

FAULT FINDING

Type of fault	Potential cause and correction
Pressure gauge shows strong loss of pressure during injection	<ul style="list-style-type: none">a) Too little nitrogen in the accumulator. - Check and fill if necessary.b) Defective accumulator bag. - Dismantle and replace with new bag.c) loss of pressure from the accumulator valve causing loss of nitrogen. - Replace valve insert and close valve to firmly.d) Too much nitrogen in the accumulator bag. - Check the nitrogen pressure and release nitrogen pressure if necessary. The accumulator bag pressure should always be 10% below the lower working pressure.
Injection piston fails to return	<ul style="list-style-type: none">a) limit switch b41 on the injection cylinder is jamming. - Clean the mechanism and oil.b) Defective micro insert in the limit switch. - Renew the insert.c) Timer for injection piston stress time is defective. Insert new card.d) Injection piston is jammed in the sleeve due to too high or too low metal temperature. Check temperature control

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Oil temperature is too high (it should not exceed 50 ^o C)	<p>a) Too little cooling water or cooling water too warm. - Check</p> <p>b) Pressure unloading valve does not switch off properly when required pressure is reached. - Remove valve lid below which an adjustment screw and locknut is positioned. This lid houses a piston which has to be cleaned and made workable.</p> <p><u>Warning:</u> Before removing the cover make sure that the complete machine is without pressure. (Switch off machine)</p>
Pump makes an unusual harsh noise	<p>a) Foam in the oil tank. - Switch off the machine for a short time and leave it at rest for sufficient time for the foam to deposit.</p> <p>b) Dirty suction filter. Clean</p> <p>c) Oil level is too low so that the upper foam level is being sucked into the pump.</p>
Working pressure is not achieved	<p>a) The unloading valve 27 is adjusted too low. - Readjust this and secure.</p> <p>b) The position of safety valve 28 has been altered despite being sealed. - Exchange with new sealed valve</p>

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Machine will not close on automatic cycle.	<ul style="list-style-type: none">a) Guard not fully closed.<ul style="list-style-type: none">- Limit switches b36 and b37a actuated by the guard must be closed. Check to ensure that there is no limit switch defect.b) Defective weight sensor giving no impulse to restart the cycle. Dummy plug not plugged in if not using weight sensor.c) Opening timer is defective. Insert new card.d) Limit switch b40 (middle cam in the triple limit switch) is defective.<ul style="list-style-type: none">- Check the mechanism of the cam and replace micro insert.e) Spray unit has not reached the fully upward position or limit switch b26 is defective or dummy plug is not plugged in when working without die spray unit.
Machine will not open on automatic cycle	<ul style="list-style-type: none">a) Limit switch b41 is defective. Replace the insert.b) Cooling timer is defective.<ul style="list-style-type: none">- Replace electronic card.

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<p>With two phase injection, the second phase (fast shot) does not come.</p> <p>With two phase injection piston after the pre-set stress time returns jerkily to the upper position.</p>	<p>Solenoid valve S6 is not energised, since limit switch b 42 for 'start of fast injection' is not released or is defective.</p> <p>Timer is set too low. Adjust it to 0.2 seconds minimum.</p>