11_M779_18178_Register.xls
Register overview

Nr.	Register step	126	129	128	127	126	125	124	123	122	121	120	119	118	117	116	115	114	113	112	111	110	109	108	107	106	105	104	103	102	101	100	99	98	97	96	95	94	93	92	91	90	89	88	87	86	85	84	83	82	81	80	79	78	77	76	75	74	73	72	71
111	**Area Film**																												X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X
112	**Area Blank**																												X	X	X	X	X	X	X	X																											
114	**Area Infeed 1**																														X	X	X	X	X																											
115	**Area Infeed 2**																														X	X	X	X	X																											
117	**Area Packet**																X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X																																	
119	**Area Elevator**	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X																																																		
1	Teartape detection																													X	X	X																															
2	Splice																																	X	X																											
3	Registration mark film/paper unit																													X	X	X	X																											
4	Papier not glued																																																															
5	Registration mark paper gluing																																																												
6	Tear tape break																																									X	X	X	X	X																		
7	Date coding left/right																																				X	X	X																								
8	S teartape detection																													X	X	X																															
9	Registration mark width film/paper unit																													X	X	X	X																													
10	Registration mark width paper gluing																																																												
11	Manufacturer's joint/splice																																	X	X																											
12	S splice sensor film reject																										X	X	X	X	X	X	X																													
13																																																																
14	Refer film/paper unit																													X	X	X	X	X	X	X	X	X	X																									
15	Date coding check film/paper left																																	X	X	X	X	X	X																							
16	Date coding check film/paper right																																	X	X	X	X	X	X																							
17	Date coding film/paper																																				X	X	X																							
18																																																															
19																																																															
20	Blank not removed by suction																																X																													
21	Blank reversed																																X																													
22																																																															
23	Carton glue dried																										X	X	X	X	X																															
24	Blank in front of turret 1																															X																													
25	Glue jet monitoring carton blank gluing																															X	X																													
26	Infeed detection track 1																																X																													
27	Infeed detection track 2																																X																													
28	Side track turret 1																												X																																	
29	Bottom folder turret 1																														X																													
30	Top folder turret 1																														X																													
31	Lower track guide infeed																														X																													
32	Upper track guide infeed																														X																													
33	Infeed pusher track 1																																X																													
34	Infeed pusher track 2																																X																													
35	Infeed pusher turret 1																														X																													
36	Quantity check																														X																													
37	Packet collation lifter disengaged																														X																													
38	Turret heater																											X																																	
39	Blank in front of carton gluing																																X																													
40	Double carton blank																																	X																													
41	Handwheel through carton gluing																														X	X																													
42	Barcode scanner in turret left																										X																																			
43	Clutch stage 2 disengaged																										X																																			
44	Discharge track disengaged																	X	X	X	X	X	X	X	X	X	X																																					
45	Film/paper in turret 2 left																											X																																			
46	Film/paper in turret 2 right																											X																																		
47	S film/paper in turret 2 left																										X																																		
48	S film/paper in turret 2 right																										X																																		
49	Bottom folder turret 2																												X																																	
50	Film/paper in folding guide left																								X																																			
51	Film/paper in folding guide right																								X																																			
52	S film/paper in folding guide left																								X																																			
53	S film/paper in folding guide right																								X																																			
54	Print detection carton left																																X																													
55	Print detection carton right																																X																													
56	Side seam detection left																			X																																										
57	Side seam detection right																			X																																									
58																																																																
59																																																															
60																																																															
66																																																															
67	Clearing infeed																																		X																												
68	Unexpected packets in infeed																																X																												
69	Fill infeed automatically																																X	X																											
70	Packets scratched in the infeed belt																																	X																											
71	Bad packs upstream machine																																	X																											
72	Packet dried discharge track																					X	X																																						
73	Packet dried elevator shrinking station 1								X				X																																																			
74																																																															
75																																																														
81																																																														
82																																																														
83	Quality reject						X																																																							
84	Long seam detection													X																																															
85																																																														
96																																																														
97																																																														
98	Blank removed																																X																												
99	Continous blank suction																																X																												
100																																																														
101	Main switch on																	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X
102																																																													
103																																																														
104	Brand change packet reject																																																												
105																																																														

Note:
This is a schematic representation of the shift register.
The representation is no exact illustration of the machine program.

Hinweis:
Dieses ist eine schematische Darstellung der Register.
Die Darstellung ist kein 1:1 Abbild des Maschinenprogramms.