

RT578_EN Rev.L

Error messages and troubleshooting for EIDOS Printers (valid for 5th generation and 6th generation)

The Error messages provide an immediate explanation of the error that occurred and indicate the actions to be taken to resolve it.

For printers equipped with a separate electronic unit it is possible to show the description of the reports on the screen of the electronic unit activating the relative option:



In the new generation printers (XTO) the description is visible by pressing the icon with the question mark inside the error message.

Errors E181 onwards are used exclusively for these printers.



E01 Serial Channel Error or Data Received

- Check Baud rate setup in the printer.
 - Check Baud rate setup in the PC.
- These two baud rates must be congruent.
- If RS422 enable Xon/Xoff
 - Check serial cable. Use EIDOS serial cable (Code CV496)
 - If the USB-RS232 converter is used try to change USB port on PC.

E02 Err. Parameter Files or Not Compatible or Disk Full

- Parameter file is not compatible: it could be the file of another printer model.
- Load parameter file of the printer
- Check capacity of C disk:
- Enter default parameters by formatting the FLASH.

E03 File Not Found

- Required file does not exist on disk.
- Copy missing file to disk.
- Check the file name characters in the CSE protocol.
- Check required filename syntax.
- Incorrect search path (drive) or drive not present (e.g. USB stick).
- Check the flag "Enable page from I/O" if enabled by mistake.
- Avoid network or RS232 packet transmissions. The printer accepts an inter-character RS232 timeout of max. 100 ms.

E04 Not possible to Save File on Disk or Disk Full

- Check whether there is available space on disk
- Disk protected by writing?
- Disk not formatted?

- Try to repeat operation.
- Fault on disk?

E05 File Not Found or Drive Not Ready or Write Protect

- Check syntax of file name
- Check presence of drive (USB memory)
- Check that file is present in the directory or disk
- Check that the USB memory containing files to load is not damaged (check in the PC)

E06 Insufficient Memory or Text Too Long

- Text sent through the serial line containing more than 32KB of ASCII text (code CSE) or transmission of characters not permitted by the machine. The error message is generated if the ASCII characters of the label are > 32KB.
- Memory full. Remove unused files.

E07 Error During File Copy or Disk Full

- Saving problem on disk A:
- Saving problem on disk C:
- Check "USB Memory" device on PC.
- Too many files: disk full.

E08 Stand-by Time-out Expired (STA)

- The printer does not receive the application command (STA or C2S if dual cycle enabled)
- Check STA and C2S connection from photocell or PLC
- Check green LEDs on rear connector panel SYNC24I/O (LED ON: signal received)
- If STA or C2S are given beyond Timeout disable STA WAIT Timeout flag
- Enable Auto-application Parameter if STA command is not available

E09 LMG/LSA File Reading Error or Dimensions

- LMG graphic file damaged.
- Reload the file or repeat sending of the label through the serial link.

E10 Thermal Ribbon or Paper End

- Fit in a new reel of ribbon
- Fit in a new reel of paper
- If the reels of ribbon or paper are already positioned and not empty check the following things:
 - 1) ribbon or paper passages (check if the ribbon coil has been inserted in the right way)
 - 2) operation of the ribbon release clutch and switch
 - 3) motor movement and supply; if the motor rotates but the ribbon does not feed, check the pulley fixing on the motor shaft.
 - 4) for SWING continuous: check that the 'Maximum Line Speed' parameter is set 20-30% Higher than the actual maximum line speed peak. Use the diagnosis function to sample the actual line speed
 - 5) for SWING continuous: set the 'Rewind Acceleration' at 300 (default value)
 - 6) for SWING continuous: check the proximity sensor that drive the ribbon rewinding motor.
 - 7) For swing continuous (SWG2cx): check the magnetic clutch and the ball bearing on it
 - 8) For swing continuous (SWG2cx): check the cover micro switch
 - 9) for SWING intermittent: check the magnetic disk on the rubberized roll (rewinding side); it must be mechanically fixed with the roll.
 - 10) for SWING intermittent: check the light on the board in front of the rubberized roll. When the roll rotates it must flash on and off

E11 Head Open or Not Positioned. Compressed Air Failure

- Check that there is compressed air service and that the pressure is suitable and stable during printer operation.
- The pneumatic piston may not have enough force to push down the print head.
- Check the pressure level during the print cycle: it may have pushed down below the threshold.

- Check the pressure switch operation in the diagnosis menu.
- Check the pressure switch calibration.
- "Initial margin" or "Head fall delay" too low
- Reduce printing speed
- The Distance between the head and the printing plane is too low so the head sensor does not switch when it is down.
- Check head sensor down. When the head is down the red LED on the sensor should light up.
- Check the head down sensor cable: it could be broken.
- A ribbon release clutch too strong could request print head force too high for movement.

E12 Print Area Exceeded

- The content of label exceeds the print area (texts/barcode/graphics out of margins)
 - Open the label file with EASYCODE: the objects outside the area are overlapped with a red grid.
 - Move the objects inside the available printing area.
 - View the label using EASYCODE32: set the "View Dpi" at 200/300 or 600 dpi to get WYSIWYG.
 - If variable data are transmitted to the printer check that the text are not too long.
 - In EASYCODE check if the variable data requests space out of the print area size.
 - SATO emulation:
 - S1) Load the FORMAT.LAB file created with EASYCODE32 with the same X and Y dimensions set in the SATO driver.
 - S2) Check the dimensions and margins of the label set in the SATO driver.
 - S3) Set "Auto calculation Y length" function: the Y label length will be automatically calculated when SATO file is received.
 - ZEBRA EMULATION:
 - Z1) Set ZEBRA EMU "dot" or "12dot" depending by ZPL file resolution.
 - Z2) Check the dimensions of the label in the ZPL file.
 - Z3) Check the dimensions and margins of the label set in the ZEBRA driver.
- For SATO and ZEBRA emulation: try to enable the flag "OVF alarm disable" and print the label to check which texts or objects are out of the print area.

E13 Applicator Piston Not in Home Position

- Check the home position sensor (ref. SENS8 in diagnosis function)
- The applicator piston may not be fully retracted.
- Check air flow regulators calibration on the piston.
- Check compressed-air pressure and pressure adjustment.
- Check the air stranglers adjustment.
- Check the lock valves on the piston

E14 Venturi Vacuum Switch Fault

- The vacuum level over the threshold is already detected before the vacuum generator is activated.
- Check the setting of the vacuum threshold; use the trimmer to adjust the threshold.
- Check the green LED on the local PRINTESS panel: it must be off when the vacuum generator is off.
- Check that the trimmer that adjusts the threshold is not broken or incorrectly welded.

E15 Line Speed > 550 mm/s

- The maximum peak speed limit that the printer can support is 550 mm/s.
- Reduce the line speed below limit.

E16 File Not Valid or Not Loadable or Too much long

- File not loadable from the printer for printing.
- The file of the page to be printed contains commands that are not accepted by the printer (syntax error).

E17 Print Cycle Not Completed or invalid Input

- A print or application command (STB, STA, C2S) arrives while the previous cycle is still running.

- Check that bounces in the print command are not caused by the photocell.
- Synchronize the print command using the FAP output signal available on the printer's SYNC24I/O connector.
- There could be electrical noises on the I/O cable that cause unwanted print commands.
- Without other solutions disable the "Control STA-STB" parameter
- Do not send CSE commands as ^@, ^!, ^\$, ^% while the printer is still in cycle; use Wait/Ready protocol to synchronize the data transmission with print and application cycle.
- SWING continuous: invert the "encoder direction" flag into parameter menu.

E18 Invalid Monofile or Compression

- The .LM1 file loaded is damaged: save the file again using EASYCODE and reload it on the printer.
- The working label is stored into the USB stick but the stick is not present

E19 Print Speed too high (Busy Strobe)

- Printing speed is greater than the cycle of the head.
- Reduce printing or line speed.

E20 Head temperature too high

- 1) The printer head temperature is higher than 60°C
- 2) If the print rate, Intensity and Print Speed are too high try to reduce them.
- 3) If the label contains object with black areas it is possible that the print head is too stressed
- 4) It could be necessary to cool the printer head.
- 5) Try to replace the printer head.
- 6) Try to replace the interface driving board.

E21 Print Motor Time Out Expired

- Paper photocell dirty or damaged
- Check the electrical connections of the paper photocell.

E22 Print Speed too high

- The print speed exceeds the data transfer capacity towards the print head.
- Reduce printing speed.
- Reduce the X dimension of the text.
- CPU problems: try to replace it

E23 Time Out Scrap Position Not Achieved

The printed label has not reached the pick up position on the pad before the application.

- Check if the paper passes correctly
- Check that there are no label residues avoiding correct movement of the paper
- Check that movement of the paper is correct and that paper has no treatments
- Run automatic calibration and check photocell signal.

E24 End of Programmed Lot

- The decremental number is=0 the programmed amount of prints is complete.
- Load a new label and set a decremental number greater than 0
- If not used, disable "Regressive Number Control" parameter.

E25 T.O.Bar Code or Light Pen check

This error message occurs when the scanner does not transmit any data to the printer after the barcode check activation.

If the red beam does not come on, carry out the following checks:

- Check that the scanner is powered up.
- Check the RS232 connection with scanner (USB-RS232 converter or RS232C port)
- Maybe the USB-RS232 converter lost the connection with Electronic Unit: try to switch off the electronic unit and switch it on again to re-mount the converter.
- The USB-RS232 converter must be EIDOS approved.

- Check with EASYCODE program that "barcode checker" flag is enabled on all the barcodes to be checked.
- The barcodes CSE ASCII string of the barcodes to be checked must include check command (^v). If the red beam lit up, carry out the following checks:
 - Check the printed barcode quality (ribbon folds or wrinkles during print, intensity too low or too high etc...)
 - Check the printer head cleanness: in case of dirty dots clean it.
 - Check the printer head broken dots. In case of broken dots the barcode could not be readable.
 - Check the barcode position on the label: at least 5mm of white area are necessary aside the barcode for good readability.
 - Referring to the scanner reading diagram check the bar dimensions (mils), the barcode dimensions and the distance between the scanner and the barcodes.
- Check the scanner configuration:
 - Start char <FF>: command to lit up the beam.
 - End Char <EOT>: command to make off the beam
 - Start char in the returned string: <STX>
 - Barcode separator: <DLE>
 - End chars in the returned string: <CR><LF>
 - No Read char in the returned string: <CAN>
- Other general checks:
 - Check the USB-HOST port: try to load a file from the USB memory. If the USB memory is not recognised either this means that there is a problem with the management of the USB-HOST ports.
 - Try to replace the USB-RS232 converter with another EIDOS approved or try the USB-RS232 converter on a PC.

E26 Width is larger than Ribbon Size

- The X size of the label cannot be greater than the "Ribbon width" set in the printer parameters.

E27 Bar Code Check Disabled

- The label contains one or more barcodes to be checked (^v), but the verifier has not been enabled.
- Enable the verifier from the Communication Parameters menu
 - Alternatively, open the label using Easycode and remove the barcode checking flag.

E28 RX-TX File Transfer. Sequence Error

- An error has occurred during the transfer of the file through the serial link
- Try to repeat the procedure.
- There could be running problems in the driver of the device used for dispatch (e.g. USB-RS232 converter etc)

E29 External Block Active (BLK)

- The external input (BLK) on SYNC24 I/O connector has been activated.
- If the input BLK is not connected, check the ACX9x card could have problems.

E30 RX File Transfer. Checksum Error

- A reception or checksum error has occurred
 - Try to repeat the procedure
 - There could be running problems in the driver of the device used for dispatch (e.g. USB-RS232 converter etc.)
 - Avoid network transmissions or packet serial transmissions.
- There could be data transmission problems on the network.
The printer accepts an intercharacter timeout of 100 ms.

E31 RX-TX File Transfer. Time Out Error

- Time Out for data reception.
- Try to repeat the data transmission or recall the file.

- If the printer is connected to the STARCODE, check that the program is active and that the printer to PC connection is correct.
- Avoid network transmissions or packet serial transmissions.
- There could be data transmission problems on the network.
- The printer accepts a intercharacter time out of max. 100 ms.
- Check that the "Enable I/O Page" flag is not enabled.

E32 Invalid BMP Format

- The Swing is enabled to import BMP type files only in black and white.
- The logo is not loadable: use BMP black and white only
- Use EASYCODE to convert the label .LAB file as .LM1 file; .LM1 file allows to import BMP colour logos, JPG, TIFF, PNG.
- Do not use colour .BMP files
- Do not use graphic files with extensions other than .BMP

E33 Invalid Configuration

- There are inconsistencies in the configuration or in the machine parameters.
- Check printer setup parameters and label parameters.
- The label contains barcode to be check during or after printing (^v0 string) but the barcode reader function is not enabled in the printer setup.

E34 Print Text Missing or Invalid Dimensions

- Printing has been requested but there is no text to be printed (blank page). Insert something to print
- load TEMP.Im1 label (default label).
- The label dimensions must not exceed the Printer Head Width, the Ribbon Width (only for CODITHERM) or the maximum label length Y dimension allowed from the printer.
- For CODITHERM: the calculated label pitch in the sequence must be less than the set "head-transfer distance".
- Received ^@ serially without subsequent CSE commands.
- There could be electrical noises in the serial transmission
- To send big files a RS232 baud rate setting as 115200 is advised.
- If this message appears after software upgrade, try to delete the parameter file (PARR100.STP and PARR100.TST) from the C: disk and set the correct "RS232 communication" parameters.

E35 BMP File Not Found

- If you are working with .LAB or .LBS files extensions:
 - 1) Check for the existence of the .BMP file in the printer memory.
 - 2) Check that the name of the .BMP file in the memory corresponds to the name requested by the label file to be printed
- Use EASYCODE to convert the .LAB format to .LM1 format.

E36 Venturi Does Not Accept Label

This error message occurs when the vacuum level reached during the label pick up has not exceeded the threshold.

