| Sr. No. | Operation | Condition. Procedure | Consequence | Remark |
| :-- | :-- | :-- | :-- | :-- |
| 1. | Shipper Low Level detect | Remove the all shippers from the magazine | The Alarm will generated and displayed on the HMI/IPC and Machine will be Hold condition | |
| 2. | Cylinder Extend Alarm | Remove the reed from Extend end then Alarm will generated | The Alarm will generated and displayed on the HMI/IPC and Machine will be Hold condition | |
| 3. | Infeed Conveyor Motor Forward Feedback OFF Alarm | Go to Control panel trip MCB MO2301 then Alarm will Generated | The Alarm will generated and displayed on the HMI/IPC and Machine will be Hold condition | |
| 4. | ES1001 E-Stop Channel 2 Input Test Pulse error | Press Estop ES1001 alarm will generated | The Alarm will generated and displayed on the HMI/IPC and Machine will be aborted condition | |
| 5. | SC6401 Collation Servo 1 Motion servo ON Reset Control Fault | Go to Control panel trip MCB SC6501 then Alarm will Generated | The Alarm will generated and displayed on the HMI/IPC and Machine will be Hold condition | |
| 6. | SC6401 Collation Servo 1 Safe Torque OFF Fault | Go to Control panel Remove 24vdc Safety Red Supply on SC6501 Drive alarm will generated | The Alarm will generated and displayed on the HMI/IPC and Machine will be Hold condition | |
| 7. | Palletizer Infeed Conveyor Full alarm | Shippers are full on the Palletizer infeed conveyor | The Alarm will generated and displayed on the HMI/IPC and Machine will be Hold condition | |
| 8. | Accepted Shipper's Pallet Misplacement Alarm | The pallet is not placed properly in the pallet locator. | The Alarm will generated and displayed on the HMI/IPC and Machine will be Hold condition | |