinder.
[D2900.8] 1st ROLLER CYL'UP ERROR	ERROR IN 1st ROLLER CYL' UP SENSOR	Check for faulty sensor X1114 or cylinder.
[D2900.9] 1st ROLLER CYL'DOWN ERROR	ERROR IN 1st ROLLER CYL' DOWN SENSOR	Check for faulty sensor X1114 or cylinder.
[D2900.A] 2nd ROLLER CYL'UP ERROR	ERROR IN 2nd ROLLER CYL' UP SENSOR	Check for faulty sensor X1115 or cylinder.
[D2900.B] 2nd ROLLER CYL'DOWN ERROR	ERROR IN 2nd ROLLER CYL' DOWN SENSOR	Check for faulty sensor X1115 or cylinder.
[D2900.C] 3rd ULTRASONIC CYL' UP ERROR	ERROR IN 3rd ULTRASONIC CYL' UP SENSOR	Check for faulty sensor X1116/X1117 or cylinder.
[D2900.D] 3rd ULTRASONIC CYL'DOWN ERROR	ERROR IN 3rd ULTRASONIC CYL' DOWN SENSOR	Check for faulty sensor X1116/X1117 or cylinder.
[D2900.E] 3rd ROLLER CYL'UP ERROR	ERROR IN 3rd ROLLER CYL' UP SENSOR	Check for faulty sensor X1118 or cylinder.
[D2900.F] 3rd ROLLER CYL'DOWN ERROR	ERROR IN 3rd ROLLER CYL' DOWN SENSOR	Check for faulty sensor X1118 or cylinder.
[D2901.1] RETRIEVE#1CYL' BWD ERROR	ERROR IN RETRIEVE #1 CYL' SENSOR	Check for faulty sensor X111B or cylinder.

[D2901.2] CUTTING ROLLER CYL'UP ERROR	ERROR IN CUTTING ROLLER CYL' UP SENSOR	Check for faulty sensor X1119 or cylinder.
[D2901.3] CUTTING ROLLER CYL'DOWN ERROR	ERROR IN CUTTING ROLLER CYL DOWN SENSOR	Check for faulty sensor X1119 or cylinder.
[D2901.4] MOLDING PART SERVO START SENSOR FAIL	ERROR IN NOSE WIRE CAM SENSOR	Check for faulty sensor X110C/X110D or cylinder.
[D2901.5] MOLDING PART CYCLE STOP SENSOR FAIL	ERROR IN NOSE WIRE CAM SENSOR	Check for faulty sensor X110C/X110D or cylinder.
[D2901.6] NOSE WIRE CHECK SENSOR ERROR	EMPTY NOSE WIRE/ERROR IN NOSE WIRE SENSOR	Check for empty nose wire or faulty X110B sensor.
[D2901.9] MOLDING PART FAN OFF ERROR	ERROR IN ULTRASONIC MOLDING FAN SENSOR	Check for malfunction in the ultrasonic fan in the molding compartment. Check for any faulty fan sensors.
[D2901.A] RETRIEVE #1 LEFT TRIM DETECT ERROR X100A	ERROR IN DISCARDED MOLDED PART #1 LEFT TRIM SENSOR	Check for connectivity and correct alignment of the discarded #1 left trim fabric. Check for any faulty sensors.
[D2901.B] RETRIEVE #1 RIGHT TRIM DETECT ERROR X100B	ERROR IN DISCARDED MOLDED PART #1 RIGHT TRIM SENSOR	Check for connectivity and correct alignment of the discarded #1 right trim fabric. Check for any faulty sensors.
[D2901.C] RETRIEVE #2 RIGHT TRIM DETECT ERROR X100C	ERROR IN DISCARDED MOLDED PART #2 RIGHT TRIM SENSOR	Check for connectivity and correct alignment of the discarded #2 right trim fabric. Check for any faulty sensors.
[D2901.D] RETRIEVE #2 LEFT TRIM DETECT ERROR X100D	ERROR IN DISCARDED MOLDED PART #2 LEFT TRIM SENSOR	Check for connectivity and correct alignment of the discarded #2 left trim fabric. Check for any faulty sensors.
[D2901.E] RETRIEVE #1 CYLINDER TRIM DETECT ERROR	ERROR IN DISCARD MOLDED PART #1 ROLLER CYLINDER SENSOR	Check for connectivity and correct alignment in the discarded material roller #1 on the back side of the machine. Check for endosure of roller. Check for faulty sensor X111B.
[D2901.F] RETRIEVE #2 CYLINDER TRIM DETECT ERROR	ERROR IN DISCARD MOLDED PART #2 ROLLER CYLINDER SENSOR	Check for connectivity and correct alignment in the discarded material roller #2 on the back side of the machine. Check for endosure of roller. Check for faulty sensor X111C.
[D2905.0] 1st ULTRASONIC OSCILLATOR FAN ERROR	ERROR IN ULTRASONIC #1 OSCILLATORFAN SENSOR	Check for faulty fan sensors. Check corresponding I/O in the Data Menu to check for cable/fan malfunction.