- 1) Try to make a Test Print operation and check the following:
 - The label must slide on the pad without waves.
 - Check the air jet power for label scraping
 - Check if the thermal ribbon is not correctly dragged during printing: (step motor rotation or rewinding clutch calibration).
 - If the step motor does not rotate: check the 14V driver or 24/48V supply on AIMxx board.
 - 2) Try to activate the ATT3 vacuum generator in DIAGNOSIS menu:
If the vacuum generator does not start:
 - Check the proximity switch on the PAD (it could be broken): replace it or bridge pin 2 and 3 on the proximity connector. With this bridge on proximity connector set a "Timed" applicator.
- Note: with the "3SIDES" applicator the proximity switch must be replaced otherwise the applicator does not work as it is using the "Vacuum switch" application by default.

- The vacuum generator valve can be broken.
 - Try to activate other actuators (ex. ATT2) to check the 24V supply.
- If the vacuum generator starts:
- Try to cover the pad holes with a label and check the vacuum level reached
 - If no vacuum level is shown it means 12V problem on AIPxx board
 - Check the vacuum level threshold
 - Check the vacuum switch seal on the pad (loss of vacuum in the pneumatic circuit); check the vacuum picking status on the vacuum switch.
- 3) Check the label position while the printer is in Error status: if the label is not completely exit check the following things:
- The Head Scrap distance" parameters value.
 - For Printess4N, 5N and 6N series the paper rewinding clutch or its uni-directional bearing could be locked
- 4) Other check list:
- Error message + suffix (6): no vacuum at STA arrival.
 - Error message + suffix (8): no grip at end of print.
 - Error message + suffix (9): label lost during applicator stroke
 - Error message + suffix (2): label not present at STA arrival
 - Check the compressed air: it must not contains oil or water

E37 End of Stroke Time-Out Expired

- This may occur with applications using the "Vacuum level control" to detect the object reaching during application. If no object has been reached in a time out this error occurs.
- Check that the pad reaches the object to apply the label
- Check that the pad can rotate or press a little bit to switch off the proximity or the vacuum switch during application.
- Check that compressed air pressure supply is stable at 6 bar.

E38 Pneumatic Cylinder Does Not Return to Home

- Check if the pneumatic cylinder is in home position
- Check that the pneumatic cylinder's home sensor LED is on.
- Check that the flow regulators on the pneumatic cylinder are not too closed.
- Check that the compressed air pressure is at 6 bars stable.

E39 Pneumatic Cylinder Does Not Exit from Home

- The pneumatic cylinder does not leave the home position.
- Check that the pneumatic cylinder or the applicator arm is not jammed.
- Check that the pressure regulator of the pneumatic cylinder is not too closed.

E40 Paper Missing or Photocell Error

- The paper coil is finished: replace with a new one.
 - Check that the paper moves correctly through the photocell area.
 - Do a Auto calibration function. (NOT on ONLINE.Im1 or TEMPLBS.Im1).
 - Check the paper photocell signal range.
 - Check the paper photocell: it could be dirty by a paper internally glued.
 - Check, by moving the paper, that the red LED changes state at each label skip.
- This error normally occurs when there is no paper or automatic calibration has not been carried out.

However, it may also occur in the following particular cases:

1) Label jump photocell is not reading correctly:

if the LED bar on the local panel is completely switched off, check the connector J13 on card AIPxx.

Rotate the paper motor manually to check that the second or third LED nearer the emergency switch normally remains lighted on the LED bar but that when the label jumps the the LED comes on that is further from the emergency switch. If this does not occur, check that the beam of the

photocell is not broken by remnants of paper that has remained trapped or that the passage of the paper has not been carried out incorrectly.

- 2) No 12V power supply on AIPxx interface board.
- 3) No motors driver power supply (24V/48V) on AIM95: motors do not rotate.
- 4) No 14V power supply on motors driver circuit.
- 5) Motor power supply broken: replace it.
- 6) Try to replace the AIP9x interface board on the printer unit.
- 7) Check the "Inverted Paper Photocell" flag in the "Printer Parameters" menu.
- 8) The paper rewinding roll or paper rewinding clutch could have problems: broken belts or locked clutch give problems in the paper feeding.
- 9) Check the paper photocell cable and connection to the interface AIP9x board.

E41 Invalid Position of BMP file

One or more bitmaps on the label are outside the print Area, or the X and Y position coordinates are incorrect or outside the area.

-Reposition the bitmap or reduce the dimensions until it is inside the print area.

E42 Error Write E2PROM Electronic Unit

An error has occurred during data saving to the E2PROM inside the electronic unit.

-Dismantle the side walls of the electronic unit and check that all the connectors of the internal connecting cables have been inserted correctly.

-If the problem persists, contact Eidos Customer Service Department.

E43 Error Write E2PROM Printing Unit

An error has occurred during data saving to E2PROM inside the print unit

-Check that the connecting cables between the electronic unit and the printer have been inserted correctly and that there is not any bent or broken PIN on the connectors.

-Check that E2PROM on the print unit is working and inserted correctly into the base.

-If the problem persists, contact Eidos Customer Service Department.

E44 Disk K

-Problems during reception of the label from disk K (STARCODE).

E45 Roller Length > Max Skids Stroke

The length of the image to be transferred is greater than the maximum length provided for the skid.

-Try reducing the length Y of the label

-Try reducing the minimum margin between the prints

-It must be: $(Y + \text{minimum margin}) < 30 \text{ mm}$

E46 Scanner or Pen Check Serial error (STX Fault)

-An error has occurred in the serial line between the scanner or optical pen and the printer.

-Check setting of the bar reader (the STX may be missing)

-Check the serial connection cable between the printer and bar reader

E47 Bar Code Check

The scanner has read a number of barcodes which does not correspond to the expected by the printer or has read the same number of codes but one or more codes do not correspond.

- Check the scanner configuration using its specific configuration program.

- Start char <FF>: command to lit up the beam

- End Char <EOT>: command to make off the beam

- Start char in the returned string: <STX>

- Barcode separator: <DLE>

- End chars in the returned string: <CR><LF>

- No Read char in the returned string: <CAN>

Other checks:

-Check head cleanness: in case of dirty dot clean the head dot line

- Check the printed barcode quality: ribbon folds or wrinkles presence in some of printed barcodes
- Check the barcode position on the label: at least 5mm of white area are necessary aside the barcode for good readability.
- Referring to the scanner reading diagram check the bar dimensions (mils), the barcode dimensions and the distance between the scanner and the barcodes.
- Check with EASYCODE program that "barcode checker" flag is enabled on all the barcodes to be checked.
- The barcodes CSE ASCII string of the barcodes to be checked must include check command (^v)

E48 ESSID Not linked as desired

The printer has not detected the Access Point with ESSID the same as data entry. WiFi connection cannot operate correctly.

- Try switching printer off and on again and run WLAN scan.
- Try switching Access Point off and on again
- Check that the ESSID of the Access Point and the one inserted on the printer are the same
- Check that all the Access Point settings are correct

E49 Invalid Barcode

An error occurred during the generation of the barcode.

The number of characters entered does not correspond to the required barcode length.

- Check length of the entered code.

E50 Code Length Different from Setup

- The length of the barcode read by the pen differs from the length saved in the SETUP.
- Check barcode length in SETUP.
- Check reader setting.

E51 Head Cable Disconnected or Low Temperature

This error normally occurs when the electronic unit lights up without any connection to the printing unit.

However, it may also occur in these particular cases:

- 1) the head flat cable is disconnected from the head
- 2) the head flat cable is disconnected from the interface card on the printing unit.
- 3) the 44-path cable that connects the printing unit to the electronic unit may be broken or have damaged or twisted pins.
- 4) check the flat cables inside the electronic unit that connects the card ACX to the card AIM. They may not be correctly inserted.
- 5) check the head flat cable status in the chain internally to the printer unit: it could be damage.

E52 Incorrect Sequence:

- The command sequence of the CSE protocol is incorrect
- Check the command sequences carefully.
- Unlock the printer and copy the label on floppy disk, then use an editor to check that the sequences received are still correct.
- A variable number of fields lower than those required by the label has been received through the serial line. Check the ^|ixx sequence.
- If barcode EAN128 and AI = (00), send only 17 digits as the checksum is auto-calculated.

E53 Discard Out Timeout

The discard piston sensor has not detected the departure from the home position.

- Check that the LED of the piston home sensor is ON.
- Check that the flow regulator is not too clogged.
- Check that compressed-air pressure is stable at 6 bar.

E54 Piece Not Available at STA Command

- The piece is not present during the application or transfer phase (C2S input).

- Check whether "Check part presence" flag needs to be checked or not in "SYNC24I/O Parameters" menu.

E55 Jet-Home Time Out Expired

-The waiting time for return of the Jet Piston with Search has expired.

E56 Motor or Photocell Time Out

-The machine was unable to identify the dimensions of the labels during the automatic calibration phase.

-Check:

- 1) Passages of the paper
- 2) Operation of the photocell of detecting label jump
- 3) Paper photocell excursion signal
- 4) For transparent labels with black intermediate label enable the parameter "Inverted paper photocell".
- 5) Paper photocell dirty
- 6) Problems of electrical connection to the Paper photocell.

E57 TX File Transfer. NACK from Host

- A file transmission error has occurred through the serial link

-Repeat the procedure

E58 TX File Transfer. File Not Found

-The file requested does not exist.

-The PC must repeat the file access procedure from the beginning.

E59 Label Eccentric or Head Open or Low Pressure

-Check that the knob of the eccentric counter-roller on the paper feed roll is tightly closed.

-Check the position of the knob for setting closure of the eccentric paper roller: it could be open.

-Air pressure is too low. It must be steady at 6 bar.

E60 Label's Width Exceeds MAX Value

-Check the dimensions of the label in the "Label parameters" menu.

-Label width must be no wider than the width of the print head.

-If this error happens after a software upgrade, check the "Thermal Head Type" parameter

-Use EASYCODE to change label dimensions.

E61 Roller Motor Running Fault

-Intermittent swing:

The carriage does not leave the rest position. If the printout is short (length Y short) increase print shift.

-CODITHERM Roller, Round.

The carriage does not return to rest position after rolling. Check driving, connections on carriage translation roller.

-Check accelerations value in diagnostic menu: accelerations must not have a value = 0.

If fault E61 cannot be eliminated, switch off the printer, disconnect the cables that connect the electronic unit to the printing unit and switch on the electronic unit again. After switching it on, eliminate fault E51 and use diagnostics to check the value of the acceleration. The optimum values are default values.

Only for PRINTESS4 set Paper Acceleration=1000 rather than 3500.

E62 Head Not in Home Position

-The carriage has not returned to the HOME position

- 1) Check carriage slide
- 2) Lubricate slide guides with BALLISTOL oil
- 3) Reduce Return Speed of the carriage

E63 Insert Flash Memory Key...

The flash key was removed during a copying operation.
Re-insert the flash key and repeat the operation.

E64 Discard Return Timeout

The sensor has not detected the return of the discard piston to the home position at the end of the cycle.

- Check that the LED of the sensor of the discard piston in the home position is ON.
- Check that the flow regulator on the discard piston is not too closed.
- Check that compressed-air pressure is stable at 6 bar.

E65 Labels Discard Full or Not in Home

- On the discard there is an excessive number of rejected labels. Take the discard to the Service position using the pushbutton on the touch screen and remove the labels.
- At the end of the operation, push the pushbutton on the touch screen to return the discard to the Home position.
- Check that the transparent cover has been inserted and that the retroreflector is present on the cover.

E66 Zero Print Area Received (Check EMU Mode)

- Check the dimensions of the page in the menu "Label Parameters". The dimensions X or Y could be 0.

E67 Wait time for RFID Reading Too Long

The Programmed Tag verification time has expired.

- The tag could be faulty
- The verification of tag could be disturbed by metal objects near the verifier.

E68 Line Stopped or Print Speed too low

- The line has stopped in the printing phase ($V < 50\text{mm/s}$).
- Clean the rubber-coated print roll with ethylic alcohol.
- Check for a constant and jerk-free tension of the film that could reduce the friction between the film and rubber-coated roll.
- The line speed drop may be below 50mm/s, disable the minimum speed control.

Warning! Good quality printing is not assured in these cases.

E69 T.O. Calibration Distance Verification

E70 Nick Distance Greater than...

- The line has advanced by a length the same as the length set as a "Nicks check", but the printer has received no command from the photocell.
- Check the nick reader: it might not detect the nick.
- Check parameter "Nicks distance": it must be = 1.5 times the length of the bag.

E71 Y Dimension Greater than Nick Distance

The label cannot be printed because the distance set as nick receipt check is less than the length Y of the loaded label.

If the product has changed and the pitch between the nicks has changed, check the parameter "Nicks distance".

Reduce the Y length using EASYCODE.

E72 Pitch Automatic Calculation Failed

-The print pitch calculation has detected an impossible condition, for instance:

- 1) label length is greater than "Head-transfer or distance".
- 2) unpredictable event that upsets calculation of print pitch.

E73 Heater out of Temperature required

- The heater has not yet reached temperature (red LED 1 OFF on thermostat)
- Wait for the heater to reach set temperature.
- Test printing can be carried out during this phase.

E74 Ribbon End or Break-up

- This error means that the ribbon with red inserts has ended.
- Replace the ribbon.

E75 Ribbon Equipment Does Not Exit from Home

- The ribbon equipment does not move from the home position.
- Check the compressed air or adjust the pressure by operating on the adjustment screw on the front of the transfer unit.
- Check the status of the interlock contacts connected to the SAFETY SWITCH connector.

E76 Ribbon Equipment Does Not Return to Home

- The ribbon equipment is not in the home position before the transfer cycle starts.
- Check correct working of the pneumatic cylinder and of the sliding linear guides.
- Check the status of the cylinder's home sensor.
- Check the SAFETY LOCK circuit. It could be open.
- Check if the PAD transfer unit is set as ROLLER, FLAT or ROUND in the setup parameters.

E77 Head Open

To SWING:

- Lower the print-head to the print position.
- For CODITHERM:

Using the red button to the left of heater display move the ribbons to spread out the folds.

This button is used to spread the ribbons after a ribbon change or after cleaning the print-head.

When the fault is cleared or after moving the ribbons, the print sequence must be loaded manually.

E78 SATO Conversion Impossible

Values of conversion/expansion characters not valid.

