

D.4

D.4 ERROR CODES

| Error message | Cause | Elimination |
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| Error 01: Seam program not loaded | Current seam program not loaded; possibly sections and parameters have not been entered or the seam program was deleted | Enter parameters manually or take them over from other seam programs, copy from fixed programs |
| Error 02: Seam not activated | Current seam number not activated | Press key 5 to activate seam program |
| Error 04: Wrong clamp | Clamp is not at positioning station | Check Initiator ES02 |
| Error 05: I/O communication error | Error when transferring data between control unit and I/O module | Check the connection cable; if necessary replace control unit, I/O module |
| Error 08: Clamp at stop | Reverse feed lock does not become bright | Check limit initiator S02; test program input test |
| Error 09: Main clamp does not move when switched | Main clamp is blocked at loading position | Check limit initiator S02; test program input test; check smooth running of clamp |

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| Error 14: Wrong insertion / seam length | Seam length longer than max. possible seam | Positioning point or seam length not programmed correctly |
| Error 18: Folder not lowered | Folder not or too late in loading position | Check S07 input; check smooth running of cylinder Y06; check air pressure |

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| Error 29: No impulses from sewing motor | Sewing motor does not start | Check sewing motor and synchronisation; check connection board to sewing motor |
| Error 30: Sewing motor is too quick | When trimming thread sewing motor has not reached trimming speed | Check sewing motor control unit |
| Error 32: No thread trimmer position | Cutting position for thread trimming not reached | Reduce thread trimmer speed; check sewing motor control unit |
| Error 33: Sewing motor does not stop | Sewing motor does not stop in position | Reduce speed thread trimmer; check sewing motor control unit |
| Error 34: Needle not raised | Needle is not in "raise take-up lever" position | I Check Efka initiator; check sewing head for binding; reload motor parameters |
| Error 35: Thread breakage | Needle thread monitor reacts | |

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| Error 49: Error AT I/O | Communication error | Hardware error; transfer error |
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