[D2905.1] 1st ULTRASONIC HORN #1 FAN ERROR	ERROR IN ULTRASONIC #1 RIGHT FAN SENSOR	Check for faulty fan sensors. Check corresponding I/O in the Data Menu to check for cable/fan malfunction.
[D2905.2] 1st ULTRASONIC HORN #2 FAN ERROR	ERROR IN ULTRASONIC #1 LEFT FAN SENSOR	Check for faulty fan sensors. Check corresponding I/O in the Data Menu to check for cable/fan malfunction.
[D2905.3] 2nd ULTRASONIC OSCILLATOR FAN ERROR	ERROR IN ULTRASONIC #2 OSCILLATOR FAN SENSOR	Check for faulty fan sensors. Check corresponding I/O in the Data Menu to check for cable/fan malfunction.
[D2905.4] 2nd ULTRASONIC HORN #1 FAN ERROR	ERROR IN ULTRASONIC #2 RIGHT FAN SENSOR	Check for faulty fan sensors. Check corresponding I/O in the Data Menu to check for cable/fan malfunction.
[D2905.5] 2nd ULTRASONIC HORN #2 FAN ERROR	ERROR IN ULTRASONIC #2 LEFT FAN SENSOR	Check for faulty fan sensors. Check corresponding I/O in the Data Menu to check for cable/fan malfunction.
[D2905.6] 3rd ULTRASONIC OSCILLATOR FAN ERROR	ERROR IN ULTRASONIC #3 OSCILLATOR FAN SENSOR	Check for faulty fan sensors. Check corresponding I/O in the Data Menu to check for cable/fan malfunction.
[D2905.7] 3rd ULTRASONIC HORN #1 FAN ERROR	ERROR IN ULTRASONIC #3 RIGHT FAN SENSOR	Check for faulty fan sensors. Check corresponding I/O in the Data Menu to check for cable/fan malfunction.
[D2905.8] 3rd ULTRASONIC HORN #2 FAN ERROR	ERROR IN ULTRASONIC #3 LEFT FAN SENSOR	Check for faulty fan sensors. Check corresponding I/O in the Data Menu to check for cable/fan malfunction.
[D2905.B] MOLDING PART OUTSIDE MATERIAL EMPTY ERROR	EMPTY OUTER FABRIC MATERIAL. ERROR IN OUTER FABRIC DETECTION SENSOR	Replace outer fabric material. Check for faulty sensor X1105 in the case of remaining outer fabric material.
[D2905.C] MOLDING PART FILTER MATERIAL EMPTY ERROR	EMPTY FILTER FABRIC MATERIAL. ERROR IN FILTER FABRIC DETECTION SENSOR	Replace outer fabric material. Check for faulty sensor X1103 in the case of remaining outer fabric material.
[D2905.D] MOLDING PART LINING MATERIAL EMPTY ERROR	EMPTY INNER FABRIC MATERIAL. ERROR IN INNER FABRIC DETECTION SENSOR	Replace outer fabric material. Check for faulty sensor X1101 in the case of remaining outer fabric material.
[D2908.0] SM#01 NOSE WIRE SERVO OFF ALARM	ERROR IN NOSE WIRE SERVO POWER	If this alarm rings during automatic operation, check the SM101 SERVO 01 on the back of the equipment. May need servo replacement.
[D2908.1] SM#01 NOSE WIRE SERVO ORIGIN REQUEST ALARM	ERROR IN NOSE WIRE ORGIN DETECTION	Realign the nose wire servo back to the orgin position using the ORIGIN button from the SERVO MOTOR - AXIS 1,2 - J01 NOSE WIRE Menu.
[D2908.2] SM#01 NOSE WIRE SERVO OverLoad ALARM	ERROR IN NOSE WIRE SERVO OVERLOAD	Restart the servo system. If problem is still present, look for error number in the servo and search online for specific solution instructions.
[D2908.3] SM#01 NOSE WIRE SERVO USER LOAD ALARM	ERROR IN NOSE WIRE SERVO AMP LOAD	This alarm rings due to abnormal spike in servo load. Manually change the operation servo load value in the Servo Data Menu.
[D2908.4] SM#01 NOSE WIRE SERVO ALARM CODE CHECK	ERROR IN SERVO SYSTEM	This alarm is present when any problem is detected within the servo. Check servo status and presence of any other malfunction within the servo system.
[D2908.F] ST.41 MAIN INVERTER MOTOR ALARM	ERROR IN MAIN INVERTER MOTOR	Check the Main Motor Inverter INV01 on the back of the molding equipment compartment. Reset or replace the motoor inveter as necessary.
[D2909.D] DURING CYCLE STOP MOLDING PART CYCLE STOP SENSOR NOT DETECTED	ERROR IN NOSE WIRE STOPPING TIMING/SENSOR	Check the nose wire cam gear alignment in th back of the nose wire cutter. Check for nose wire delay time in the Material Setting Menu.