Check expansion of the characters of the label from the used label editing program.

The type of graphic compression inside the SATO label may not be recognized by the EIDOS printer.

E79 Dimensions or Printing Pitch Inappropriate

The carriage must perform a larger stroke than is allowed.

If you are working in "individual prints" check:

- the Y length of the label
- the "Shift from Home"

If you are working in "multiple prints" check:

- the "Shift from Home"
- the print pitch (pitch > Y Length)-
- The number of prints.

If the label is a .LMT type, check:

- the "print pitch"
- the "repetition pitch".

E80 RFID:

- Check that the cables connecting the electronic unit to the reader are correctly wired.
- Tag could be faulty.
- Check that there no metal structures that may affect reading/writing of the tag.
- Check that no tags have already been programmed with the same code in the range of the RFID antenna.
- Check that the type of Tag used is type Class1 Gen2 or EPC 1.19

E81 Insufficient Memory for font Generation

- The RAM is insufficient for generation of the characters required by the label.
- Check the capacity of the RAM available (INFO).
- Try to switch off and on\n-Recheck the capacity of the RAM available (INFO).
- Must be increased.

E82 Font Not Specified or File Not Found

- The font file required for the label (^U...) has not been found, either in C:\ or on flash key.
- Load the required .TTF file into the label
- The .TTF files must be copied to C:

E83 Home Search Failed

- The home sensor has not detected any signal variations
- Check the sensor and relative connection and cable.
- Check setting of the sensor and its positioning.
- Check manually the carriage movement in the complete stroke.
- Check the step motor carriage: there could be too high backlash on the pulley driving.
- Check the belt tension and the status of the teeth.
- The motor power supply could have problems: replace the power supply.
- Check the pins and the cable connections between electronic and printer unit.
- In case of SWING5i vertical mounted: check the weight compensator piston pressure calibration and also the internal air pressure leaking of the piston during the carriage movement.
- For old SWING5i check the AHS interface board: it could have broken internally connections.
- Check in the "Diagnosis" menu the Accelerations values.
- Power supply broken: replace it

E84 Line Speed too high

- the programmed print pitch cannot be performed by the printer because the speed of the line is too high. The cycle time is greater than the programmed pitch/line speed.
- 1) Reduce the line speed
- 2) Disable the "Autocalculation" for ribbon saving and reduce the "Back step Length" to recover ribbon. It may be necessary to set the value to 0.
- 3) Check that the label file is functioning under "Automatic" rework."Before" or "After" rework of the printout increase the cycle time.
- 4) If the label contains a progressive or automatic data, the line speed must be reduced to attain the programmed pitch.

E85 User font Table Not Found (^U)

- The label requires the uses of an internal font that is not found in the FLASH memory (C:).
- Load the file font (.TTF) with EASYCODE or with the use of the USB memory.

E86 Family Name Not Found in User fonts

- The .TTF file in the memory is damaged
- Load another file taking it from a different PC.

E87 User font File Not Found

- Load the .TTF font file required by the label.
- For fixed data (fixed texts) use Windows fonts instead of User fonts.

E88 Ribbon Saving too high

- The printer is unable to perform the programmed ribbon saving in the time between one print and the next
- Disable automatic calculation of ribbon saving and set "Back Saving"=0.
- If the error disappears, increase "Back Saving" until the error appears again. Then reduce "Back Saving" in order to obtain the max. allowed ribbon saving.

E89 MAX Partial Reprocessing Exceeded

- The maximum number of automatic data which can be reprocessed on the label has been exceeded:
- Up to 16 TIME fields can be processed on a label.
- Up to 16 DATE fields can be processed on a label.
- Up to 8 PROGR fields can be processed on a label.
- The max. total number of automatic data that can be partially reprocessed is = 16.

E90 Insert Smart Card

- Insert a Smartcard into the reader to reactivate production.
- Check that the cable of the smartcard reader is connected correctly to a USB port.
- If it is connected, trying switching the machine off, then on again. The drivers of the USB devices are loaded when the program boots.

E91 Data not found in Smart Card

- The label contains a number of data entries greater than those stored in the Smartcard.
- No data entry is stored in the Smartcard.
- The Smartcard could be faulty.

E92 Time Error. Check Battery...

- The machine hardware clock has stopped.
 - Upon release, Real Time Clock is reprogrammed and default date and time appear (01/01/00 01:01).
 - Set real date and time in Date-Time-Languages menu to clear the error message.
- If the problem persists:
- CR2032 battery on ACS96 board (CPU) may be flat or faulty.
 - ACS96 board (CPU) may be faulty.

E93 Heater Motor Fault

Anomaly of supply in the motor of the heating roller.

- Check that the connecting cables between the electronic unit and the printer are correctly inserted and no connector PIN is damaged.
- Check that the connector placed on the heating unit is installed correctly
- Dismantle the side walls of the electronic unit and check that all the connectors of the connecting cables inside the electronic unit are inserted correctly.
- On the rear side of the ROLLER or FLAT or ROUND transfer module there is a SMA95 electronic board that supplies the step motor that make rotating the heater transfer roller:
- Check the fuse on the SMA95 board; if broken try to replace it.
- If the replaced fuse burns again it means that there could be a short circuit on the heater step motor phases.
- Retry to replace the fuse after disconnected the motor connector.
- If the fuse continues to burn or the E93 error persists, try to replace the SMA95 board
- Check also the 27Vout power supply: try to replace it.

E94 Label does not contain Smart Card data

- If the Smartcard reading function is enabled, a label containing data must be loaded from the Smartcard.
- Check that the loaded label contains Smartcard data.

E95 Carriage End of Stroke

Carriage reached end of stroke during printing.

- Reduce set value of Home Out Shift.
- Reduce length Y of the label.
- If multiple print is enabled, reduce the number of prints.

E96 Progressive Number: Error or End of Counting

- A consecutive number was used in descending order or the consecutive number became less than or the same as zero.
- Set a new consecutive number.
- If serial transmission of the consecutive number is used check that a negative number is not sent (^#00-nnnnnn), or the command ^#00 without numbers at the end.

E97 BarCode Scanner Not Configured

- The label contains one or more barcodes undergoing verification (^v), but the verifier is not enabled in the printer parameters.
- Enable the verifier from the Communication Parameters menu
 - Open the label under Easycode and remove the barcode Verify flag if verification is not required.

E98 Scanner or Pen Not Connected

- The light pen does not appear to be connected.
- Check that the connecting cables are correctly inserted.
 - Check that the light pen is powered up.

E99 Computer Data not Updated

- One or more variable data entries in the label need to be updated at each printing.
- Check that the connections between PC and Eidos printer are correct.
 - Check that the communication parameters in the PC and printer are correct.
 - Check that between one print and the next the program sends the required operators data to the printer.

E100 SCH Error:

- Error message of the Schleuniger CAYMAN system
- CODITHERM not READY: set the printer to AUTOMATIC.
- Diameter not found: Close and re-open the CAYMAN program and restart production.
- The CAYMAN does not send the diameter of the wire.

E101 Print Cycle Not Completed

- A print command (STB) arrives while the printer is receiving or reprocessing the label file.
- Delay the print command (STB) to give enough time for label receiving and reprocessing.
 - In order to obtain the best synchronism it is advised to disable the flag "Print I/O only" and to disable the flag "Autoapplication". The printer will automatically print at the end of the label reprocessing and will wait for the STA command from PLC to apply the label on the pallet.

E102 Safety-lock Open or Low Pressure

- The safety circuit connected to the SAFETY LOCK connector is open.
- Check the emergency switch.
 - Check the guards: they must be closed.
 - Close the protection cover or guard.

E103 Invalid File on Flash key

- The file in the flash key cannot be loaded or it is unreadable.
- File may be damaged.
- The flash key may need to be formatted.
- The flash key may be damaged.

E104 Invalid Operator Data Length

- Data set by the operator has not valid length of digits.
- It is necessary to repeat data entry.
- This message is given only if the Length Check flag has been enabled on the data contained in the label.

E105 Non Numerical Operator Data

- The field can only accept numerical data
- It is necessary to repeat data entry.
- This message is given only if the Number Check flag has been enabled on the data contained in the label.

E106 Invalid Operator Data

- The Operator has not entered any character or entered blank character sequence into a field where, when creating the label with EASYCODE, the flag to "Check presence of data" has been activated.

E107 Watch Dog Interrupt

- The printer has received up to 8 consecutive print commands (STA or STB input on SYNC24 I/O connector), but none of these have been executed.
- Check the photocell signal command bouncing
- Printer firmware blocked.
- READY the printer.
- If continuous SWING2:
 - a) try to invert the "Encoder direction" flag.
 - b) clean the rubberized print roll
 - c) check the rotation of the rubberized print roll on bearings
 - d) check the encoder belt
 - e) check the encoder cable connection with electronic unit
 - f) check the encoder pulses in diagnosis menu.
 - g) check the encoder pulley; it must be screwed on encoder axis

E108 Inappropriate mechanics, Detected:

The printing unit connected to the electronic unit is not consistent with the firmware installed on the electronic unit

- Update the electronic unit with the correct firmware.

Example: the firmware is CODITHERM whilst the connected printer is a PRINTESS.

- If the printing unit is consistent with the firmware the problem may be due to the cables connecting the electronic unit and the printing unit.

- Extract the cables and check that the pins are not twisted.

Also check the pins on the connectors on the printing unit and electronic unit side.

- Try to replace the cables connecting the two units.

In particular, for CODITHERM:

Coditherm, to be recognised as such, has pins 15 and 30 of the connector with 44 earth paths. If one of the two is not connected (e.g. because a pin is squashed or twisted) Coditherm may be recognised as a different printer. See figure to find pins 15 and 30 on the card.

In general, for all the printers:

Open the right side panel of the electronic unit and check that all the connectors on the card AIM96 and on the card ACX96 are inserted properly. Try pressing each of them with a finger. In particular check the cable on the connector CN2 on AIM96.

E109 The format must contain one operator data

- The format must include operator data when the format is being loaded or during light pen reading.

E110 The format contains more than one operator data

- The format includes more than one operator's data when the format is being loaded or during light pen reading.

E111 Printing Not Allowed. Read data from Light Pen

- Read data with the light pen
- The message is activated at the arrival of the STB command if the data entry is not read by the light pen.

E112 New serial sending is necessary

-A new serial sending (complete label or variable data) is required in as much as the printer has not saved the label received because of the switch-off.

To safeguard the FLASH memory, the label or the variable data received (serially, LAN etc.) are saved only after 3 minutes.

For a 3 minutes duration, next to the file name a "*" character appears. When the 3 minutes time is over, the entry is saved.

E113 Emergency switch or cover open or Safety-lock

-The safety circuit connected to the SAFETY LOCK connector is open.

-Check the emergency switch.

-Check the guards: they must be shut.

-Close the protection cover or guard.

-Check the interface board on the printer unit: an electrolytic condenser could be pulled off from the board.

E114 24/56V Motor Power Supply Failure

A power supply anomaly has been detected.

-Remove the left cover of the electronic unit and check that the bridge on the power connector is positioned between COM and 56V for PRINTESS or SWING and between COM and 28V for CODITHERM.

-Check that all the connectors of the cables connecting to the inside of the electronic unit are inserted correctly; there may be a false contact.

- The grey power supply (48V or 27V) could be broken. Check with a tester the output voltage level.

- A colour display was mounted instead of a monochrome display

-If the problem persists, contact Eidos Customer Service Department.

- For SWING2i: the high power electronic unit cannot be used for this printer.

E115 28V Heater Power Supply

A power supply anomaly has been detected on the heater.

-The heater is supplied with incorrect voltage.

Unmount the left cover of the electronic unit and check that the bridge on the power connector is positioned between COM and 28V and not between COM and 56V.

-Check that the connector placed above the transfer unit is installed correctly

-If the problem persists, contact Eidos Customer Service Department.

E116 24V Head Rele Power Supply Failure

1) Check that the connections inside the electronic unit between card AIM96 and card ACX96 (flat cables in particular)

2) Check that there are no short circuits on the 24V supply on the printing unit (sensors connection, step motor cabling, applicator's pneumatic box etc).

E116 14V Mosfet Driver Power Supply Failure

1) Check that the connections inside the electronic unit between card AIM97 and card ACX96 (flat cables in particular)

2) Check that there are no short circuits on the 24V supply on the printing unit (sensors connection, step motor cabling, applicator's pneumatic box etc).

E117 5V USB Power Supply Failure

A power supply fault has been detected on the USB ports.

-Try switching off and on again. The problem might not come out again.

-Open the left cover of the electronic unit and check that all the connectors of the connecting cables inside the electronic unit are inserted correctly.

-Check for false contacts.

-If the problem persists, contact Eidos Customer Service Department.

E118 5V Serial Power Supply Failure

A power supply fault has been detected on the serial line.

- Try switching off and on again.
- Open the left cover of the electronic unit and check that all the connectors of the connecting cables inside the electronic unit are inserted correctly.
- Check for false contacts.
- If the problem persists, contact Eidos Customer Service Department

E119 24V Sensors/Actuators Power Supply Failure

A power supply fault has been detected.

- Open the left cover of the electronic unit and check that all the connectors of the connecting cables inside the electronic unit are inserted correctly.
- Check for false contacts.
- If the problem persists, contact Eidos Customer Service Department.

E120 24V SYNC24 I/O Power Supply Failure

A power supply fault has been detected on the connector SYNC24I/O.

- Open the left cover of the electronic unit and check that all the connectors of the connecting cables inside the electronic unit are inserted correctly.
- Check for false contacts.
- If the problem persists, contact Eidos Customer Service Department.

E121 12/24V AIP95 I2CBUS Power Supply Failure

-Check that the connecting cables between the electronic unit and the printer are correctly inserted and that no PIN connector is damaged.

-Open the guard under the control panel, dismantle the AIP95 card and check that all the connectors on the card are inserted correctly.

- If the problem persists, contact Eidos Customer Service Department.

E122 Cartridge Voltage Error 56V

The electronic unit is set to operate at 56V, but the cartridge operates at 28V.

-The heater is supplied at an incorrect voltage.

