

2.2 Trouble-shooting: Electrical & Control System

Although all parts used in the machine are selected through our stringent testing processes, they are still subject to wear-and-tear. As fuses are used to protect all expensive electrical equipment, always inspect their condition when failure occurs.

The following are basic trouble-shooting tasks. Contact us should any of the problems persists.

2.2.1 Operator Panel (Micro-Controller Data System)

Situation 1: No **LED** display
Task: Check socket connection behind the panel.

Situation 2: Revolution **counter** is not working
Task: Check mounting of revolution sensor and its condition below Bed Plate.

Tip: If you have 2 units of Unitex machine, and they are using same Micro-controller Data System, you can exchange them to check if the problem is caused by Micro-controller data system or other components.

2.2.2 Electrical

Situation 1: **Machine** stops (trips) after running for a while
Task: Check the final blinking display on the inverter just when the tripping occurs. Refer to inverter manual to determine the cause. It could be motor or inverter overheat, overload or damage. Contact Unitex immediately.

Situation 2: **Top fan** does not turn on after the first 3 machine revolutions.
Task: First check if revolution counter on the operator panel is working. If it's working, check the mounting of revolution sensor and its condition below Bed Plate. If it's working, check wiring of the top fan.

Situation 3: **Machine** does not stop when machine door is opened
Task: Check condition of the limit switch for door and its wiring.

Situation 4: Noisy **magnetic contactor**
Task: The humming noise generated is caused by the accumulation of carbon dust inside contactor. Switch off main power supply and dismantle contactor for cleaning using compressed air.

Situation 5: Frequent tripping of **magnetic contactor**
Task: Switch off main power supply and dismantle contactor for cleaning.