[D2920.1] 1st SLOT#2 INPUT TIME OVER ERROR	ERROR IN DETECTION SENSOR IN AXIS #3 SLOT # 2	Check for stuck product in the Slot #2 Axis #3. Clear the light reflector below the Axis #3 of any dust particles. Check for faulty X121B sensor.
[D2920.2] 1st_SLOT#1 -> SLOT#2 MOVING TIME OVER ERROR	ERROR IN DETECTION SENSOR IN AXIS #3 SLOT #1, #2	This alarm rings when multiple material is detected in Slot #1 or #2. Remove product from Slot #1, #2. Clean the sensors and light reflector in the Axis #3, #4 area.
[D2920.3] 1st SLOT ROLLER UP ERROR	ERROR IN 1st SLOT ROLLER CYLINDER UP MOVEMENT	Check for faulty sensor (X1218, X1219) /cylinder.
[D2920.4] 1st SLOT ROLLER DOWN ERROR	ERROR IN 2nd SLOT ROLLER CYLINDER DOWN MOVEMENT	Check for faulty sensor (X1218, X1219) /cylinder.
[D2920.9] 1st SLOT DOG SENSOR DETECT ERROR DURING MOVING	ERROR IN DOG GEAR DETECTION SENSOR	Check for faulty sensor SM102 or misalignment in dog gear/sensor.
[D2928.0] SM#03 1 SLOT SERVO OFF ALARM	ERROR IN AXIS #3 SERVO POWER	If this alarm rings during automatic operation, check the SM103 SERVO 02 on below the reverser compartment. May need servo replacement.
[D2928.1] SM#03 1 SLOT SERVO ORIGIN REQUEST ALARM	ERROR IN AXIS #3 ORIGIN DETECTION	Realign the axis #3 servo back to the origin position using the ORIGIN button from the SERVO MOTOR - AXIS 3,4 - J03 Input Pitch Menu.
[D2928.2] SM#03 1 SLOT SERVO OverLoad ALARM	ERROR IN AXIS #3 SERVO OVERLOAD	Restart the servo system. If problem is still present, look for error number in the servo and search online for specific solution instructions.
[D2928.3] SM#03 1 SLOT SERVO USER LOAD ALARM	ERROR IN AXIS #3 SERVO AMP LOAD	This alarm rings due to abnormal spike in servo load. Manually change the operation servo load value in the Servo Data Menu.
[D2928.4] SM#03 1 SLOT SERVO ALARM CODE CHECK	ERROR IN REVERSER SERVO SYSTEM	This alarm is present when any problem is detected within the servo. Check servo status and presence of any other malfunction within the servo system.
[D2930.0] 1st > 2nd INPUT TIME OVER ERROR	ERROR IN DETECTION OF PRODUCT TRANSITION FROM AXIS #3 TO AXIS #4	This alarm occurs when product is in Axis #3 in improper timing sequence. Check for stuck material in the Axis #3/#4 or faulty sensor in X121A/X121B.
[D2930.1] 2nd SLOT GUIDE UP ERROR	ERROR IN SLOT GUIDE CYLINDER UP MOVEMENT	Check for faulty sensor X121C/X121D or cylinder.
[D2930.2] 2nd SLOT GUIDE DOWN ERROR	ERROR IN SLOT GUIDE CYLINDER DOWN MOVEMENT	Check for faulty sensor X121C/X121D or cylinder.
[D2930.3] 2nd SLOT OUTPUT SENSOR ERROR (TAKE OUT THE PRODUCT)	ERROR IN 2nd SLOT DETECTION SENSOR	This alarm is present when product is sent from Axis # 3 but not received by the sensor in the Axis # 4. Check for malfunction in sensor X121E/X121F.
[D2930.4] 2nd SLOT MASK JAM DETECT ERROR	MASK DETECTION ERROR IN SLOT RETRIEVING PROCEDURE	Take out mask in the vertical slot transition line below the maske output. Check sensor X1240/X1241.
[D2930.9] 2nd SLOT DOG SENSOR DETECT ERROR DURING MOVING	ERROR IN DOG GEAR DETECTION SENSOR	Check for faulty sensor SM103 or misalignment in dog gear/sensor.
[D2938.0] SM#04 2 SLOT SERVO OFF ALARM	ERROR IN AXIS #4 SERVO POWER	If this alarm rings during automatic operation, check the SM104 SERVO 02 below the reverser compartment. May need servo replacement.
[D2938.1] SM#04 2 SLOT SERVO ORIGIN REQUEST ALARM	ERROR IN AXIS #4 ORIGIN DETECTION	Realign the REVERSER servo back to the origin position using the ORIGIN button from the SERVO MOTOR - AXIS 3,4 - J04 Output Pitch Menu.