Dismantle left wall of the electronic unit and check that the bridge on the power connector is positioned between COM and 28V and not between COM and 56V.

E123 Configuration not Coherent. Impossible to continue. (56V)

The hardware has reported an anomaly on the 56V supply.

-Check that the connecting cables between electronic unit and the printer are correctly inserted and no connector PIN is damaged.

-Open the left cover of the electronic unit and check that the bridge on the power connector is positioned on the 56V outlet for PRINTESS and SWING and on the 28V outlet for CODITHERM.

- If the problem persists, contact Eidos Customer Service Department.

E124 Roller length or Y dimension too long or Dimensions

Inappropriate.(Print.Queue No.=0)

Total length exceeds maximum length of image that the machine can transfer.

-Try reducing the length Y of the label

-Try reducing set Home Out Shift

-Try reducing the set overrun value

-Try reducing the set minimum margin

-Check "roller type" parameter: Short, Long, Extralong. Must be congruent with your ROLLER transferor.

E125 Invalid Upgrade Program on Flash-key or too many ZIP files

E126 B-LFT Rotator Not in Home Position

The LH swiping arm piston has not returned home.

- Check that there no obstacles to head rotation.
- Increase "Head rotation wait" (>30)
- Check sensor position. The yellow LED must be ON when the piston is in home.
- Air pressure of the piston control could be too low.
- Check that inlet pressure is correctly adjusted
- Check flow regulators on the cylinders that control rotation.

E127 A-RGT Rotator Not in Home Position

The RH swiping arm piston has not returned home.

- Check that there no obstacles to head rotation.
- Increase "Head rotation wait" (>30)
- Check sensor position. The yellow LED must be ON when the piston is in home.
- Air pressure of the piston control could be too low.
- Check that inlet pressure is correctly adjusted
- Check flow regulators on the cylinders that control rotation.

E128 Secondary Applicator Not in Home Position

-The secondary piston has not returned home.

- Check that there no obstacles to the return.
- Check adjustment of air flow on the piston.
- Check compressed-air pressure.
- Check piston home sensor.

E129 Print Shift too short

-Check set "movement from home".

Try increasing its value until the problem is eliminated.

- Do not run ZOOM whilst the printer is printing.
- Try to invert the "Invert encoder direction" flag.

E130 A-RGT Rotator cannot exit Home Position

- Increase "Head rotation wait" (>30).
- Check that the LED piston home sensor is ON.
- Check that the flow regulator is not too clogged.
- Check that the compressed-air pressure is stable at 6 bar.
- The air pressure of the piston control could be too low.

E131 B-LFT Rotator cannot exit Home Position

- Increase "Head rotation wait" (>30)
- Check that LED of piston home sensor is ON.
- Check that the flow regulator is not too clogged.
- Check that the compressed-air pressure is stable at 6 bar.
- The air pressure of the piston control could be too low.

E132 Printing Sequence or STB-C2S Not Coherent

A C2S command has been sent from the line that is out of sequence.

The permitted sequences are:

- 1) STB, STB, STB ...for a single label on the pallet.
 - 2) STB, C2S, STB, C2S, ...for two labels on the pallet.
 - 3) STB, C2S, C2S; STB, C2S, C2S; ... for three labels on the pallet.
- Check that the sequence of the commands is correct.

E133 Pallet Not Positioned

The vacuum sensor has detected a vacuum fall before the start of pad rotation.

The pad has found an obstacle during its advance before the head is rotated.

- Check the position of the pallet arrest photocells. The pallet could be arrested inside the movement area of the piston, preventing it from rotating correctly.
- Check compressed-air pressure: at least 6 bar, stable
- Check that the vacuum circuit is not clogged.
- Check that the vacuum circuit has a seal and that there are no seal leaks.

E134 Ribbon separator not homed

-The blade detaching the ribbon from the object is not in Home position.

-If the ribbon detachment blade is not present on ROUND transfer in use, set "Pulse Release Time" to zero in "Application Parameter Settings" menu

- Check blade sliding
- Check position of blade home sensor.
- Check movement of blade slide.

E135 Object Positioner Failure

-Check the air pressure

-Check the positioner piston flow regulators.

If Object Positioner = A Impulse:

-the piece positioner piston may not reach the limit switch: it may be jammed.

-Increase the time for the "Object Load Time" parameter.

-Check that there are no caps that are greater than or shorter than those expected. The caps must be of the same length for each production lot.

E136 Operator data new and old format not allowed

-The label contains an ASCII syntax containing old type variable data (e.g. |*080lotto) and new type variable data (e.g. |*#08000lotto). The two formats cannot coexist on the same label.

-If you want to work with the new format, edit old operator data using new operator data and assign an ID number to each of them.

-To maintain the old format, deactivate "Touchscreen Printer Operation" flag on EASYCODE, select data and press "Edit".

E137 Program is a release<3.00, Is not Compatible with UBOOT

- This program version is not compatible with "UBOOT" bootstrap loader. Ask EIDOS for a compatible version.

E138 Bar Code Check Disabled. Label with Verify Enabled

- The label asks to be checked (syntax contains ^v0), but the checker is off.

- At each print, "Checker Off" message appears on printer screen and a warning is written in status string.

E139 Not found System Font

- The system fonts are damaged or deleted: repeat the printer "Program Upgrade" procedure.

E140 WARNING: The Flash Memory is about to finish

- Flash memory check at program start-up: less than 100KB still available.

- Delete files not used from disk C:\ to free space.

E141 WARNING: The Flash Memory does not Work properly

Internal flash is not working correctly and generates writing errors.

- Format FLASH memory.

- Call EIDOS Technical Assistance Service if the problem persists.

E142 Check-sum error in Monofile

The loaded .LM1 or .LMT file is damaged.

Error in the CRC of the file.

-Make a new copy of the file.

-If you use the USB memory key, check its operation on a PC.

-If the label is sent by PC, check that the settings of the communication parameters are correct

-.LM1 labels created or saved with EASYCODE 16 bit can create this error.

E143 Calculated Length Exceeds Label Dimension

-The length of the label evaluated as the distance along the Y axis from the first black dot and the last black dot on the label exceeds the maximum Y length allowed by the printer model in use.

The allowed limits are the followings:

a) PRINTESS: Max Y = label length evaluated in autocalibration

b) SWING5i: Max Y = 520mm

c) SWINGcx and CODITHERM: Max Y = 360mm.

d) SWING2i: Max Y = 70mm.\ne) SWINGie: Max Y = 90 mm (Short model); Max Y = 200 mm (Long model).

E144 Positioner Not in Home Position

- The film positioning device is not in the Home position.

- If the printer has no positioning device, make sure that the film positioning function is disabled in the printer parameters menu (page 2)

- If there has been an upgrade to version 3.02 perform the following operations: enter the printer parameters menu and disable the positioner.

If it is SWING2i disconnect the cables with the print unit, disable the parameter, switch off, reconnect the cables and switch on again.

E145 Positioner Not in End of Stroke Position

The positioner has not performed its full stroke towards the limit switch.

Check:

-Air pressure: it must be stable during operation.

-Remove pressure and check that the positioner slides on its guides.

-Check the diagnostics to see if the limit switch is activated when the positioner is at the end of the stroke.

E146 Unexpected Parameters Error.

Verify Parameters and accelerations

The printer parameters are incongruent:

-Some values are out of range

-Some values are not coherent

Check that all parameters in the "Printer Parameters", "Application Parameters", "Counter Parameters", "SYNC24I/O Parameters", "Data-Language Parameters", and "Communication Parameters" menus are correct.

Also check the "Diagnostics" menu for the acceleration values.

E147 Stand-by Time-out Internal coil Expired

The clamps that apply the labels inside the reel have not returned to stand-by.

This means that the secondary piston controlled by ATT5 has not returned to home (SENS10) after application.

Use the Diagnostics functions to check that the piston (ATT5) and the Home sensor (SENS10) are functioning properly.

E148 +5V Printer Power Supply

Problem with the + 5 V power supply in the print unit.

Try to replace the interface board in the print unit.

This fault may occur after clearing the "E20: high print-head temperature" error.

E149 Carriage Not in Home Position

The printer carriage has not returned to home position.

Change the print speed and carriage return speed and verify if the fault persists.

Go to the "Diagnostics" menu, open the cover and manually move the carriage. Check to see if the home sensor (SENS8) switches normally.

E150 Internal Relay Not Switched

During the print-head dot check phase, the internal relay has not switched.

To avoid burning the print-head, the printer generates an error.

Check the operation of the relays on the AIM96 board.

Use the "Diagnostics" functions to check (Relay).

E151 Invalid Input Configuration

3SIDES applicator in "Additional Inputs" mode.

The input configuration is invalid when the STB command arrives.

INP0=1: incr. progressive and apply on right

INP1=1: incr. progressive and apply straight

INP2=1: incr. progressive and apply on left

INP3=1: do not increment the progressive

Configurations such as the following are not allowed:

INP0=1 and INP1=1

INP0=1 and INP2=1

INP1=1 and INP2=1

E152 Carriage return speed too high

-Set the "Print Speed" and "Carriage Movement Speed" at the same value.

-The instantaneous speed of the carriage detected by the home sensor is too high and does not allow the carriage to decelerate and stop within the space physically available for stopping without hitting the limit switch.

E153 New sending or loading is necessary. Label cleared.

-The flag "Clear Label after print" is enabled.

It is necessary to send a new label or new variable data after every print cycle.

E154 Invalid Y dimension in LMT texts

For CODITHERM all the pages in the LMT file must have the same Y length.

E155 LMT Sequence command error: Load queue.

For CODITHERM when you use a LMT multi text file to print different text or to print in "dual pass" mode, a print command STA,C2S,..,C2S sequence may be an incorrect sequence.

-Reload the printing queue

-Check the commands sequence

E156 Gateway error: Network is unreachable

Gateway error: Network is unreachable. Verify Gateway IP address

Verify cable connection.

Verify Eidos BusyBox program file.

E157 Invalid number of texts in LMT page

If This error occurs only on SWING5i, SWINGie and SWINGT2 when a "pneumatic" or "motorized" film positioner device is enabled.

- If positioner "Pneumatic Double Pitch 3 Fig. (.LMT)" is enabled the. LMT file must be made of 2 pages.

- If positioner "Motorized" is enabled the .LMT file must have the same number of pages as set in the "number of positions" parameter.

E158 Pliers out of home position:

- The pliers are not in home position
- Check the pliers movement
- Check the home position pliers sensor
- Select the correct "type of applicator" in the "Application parameters" menu. It might be that the "Cord" applicator is enabled but your printer has a different applicator.

E159 Secondary piston out of home:

- The secondary piston on the pad is not in home position.
- Check the home position sensor on the secondary piston.
- Select the correct "type of applicator" in the "Application parameters" menu. May be that the "Cord" applicator is enabled but your printer has a different applicator.

E160 Pliers do not exit from home position:

- The pliers do not exit from home position when activated.
- Check the pliers movement.
- Check the home position pliers sensor

E161 Cord not present:

- The sensor does not detect the presence of the cord during the label application.
The sensor might be dirty.

E162 Secondary piston do not exit from home position:

- The secondary piston does not exit from home position when activated.
- Check the piston movement.
- Check the home position secondary piston sensor.

E163 Positioner positive end of stroke:

- The slider of the "multipitch positioner device" reached the positive "end of stroke" sensor.
- The positive "end of stroke sensor" detects when the slider moves over the end of stroke at the opposite side than the home position.
- Check the status of the positive "end of stroke" sensor.

E164 Positioner negative end of stroke:

- The slider of the "multipitch positioner device" reached the negative "end of stroke" sensor.
- The negative "end of stroke sensor" detects when the slider moves to the end of stroke over the home position side.
- Check the status of the negative "end of stroke" sensor.

E165 Positioner fault or cover open:

- The slider of the "multipitch positioner" does not reach the next position because the motor does not move.
- The positioner motor driver could be in error or not ready.
- The safety cover could be open so the motor driver is not powered.
The emergency mushroom could be pressed so the motor driver is not powered.
- The motor driver is not powered. Check the power supply.
- It could be that the "multipitch positioner" is enabled but not mounted on the printer.

E166 Positioner Home Search Failed:

- The slider of the "multipitch positioner" does not reach the home position sensor.
- The home position sensor does not detect the passage of the slider when a homing command is operated.

E167 Position not reached:

- The slider of the "multipitch positioner" does not reach the programmed position because the motor does not move.
- Check the slider and motor movement when a "move" command is operated.

E168 Positioner not in Start Position:

- The slider of the "multipitch positioner" is not in the first position POS1 when a print command STA is given to the printer.
- There could be a synchronism problem between print command and "multipitch positioner" device position.
- Try to open and close the safety cover; a homing function will be operated.

E169 Positioner driver communication error:

- The "multipitch positioner" device is to be connected to the printer by means of a RS232 serial line. Check the connection between printer and step motor driver.

E170 Package too close to the positioner:

- With "Dynamic Corner" applicator it means that the box to be labeled is too close to the pad so the pad rotation is too high.
- With "Wedge" applicator it means that the boxes to be labeled are too close so the pad touches the box while is going down for application.

E171 Package not arrived:

- With "Wedge" applicator it means that the pack to be labeled is not arrived in the application zone in 30s of time out.
- With "Dynamic corner" and application on side it means that the pack to be labeled is not present when the application command is given.

E172 Codified year out of range

- In the label is present an automatic codified data that refers to a year exceeding 2019. Resave the label with a Easycode32 version 7.03 or greater.

E173 Positioner driver error:

- The slider of the "Motorized standing pole" does not reach the next position because the motor does not move.
- The positioner motor driver could be in error or not ready.
- The safety protection could be open so the motor driver is not powered.
- The emergency button could be pressed so the motor driver is not powered.
- The motor driver is not powered. Check the power supply.
- May be the "Motorized standing pole" parameter is enabled but the motorized standing pole is not present.

E174 Secondary piston has not reached the position

- This may occur with "Dynamic Corner" applicator when the pad has not been deflected sufficiently
- Check that the pad can rotate up to end of stroke.

