19 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.

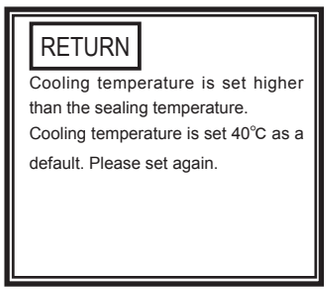
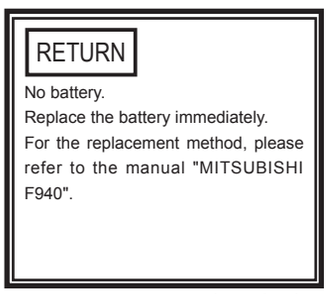
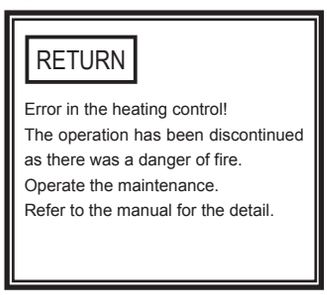
Warning Be sure to unplug power cord from the wall outlet when replacing parts.

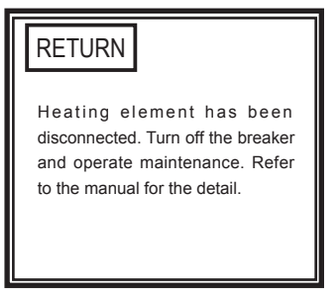
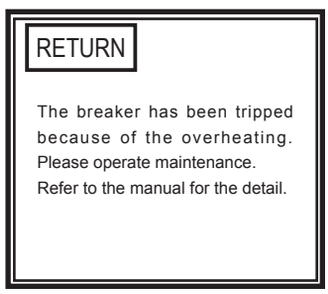
Seal

Problems	Check	Solutions
Seal result is unsatisfactory	Heating element, teflon sheet, or silicone rubber is dusty.	Wipe with clean cloth.
	Zone tape (teflon center dry tape) is damaged.	Replace the zone tape (teflon center dry tape).
	Silicone rubber is damaged	Replace the silicone rubber.
	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.
Sealing result is uneven at the right and left side.	Silicone rubber is damaged.	Replace the silicone rubber.
Heating element breaks 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.
Heating lamp is on, but there is no heat.	Heating element is damaged.	Replace the heating element.
	Heating element doesn’t fully contact with electrode.	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.

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.

Error message

Display	Check	Solutions
Input value error 	Input numeral is over the setting range.	Input the correct value again. (Ref. "8-2-2 Change the setting") "Input value error" is not counted to the alarm history.
Decrease of touch panel battery  This message appears when the battery of crystal liquid panel is decreased.		Refer to the touch panel manual and replace the battery. Touch panel keeps alarm record for about 1 month. After that, the data cannot be maintained.
Communication error  This message appears when the error occurs in communication with microcomputer.		Push "RETURN" button. Touch panel will return to the previous display for setting. Input values and push "FINISH" button again. Please contact with us if the same error occurs over again.
Heating control error.  This message appears when the heating temperature doesn't reach to the setting value even if 3 seconds passed after the heating starts.	Temperature sensor is damaged. Temperature sensor is slipped.	Replace the temperature sensor, or check the position of temperature sensor. (Ref. "9-2 Replacing the temperature sensor".) Please contact with us if this error occurs even after the sensor is replaced. It is very dangerous to continue the operation before the problem would t be resolved.

Display	Check	Solutions
Heating element disconnection 	Heating element is damaged.	Replace the heating element. (Ref. "9-3 Replacing the heating element".)
	Temperature sensor is damaged.	Check the sensor position or replace it if necessary. (Ref. "9-2 Replacing the temperature sensor".)
	Temperature sensor is slipped.	
	SSR-03 Relay poor contact	※ Please consult with your local dealer or Fuji Impulse.
	Safety circuit micro-switch poor contact	
	Heating element doesn't fully contact with electrode.	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.
Heating temperature error  When the heating temperature is over 220C, temperature controller percept it and make the circuit breaker turn off.	SSR-03 Relay doesn't contact enough.	※ Please consult with your local dealer or Fuji Impulse.
	Microcontoroller is damaged.	

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

Chuck bar/ seal receiving plate function

⚠Warning There is a danger of electric shock or leaks in the replacement or adjustment in following situation. Always consult with your local dealer or Fuji Impulse.