[D2938.2] SM#04 2 SLOT SERVO OverLoad ALARM	ERROR IN AXIS #4 SERVO OVERLOAD	Restart the servo system. If problem is still present, look for error number in the servo and search online for specific solution instructions.
[D2938.3] SM#04 2 SLOT SERVO USER LOAD ALARM	ERROR IN AXIS #4 SERVO AMP LOAD	This alarm rings due to abnormal spike in servo load. Manually change the operation servo load value in the Servo Data Menu.
[D2938.4] SM#04 2 SLOT SERVO ALARM CODE CHECK	ERROR IN AXIS #4 SERVO SYSTEM	This alarm is present when any problem is detected within the servo. Check servo status and presence of any other malfunction within the servo system.
[D2940.0] #1 FIXED CLAMP CLOSE ERROR	ERROR IN EAR # 1 FIXED CLAMP CYLINDER CLOSE POSITION	Check and clean out debris in fixed clamp opening. Check for faulty fixed clamp cylinder.
[D2940.1] #1 FIXED CLAMP OPEN ERROR	ERROR IN EAR # 1 FIXED CLAMP CYLINDER OPEN POSITION	Check and clean out debris in fixed clamp opening. Check for faulty fixed clamp cylinder.
[D2940.2] #1 MOVING CLAMP CLOSE ERROR	ERROR IN EAR # 1 MOVING CLAMP CYLINDER CLOSE POSITION	Check and clean out debris in moving clamp opening. Check for faulty moving clamp cylinder.
[D2940.3] #1 MOVING CLAMP OPEN ERROR	ERROR IN EAR # 1 MOVING CLAMP CYLINDER OPEN POSITION	Check and clean out debris in moving clamp opening. Check for faulty moving clamp cylinder.
[D2940.4] #1 SUPPLY CLAMP CLOSE ERROR	ERROR IN EAR # 1 LOOP SUPPLY CLAMP CLOSE POSITION	Check and clean out debris in the ear loop supply clamp opening. Check for faulty supply clamp cylinder.
[D2940.5] #1 SUPPLY CLAMP OPEN ERROR	ERROR IN EAR # 1 LOOP SUPPLY CLAMP OPEN POSITION	Check and clean out debris in the ear loop supply clamp opening. Check for faulty supply clamp cylinder.
[D2940.6] #1 SUPPLY CLAMP TURN ERROR	ERROR IN EAR # 1 EAR LOOP SUPPLY CLAMP FOLD IN POSITION	Check and clean out debris in the ear loop folding radius. Check for faulty ear loop folding cylinder.
[D2940.7] #1 SUPPLY CLAMP RETURN ERROR	ERROR IN EAR# 1 EAR LOOP SUPPLY CLAMP FOLD OUT POSITION	Check and clean out debris in the ear loop folding radius. Check for faulty ear loop folding cylinder.
[D2940.8] #1 ULTRASONIC UP ERROR	ERROR IN ULTRASONIC #1 UP CYLINDER MOVEMENT	Check for correct positioning and working cylinder in the ultrasonic ear modling compartment.
[D2940.9] #1 ULTRASONIC DOWN ERROR	ERROR IN ULTRASONIC #1 DOWN CYLINDER MOVEMENT	Check for correct positioning and working cylinder in the ultrasonic ear modling compartment.
[D2940.A] #1 EAR CUTTER UP ERROR	ERROR IN EAR #1 CUTTER OPEN POSITION	Check and clean out debris in cutter opening. Check for faulty cutter cylinder.
[D2940.B] #1 EAR CUTTER DOWN ERROR	ERROR IN EAR #1 CUTTER CLOSED POSITION	Check and clean out debris in cutter opening. Check for faulty cutter cylinder.
[D2940.C] #1,3 MOVING FWD ERROR	ERROR IN MOVING CYLINDER EAR #1, #3 FORWARD POSITION	Check and clean out debris near the moving cylinder. Check for faulty cylinder movement.
[D2940.D] #1,3 MOVING BWD ERROR	ERROR IN MOVING CYLINDER EAR #1, #3 BACKWARD POSITION	Check and clean out debris near the moving cylinder. Check for faulty cylinder movement.
[D2940.E] #1,2 EAR SUPPLY UP ERROR	ERROR IN #1,2 EAR SUPPLY COMPRESSING CYLINDER UP	Check and clean out debris near the compressing cylinder. Check for faulty cylinder movement.
[D2940.F] #1,2 EAR SUPPLY DOWN ERROR	ERROR IN #1,2 EAR SUPPLY COMPRESSING CYLINDER DOWN	Check and clean out debris near the compressing cylinder. Check for faulty cylinder movement.
[D2941.0] EAR#1 EAR STRING PULL LOOP SENSOR ERROR	ERROR IN #1 EAR LOOP RETRIEVING ROLLER DETECTION SENSOR	Check for any ear loop knots or debris in the ear loop roller. Check for sensor X122C error.