E175 Ever controller application file missing or invalid

E176 Heater box overtemperature

E177 Error in receiving a graphic block

- This may occur in case of a reception problem of the compressed graphic block contained in Monofiles LM1 / LMT.
- Check the graphic block in the label file.

E178 Error wrong printheads distance

The current distance between the printheads is not compatible with the required print, you must change it.

E179 Warning the printheads distance is not the best

You can speed up the print cycle by modifying the distance between the printheads.

E180 LMT With mixed rotation not printable

LMT containing labels with different rotations are not allowed to print on Swing with 2 printheads.

E181 Motor Error

This is a generic error that comes from the Motor Board.
If it persists try to replace the Motor Board.

E182 Carriage motor Error (xx)

If (xx) = C8/88/D0/90, check if the Motor Board version is N102399-002.
Check the carriage motor current and acceleration in the Extra Parameters menu. Set the values to a default.

E183 Rewinder motor Error (xx)

If (xx) = C8/88/D0/90, check if the Motor Board version is N102399-002.
Check the rewinder motor current and acceleration in the Extra Parameters menu. Set the values to a default.

E184 Releaser motor Error

This error refers to a problem on the BLDC ribbon release motor drive on the Motor Board.
Check the release motor current range in the Extra Parameters menu and the Ribbon Release Force in the Printer parameters. Set the values to a default.

E185 FeRam on Interface Board Fault

The FeRam memory on the Interface Board (43SIB01) has a fault. It must be reinitialized.
Replace the Interface Board.

E186 CPU-Flash Memory Fault

The flash memory on the CPU has a fault. It must be formatted.
Replace the CPU.

E187 Print Head 1 Memory Communication Fault

The error appears when the I2C communication with the crypto memory of the Print Head 1 is not coming.

Check if the Servomotor temperature on diagnostic page is OK.

If it is not OK:

- check the 45CV879/1 pin 21-22 cable that connect the CPU Board (Thermal head) and Interface Board (J2): cable 45CV879/1.
- Check the flat cable 26 wires that connects the Carriage Board to the Interface Board.

If it is OK:

Check if the print head has a cryptochip.
Check connections between print head and Carriage Board (flat cable 45CV881/1).
Check the connection between Carriage Board and Interface Board (flat cable).
Check the connection between Interface Board (J2) and CPU board (Thermal head): 45CV879/1 cable.

E188 Print Head 2 Memory Communication Fault

The error appears when the I2C communication with the crypto memory of the Print Head 2 is not coming.

Note: the XTO22i with 2 x 53 mm print heads is not still implemented in the 2.0 release.

Check if the Servomotor temperature on diagnostic page is OK.

If it is not OK:

- check the 45CV879/1 pin 21-22 cable that connect the CPU Board (Thermal head) and Interface Board (J2): cable 45CV879/1.
- Check the flat cable 26 wires that connects the Carriage Board to the Interface Board

If it is OK:

check if the print head has a cryptochip.

Check connections between print head and Carriage Board (flat cable 45CV881/1).

Check the connection between Carriage Board and Interface Board (flat cable).

Check the connection between Interface Board (J2) and CPU board (Thermal head): 45CV879/1 cable.

E189 TPH's 1 Servo Temperature Sensor Communication Fault

The error refers to the carriage 1 servo temperature sensor that is located on the carriage board.

Check the connection between carriage 1 and the interface board (flat cables connectors insertion in the boards, flat cables damaged or sensor or boards broken).

E190 Parameters not found

File "parameters.json" or parameters not found

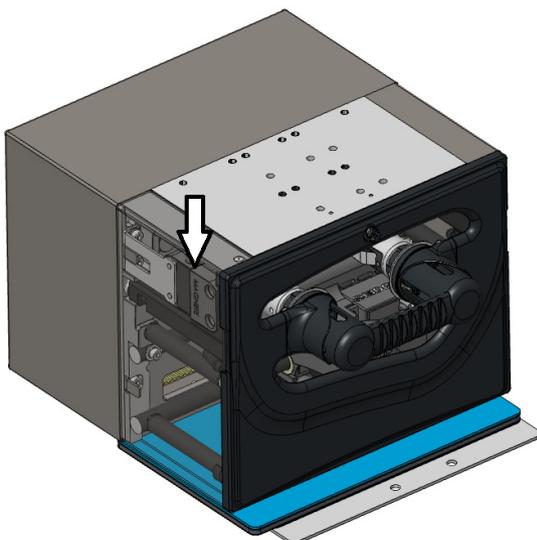
E191 Parameter values out of range

There is a parameter with value out of the allowed range.

E192 Safety-lock Open

The error appears when the front cover is open or when the inputs "Safety Chan-A" and or "Safety Chan-B" on DSUB-25 I/O SIGNALS connector are open.

When the cover has been closed the printer makes a ribbon rewind operation and a carriage home-service-home search.



Or

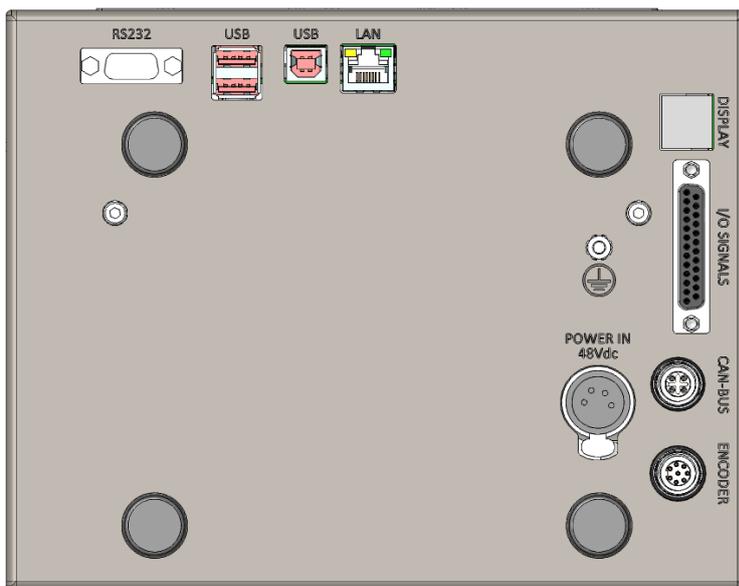
If there are no external safety contacts, "Safety_Chan-A" and "Safety_Chan-B" must be joint together and with "Safety-COM": join pins 5 – 18 – 6 on I/O SIGNALS connector.



D-Sub 25P MALE	
OUTPUT - FAP	1
OUTPUT - RIS	14
OUTPUT - ANM	2
OUTPUT - RDY	15
OUTPUT - LABEL RDY	3
COM OUTPUT	16
	4
	17
INPUT SAFETY CHAN-A	5
INPUT SAFETY CHAN-B	18
INPUT SAFETY COM	6
	19
INPUT - RST	20
INPUT - STB	8
INPUT - C2S	21
INPUT - STA	9
COM INPUT	22
	10
	23
INPUT - PG0	11
INPUT - PG1	24
INPUT - PG2	12
INPUT - PG3	25
COM INPUT PG	13

E193 External Block Active (RESET)

- The INPUT-RST on I/O SIGNAL DSUB 25 connector has been activated.
- When the input is deactivated the error disappears while a ribbon rewind and carriage home search functions are made.



D-Sub 25P MALE	
OUTPUT - FAP	1
OUTPUT - RIS	14
OUTPUT - ANM	2
OUTPUT - RDY	15
OUTPUT - LABEL RDY	3
COM OUTPUT	16
	4
	17
INPUT SAFETY CHAN-A	5
INPUT SAFETY CHAN-B	18
INPUT SAFETY COM	6
	19
INPUT - RST	20
INPUT - STB	8
INPUT - C2S	21
INPUT - STA	9
COM INPUT	22
	10
	23
INPUT - PG0	11
INPUT - PG1	24
INPUT - PG2	12
INPUT - PG3	25
COM INPUT PG	13

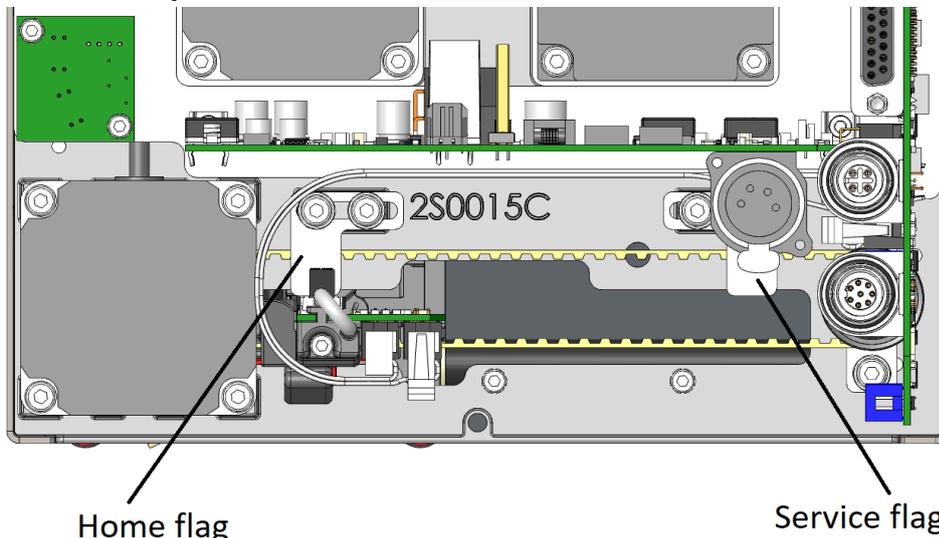
E194 Home Search Failed

The home position is not been reached when the carriage come back to home.

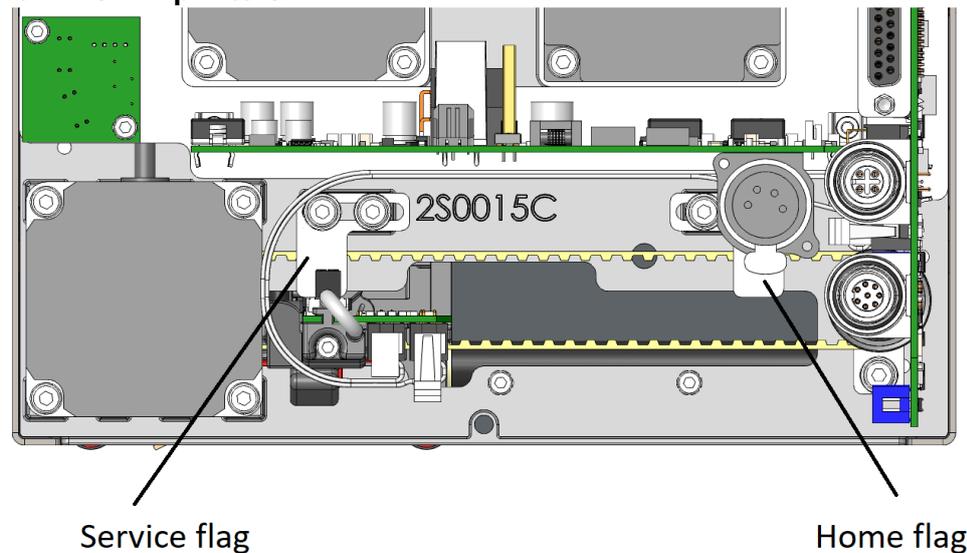
- Check the Home flag calibration position. Try to open the front cover and check if the carriage move manually to home of 0.5 – 1 mm. If not, open the rear cover and move the Home flag plate 0.5 – 1 mm far from carriage Home.
 - Carriage Return speed too much high
 - Carriage motor drive is not working well (belt with broken teeth, pulley on motor shaft)
 - Photo fork sensor broken: open the front cover and move the carriage manually. When the carriage is in position between home and service a green led on carriage lit up. Try to move the fork sensor with a finger and check if the green led stays ON or sometimes become OFF. In this last case it means that the fork sensor is broken and the carriage board must be replaced.
- If the fork sensor is broken, check the home and service flags positioning than the fork slot.

- The home sensor has not detected any signal variations.
- Check the sensor and relative connection and cable.
- Check manually the carriage movement in the complete stroke.
- Check the step motor carriage: there could be too high backlashes on the pulley driving.
- Check the belt tension and the status of the teeth.

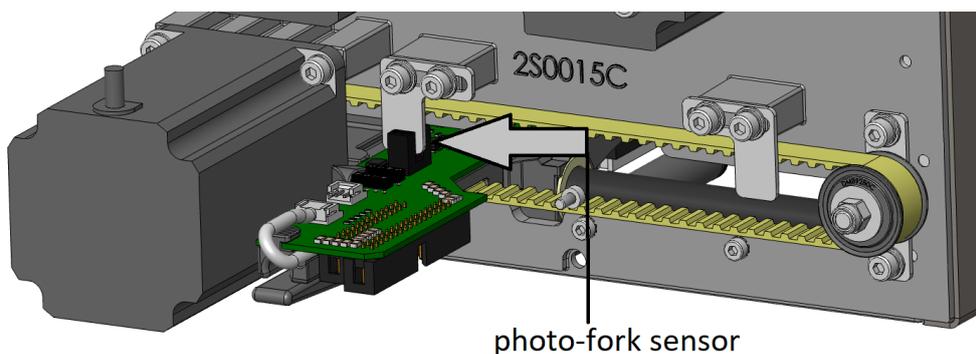
For XTO-LH printers



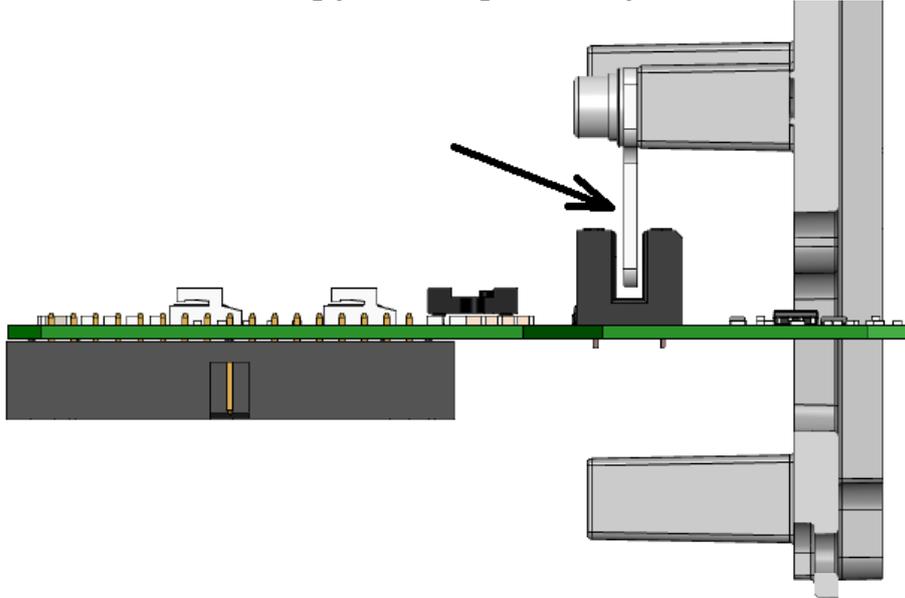
For XTO-RH printers



Home-Service position photo-fork sensor:



Home – Service metal flag positioning than the photo fork sensor



E200 Color Bitmap not supported

The colored bitmap are supported only when included in a .LM1 or a .LMT label files, or when sent to the printer by a ZEBRA driver.

