



Troubleshooting Guide

A. POWER UP

PROBLEM: Monitor HT II will not power up (no pushbutton lights, touchscreen is blank).

1. Main power is not connected. No main power from house source.
2. Main circuit breaker tripped (disconnect switch).
3. Fuse FU-1 open.

B. START UP

PROBLEM: Stacker powers up, but will not start when the Start/Clear is pushed. SSR does not pull in.

1. E-Stop button is pushed in.
2. Faulty normally closed contact on E-Stop.
3. Fuse FU-4 open.
4. Faulty Start/Clear Relay.
5. Faulty Safety Stop Relay [SSR].

PROBLEM: Stacker powers up but will not start when the Start/Clear is pushed. SSR pulls in and latches.

1. Check SYSTEM MESSAGES and refer to the appropriate section of the troubleshooting guide.
2. Fuse SU-2 open.
3. Faulty CPU power supply.
4. Fuse FU-4 open.
5. Faulty 24 VDC power supply.
6. Faulty CPU board.
7. Faulty Motion Control board.

C. TOUCHSCREEN

PROBLEM: No response on the screen when touched.

1. Dirt or dust accumulated around the touch bezel.
2. Faulty touchscreen (perform touchscreen diagnostics).

PROBLEM: Touchscreen has flashing cursor only. CPU board is not communicating with the touchscreen.

1. Check communication cable connections between the CPU board and the touchscreen.
2. Perform touchscreen diagnostics, if touchscreen passes replace CPU board, if touchscreen fails replace screen.

PROBLEM: Touchscreen blanks out after a period of time.

1. Faulty touchscreen power supplies. Check for crowbaring and adjust power supplies. Replace supplies if necessary.
2. Loose connections inside touchscreen. Check PC board connections and jumpers.
3. Faulty touchscreen.

PROBLEM: Touchscreen locks up on any menu. No information can be entered and the touchscreen will not respond to operator input.

1. Check to see that the controller board is properly seated on the mother board.

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PROBLEM: Touchscreen is completely blank.

1. Fuse FU-1 or FU-5 open.
2. Check for loose connections and loose power plug on touchscreen.
3. Check that the power switch on the touchscreen is "ON".
4. Check the fuse located next to the power plug on the touchscreen. Check the internal fuse located on the touchscreen power supply circuit board.
5. Faulty CPU board.

D. INFEEED SECTION

PROBLEM: Stacker starts up, but input section does not run.

1. Fuse FU-10 or FU-13 open.
2. Misadjusted or faulty KB drive or isolator board.
3. Misadjusted or faulty motion control board.
4. Faulty motor and/or gearbox.

PROBLEM: Start starts up, but input section runs in forward or reverse at full speed (no control).

1. Misadjusted or faulty motion control board.
2. Faulty KB drive.
3. Faulty KB isolator.
4. Faulty ring tach.

PROBLEM: Infeed section speed is erratic or inaccurate.

1. Faulty ring tach.
2. Misadjusted or faulty motion control board.
3. Misadjusted KB drive.
4. Faulty motor and/or gearbox.

PROBLEM: Paper stream not deflected evenly.

1. Misadjusted top skis. (see machine adjustments)

PROBLEM: Paper jams above tyne tips while in position.

1. Misadjusted top skis. (see machine adjustments)

PROBLEM: Input section will not follow stream tach.

1. Stream tach not connected.
2. Delivery type is set to "INSERT". Must be sent to "PRESS".
3. Faulty stream tach
4. Faulty cable between stream tach and slacker.
5. Faulty I/O module #1.

PROBLEM: The readings on the infeed section tach are incorrect. Infeed speed does not correctly tach follow the stream conveyor.

1. The stream tach is incorrectly calibrated. (see machine adjustments)

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PROBLEM: Dump gate will not go up.

1. Dump gate air pressure to low.
2. Faulty gate solenoid.
3. Faulty gate up I/O module #6.
4. JLS stuck in active state.
5. Faulty bypass button.
6. Faulty bypass I/O module #17.

PROBLEM: Dump gate will not go down.

1. Faulty gate up solenoid

PROBLEM: Dump gate goes up, but falls after approximately five (5) seconds.

1. Faulty low pressure regulator.
2. Faulty shuttle valve.

PROBLEM: Dump gate reaction slow or sluggish.