[D2941.1] EAR#1 OSCILLATOR FAN ERROR	ERROR IN EAR #1 ULTRASONIC FAN	Check for sensor error in the ultrasonic fan compartment. Check for malfunctioning ultrasonic fan.
[D2941.2] EAR#1 HORN FAN ERROR	ERROR IN EAR #1 ULTRASONIC FAN	Check for sensor error in the ultrasonic fan compartment. Check for malfunctioning ultrasonic fan.
[D2942.0] #2 FIXED CLAMP CLOSE ERROR	ERROR IN EAR # 2 FIXED CLAMP CYLINDER CLOSE POSITION	Check and clean out debris in fixed clamp opening. Check for faulty fixed clamp cylinder.
[D2942.1] #2 FIXED CLAMP OPEN ERROR	ERROR IN EAR # 2 FIXED CLAMP CYLINDER OPEN POSITION	Check and clean out debris in fixed clamp opening. Check for faulty fixed clamp cylinder.
[D2942.2] #2 MOVING CLAMP CLOSE ERROR	ERROR IN EAR # 2 MOVING CLAMP CYLINDER CLOSE POSITION	Check and clean out debris in moving clamp opening. Check for faulty moving clamp cylinder.
[D2942.3] #2 MOVING CLAMP OPEN ERROR	ERROR IN EAR # 2 MOVING CLAMP CYLINDER OPEN POSITION	Check and clean out debris in moving clamp opening. Check for faulty moving clamp cylinder.
[D2942.4] #2 SUPPLY CLAMP CLOSE ERROR	ERROR IN EAR # 2 LOOP SUPPLY CLAMP CLOSE POSITION	Check and clean out debris in the ear loop supply clamp opening. Check for faulty supply clamp cylinder.
[D2942.5] #2 SUPPLY CLAMP OPEN ERROR	ERROR IN EAR # 2 LOOP SUPPLY CLAMP OPEN POSITION	Check and clean out debris in the ear loop supply clamp opening. Check for faulty supply clamp cylinder.
[D2942.6] #2 SUPPLY CLAMP TURN ERROR	ERROR IN EAR # 2 EAR LOOP SUPPLY CLAMP FOLD IN POSITION	Check and clean out debris in the ear loop folding radius. Check for faulty ear loop folding cylinder.
[D2942.7] #2 SUPPLY CLAMP RETURN ERROR	ERROR IN EAR# 2 EAR LOOP SUPPLY CLAMP FOLD OUT POSITION	Check and clean out debris in the ear loop folding radius. Check for faulty ear loop folding cylinder.
[D2942.8] #2 ULTRASONIC UP ERROR	ERROR IN ULTRASONIC #2 UP CYLINDER MOVEMENT	Check for correct positioning and working cylinder in the ultrasonic ear modling compartment.
[D2942.9] #2 ULTRASONIC DOWN ERROR	ERROR IN ULTRASONIC #2 DOWN CYLINDER MOVEMENT	Check for correct positioning and working cylinder in the ultrasonic ear modling compartment.
[D2942.A] #2 EAR CUTTER UP ERROR	ERROR IN EAR #2 CUTTER OPEN POSITION	Check and clean out debris in cutter opening. Check for faulty cutter cylinder.
[D2942.B] #2 EAR CUTTER DOWN ERROR	ERROR IN EAR #2 CUTTER CLOSED POSITION	Check and clean out debris in cutter opening. Check for faulty cutter cylinder.

[D2942.C] #2,4 MOVING FWD ERROR	ERROR IN MOVING CYLINDER EAR #2, #4 FORWARD POSITION	Check and clean out debris near the moving cylinder. Check for faulty cylinder movement.
[D2942.D] #2,4 MOVING BWD ERROR	ERROR IN MOVING CYLINDER EAR #2, #4 BACKWARD POSITION	Check and clean out debris near the moving cylinder. Check for faulty cylinder movement.
[D2942.E] EAR1,3 MOVING LENGTH SENSOR ERROR CONSECUTIVE THRICE	DETECTION ERROR OF EAR #1, #3 CYLINDER SENSOR	Check proper sensor X122A and cylinder function. Turn the knob at the end of the cylinder for length adjustment. Monitor the ear loop length setting time in the PLC monitor.
[D2942.F] EAR2,4 MOVING LENGTH SENSOR ERROR CONSECUTIVE THRICE	DETECTION ERROR OF EAR #2, #4 CYLINDER SENSOR	Check proper sensor X123A and cylinder function. Turn the knob at the end of the cylinder for length adjustment. Monitor the ear loop length setting time in the PLC monitor.
[D2943.0] EAR#2 EAR STRING PULL LOOP SENSOR ERROR	ERROR IN #2 EAR LOOP RETRIEVING ROLLER DETECTION SENSOR	Check for any ear loop knots or debris in the ear loop roller. Check for sensor X123C error.
[D2943.1] EAR#2 OSCILLATOR FAN ERROR	ERROR IN EAR #2 ULTRASONIC FAN	Check for sensor error in the ultrasonic fan compartment. Check for malfunctioning ultrasonic fan.