In case of .LAB label files with external .BMP files stored in the printer C: disk, only monochrome bitmap are supported.

E201 Out of memory

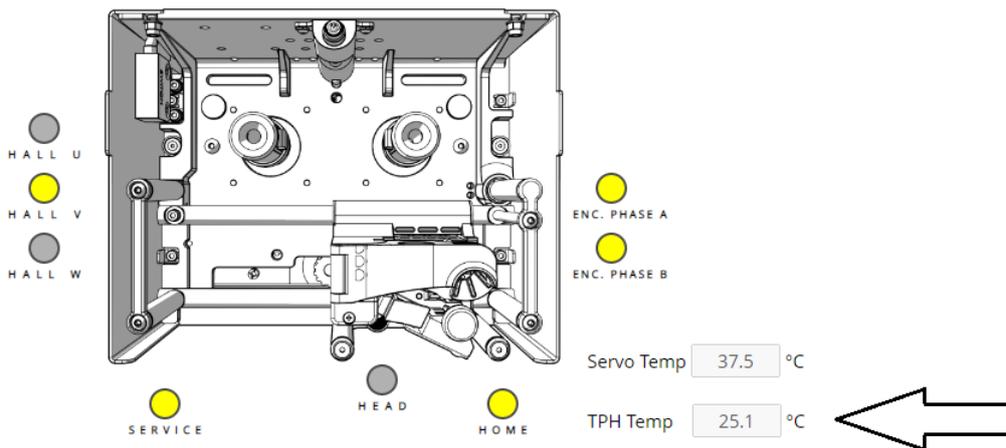
Not enough RAM memory when a BMP image file is allocated.

E202 Printhead 1 overheated

This error appears when the printer head temperature detected is over than 85°C.

Check the printhead temperature in the “Diagnostic” page.

Reduce the print rate or the % of black areas to be printed (negative areas, logos etc.)



E203 Printhead 2 overheated

This error appears when the printer head 2 temperature on XTO22ix detected is over than 85°C

Check the printhead temperature in the “Diagnostic” page.

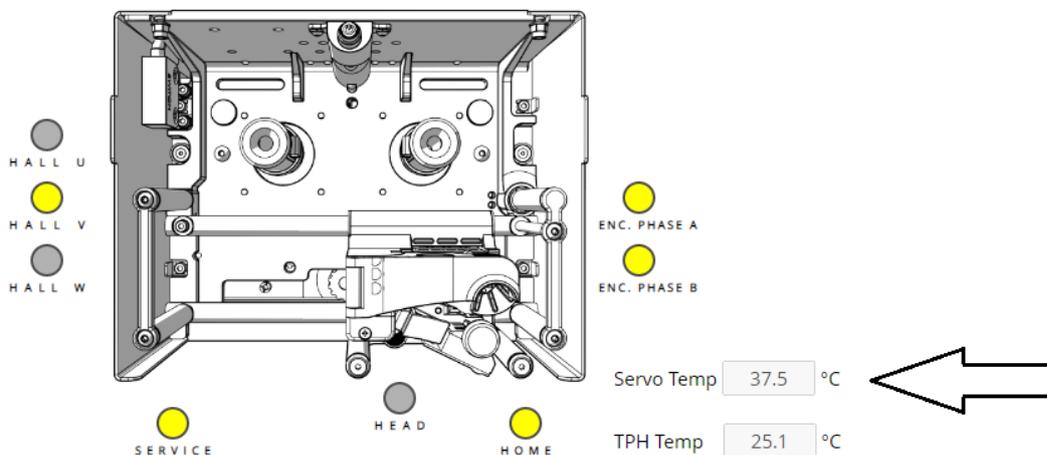
Reduce the print rate or the % of black areas to be printed (negative areas, logos etc.)

Note: the XTO22i with 2 x 53 mm print heads is not still implemented in the 2.0 release.

E204 Servo 1 overheated

This error appears when the temperature detected of Servomotor that move the print head is over than 85°C.

Check the servomotor temperature in the “Diagnostic” page.
Reduce the print rate.



E205 Servo 2 overheated

This error appears when the temperature detected of Servomotor that move the print head 2 on XTO22i is over than 85°C.

Check the servomotor temperature in the “Diagnostic” page.
Reduce the print rate.

Note: the XTO22i with 2 x 53 mm print heads is not still implemented in the 2.0 release.

E206 TPH's 2 Servo Temperature Sensor Communication Fault

The error refers to the carriage 2 servo temperature sensor that is located in the carriage 2 board for XTO22i with 2 x 53 mm print heads.

Check the connection between carriage 2 and the interface board (flat cables connectors insertion in the boards, flat cables damaged or sensor or boards broken).

Note: the XTO22i with 2 x 53 mm print heads is not still implemented in the 2.0 release.

E207 Internal Canbus Communication Fault

On version 1.0.2413 validated for XTO2ie we encountered the following bug:

In the event of an error "E207 Internal CAN BUS communication error" it may happen that:

a) If the error can be unlocked: the printer continues to work as if nothing had happened. This is a spurious signal due to a disturbance generated by, for example, when the ribbon holder cover is inserted or when the printer is turned on, especially when using the power supply for DIN rail from the electrical cabinet.

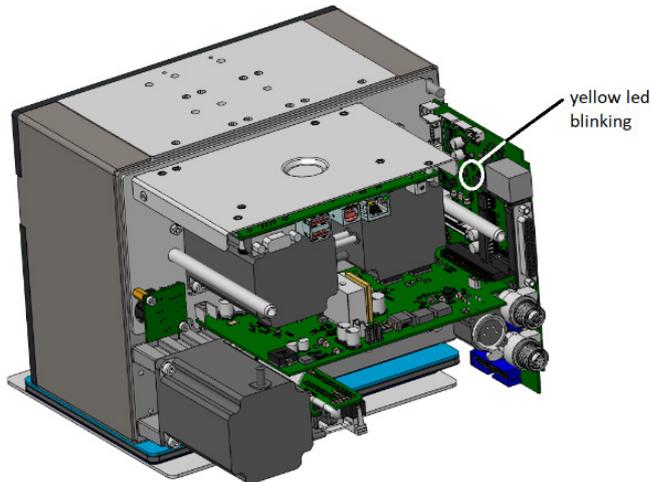
If the DIN Power Supply is and EIDOS NDR-240-48 check if there is already the Electrolytic Capacitor on the V+/V- outputs.

If the 48Vdc is provided by the customer, an electrolytic capacitor 63V-2200uF at least must be added on the voltage output must be added

b) If the error is not unlockable, or if it reappears after unlocking, then it means that there may be a real CAN BUS communication problem between the various internal processors of the XTO2ie.

It is necessary to open the rear casing and:

- check if on the SIB01 interface board there is a flashing yellow LED in the upper portion (area above the Power Board); it means the KV11 processor is active.



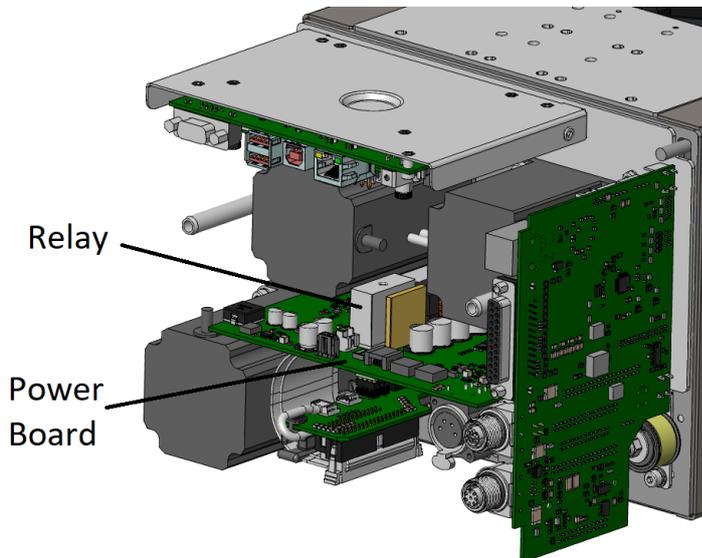
- check the connections relating to the 45CV882 / 1 cable (ref. to DEB9009 electrical diagram) which connects the J1-CAN connector on the 43SIB01 interface board with the CAN-2 connector on the CPU and the J4 connector of the 43SPB01 Power board.

E208 Motors' Power still ON – No Safe condition

For safety reasons, when the front cover is opened or Safety_CHAN-A – Safety_CHAN-B input on D-SUB25 I/O SIGNALS connector are open the voltage supply to carriage, ribbon rewind and ribbon release motors and the voltage supply to servomotor are immediately deactivated. In the above conditions the software checks if the motors power supply voltage and the is really felt down.

In case a voltage is still detected this error appears.

This error means a no safe condition, because with cover open or safety inputs open the motors are not completely deactivated. The relay and the power supply circuit on the Power Board must be checked or the Power Board replaced.

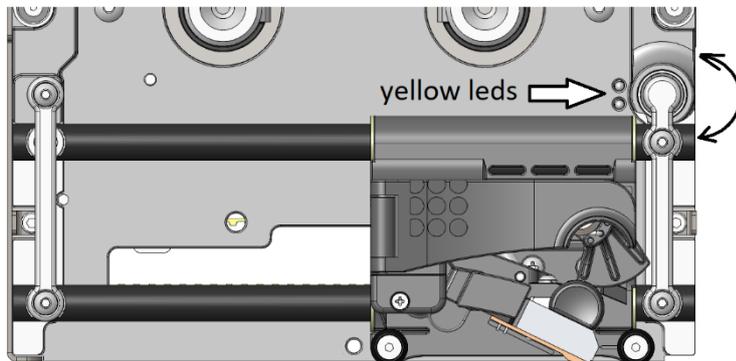


E209 Ribbon Encoder problem

-Check the ribbon passage.

-Clean the rubber surface of the ribbon roll encoder.

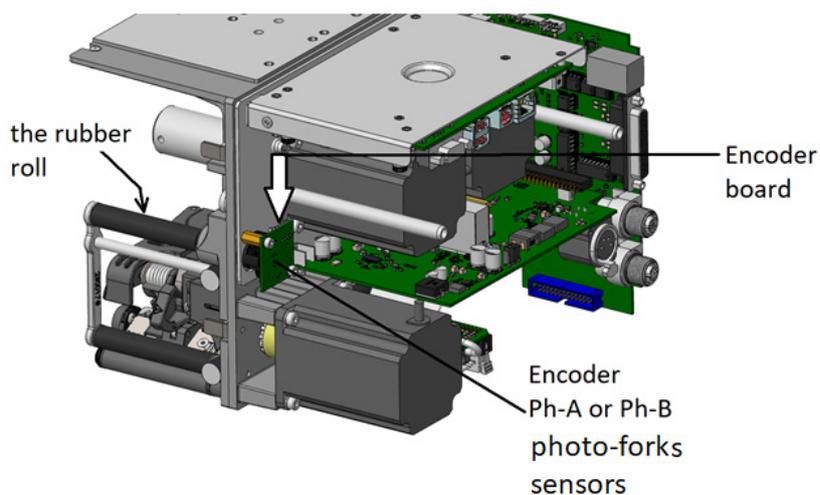
Rotate the encoder manually and check if the yellow leds lit up during rotation.



The led 1 – led 2 sequence during rubber roll rotation must be:

“00, 01, 11, 10” four times every 360 degrees of roll turn.

There could be a hardware problem on the encoder board or on the 45CV867/1 cable that connect the Encoder Board to J9 connector of the Interface Board.

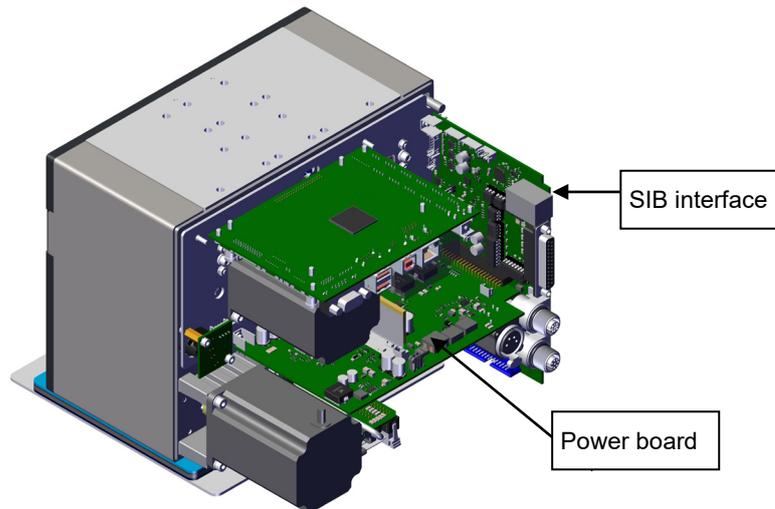


E210 Canbus communication fault with SIB board

Check the connections relating to the 45CV882/1 cable which connects the J1-CAN connector on the 43SIB01 interface board, the CAN-PWR connector on the CPU board and the J4 connector of the 43SPB01 Power board.

