

15 Common problems and solution

If you are experiencing problems with the machine, 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 after referring to the chart, the problem cannot be resolved.

Please refer any questions regarding replacement of parts not listed in the operating instructions or adjustment of such parts to your dealer or Fuji Impulse.

Items marked with an asterisk *in the "Solutions" column refer to the fact that these problems should be addressed by an electrician. If there are any problems, please contact your dealer or Fuji Impulse.



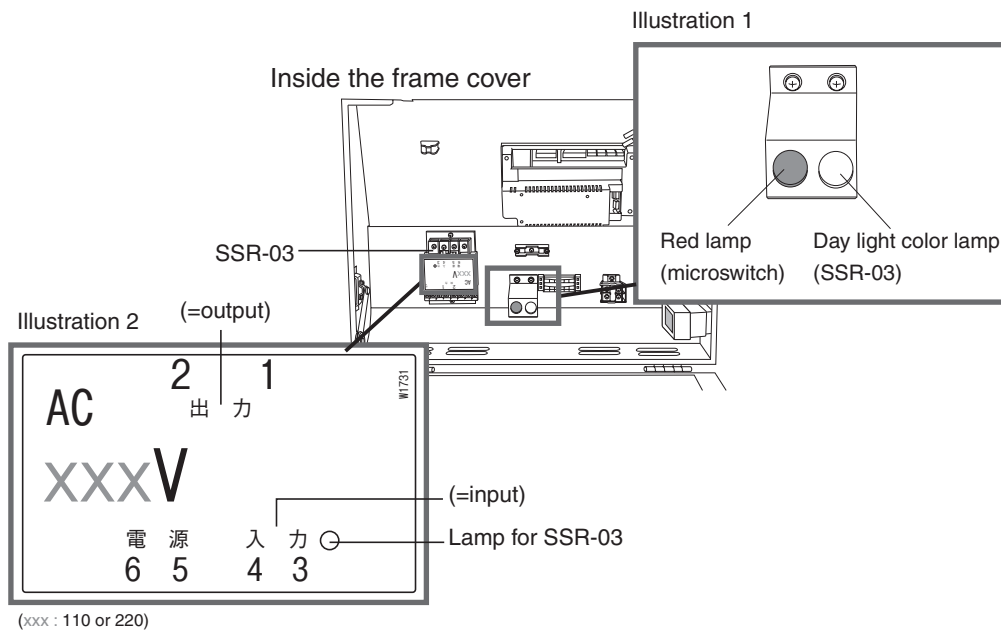
When replacing parts, be sure to unplug power cord from the wall outlet.

Problems	Check	Solution
Seal result is unsatisfactory.	Heating element, teflon sheet or silicone rubber (white) is dusty.	Wipe with clean cloth.
	Teflon sheet is damaged.	Slide the teflon sheet.
	Silicone rubber is damaged.	Replace the silicone rubber (white).
	Glass tape is damaged.	Replace the glass tape.
	Heating temperature is too high.	Set the heating temperature to the lowest in which sealing is possible.
	Cooling temperature is too high.	Lower the cooling temperature.
Seal result is uneven at the right and left sides.	Silicone rubber is damaged.	Replace the silicone rubber (white).
Heating element is bent and risen in the center.	Electrode is damaged.	* Replace the electrode.
	Silicone rubber (white) is exhausted and becomes uneven.	Replace the silicone rubber (white).
Heating element is burnt out easily.	Heating temperature is too high.	Set the heating temperature to the lowest in which sealing is possible.
	Cooling temperature is too high.	Lower the cooling temperature.
	Glass tape is damaged.	Replace the glass tape.
	Electrode is damaged.	Replace the electrode.
Although the heating lamp is on, heating element does not heat up.	Heating element is broken.	Replace the heating element.
	Electrode does not touch with heating element.	Scour the metal contact part of electrode and heating element with a sand paper.
	Electric wire / black (or blue) from the transformer is not connected with electrode.	* Attach the electric wire / black (or blue) to the electrode certainly.
	SSR input lamp is off.	* Control unit may be damaged. Replace the control unit.
	SSR input lamp is on.	* SSR may be damaged. Replace the SSR.
Heating continues (heating lamp being on), and heating element and teflon sheet are burnt out.	SSR input lamp is off.	* Control unit may be damaged. Replace the control unit.

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Error message

Problems	Check	Solution
Poor heating	Is heating element broken?	Replace the heating element
	Is electrode damaged, rusted, or temperature sensor slipped, or not installed?	If the temperature sensor is not installed, it doesn't sense the rising temperature and the pressure lever return to the initial state. Be sure to install the sensor (Refer to P.52)
When the error is not solved with the above-mentioned solution, please check the lamp of the lower illustration 1, with operating a machine. (Usually both two lamps are turned on during heating.)	Are two red and daylight color lamps turned off during heating? (Ref. illustration 1) ↓ If turned off	If SSR-03 lamp is turned off, control unit may be troubled. If SSR-03 lamp is turned on, SSR-03 may be troubled.
	Is SSR-03 lamp of the lower illustration 2 turned on during heating?	* Consult with your dealer or our company.
	Is only the red lamp turned off during heating?	Microswitch may be troubled. Replace it with reference to P.50



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Error message on display

Error message	Prblems	Prblems
X1 NG! lever-upper	Upper lever position cannot be recognized	Adjustment or replacement of cylinder sensor is necessary. Please consult with your local dealer.
X4 NG! nozzle-back	Nozzle back position cannot be recognized	
X2 NG! lever-sponge	lever sponge position cannot be recognized	
X3 NG! lever-lower	Lower lever position cannot be recognized	

Problems	Check	Solution
Heat control can't function! Don't operate until it removes a trouble	Is SSR-03 lamp in the frame cover turned on?	If SSR-03 lamp is turned on, control unit may be troubled. If SSR-03 lamp is turned off, SSR-03 may be troubled. * Consult with your dealer or our company.
Over heating If the temperature does not reach to the setting within 3.5 seconds at heating, this message is displayed.	Is the temperature sensor slipped or not installed?	If the temperature sensor is not installed exactly, it doesn't sense the rising temperature and the pressure lever return to the initial state. Be sure to install the sensor. (Refer to P.52)
	Transformer	* Transformer may be troubled. Consult with your dealer or our company.

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Recommendation of the maintenance mode

The state of a machine is found by display in the maintenance mode.

When the trouble occurs, we recommend to display the maintenance mode.

The position of black marked X and Y told operator the trouble pattern.

Please tell your dealer or our company the result.

(Ref. "Select the maintenance mode" in page 34)

Each working of X0---, Y0--- is described in electric diagrams (page 58 or 59) as IN(X) side and OUT(Y) side.