[D2943.2] EAR#2 HORN FAN ERROR	ERROR IN EAR #2 ULTRASONIC FAN	Check for sensor error in the ultrasonic fan compartment. Check for malfunctioning ultrasonic fan.
[D2944.0] #3 FIXED CLAMP CLOSE ERROR	ERROR IN EAR # 3 FIXED CLAMP CYLINDER CLOSE POSITION	Check and clean out debris in fixed clamp opening. Check for faulty fixed clamp cylinder.
[D2944.1] #3 FIXED CLAMP OPEN ERROR	ERROR IN EAR # 3 FIXED CLAMP CYLINDER OPEN POSITION	Check and clean out debris in fixed clamp opening. Check for faulty fixed clamp cylinder.
[D2944.2] #3 MOVING CLAMP CLOSE ERROR	ERROR IN EAR # 3 MOVING CLAMP CYLINDER CLOSE POSITION	Check and clean out debris in moving clamp opening. Check for faulty moving clamp cylinder.
[D2944.3] #3 MOVING CLAMP OPEN ERROR	ERROR IN EAR # 3 MOVING CLAMP CYLINDER OPEN POSITION	Check and clean out debris in moving clamp opening. Check for faulty moving clamp cylinder.
[D2944.4] #3 SUPPLY CLAMP CLOSE ERROR	ERROR IN EAR # 3 LOOP SUPPLY CLAMP CLOSE POSITION	Check and clean out debris in the ear loop supply clamp opening. Check for faulty supply clamp cylinder.
[D2944.5] #3 SUPPLY CLAMP OPEN ERROR	ERROR IN EAR # 3 LOOP SUPPLY CLAMP OPEN POSITION	Check and clean out debris in the ear loop supply clamp opening. Check for faulty supply clamp cylinder.
[D2944.6] #3 SUPPLY CLAMP TURN ERROR	ERROR IN EAR # 3 EAR LOOP SUPPLY CLAMP FOLD IN POSITION	Check and clean out debris in the ear loop folding radius. Check for faulty ear loop folding cylinder.
[D2944.7] #3 SUPPLY CLAMP RETURN ERROR	ERROR IN EAR#3 EAR LOOP SUPPLY CLAMP FOLD OUT POSITION	Check and clean out debris in the ear loop folding radius. Check for faulty ear loop folding cylinder.
[D2944.8] #3 ULTRASONIC UP ERROR	ERROR IN ULTRASONIC #3 UP CYLINDER MOVEMENT	Check for correct positioning and working cylinder in the ultrasonic ear modling compartment.
[D2944.9] #3 ULTRASONIC DOWN ERROR	ERROR IN ULTRASONIC #3 DOWN CYLINDER MOVEMENT	Check for correct positioning and working cylinder in the ultrasonic ear modling compartment.
[D2944.A] #3 EAR CUTTER UP ERROR	ERROR IN EAR #3 CUTTER OPEN POSITION	Check and clean out debris in cutter opening. Check for faulty cutter cylinder.
[D2944.B] #3 EAR CUTTER DOWN ERROR	ERROR IN EAR #3 CUTTER CLOSED POSITION	Check and clean out debris in cutter opening. Check for faulty cutter cylinder.
[D2944.E] #3,4 EAR SUPPLY UP ERROR	ERROR IN #3,4 EAR SUPPLY COMPRESSING CYLINDER UP	Check and clean out debris near the compressing cylinder. Check for faulty cylinder movement.
[D2944.F] #3,4 EAR SUPPLY DOWN ERROR	ERROR IN #3,4 EAR SUPPLY COMPRESSING CYLINDER DOWN	Check and clean out debris near the compressing cylinder. Check for faulty cylinder movement.
[D2945.0] EAR#3 EAR STRING PULL LOOP SENSOR ERROR	ERROR IN #3 EAR LOOP RETRIEVING ROLLER DETECTION SENSOR	Check for any ear loop knots or debris in the ear loop roller. Check for sensor X124C error.
[D2945.1] EAR#3 OSCILLATOR FAN ERROR	ERROR IN EAR #3 ULTRASONIC FAN	Check for sensor error in the ultrasonic fan compartment. Check for malfunctioning ultrasonic fan.
[D2945.2] EAR#3 HORN FAN ERROR	ERROR IN EAR #3 ULTRASONIC FAN	Check for sensor error in the ultrasonic fan compartment. Check for malfunctioning ultrasonic fan.
[D2946.0] #4 FIXED CLAMP CLOSE ERROR	ERROR IN EAR # 3 FIXED CLAMP CYLINDER CLOSE POSITION	Check and clean out debris in fixed clamp opening. Check for faulty fixed clamp cylinder.
[D2946.1] #4 FIXED CLAMP OPEN ERROR	ERROR IN EAR # 3 FIXED CLAMP CYLINDER OPEN POSITION	Check and clean out debris in fixed clamp opening. Check for faulty fixed clamp cylinder.