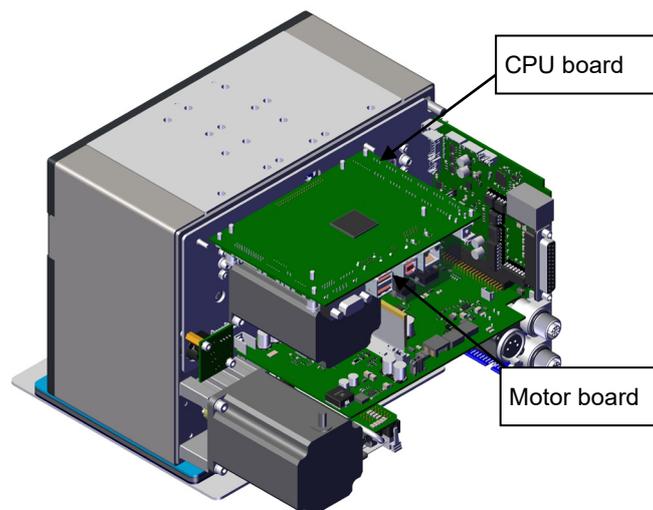
Ref. to DEB9009 electrical block diagram for XTO2i and to DEC1018 electrical block diagram for XTO2i.nn for internal connection.

Check also that the KV11 processor on the SIB interface board is running (the yellow led is blinking)



E211 Canbus communication fault with BLDC controller board

Check the connection between the CPU and the Motor Board (the Motor Board is screwed to the CPU by means of 4 screws; check they are well screwed).



E212 Function not yet implemented

This error appears when the function selected is not implemented.

Cases:

- 1) Check if the .PAF file the parameter Pitch type = "Fixed from printer"
- 2) If the "Machine Type" set is not implemented.

E213 Print Head 1 Temperature Sensor Communication Fault

There is no communication with the Print Head temperature sensor on carriage 1

The reasons could be:

- the sensor on the Print Head is damaged: try to replace the print head.
- the communication bus between the sensor and the CPU is not working: try to check the connection between the carriage and the interface board (flat cable insertion on the boards)

E214 Print Head 2 Temperature Sensor Communication Fault

There is no communication with the Print Head temperature sensor on carriage 2

The reasons could be:

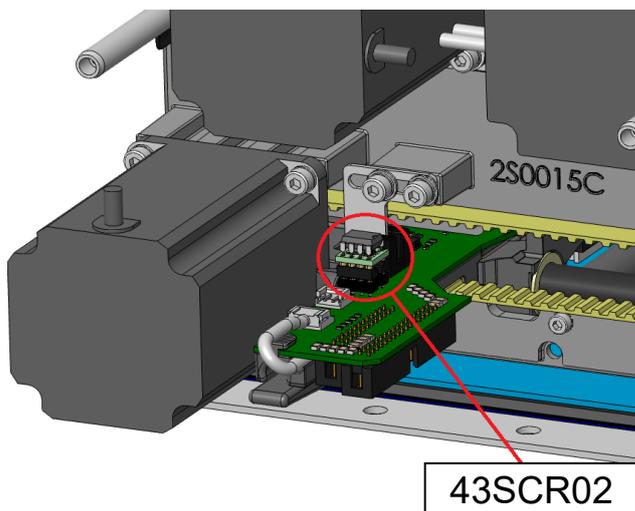
- the sensor on the Print Head 2 is damaged: try to replace the print head 2.
- the communication bus between the sensor and the CPU is not working: try to check the connection between the carriage and the interface board (flat cable insertion on the boards)

Note: the XTO22i with 2 x 53 mm print heads is not still implemented in the 2.0 release.

E215 Carriage Crypto Memory Communication Fault

Check the 43SCR02 board presence and correct insertion on the Carriage board.

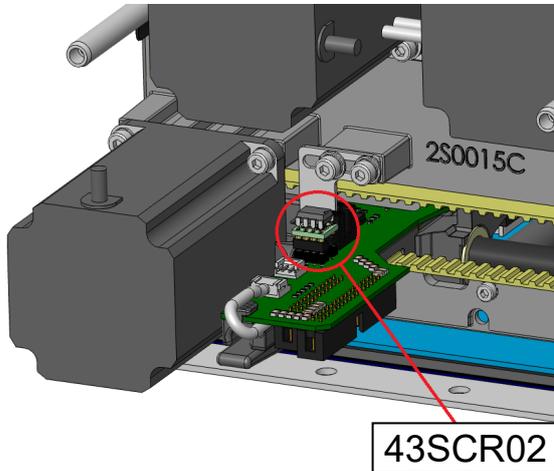
Warning: if the 43SCR02 board is inserted opposite in the 8 dip socket, it will be irreparably damaged and it must be replaced.



E216 Carriage Eeprom Memory Communication Fault

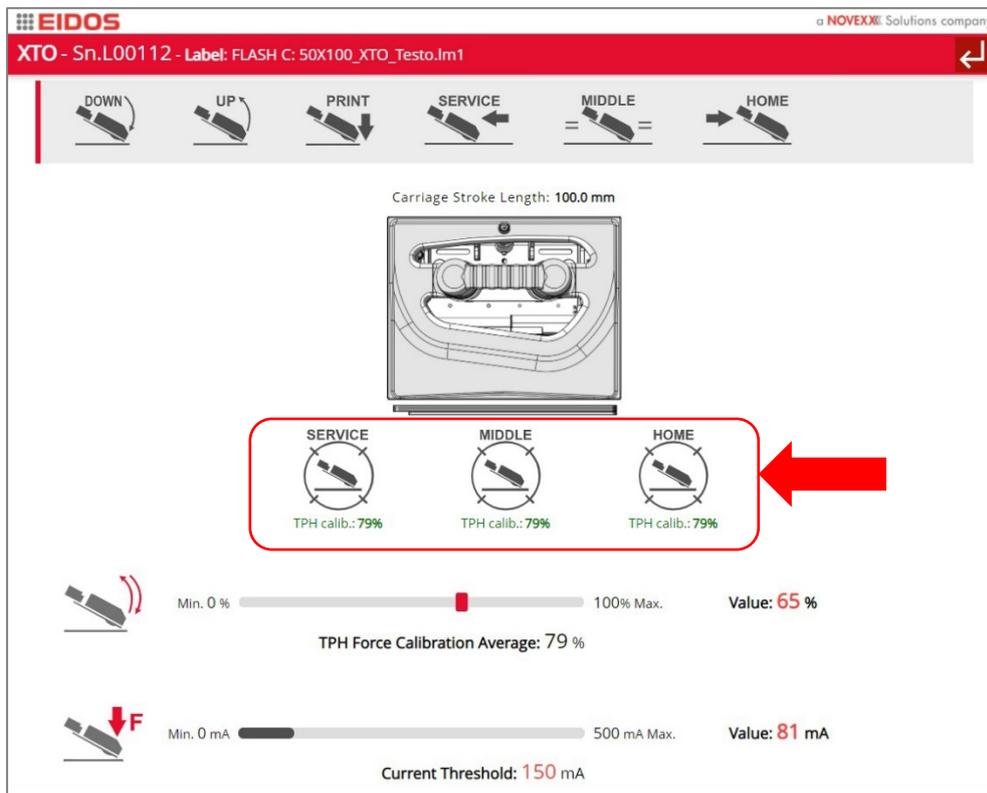
The Eeprom memory does not work properly. Change the 43SCR02 board.

Warning: if the 43SCR02 board is inserted opposite in the 8 dip socket, it will be irreparably damaged and it must be replaced.



E217 Ribbon dragged by packaging film

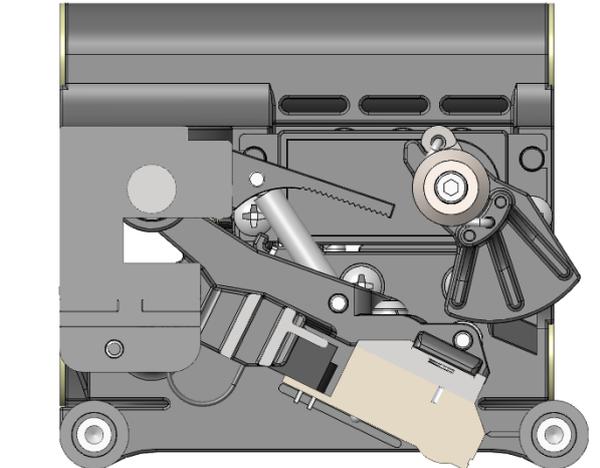
This error happens when the ribbon release coil rotates when the printer is not in cycle. It means that the ribbon is fed by the packaging film during movement in the next position. Check the print-head's calibration or the distance between the print head and the print plate.



The TPH calibration function detects the distance between the print head and the rubber plate when the carriage and set the best advised TPH FORCE value in term of head pressure on film. The advised values as calibration results are in the range 74 – 80% (best for us is 75-76%).

E218 TPH servomotor current too much high

This error appears when the servomotor current absorbed is $> 3A$ for 6 seconds. Open the cover and rotate manually the servo cam in the direction to push down the print head. Try to rotate manually the servo cam in alle the rotation range to check if the gears are locked.



The servomotor moves the print head toward the print plate or print roller by rotating a cam that has a specific profile. A spring returns back the head to home.

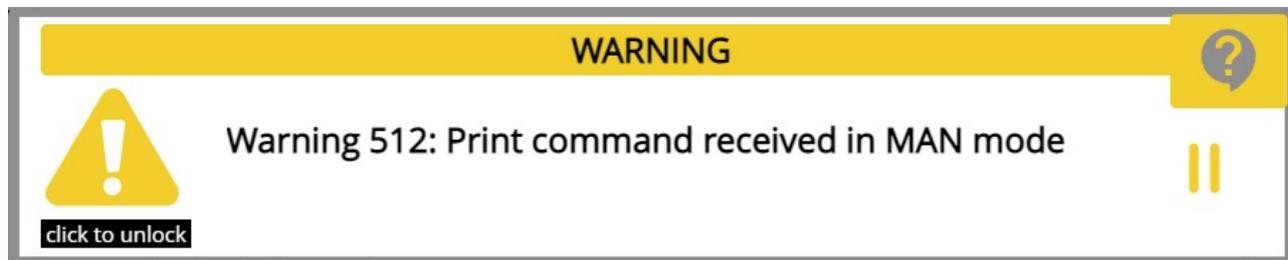
The cam can assume different angle depending by the servomotor % of rotation in a range between 0 to 100%.

E219 The label contains operator data

It cannot be loaded from the digital input label selection with Page I/O recall function.

WARNINGS:

Warnings inform the operator about the occurrence of a certain event at the printer. The message is displayed until it is unlocked by the user. If in READY status the printer continues operating without intervention from the user.

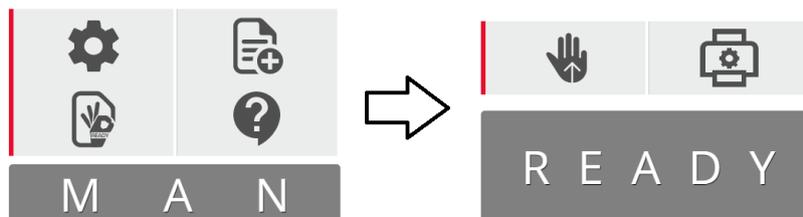


W512 Print command received in MAN mode

This warning appears when an input STA print command or an ethernet (CSE or ZPL) print command has been received when the printer is in MANUAL mode.

The print commands received in MAN mode are not executed.

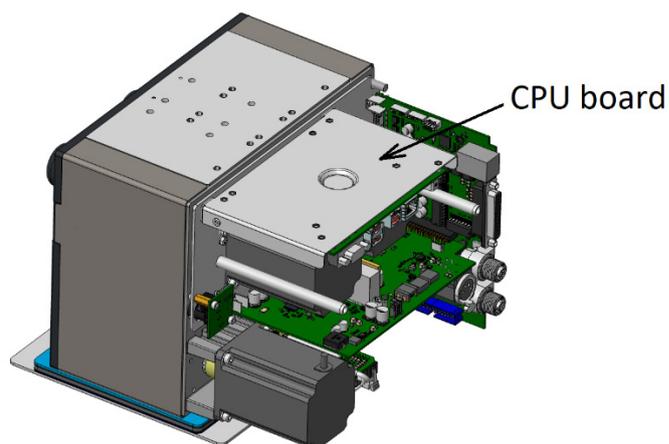
Set READY Mode and retry.



W560 Flash memory usage is more than 75%

It is possible that the CPU flash memory is too much high in the time.

This warning appears when the memory usage is over 75%, then it is necessary to replace in a short time the CPU board on printer.



W561 To enable the use of passwords, the first user must be level 2

It is possible to manage various Users for different levels of printer parameters access (Level 1, Level 2, Level3). It is possible to create a new Users for “Level 0” and “Level 1” only if an higher user level (ex. “Level 2”) is previously configured.

EIDOS
XTO - Sn.L00112
Printer Parameters

- Level 0
- Level 1
- Level 2
- Level 3

USER

LOGOUT

EIDOS a NOVEX Solutions company
XTO - Sn.L00112

Passwords Setting **NEW**

Username	Level	View Only	
John	2		

W562 Printhead too much distant from print plate

This warning appears when after a TPH calibration the detected “TPH force calibration” value is over 80%. It means that the print rubber plate (XTOi) or the print rubber roll (XTOc) is too much far from print head dot line. The distance between print head and print rubber plate or print rubber roller must be reduced. Optimal is to get a Calibration value in the range 74 – 76%, with distance “d” around 1 - 1.5 mm.

