

17 Common problems and solutions

In case of machine malfunctioning, please refer to the chart below.

Carefully follow the directions in the operating instructions when replacing parts.

Please consult your dealer or Fuji Impulse if the problem cannot be resolved even after referring to below explanation.

Also please consult your dealer or Fuji Impulse for the replacement of parts not listed in the operating instructions or adjustment of those parts.

Items marked with the asterisk* mark in the “Solution” column indicate that these problems should be addressed by electrician or expert of replacing electric parts. If there are any problems, please contact your dealer or Fuji Impulse.



Be sure to unplug power cord from the wall outlet when replacing parts.

Problems	Check	Solutions
Sealing is not clean	Is the dust adhering to the heating element, Teflon or sarcon sheet?	Wipe off with the clean cloth.
	Is the Teflon sheet damaged?	Slide the Teflon sheet.
	Is the silicone rubber damaged?	Replace the silicone rubber.
	Is the glass tape damaged?	Replace the glass tape.
	Heating temperature is set too high.	Set the heating temperature at minimum required to make sufficient seal.
	Cooling temperature is set too high.	Lower the cooling temperature.
Sealing results uneven.	Is the silicone rubber damaged?	Replace the silicone rubber.
Heating element bends in the center.	Is the electrode damaged?	*Replace the electrode.
	Silicone rubber is uneven.	Replace the silicone rubber.
Heating element breaks easily.	Heating temperature is set too high.	Set the heating temperature at minimum required to make sufficient seal.
	Cooling temperature is set too high.	Lower the cooling temperature.
	Is the glass tape damaged?	Replace the glass tape.
	Is the electrode damaged?	*Replace the electrode.
Although the heating lamp turns ON, there is no heat.	Check the SSR replay input lamp.	- When input lamp turns ON: *Control unit may be damaged. Replace the control unit. - When input lamp does NOT turn ON: *SSR replay may be damaged. Replace the SSR replay.
Heating lamp continues to be turned ON and the heating element burns.	SSR replay input lamp does not turn OFF.	*Control unit may be damaged. Replace the control unit.

Solutions marked with an asterisk * mark should be addressed by electrician or experts in replacing electric parts. If you have any troubles is solving the problems, please contact with your local dealer or Fuji Impulse.

17-1 Air Related Problems



The below indicated problem will require the parts replacement or complicated adjustment.

Please contact Fuji Impulse or your local dealer when your machine applies to the below problem.

Problems	Check	Solutions
The sealing cannot be made due to the lack of air pressure.	Lack of air pressure from the compressor or regulator.	Please check the air pressure from the compressor or regulator referring to "7 Preparation" >> "7-4 Set up the air source."

17-2 Error Message

Error Message	Problems	Solutions
N G ! X1 lever-upper	Lever upper position cannot be recognized.	Cylinder sensor position adjustment or replacement is required. Please contact your local dealer or Fuji Impulse.
N G ! X3 lever-lower	Lever lower position cannot be recognized.	
S E A L N G ! Poor heating	Heating element is broken (disconnected).	<ul style="list-style-type: none"> • Replace the heating element if it is broken. • When the heating element is NOT broken, please check the SSR relay input lamp. • When the input lamp turns ON, replace the SSR. • When the input lamp does not turn ON, replace the control unit.
S E A L N G ! Sensor trouble	Displayed when the sensor does not sense the raise in the temperature.	<p>Please make sure that the sensor is not shifted. If it does, please make sure the sensor is installed to the proper position.</p> <p>The sensor tip has to come in the middle of seal receiving plate.</p> <p>If the sensor is properly installed, the sensor may be damaged. Replace the sensor.</p>
S E A L N G ! Time up	Displayed when the heating temperature does not reach to the set heating time within the fixed time.	To avoid the voltage drop, do not insert the power plug to the outlet that has multiple numbers of connections.

<p>SEAL NG ! Cooling trouble</p>	<p>Displayed when the raise in temperature is sensed during the cooling process.</p>	<p>Replace the temperature sensor.</p>
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*When the machine is normal except for the poor heating, the heating element disconnection alarm may be damaged. Please deactivate the disconnection alarm from the maintenance mode so you can perform sealing operation. After replacing the disconnection alarm, please activate the disconnection alarm again.