[D2946.2] #4 MOVING CLAMP CLOSE ERROR	ERROR IN EAR # 3 MOVING CLAMP CYLINDER CLOSE POSITION	Check and clean out debris in moving clamp opening. Check for faulty moving clamp cylinder.
[D2946.3] #4 MOVING CLAMP OPEN ERROR	ERROR IN EAR # 3 MOVING CLAMP CYLINDER OPEN POSITION	Check and clean out debris in moving clamp opening. Check for faulty moving clamp cylinder.
[D2946.4] #4 SUPPLY CLAMP CLOSE ERROR	ERROR IN EAR # 3 LOOP SUPPLY CLAMP CLOSE POSITION	Check and clean out debris in the ear loop supply clamp opening. Check for faulty supply clamp cylinder.
[D2946.5] #4 SUPPLY CLAMP OPEN ERROR	ERROR IN EAR # 3 LOOP SUPPLY CLAMP OPEN POSITION	Check and clean out debris in the ear loop supply clamp opening. Check for faulty supply clamp cylinder.
[D2946.6] #4 SUPPLY CLAMP TURN ERROR	ERROR IN EAR # 3 EAR LOOP SUPPLY CLAMP FOLD IN POSITION	Check and clean out debris in the ear loop folding radius. Check for faulty ear loop folding cylinder.
[D2946.7] #4 SUPPLY CLAMP RETURN ERROR	ERROR IN EAR#3 EAR LOOP SUPPLY CLAMP FOLD OUT POSITION	Check and clean out debris in the ear loop folding radius. Check for faulty ear loop folding cylinder.
[D2946.8] #4 ULTRASONIC UP ERROR	ERROR IN ULTRASONIC #3 UP CYLINDER MOVEMENT	Check for correct positioning and working cylinder in the ultrasonic ear modling compartment.
[D2946.9] #4 ULTRASONIC DOWN ERROR	ERROR IN ULTRASONIC #3 DOWN CYLINDER MOVEMENT	Check for correct positioning and working cylinder in the ultrasonic ear modling compartment.
[D2946.A] #4 EAR CUTTER UP ERROR	ERROR IN EAR #3 CUTTER OPEN POSITION	Check and clean out debris in cutter opening. Check for faulty cutter cylinder.
[D2946.B] #4 EAR CUTTER DOWN ERROR	ERROR IN EAR #3 CUTTER CLOSED POSITION	Check and clean out debris in cutter opening. Check for faulty cutter cylinder.
[D2947.0] EAR#4 EAR STRING PULL LOOP SENSOR ERROR	ERROR IN #3 EAR LOOP RETRIEVING ROLLER DETECTION SENSOR	Check for any ear loop knots or debris in the ear loop roller. Check for sensor X125C error.
[D2947.1] EAR#4 OSCILLATOR FAN ERROR	ERROR IN EAR #3 ULTRASONIC FAN	Check for sensor error in the ultrasonic fan compartment. Check for malfunctioning ultrasonic fan.
[D2947.2] EAR#4 HORN FAN ERROR	ERROR IN EAR #3 ULTRASONIC FAN	Check for sensor error in the ultrasonic fan compartment. Check for malfunctioning ultrasonic fan.
[D2948.A] EAR#1 EAR STRING UNWIND LOOP SENSOR ERROR	ERROR IN EAR #1 PULL LOOP RETRIEVE SENSOR	Check for any ear loop knots or debris in the ear loop roller. Check for sensor X122C error.
[D2948.B] EAR#2 EAR STRING UNWIND LOOP SENSOR ERROR	ERROR IN EAR #2 PULL LOOP RETRIEVE SENSOR	Check for any ear loop knots or debris in the ear loop roller. Check for sensor X123C error.
[D2948.C] EAR#3 EAR STRING UNWIND LOOP SENSOR ERROR	ERROR IN EAR #3 PULL LOOP RETRIEVE SENSOR	Check for any ear loop knots or debris in the ear loop roller. Check for sensor X124C error.
[D2948.D] EAR#4 EAR STRING UNWIND LOOP SENSOR ERROR	ERROR IN EAR #4 PULL LOOP RETRIEVE SENSOR	Check for any ear loop knots or debris in the ear loop roller. Check for sensor X125C error.
[D2949.1] EAR#1 LOOP SENSOR NOT DETECTED ERROR	MISSING EAR #1 EAR LOOP MATERIAL	Replace ear loop material.
[D2949.2] EAR#2 LOOP SENSOR NOT DETECTED ERROR	MISSING EAR #2 EAR LOOP MATERIAL	Replace ear loop material.
[D2949.3] EAR#3 LOOP SENSOR NOT DETECTED ERROR	MISSING EAR #3 EAR LOOP MATERIAL	Replace ear loop material.
[D2949.4] EAR#4 LOOP SENSOR NOT DETECTED ERROR	MISSING EAR #4 EAR LOOP MATERIAL	Replace ear loop material.
