15.0 SLICE® Trouble-Shooting Guide

IMPORTANT

Before opening up the SLICE® machine for inspection or for repairs/component replacement, be sure to turn the machine off, unplug the power cord from the ECONO-SLICE® machine completely!

15.1 Product Feeds But Does Not Cut

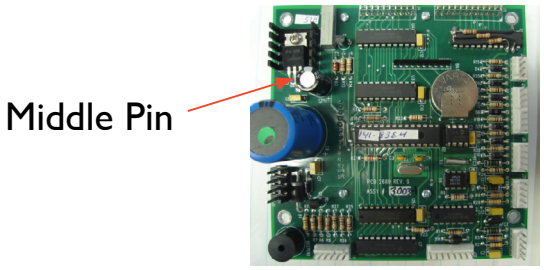
A. Check fuses on Power Board.
B. Check to make sure no material is stuck in Blade/Die.
C. Check that Blade/Die are sharp.

15.2 LCD Displays "Clear Input Jam"

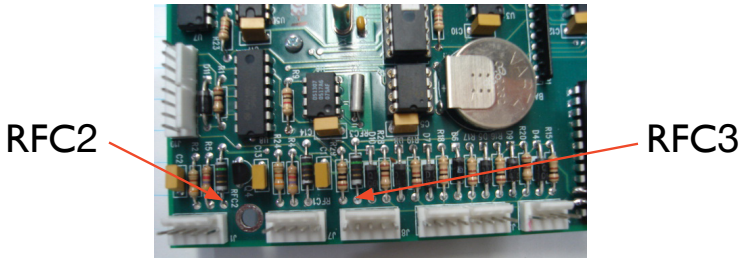
A. Check fuses on Power Board.
B. Check connections for Encoder.
C. Check for damaged Encoder (see 15.3).
D. Check to see if anything is jammed by wheels.
E. Check to make sure no material is stuck in Blade or Die.
F. Press load button.
G. Check functionality of Encoder.

15.3 TEST ENCODER INSTRUCTIONS For ELS3090

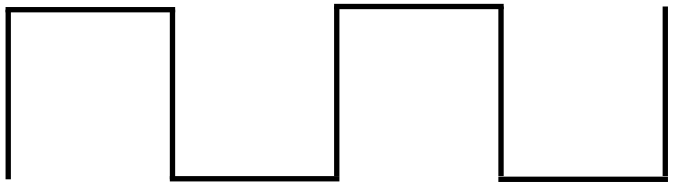
1. Use scope – set volts/div to .5 and sec/div to 2 ms.
2. Connect probe #1 to RFC2 and the clip lead coming off that probe to ground (middle pin).



3. Connect probe to #2 to RFC#3.



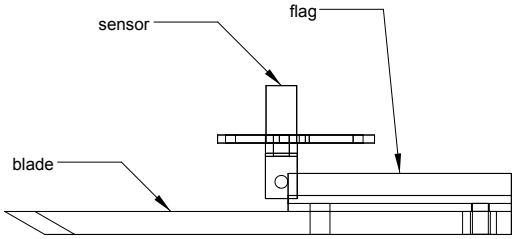
4. Spin the wheels on the unit and on the scope the 2 lines should resemble the following:



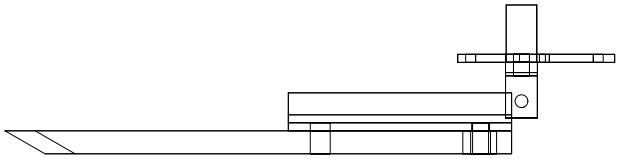
5. If the lines do not resemble this the encoder is bad.

15.4 LCD Displays "Flag Not Set"

A. Check Flag and Sensor alignment (see below).



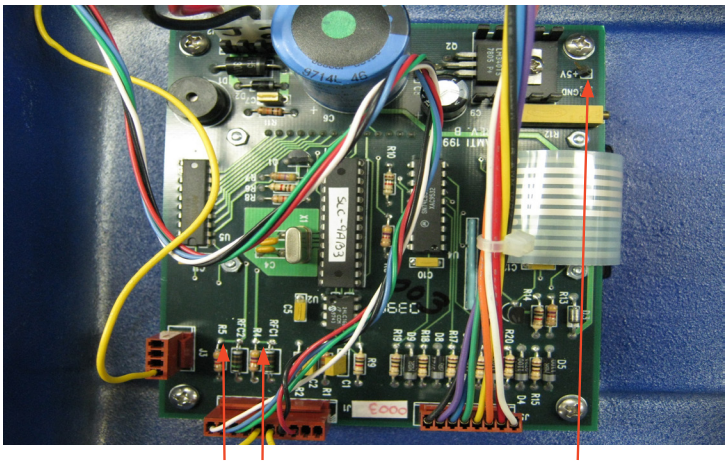
Side Elevation



B. Check connection between sensor and board are intact.
C. Check Optic Sensor making sure that component is free from debris.
D. Check functionality of optic sensor.

