CAN MAN®
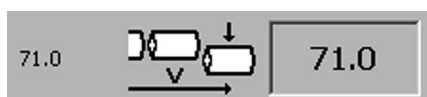
FAQ_X1/X6_038 – Error message: "Error cylinder eject station"!

Possible Cause:

1. Check air supply for the cylinder.
2. Eject cylinder must push the canbodies in the center, the can must move vertically away from eject cylinder.
3. Second light barrier is always ON. Sensor dirty or bad adjustment. LED on light barrier must be ON without can, OFF if a can is detected.
4. Control wiring of first and second light barrier according electrical diagram.
5. Make sure the faulty can is really ejected, means does not touch the edge of the bin and jumps back.
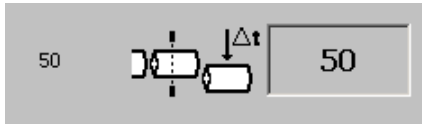   => Use a fixed channel underneath the eject station, instead of a mobile bin!

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6. Adjustment of the light barrier distance to eject cylinder might be wrong. Refer also to chapter 5.9.2.
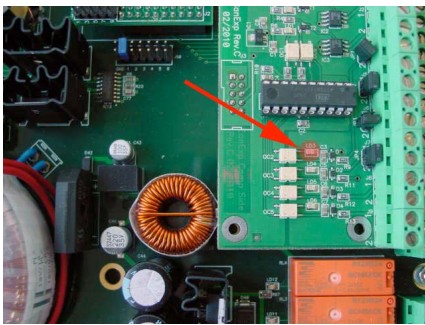

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7. Wrong adjustment of the transport belt speed.

NOTE:
The ejected can should whether touch the can before nor the following.

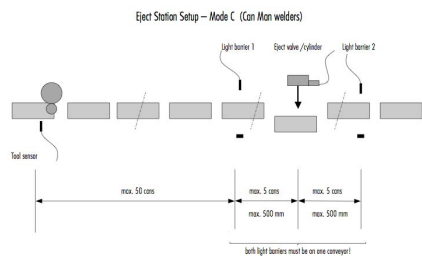8. Eject pulse cylinder has to fit to production speed:

Recommendation:
150 - 200 ms for < 100 cpm
100 - 150 ms for 100 - 200 cpm
 80 - 100 ms for 200 - 400 cpm
 50 – 80 ms for 400 - 600 cpm