[D2950.0] FINAL PRODUCT DETECT ERROR	DETECTION ERROR OF FINAL PRODUCT OUTPUT	Check for any stuck product in the final product conveyor belt or output cylinder.
[D2950.1] OUTPUT SOL UP ERROR	ERROR IN OUTPUT CYLINDER UP POSITION	Check for any stuck products in the output cylinder. Check for malfunctioning cylinder/sensor.
[D2950.2] OUTPUT SOL DOWN ERROR	ERROR IN OUTPUT CYLINDER DOWN POSITION	Check for any stuck products in the output cylinder. Check for malfunctioning cylinder/sensor.
[D2950.3] FINAL PRODUCT OUTPUT DETECT ERROR	CONSECUTIVE DETECTION ERROR OF FINAL PRODUCT OUTPUT	Check for any stuck product in the final product conveyor belt or output cylinder.
[D2990.0] MOLDING PART TOUCH EMG STOP	MANUAL STOP FROM THE EMERGENCY STOP BUTTON MOLDING PART	Check if any stop has occurred from the emergency stop button from the molding compartment.
[D2990.1] EAR TOUCH EMG STOP	MANUAL STOP FROM THE EMERGENCY STOP BUTTON EAR PART	Check if any stop has occurred from the emergency stop button from the ear loop compartment.
[D2990.2] MAIN MC ON FAIL	SERVO & INVERTER MOTOR POWER/CONTROL ERROR	Check for any malfunctioning part in MC01.
[D2990.3] SERVO POWER CP TRIP	SERVO POWER TRIP MODE ERROR	Check for any trip mode or turned off power supply in the back.
[D2990.4] MS04 NOT READY	PLC ERROR	Restart the PLC. If problem still occurs, contact engineer.
[D2990.5] EAR#1 SUPPLY MOTOR MC OFF	EAR #1 LOOP SUPPLY MOTOR ERROR	Check proper function of induction motor in the ear loop compartment.
[D2990.7] EAR#2 SUPPLY MOTOR MC OFF	EAR #2 LOOP SUPPLY MOTOR ERROR	Check proper function of induction motor in the ear loop compartment.
[D2990.9] EAR#3 SUPPLY MOTOR MC OFF	EAR #3 LOOP SUPPLY MOTOR ERROR	Check proper function of induction motor in the ear loop compartment.
[D2990.8] EAR#4 SUPPLY MOTOR MC OFF	EAR #4 LOOP SUPPLY MOTOR ERROR	Check proper function of induction motor in the ear loop compartment.
[D2990.D] MOLDING PART ULTRASONIC NFB OFF ERROR	ERROR IN MOLDING PART ULTRASONIC NFB	Check and turn back on molding part ultrasonic NFB.
[D2990.E] EAR STRING PART ULTRASONIC NFB OFF ERROR	ERROR IN EAR STRING PART ULTRASONIC NFB	Check and turn back on ear string part ultrasonic NFB.
[D2990.F] MOLDING PART RETRIEVE EMG STOP	MANUAL STOP FROM THE EMERGENCY STOP BUTTON MOLDING RETRIEVE	Check if any stop has occurred from the emergency stop button from the discarded material roller compartment.
[D2992.1] EAR STRING OPERATING S/W ERROR	MANUAL EAR STRING OPERATION SWITCH ON MODE	Check and turn off manual operation switch in ear molding compartment.

[D2992.2] OUTPUT EMG STOP	MANUAL STOP FROM THE EMRGENCY STOP BUTTON OUTPUT	Check if any stop has occurred from the emrgency stop buttton from the back side of ear string attacment.
[D2995.0] Diagnostic Error		
[D2995.1] Self Test Error	PLC ERROR	Restart the PLC system. If problem still occurs, PLC needs to be exchanged.
[D2995.2] Common Error Information		
[D2995.3] PLC BATT ERROR	PLC BATTERY ERROR	Exchange the battery in the PLC compartment.
[D2995.4] PLC POWER ERROR	PLC POWER SUPPLY ERROR	Check the power cable from the PLC box.
[D2995.5] PLC FUSE ERROR	PLC ERROR	Restart the PLC system. If problem still occurs, PLC needs to be exchanged.
[D2995.6] PLC I/O MODULE COMBINATION ERROR		
[D2995.7] CC-LINK #1 ERROR	PLC I/O ERROR	Check PLC I/O and CC-Link for any malfunctioning parts.
[D2995.8] CC-LINK #1 DATA LINK		
[D2995.9] MAIN POWER MC OFF ERROR	MAIN POWER ERROR	Check main power supply.
[D2999.0] [SYSTEM]MOLDING PART MAIN AIR DOWN	MOLDING PART AIR PRESSURE ERROR	Check air supply.
[D2999.1] [SYSTEM]EAR STRING PART MAIN AIR DOWN	EAR STRING PART AIR PRESSURE ERROR	Check air supply.