

Troubleshooting

This chapter describes the possible causes of troubles you may encounter and the actions to be taken against them. Check the following troubleshooting table before requesting our service. When a problem cannot be solved even after taking the actions described here, contact the nearest our service division. (see back page) and request service.



Operate the stop of the equipment before working in the check. And, after the confirmation in the full stop of the equipment. Check after making a breaker "OFF" and heating part temperature's falling to the temperature that doesn't get a burn. And refer to Chapter 6. "Maintenance and Check" about the filter removal method.

The Convey blower does not rotate.		
Check point	Remedy	Note
Confirm whether or not the indicator of the controller lights up.	Set the primary power and a front power breaker in ON. Press <input type="button" value="CONTROL ON"/> switch.	When the following disposal doesn't correct dispose by CHAPTER8. [The indicator with the PV value of the controller doesn't display the condition of "ON" in primary power].
Confirm whether or not the Feed to <input type="button" value="No,1"/> indicator of the controller lights up.	When not lighting up, press Feed to <input type="button" value="No,1"/> switch. When the indicator doesn't light up even if it pushes the switch, exchange a controller.	Inspection and replacement by persons who have not enough knowledge about electricity may cause failure and danger. Ask our service department to inspect and replace.
Open the door of control panel and are there not dissolving and consumption of the magnet point of the electromagnetic switch unit, and At the time of power "ON", check the opening and shutting motion for the magnet.	When the dissolving, the consumption condition, and the normal operation are impossible, exchange the electromagnetic switch unit.	<u>Tolerance: 2,000,000 times</u>
Confirm whether or not the malfunction character of 『E3』 isn't displayed at the controller indicator.	In the cause of the over load of blower, after repair, open the control panel door and press the reset button of thermal relay.	As for the overloaded cause of the blower, refer to CHAPTER8. [The blower does overloaded operation and the thermal relay trips].

The Convey blower does not rotate.		
Check point	Remedy	Note
Confirm whether or not the limit switch of jet clone at the end of convey doesn't become "ON" in spite of not being in the full material condition.	At the time of "ON", refer to the full signal adjustment of jet clone-type of chapter 6 "Maintenance and Check " and adjust the limit switch.	When a right adjustment isn't performed, the convey stop becomes impossible in the full material condition. Therefore, be careful.
Confirm the sensitivity of the level gage of the end convey hopper.	Refer to the sensitivity adjustment for paddle-type level switch and proximity switch of chapter 6 "Maintenance and Check" and adjust the sensitivity for level switch.	When a right adjustment isn't performed, the convey stop becomes impossible in the full material condition. Therefore, be careful.

The dry blower does not rotate.		
Check point	Remedy	Note
Confirm whether or not the indicator of the controller lights up.	Set the primary power and the front power breaker in ON.	When the following disposal doesn't correct dispose by CHAPTER8. [The indicator with the PV value of the controller doesn't display the condition of "ON" in primary power].
Confirm whether or not the RUN/STOP indicator of the controller lights up.	When not lighting up, press RUN/STOP switch. When the indicator doesn't light up even if it pushes the switch, exchange a controller.	When the start timer is set, after the setting time, the dry operation is started.
Open the door of control panel and are there not dissolving and consumption of the magnet point of the electromagnetic switch unit, and At the time of power "ON", check the opening and shutting motion for the magnet.	When the dissolving, the consumption condition, and the normal operation are impossible, exchange the electromagnetic switch unit.	<u>Tolerance: 2.000.000 times</u>
Confirm whether or not the malfunction character of 『E2』 isn't displayed at the controller indicator.	In the cause of the over load of blower, after repair, open the control panel door and press the reset button of thermal relay.	As for the overloaded cause of the blower, refer to CHAPTER8. [The blower does overloaded operation and the thermal relay trips].

The blower does overloaded operation and the thermal relay trips.		
Check point	Remedy	Note
Remove the cartridge filter in the filter case of the convey line and check the filter stuff.	When there are dirt and stuff, blow the clean dry air into the cartridge filter and remove the clinging particles.	When the degradation of cartridge filter progresses and it isn't possible to remove clinging particles, exchange at the new cartridge filter.
Remove the dry filter and check the filter stuff.	When there are dirt and stuff, blow the clean dry air into the filter and remove the clinging particles.	When the degradation of filter progresses and it isn't possible to remove clinging particles, exchange at the new filter.
Open the door of control panel and are there not dissolving and consumption of the magnet point of the electromagnetic switch unit, and At the time of power "ON", check the opening and shutting motion for the magnet.	When the normal operation are impossible, exchange the electromagnetic switch unit.	<u>Tolerance: 2.000.000 times</u>
Check whether or not the thermal in control panel is set to the standard value.	Refer to [The thermal setting value of every model] and set a thermal to the standard value.	Work after setting primary power to "OFF".

A little airflow rate of the blower.		
Check point	Remedy	Note
Remove the cartridge filter in the convey filter case and check the filter stuff.	When there are dirt and stuff, blow the clean dry air into the cartridge filter and remove the clinging particles.	When the degradation of cartridge filter progresses and it isn't possible to remove clinging particles, exchange at the new cartridge filter.
Remove the filter in the dry blower and check the filter stuff.	When there are dirt and stuff, blow the clean dry air into the filter and remove the clinging particles.	When the degradation of filter progresses and it isn't possible to remove clinging particles, exchange at the new filter.