1. Faulty high pressure solenoid.
2. Faulty shuttle valve.
3. Faulty high pressure I/O module #5.

E. STACKING SELECTION

PROBLEM: Stacking selection will not cycle or stops in middle of a cycle.

1. See "SYSTEM MESSAGES"- 'Stacking section failed to drive'.
2. Fuses FU-9; FU-11; FU-12; FU-13 open.
3. 15 AMP circuit breaker located on servo drive tripped. **NOTE:** circuit breaker looks like "ON/OFF" rocker switch.
4. Faulty motion control board
5. Mechanical binding or broken springs in tyne truck assembly.
6. Servo drive error.

PROBLEM: Stacking tynes run continuously.

1. Servo drive error.
2. Misadjusted or faulty motion control board.
3. Misadjusted or faulty home proximity switch.

PROBLEM: Paper misses one tyne.

1. Misadjusted or missing input section wire.
2. Poor delivery. Paper stream coming into stacker is skewed.
3. Dump gate air pressure incorrectly set.
4. Misadjusted intercept distance.

PROBLEM: First paper in stack is repeatedly forked by the intercept tyne.

1. Misadjusted intercept distance.

PROBLEM: Bundle quality is poor.

1. Misadjusted bypass deflector struts.
2. Misadjusted stacking side guides.

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PROBLEM: Papers jam in stacking section.

1. Misadjusted stacking guides.

PROBLEM: The tynes are forking, or catching the trigger paper.

1. Misadjusted intercept distance.

PROBLEM: Intercept paper falls short, or nose dives into the batch.

1. Misadjusted intercept distance.

PROBLEM: The bottom 3-5 papers are not aligned in the stack.

1. The tyne pull out speed is misadjusted in relationship to the bypass strut assembly.

F. TURNTABLE BUCKET

PROBLEM: Discharge bars will not drive.

1. Fuses FU-6; FU-7 or FU-8 open.
2. Discharge motor overload tripped. Reset pushbutton is located on the discharge motor enclosure next to the discharge motor.
3. Misadjusted or faulty discharge motor brake.
4. Faulty brake rectifier.
5. Faulty Quad I/O module #20-23 Channel 3 for clockwise and Channel 4 for counter clockwise.

PROBLEM: Bucket does not rotate.

1. Rotate is turned off on touchscreen.
2. Faulty rotate solenoid.
3. No air pressure.
4. Faulty output I/O module #4.
5. Bucket rotate cylinder seized.

PROBLEM: Bucket slams into home.

1. Air pressure is set too high.
2. Misadjusted bucket flow control valves.

PROBLEM: Bucket rotation is sluggish.

1. Binding in rotate cylinder and/or rod end bearings.
2. Misadjusted bucket flow control valves.

PROBLEM: Bucket discharges a single batch.

1. Touchscreen parameters set incorrectly.
2. Stacking height of bundles too high and triggers MBLs.

PROBLEM: Discharge motor discharges the opposite direction than what was selected with the pushbuttons.

1. Incorrect phasing of input "AC" line.

PROBLEM: Papers will not stack evenly.

1. Misadjusted turntable "L" slides.

G. RANGER COUNT SENSOR

PROBLEM: Ranger will not count

1. Selector switch on laser power supply set for mechanical counter.
2. Laser power supply (key) switch is set in "OFF" position.
3. Safety interlock plug missing on laser power supply.
4. Loose connections on Ranger
5. Fuse FU-3 open.
6. Misadjusted laser power supply voltages.
7. Faulty laser power supply.
8. Faulty Ranger counter.

PROBLEM: Paper count is bad. Simulated count is good (801).

1. Misadjusted laser power supply voltages. Minimum "AC" input voltage is 200 VAC.
2. Faulty laser power supply.
3. Faulty Ranger counter.
4. Bad incoming paper stream.
5. Misadjusted intercept distance.
6. Delay potentiometer on Ranger head not set to "0.10".

PROBLEM: Inaccurate paper counts.

1. Inconsistent product (i.e., slipped sections, lapped, torn, or misaligned sections).
2. Misaligned Ranger head.
3. Delay potentiometer on Ranger head not set to "0.10".
4. Misadjusted intercept distance.
5. Rotary mode selector switch on laser power supply incorrectly set.
6. Misadjusted laser power supply voltages. Minimum "AC" input voltage is 200 VAC.