Display	Check	Solutions
Power lamp is turned on, but the chuck bar and pressure lever does not move down (Note.1)	Foot switch bad contact	Check whether sequencer IN lamp [X1] is on or not when the foot switch is de-pressed.
	Chuck bar upper position cylinder sensor [X3] is slipped.	Check whether sequencer IN lamp [X3] is on or not.
	Pressure lever upper position cylin-der sensor [X2] is slipped.	Check whether sequencer IN lamp [X2] is on or not
	In seal only operation; Nozzle backward position cylinder sensor [X7] is slipped.	Check whether sequencer IN lamp [X7] is on or not.
	In "not" seal only operation; Nozzle forward position cylinder sen-sor [X6] is slipped	Check whether sequencer IN lamp [X6] is on or not.
	Chuck bar valve is damaged.	Check whether sequencer OUT lamp [Y3] is on or not when the foot switch is de-pressed. (On: close)
	Seal receiving bar valve is damaged.	Check whether sequencer OUT lamp [Y2] is on or not when the foot switch is de-pressed. (On: close)
When the foot switch is de-pressed, pressure lever start to close, but return immediately. (Note.1)	Lever middle position cylinder sensor [X4] is slipped.	Check whether sequencer IN lamp [X4] momentarily turn on or not. (On: close)
"Seal cycle" message is not dis-played. (Seal is not achieved.)	Heating starts cylinder sensor [X5] is slipped.	Check whether sequencer IN lamp [X5] is on or not.
Chuck bar/ pressure lever does not open after sealing. (Note.1)	Chuck bar and/or seal receiving plate valve is damaged.	Check whether sequencer OUT lamp [Y1], [Y2], and [Y3] turns on or not.

(Note 1) Please check in the maintenance mode. (Ref. 8-2-5 Maintenance)

Nozzle function

Display	Check	Solutions
Nozzle does not come forward even when the foot switch is depressed.	Foot switch bad contact	Check whether sequencer IN lamp [X1] is on or not when the foot switch is depressed.
	Chuck bar upper position cylinder sensor [X3] is slipped.	Check whether sequencer IN lamp [X3] is on or not.
	Nozzle backward position sensor [X7] is slipped.	Check whether sequencer IN lamp [X7] is on or not.
	Nozzle valve is damaged.	Check whether sequencer IN lamp [Y5] is on or not when the foot switch is depressed.
Nozzle doesn't return backward.	Nozzle valve is damaged.	Check the sequencer IN lamp [Y5] turning on or not when the foot switch is depressed
Tension nozzle does not open. (Tension nozzle is optional function.)	Failed operation	Check the touch panel if the tension nozzle function is on or not.
	Tension nozzle is damaged.	Check whether sequencer OUT lamp [Y4] is on or not. (On: open)

Vacuum/ gas-flushing function

Display	Check	Solutions
When foot switch is depressed, vacuum start, but the air in a pouch is not removed.	Nozzle is not inserted into a pouch.	Turn off the power switch and start the operation again.
	Nozzle suction part is covered with pouch so that the inside air is not removed.	Set the contents of pouch at the nearest position to nozzle, then start vacuuming process.
	Nozzle or filter is not cleaned.	Clean the nozzle or filter. (Ref. "10-1 clean the nozzle" and "10-2 The role of the air filter and how to clean it".)
	Air is leaked from the pipe connecting part.	Insert the tube again.
Machine works correctly, but seal is not achieved.	Air pressure is not provided enough.	Check the pressure value of air compressor (Ref. "7-4 Connect the piping>> Air source".) Setting point (350 – 400kpa)
Vacuum process doesn't start even if the foot switch is depressed.	Nozzle forward position sensor switch [X6] is slipped.	Check whether sequencer IN lamp [X6] momentarily turns on or not.
	Lever middle position sensor [X4] is slipped.	Check whether sequencer IN lamp [X4] turns on or not
	Vacuum valve is damaged.	Check whether sequencer OUT lamp [Y6] turns on or not. (On on: in vacuum process)
	Vacuum pump or relay is damaged.	
Vacuum result is not uniform.	Space between nozzle and contents of pouch is different every time.	Usually set a pouch as same condition.
Vacuum process does not finish.	Vacuum valve is damaged.	After vacuum cycle stops, check whether sequencer OUT lamp [Y6] is on or not. (On: in vacuum process.)
Gas is not fulfilled in a pouch.	Compressed gas cylinder is empty.	Replace the gas cylinder.
	Gas valve is damaged.	Check whether sequencer OUT lamp [Y7] is on or not. (On: in gas flushing process.)
	Gas leakage from piping (insert part)	Insert a tube carefully again.
Gas flushing process does not finish.	Gas valve is damaged.	Check whether sequencer OUT lamp [Y7] is on or off. (On: in gas flushing process)
Gas flushing result is not uniform.	Vacuum result is not uniformed.	Usually set a pouch as same condition.