Following is how you can check your blade flag sensors - SA2187, SA3376.
-Use a voltmeter set on DC voltage.
-Shut off power on machine and remove cover but keep all cables connected.
-Follow the black sensor cables from the machine to the control board in front cover.
-To test flag sensor connect red end of meter to "B" –RFC1 and black end to "C"-GND. Turn power on. Move flag in and out by hand passing it through sensor. It should read 5V when flag is clear and 0 when blocked by flag.
-Turn power off.
-To test encoder sensor connect red end of meter to "A" –RFC2 and black end to "C"-GND. Turn power on. Turn encoder wheel slowly. As it turns it should alternate reading 5V when clear and 0 when blocked.

If you do not get 5V the sensor is bad.



15.5 LCD Displays “Flag Not Set”

A. Check Flag and Sensor alignment.
B. Check connection between sensor and board are intact.
C. Check Optic Sensor making sure that component is free from debris.
D. Check functionality of optic sensor.

15.6 LCD Displays “Blade Not Moving”

A. Check fuses.
B. Check air pressure. (Should be 80 psi) and air line connections.
C. Check connections.
D. Check for debris in both Blade and Die.

15.7 LCD displays “Black Squares”, No Text

A. Check that Control Board IC is not loose or removed.
B. Control Board IC corrupted and needs to be replaced.
C. Control Board needs to be replaced.

15.8 Machine Not Cutting Accurate Lengths

A. Check the calibration factory setting. Check if there is a 4-digit number listed under calibration program. (4-digit required)
B. Insure material feed is smooth and free of kinks or hang ups.
C. Recalibration may be required (See Operating Manual Section 12)
D. Check bearings on wheels as they may have been worn down.
E. Check encoder wheel as it may be damaged.
F. Check both the Power and Control Boards.

15.9 Machine Not Able To Pull Material Through Cutter

A. Check for jam or material obstructions in opening.
B. Is the material feeding freely? Undue amount of tension on material? Check set up.
C. Are you using a material appropriate for this model machine?

15.10 Machine Freezes Up During Load Cycle And is Sluggish

A. Is an adhesive material being used?
B. Are Blade and Die being routinely cleaned?
C. Check air pressure and air line connections

15.11 LCD Displays Words Not Related To Correct Functions Being Performed

A. Contact Service Tech.

15.12 Motor Making Grinding Noise

A. Check fuses/transistors on Power Board. The majority of the time, when the motor is grinding, it is due to a blown resistor.
B. Check Motor.
C. Check bearings on wheels to see if they are free spinning. Bearings may be worn out.

15.13 Machine On "LOAD" Cycle Cuts Ok But Fails On "RUN" Cycle

A. Check that wheels are closed enough.
B. Check Encoder connections.
C. Set screw on Encoder may be loose, refer to Encoder in manual.

Note: Encoder not engaged when machine on "LOAD" cycle, only engaged during the "RUN" cycle, So Encoder may need to be replaced.

15.14 Loosing "Batch" Sequence Programs

A. Check to make sure programs were set properly.
B. Check fuses.
C. Possible Software corruption.

15.15 Blade Jams

A. Is adhesive product being cut?
B. Are Blade and Die routinely cleaned?
C. Check for material stuck in die.
D. Check if Ball Plunger(s) are too tight or damaged.
E. Check Air Cylinder.

15.16 Solenoids Not Firing

A. Check connections.
B. Check fuses on power board.

15.17 Solenoids Stuck In Closed Position

A. Check fuses on Power Board.

15.18 Machine Has No Power

A. Check fuses in power input receptacle.

15.19 Material Not Cutting Clean

A. Blade or Die is dull.
B. Ball plungers are damaged.
C. Material stuck in Die.
D. Check Air Pressure.

