

## 10.3 - TROUBLESHOOTING

1. No power overall or to some components (no green light on front panel)
  - Check power cord is plugged in and in good condition
  - Check Main Disconnect switch is on
  - Check main circuit breaker inside left side access panel
  - Check component fuses inside left side access panel  
(LED on indicates blown fuse)
  
2. Have power but front display does not light up.
  - Check Emergency Stop switch is not depressed (twist to release)
  - Check Start push button has been pressed
  - Check power connector is plugged in to front display (inside front door)
  - Check 24VDC power supply (inside left side access panel)
  - Check component fuses (inside left side access panel)  
(LED on indicates blown fuse)
  
3. Have power but no response in operator interface action keys.
  - Check component fuses (inside left side access panel)  
(LED on indicates blown fuse)
  - Check PLC is in run mode and terminal mode (inside front door)
  - Check PLC data cable is connected to front display (inside front door)
  
4. Have power but divider flag and trap flag do not respond when RESET is pressed.
  - Check that compressed air is connected and turned on (80 psi)
  - Check electric solenoid air valves are working (inside right side access panel)
  
5. Disc does not rotate in any mode
  - Check Disc+Feeder override switch is in the AUTO position (up)
  - Check speed setting is not zero
  - Press RESET and try again
  - Check component fuses (inside left side access panel)  
(LED on indicates blown fuse)
  
6. Feeder does not operate in any mode
  - Check Feeder override switch is in the AUTO position (up)
  - Check Disc+Feeder override switch is in the AUTO position (up)
  - Check speed setting is not zero
  - Press RESET and try again
  - Check component fuses (inside left side access panel)  
(LED on indicates blown fuse)
  - Check function of the Auto-feed Sensor (center hub)

### 10.3 – TROUBLESHOOTING (Cont'd)

7. Disc and Feeder stop before target count is reached
  - ❑ Check Disc+Feeder override switch is in the AUTO position (up)
  - ❑ Check Slowdown % is not set to zero
  - ❑ Press RESET and try again
  
8. Feeder stops too often (if equipped with Auto Feed Sensor)
  - ❑ Check mechanical adjustments of the Auto-feed Sensor (center hub)
  - ❑ Check function of the Auto-feed Sensor (center hub)
  
9. Count is not accurate – too many in container (large error)
  - ❑ Check Counting Sensor adjustment – One-shot Delay not too long
  - ❑ Check Counting Head is properly centered on product flow.
  - ❑ Check adjustment of product guides – no doubles getting through
  
10. Count is not accurate – too few in container (large error)
  - ❑ Clear gels or product with hole - Check Counting Sensor adjustment – One-shot Delay too short
  - ❑ This is very rare – possibly due to electrical interference from nearby machinery
  
11. Count is not accurate – small error, random over/under
  - ❑ Check product flow down exit chute – sliding freely and adequate separation
  - ❑ Check setting of Flag Delay using Fill One Mode.
  - ❑ Check Counting Head is properly centered on product flow.
  - ❑ Check adjustment of product guides – no doubles getting through
  - ❑ Check Counting Sensor adjustment – One-shot Delay not too long
  - ❑ Check Counting Sensor adjustment – try various Threshold settings
  - ❑ Check Counting Sensor for dust buildup