9. Place a canbody between the second light barrier and check the LED „LD3" on the eject print (inside the Pacemaker). Must be „ON".
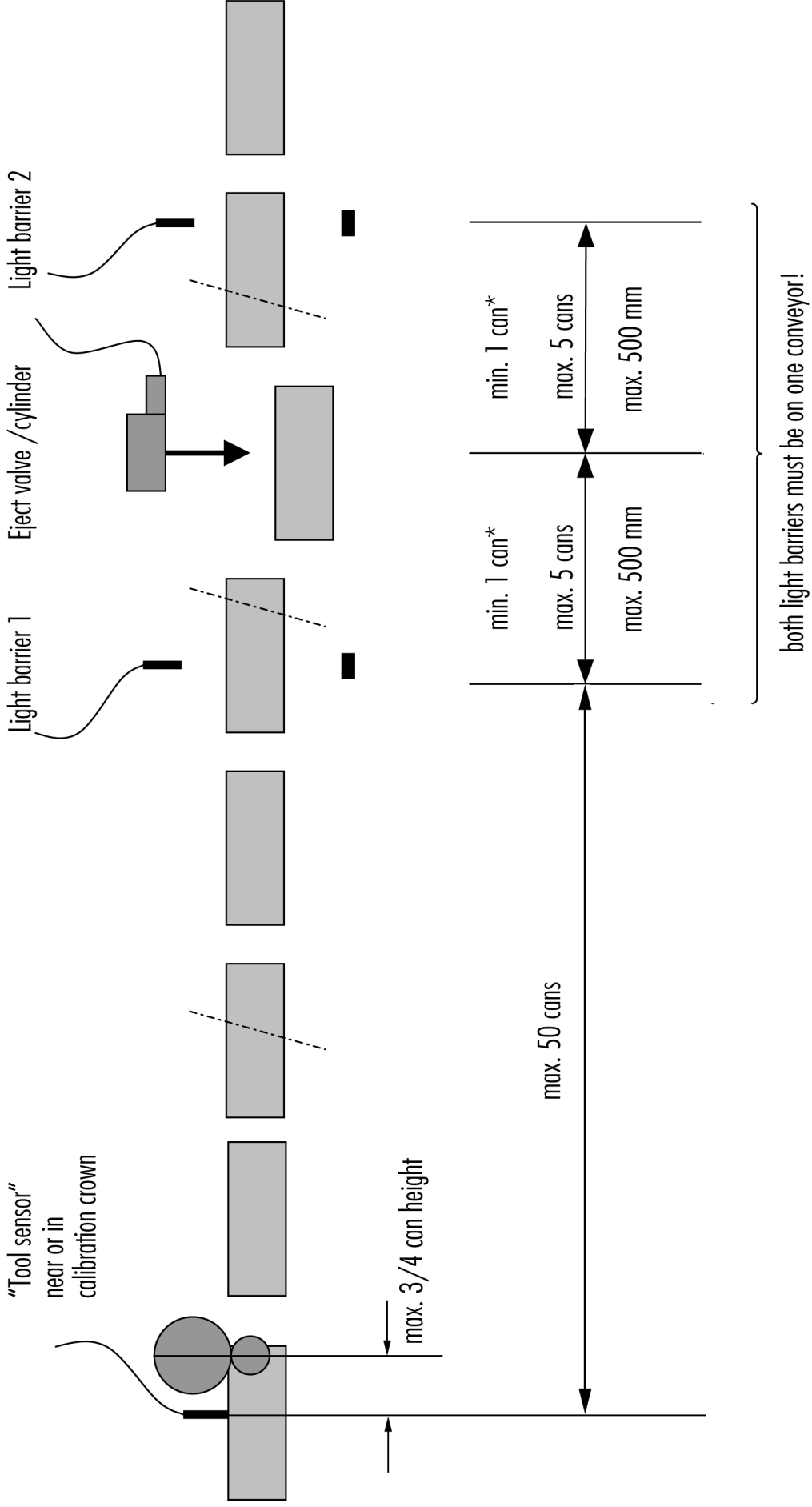

