

### 13 Common problems and solutions

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.

 **Warning** Always unplug the power plug before replacing parts.

| Problems   | Check   | Solutions  |
|--|---|--|
| The digital display does not turn ON even after turning ON the power switch.   | Does the electricity come to the outlet?  | Make sure the electricity flows to the outlet.   |
|  | Is the power plug fully plugged in?   | Insert the power plug fully to the outlet.   |
|  | Is the power plug damaged?  | *Replace the power cord or power plug.   |
|  | Is the fuse on the back of the control unit blown?  | Replace the fuse.  |
| When stepping on the air pedal, the pressure lever does not descend even when the auto cycle is OFF. (With beep sound) | When stepping on the air pedal, does it click from the microswitch accommodated in the body frame air switch? | In case it does not click:<br>→*Replace the body frame air switch.<br><br>In case it clicks:<br>→*Replacement of the control unit is necessary.                      |
|  | -----   | *Defects in the control unit are assumed. Replacement is necessary.  |
| When stepping on the air pedal, the pressure lever does not lower even when the auto cycle is OFF. (No beep sound)     | -----   | * Defects in the control unit are assumed. Replacement is necessary.   |
|  | Is the air hose securely inserted to the body frame air switch?   | Securely insert the air hose to the elbow joint of body frame air switch.<br><br>In case it is securely inserted:<br>→*Replacement of the control unit is necessary. |
| Heating lamp turns on, but there is no heat and sealing is not performed.  | Is the heating element severed?   | Replace the heating element.   |
|  | Is there bad connection between the electrode and the heating element?  | Polish the metal area where the electrode and the heating element meet with the sand paper.  |
|  | Is the black (blue) wire from the transformer to the electrode disconnected?                                  | * Securely attach the black (blue) wire from the transformer to the electrode.   |
|  | -----   | * Defects in the triac of control unit are assumed. Replacement is necessary.  |

| Problems  | Check  | Solutions  |
|---|--|--|
| Heating element breaks easily .   | Is the set heating time too long?  | Set the heating time at minimum required to make a sufficient seal.                              |
|   | Is the cooling time too short?   | Allow sufficient cooling time.   |
|   | Is the glass tape and/or Sarcon sheet damaged?   | Replace the glass tape and/or Sarcon sheet.  |
| Heating element is convex and liable to break at the center.  | Is the electrode damaged?  | * Replace the electrode.   |
| Sealing is not clean.   | Have the pressure lever and seal frame become hot?<br>(As the temperature of the pressure lever and frame rises, the film may melt without changing the heating time.) | Wait until the pressure lever and frame being cooled off, and take enough operation interval.    |
|   | Is the Teflon sheet, glass tape, Sarcon sheet or silicone rubber damaged?  | Replace the Teflon sheet, glass tape, Sarcon sheet or silicone rubebr.                           |
|   | Is the cooling time too short?   | Allow sufficient cooling time.   |
|   | Is the pressure setting suitable for the thickness of your pouch?  | Precisely adjust the sealing pressure.   |
| Sealing finish differs on the right and left side.  | Is the surface of the silicone rubber uneven?  | Replace the silicone rubber.   |
|   | When the pressure lever is lowered, do you recognize the gap between the pressure lever and seal frame?  | If you do, please contact your local dealer or Fuji Impulse as the machine needs to be repaired. |
| The power switch automatically turns OFF.   | ----   | * The control unit may be broken. Replace the control unit.                                      |
| Heating lamp continues to be ON and the heating element and Teflon burn.  |  |  |
| The following error numer is displayed<br> | ----   | * The microswitch may be broken. Replace the microswitch.  |
| The following error numer is displayed<br> | The error message appears when the microswitch is turned OFF during the heating process.   |  |
| The following error numer is displayed<br> | ----   | After restarting the machine by turning OFF and On the machine, set the sealing condition again  |

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.