TPH

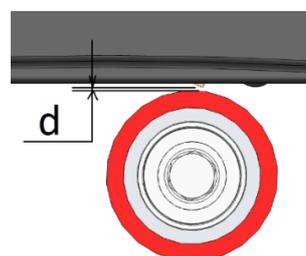
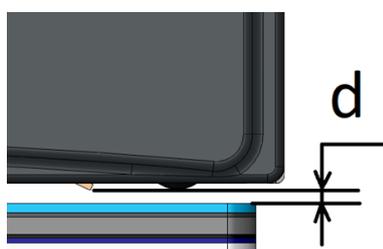
DOWN UP PRINT SERVICE MIDDLE HOME

Carriage Stroke Length: 100.0 mm

SERVICE MIDDLE HOME
TPH calib.: 79% TPH calib.: 79% TPH calib.: 79%

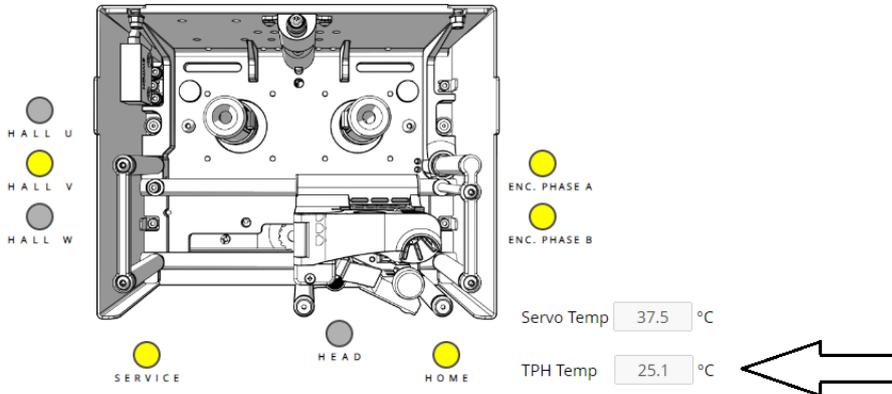
TPH Force Calibration Average: 79 %
Value: 65 % **> 80%**

Current Threshold: 150 mA
Value: 81 mA



W563 Printhead 1 overheating

This warning appears when the printer head temperature detected is over than 60°C. Check the printhead temperature in the “Diagnostic” page. It is advised to reduce the print rate or the % of black areas to be printed (negative areas, logos, etc).

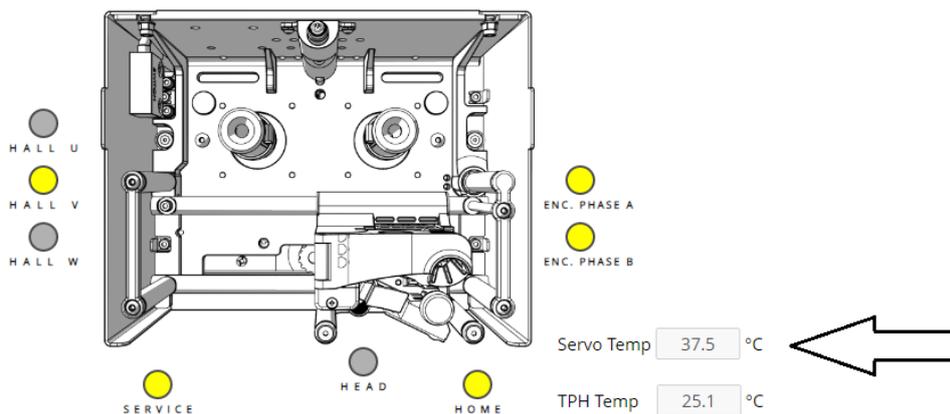


W564 Printhead 2 overheating

This warning appears when the printer head temperature detected is over than 80°C. This error appears when the printer head 2 temperature on XTO22ix detected is over than 85°C. Check the printhead temperature in the “Diagnostic” page. It is advised to reduce the print rate or the % of black areas to be printed (negative areas, logos, etc.)

W565 Servo 1 overheating

This warning appears when the temperature detected of Servomotor that move the print head is over than 60°C (this threshold has been set to 75°C form release 2.0.xxxx). Check the servomotor temperature in the “Diagnostic” page. Open the front cover and check manually if the servo shaft rotation is difficult. When the XTO printer is installed upside down the servo temperature detected can be 7-10°C higher than when the printer is in normal position.



W566 Servo 2 overheating

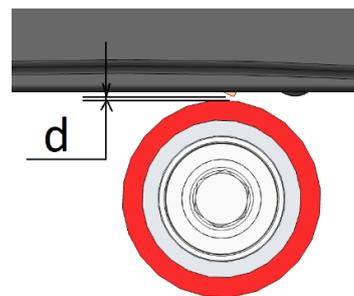
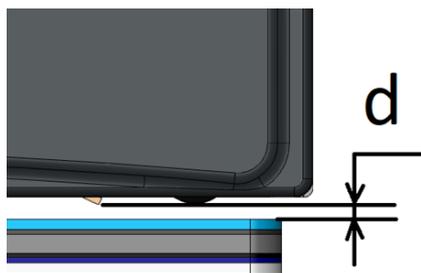
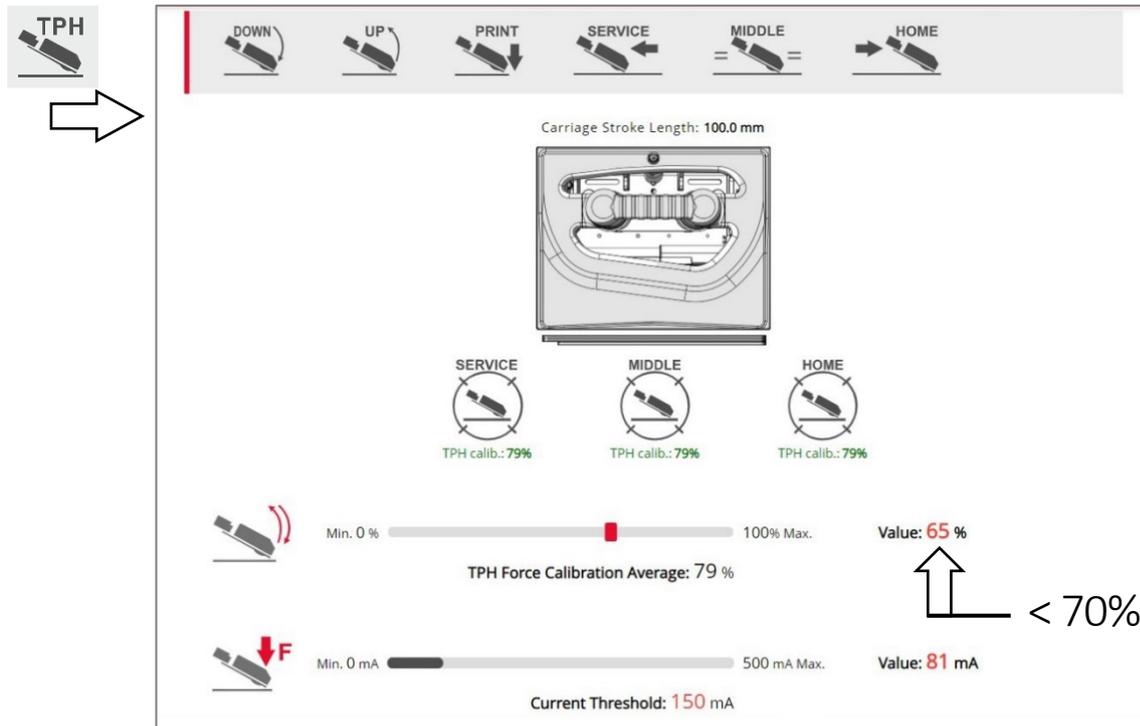
This warning appears when the temperature detected of Servomotor that move the print head 2 on XTO22i is over than 75°C. Check the servomotor temperature in the “Diagnostic” page. Same considerations as W565.

W567 Printhead too much close to print plate or roller

This warning appears when after a TPH calibration the detected “TPH force calibration” value is under 70%.

It means that the print rubber plate (XTOi) or the print rubber roll (XTOc) is too close from print head dot line. The distance between print head and print rubber plate or print rubber roller must be increased.

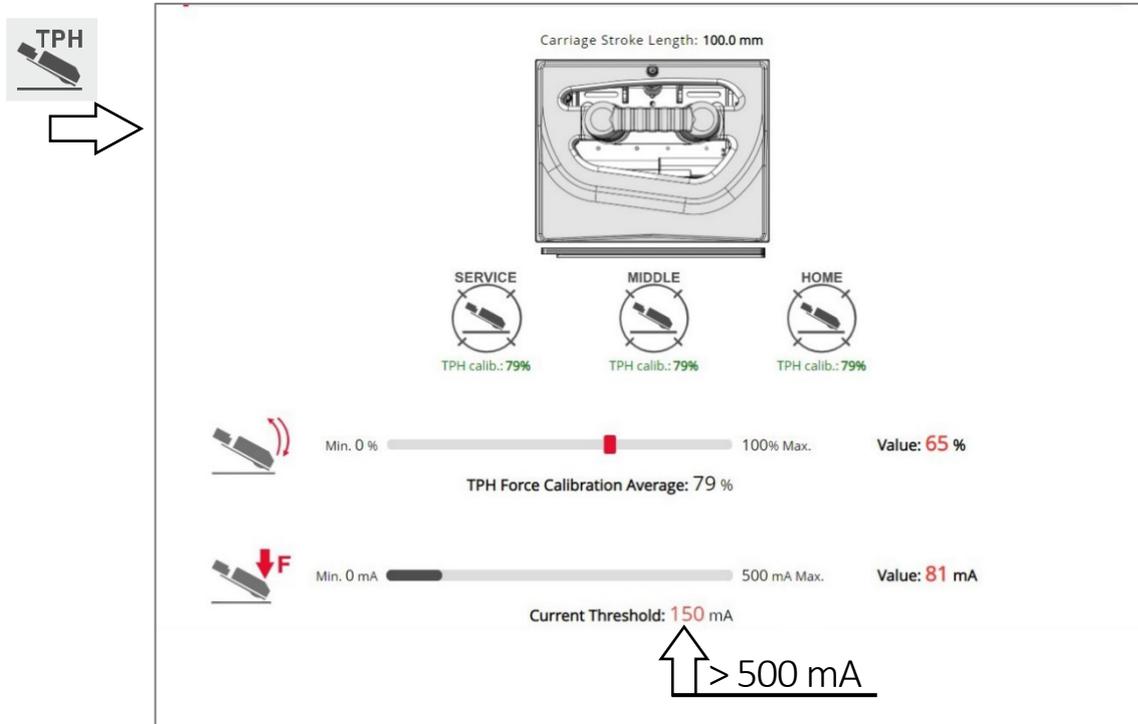
Optimal is to get a Calibration value in the range 74 – 76%, with distance “d” around 1 – 1.5 mm.



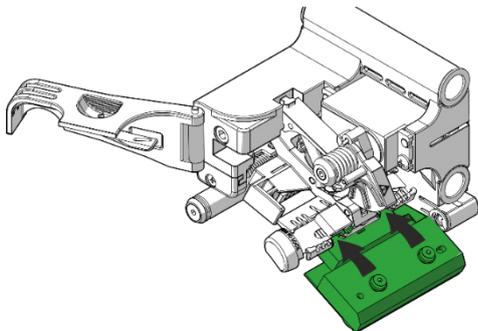
W568 TPH servomotor current too much high

This warning appears when after a TPH calibration the detected “Current Threshold” value is out of range (greater than 500 mA).

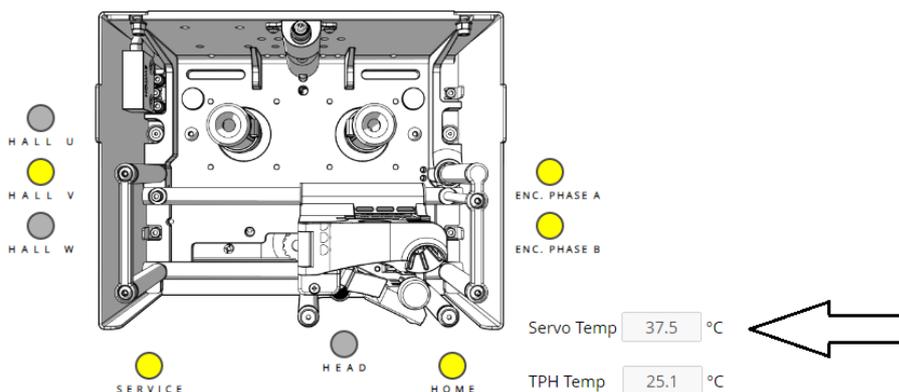
It means that the print rubber plate (XTOi) or the print rubber roll (XTOc) is too close from print head dot line. The distance between print head and print rubber plate or print rubber roller must be increased.



Check that the print head is mounted correctly.



Check the servomotor temperature in the “Diagnostic” page.



W569 Paf parameters out of range or file corrupted

The packaging format file (.PAF) parameters contains data out of range or it is corrupted. Check the .PAF file with a text editor or make a new XTO packaging format parameters configuration.

`^pa,b,cccc,dddd,eeee,ffff,gggg,h,ii,qq,rrrr,ss,p001,p002,.....,p024CrLf`

a = 1 Multipitch positioner disabled because the function is not implemented

b = number of positions (1,2,3,4)

cccc = displacement from home positioner (mm)

dddd = pitch 1 (mm)

eeee = pitch 2 (mm)

ffff = pitch 3 (mm)

gggg = Print Home Shift (1/10 mm)

h: pitch type

1 = fixed from label

2 = Variable from Printer

3 = Variable from label (function not implemented on XTO; the software considers 3 = 2)

ii: Number of print (1,...99)

qq: Repetition number (00,...,99)

rrrr: Repetition pitch (1/10mm)

ss: print number every cycle (00,99)

p001: Pitch 1

...

p024: Pitch 24

Notes:

- a) The .PAF file can contain a truncated string:

Examples:

if h = 1:

`^pa,b,cccc,dddd,eeee,ffff,gggg,hCrLf`

if h = 2

`^pa,b,cccc,dddd,eeee,ffff,gggg,h,ii,qq,rrrr,ss,p001,p002,.....,p024CrLf`

W570 Missing indexed operator data

In the layout .LM1 label an operator data index is missed.

The operator data indexes on the label must start from « 00 » and the maximum is « 47 ».

Check the operator data indexes in the label .LM1 layout using EASYCODE.