10. The autoreset needs to be "OFF". Therefore the can memory will not be reset automatically.
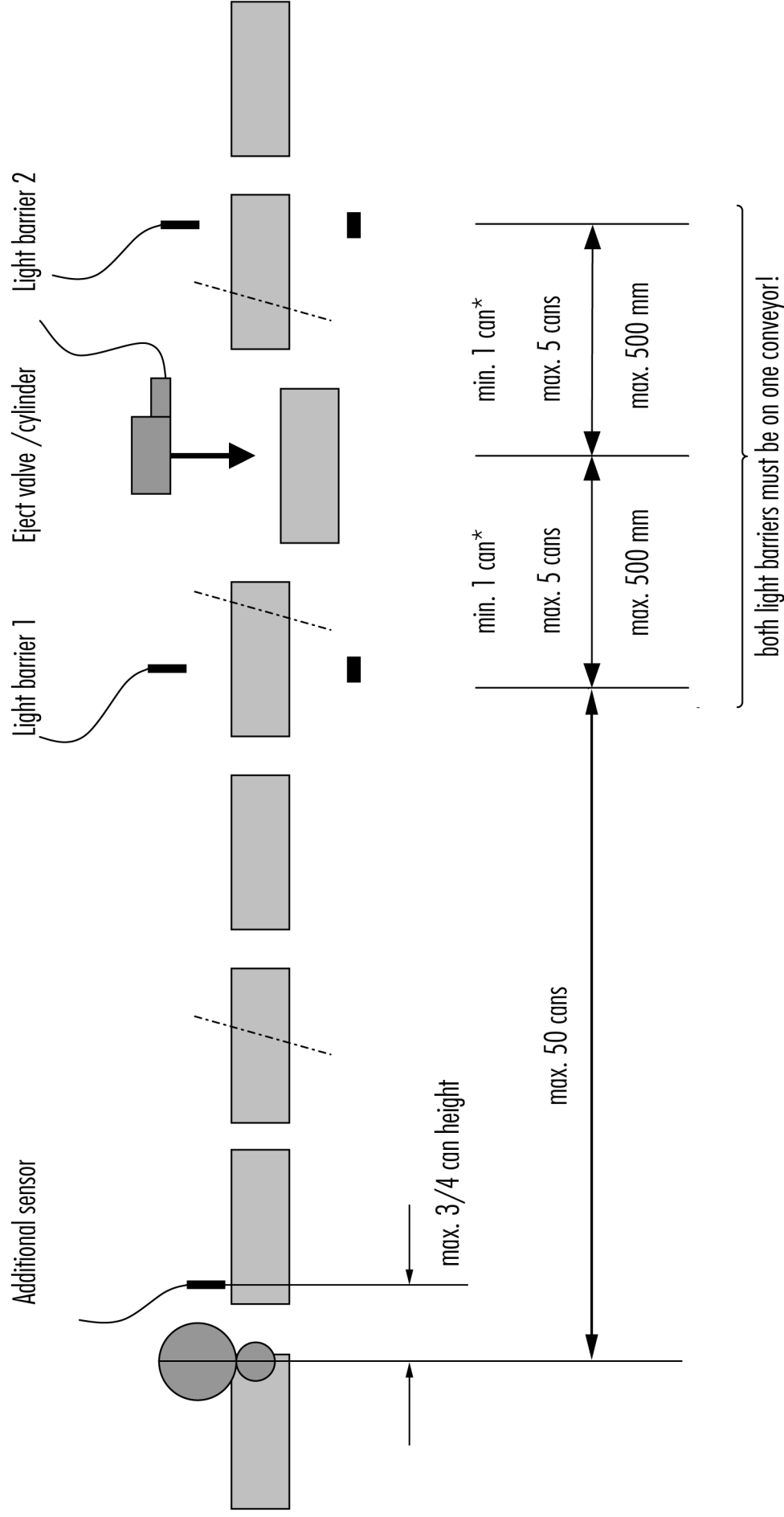

11. Check, if your hardware parameters are set correctly, according to one of the three layouts.
=> See layouts below!

Eject Station Setup – Mode A

"Tool sensor"
near or in
calibration crown

Light barrier 1

Eject valve /cylinder

Light barrier 2

max. 3/4 can height

max. 50 cans

min. 1 can*
max. 5 cans
max. 500 mm

min. 1 can*
max. 5 cans
max. 500 mm

both light barriers must be on one conveyor!

* NOTE: The minimum distance should be at least one canbody length of the longest produced canbody.