A little air flow rate of the blower.		
Check point	Remedy	Note
Confirm whether or not the damper for airflow adjustment of the dry blower is open.	Full opens a damper.	When operating in the closed condition, in the insufficiency in the suction airflow, the overheat (upper limit alarm) with dry temperature occurs. Always, use by the full open.
Remove the exhaust filter and check the filter stuff.	When there are dirt and stuff, blow the clean dry air into the filter and remove the clinging particles.	When the degradation of filter progresses and it isn't possible to remove clinging particles, exchange at the new filter.
Check whether there are not a burst of connection hose and the connection's loosening in the unit.	When the hose damages, exchange at the new hose. When there is loosening in the hose connection, tighten up a hose band surely.	If finding the part of air leak, stop the unit and repair.

The change of the dry temperature is large.		
Check point	Remedy	Note
Remove the filter in the dry blower and check the filter stuff.	When there are dirt and stuff, blow the clean dry air into the filter and remove the clinging particles.	When the degradation of filter progresses and it isn't possible to remove clinging particles, exchange at the new filter.
Remove the exhaust filter and check the filter stuff.	When there are dirt and stuff, blow the clean dry air into the filter and remove the clinging particles.	When the degradation of filter progresses and it isn't possible to remove clinging particles, exchange at the new filter.
Refer to the technical manual and confirm each setting of a controller special mode.	When mistaking by the setting value, change to the right setting value.	

The dry temperature doesn't up and down.		
Check point	Remedy	Note
Check that the dry heater is broken.	When a heater is broken, exchange a heater.	After the unit stops, making a power breaker "OFF", and work after downed with the range of the heating part temperature that doesn't get burned.
Check whether or not to mistake by the setting value of the protector of the dry overheat. Setting value: Dry temperature +20°C	When mistaking by the setting value, set a right value.	For the prevention of being shocked, work after performing the power breaker "OFF".
Check whether or not to open the control panel door and whether or not the electromagnetic contact unit is operating normally or there is turning on.	When finding the malfunction, exchange electromagnetism contact unit	As for the exchange and the model, inquire to our service division. Because there are the trouble and danger, request to our service division about the check and the exchange that doesn't have electric knowledge more.

The indicator with the PV value of the controller doesn't display the condition of "ON" in primary power and pushes the CONTROL ON switch.		
Check point	Remedy	Note
Check whether or not the front power breaker of the control panel becomes "ON".	When not becoming "ON", perform the power breaker "ON" and press CONTROL ON switch once again.	Durable switching times: 10,000 If switching function does not operate properly, replace power breaker.
Check whether or not the circuit protector (CP-1) of the control panel does not become "OFF".	After check of electric wiring and the part in the control panel, set to "ON".	After setting the primary power and the front power breaker to "OFF", check.

The power breaker trips.		
Check point	Remedy	Note
Check whether or not the circuit does not the short circuit.	Remove the short circuit.	Inspection and replacement by persons who have not enough knowledge about electricity may cause failure and danger. Ask our service department to inspect and replace.

The upper limit alarm with dry temperature occurs.		
Check point	Remedy	Note
Remove the filter in the dry blower and check the filter stuff.	When there are dirt and stuff, blow the clean dry air into the filter and remove the clinging particles.	When the degradation of filter progresses and it isn't possible to remove clinging particles, exchange at the new filter.
Confirm whether or not the setting value of the upper limit temperature alarm (deviation with dry temperature) is right. (10°C setting in case of shipment)	When the setting value is small, refer to "CHAPTER 9. Technical Manual" and set once again.	When the upper limit alarm still occurs after setting, refer to CHAPTER 9 of "The start-up method for the auto tuning" and perform it. (set in the hopper under (You set in the hopper in the material feeding condition). the material feeding condition).

The overheat alarm occurs.		
Check point	Remedy	Note
Remove the exhaust filter and check the filter stuff.	When there are dirt and stuff, blow the clean dry air into the filter and remove the clinging particles.	When the degradation of filter progresses and it isn't possible to remove clinging particles, exchange at the new filter.
Remove the filter in the dry blower and check the filter stuff.	When there are dirt and stuff, blow the clean dry air into the filter and remove the clinging particles.	When the degradation of filter progresses and it isn't possible to remove clinging particles, exchange at the new filter.
Confirm whether or not the dry blower is rotating.	When not rotating, dispose of the reference in CHAPTER 8 of "The dry blower does not rotate".	Request blower replaces of us.
Confirm whether or not setting value of the overheat protector is proper.	Set the dry temperature to +20°C.	For the details, refer to " CHAPTER 4. Preparation for operation; item 4. Setting the overheat protector " and set.
Open the door of the control panel, and inspect whether the drying heater output relay (RY2) in the main circuit board located on the backside of the controller is operating normally.	Replace the drying heater output relay (RY2).	<u>Switching endurance:</u> <u>5 million times or 1 year</u>