

7.0 Troubleshooting

7.1 Instructions

WARNING: Only trained factory technicians must perform troubleshooting to avoid any damages to the machine.

Always look **FIRST** at the Operator Interface Panel (HMI) when the machine stops for any reason. Check the HMI for alarm messages. The **main alarm history list** will show what caused the machine to stop.

7.2 General Precautions

Follow these instructions carefully in case the following troubleshooting is a must:

Cylinder Didn't Move

Check the solenoid valve:

- If the **Solenoid LED is ON** but the valve did not shift, then **turn OFF the main power or main air supply to the machine by sliding the manual air valve on the FRL** and change the solenoid valve (solenoid spool may be dirty).
- If the **LED is OFF** check the **PLC output**. (You may need a computer to check the PLC program to verify internal program output).

Cylinder Jam

Cylinder did not travel all the way:

- **Do not use any foreign objects to clear the jam and don't reach by hand while the machine is in run mode.** Push E-Stop Button.
- Make sure the main air solenoid dumped the air to the cylinders before clearing the jam (cylinders may be still pressurized).
- If the cylinders are free of air clear the jam and release the E-Stop. Air will slowly energize the cylinder.

Cylinder Sensor is Off

The Cylinder has traveled all the way but the sensor is not ON:

- **Do not touch or move any sensor while the machine is in run mode and cylinders are pressurized.** Push E-Stop Button to disconnect the air to the cylinders.
- Use a magnet to verify if the sensor is working by changing the magnetic field of the sensor (Sensor LED should energize).

- If the sensor is working, position the sensor in the right place and release the E-Stop. Air will slowly energize the cylinders.
- Check the power supply for that powers all the sensors. If the sensor is bad, replace the sensor with an exact duplicate one. If replacing the sensor does not fix the problem **contact ONEX Automation.**