Eject Station Setup – Mode B

Light barrier 2

Light barrier 1

Eject valve / cylinder

Additional sensor

max. 3/4 can height

max. 50 cans

min. 1 can*

max. 5 cans

max. 500 mm

min. 1 can*

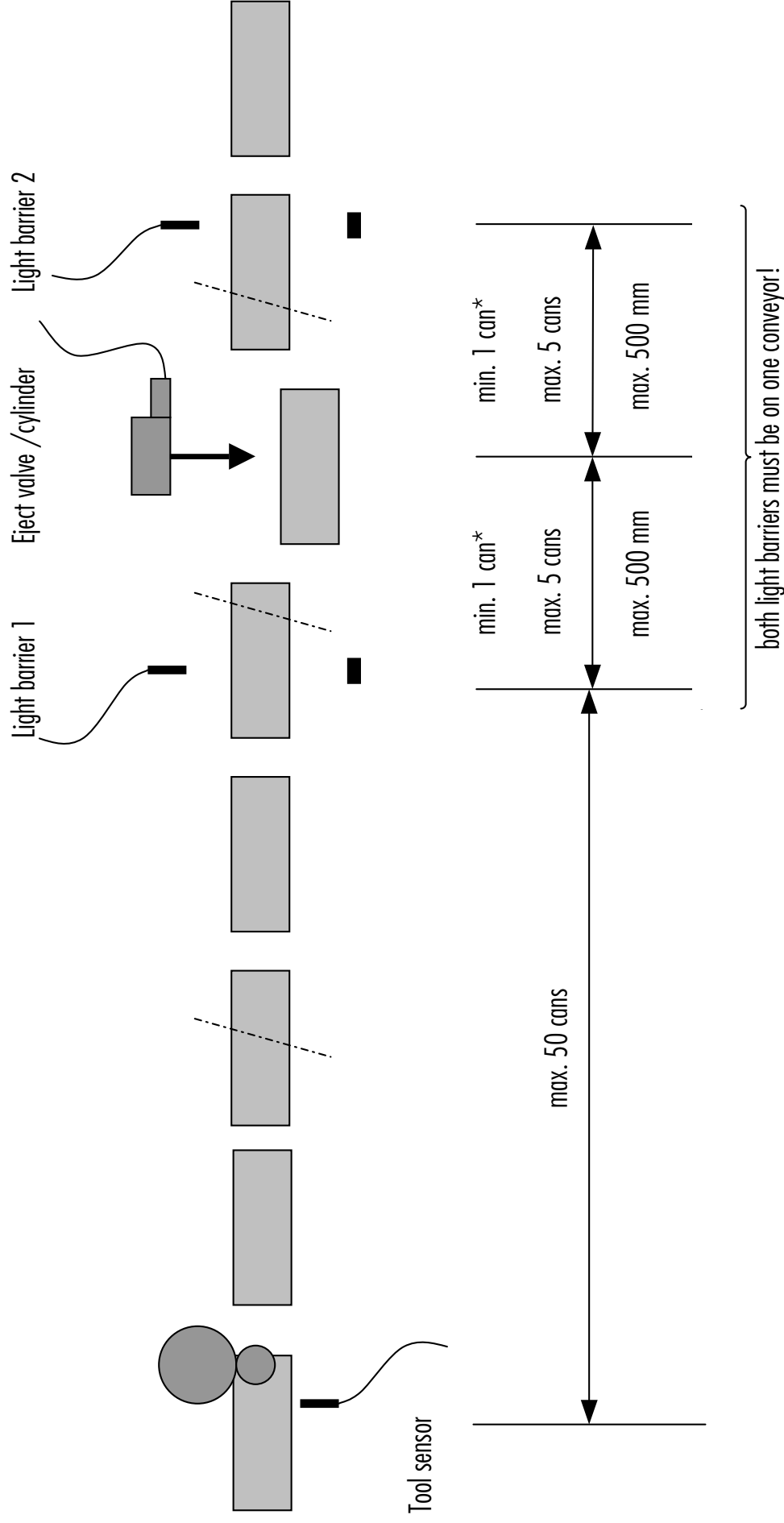max. 5 cans

max. 500 mm

both light barriers must be on one conveyor!

* NOTE: The minimum distance should be at least one canbody length of the longest produced canbody.

Eject Station Setup – Mode C (Can Man welders)

Light barrier 2

Light barrier 1

Eject valve /cylinder

Tool sensor

min. 1 can*
max. 5 cans
max. 500 mm

min. 1 can*
max. 5 cans
max. 500 mm

both light barriers must be on one conveyor!

max. 50 cans

* NOTE: The minimum distance should be at least one canbody length of the longest produced canbody.