



## **TROUBLESHOOTING**

During the maintenance electrical connections of the device should be turned off completely. All the switches and cutters should be OFF situation and the should be locked. To do fault detection some detailed points are written below.

### **Fault Detection Method**

Control of the substances specified below will help to define the problem.

- a) Value of the voltage is appropriate,
- b) 3 phase input in electrical panels is measured,
- c) Motor and electrical connections are right,
- d) All bolts are tightened,
- e) There isn't dry mortar inside the mould,
- f) Mortar car rail settings, mould height settings are controlled.
- g) Motor turning way is right (Please look at your using guide.)
- h) Pulley axes are right (Please look at your using guide.)
- i) Straps are not too tight or too loose. (Please look at your using guide.)
- j) Belts or pulleys are not worn.
- k) Rubber pads are not worn-out or has no chamber.
- l) Bearing should be turning very easily in the hand.
- m) Piston sealing elements has no problem.
- n) There is enough oil in the storage.
- o) The product which come from the machine has proper height.
- p) There isn't and problem over the product which come from machine.

**NOTE; If you still can not solve the problem please get in touch with the manufacture.**

**Please check the next page for tables...**



## TROUBLESHOOTING TABLE

TABLE-1-

PROBLEM	POSSIBLE REASON	SOLUTION
Not getting product in the height which is required.	Vibration dampers which is used might be worn-out.	Vibration dampers should be changed.
	The quantity of mixture doesn't meet the needed pressure amount.	Thick raw material should be increased.
	Mortar consistency is not appropriate. Mortar doesn't fill the mould.	Please make it available for mortar to fill the mould. Very juicy mortar will reduce the height of the product because of pres and compressing.
	Mould settings are not done.	Do the settings for above pres. Check the height of below mould.
	Vibrator timing is not proper.	Set the timing of vibrator.
	Pressure setting of middle piston is not done.	Read the pressure value from manometer and set the pressure settings according to the information given on pressure valve.
	Vibrator belt tightness is not set properly.	Set the tightness of belts according to user guide.
	Vibrator turning direction might be reverse.	Check the turning direction of vibrator.
	Above press fall down by itself.	Above piston seals and o-rings are broken, please change them.
	Vibrator thermals might be turned off.	The motor current should be measured and cooling fan should be activated.
	Belt might be broken off.	Check the belts and change them.
	Above pressure mould might be worn out.	According to worn-out of it make the setting of above pistons. If this setting is not enough they should be changed.
	Mould is filled with mortar.	Clean the mortar which is left inside.
	Mortar car doesn't fill the mould properly.	Put a grid inside the mortar car. Set the strippers of mortar car.
	Mould height doesn't fit with the raw material which is used.	Use the method of metal removal under the mould. (Consult our company)
There in curvatures and refraction on the product.	Setting of above pres has not been done.	Above pres should move 5-10mm from the bottom of below mould.
	Mixture of mortar is not good.	Check the mortar that it is not very juicy.
	Pressing is not proper.	Increase the timing of vibrators.
	Mould doesn't pres over wooden pallets properly.	Check the mould scale and call our company.
	Below vibrator pads lost their specification.	Change the below vibrator pads.
	Above press sizes might not be equal.	Check the sizes of above pres and call our company.
	Above vibrator pads lost their specification.	Change the above pres rubber pads.
	Mortar might be over above pres.	Steel wires which clean the above pres is worn-out. Change it.
Vibrator motors work very noisy.	Sizes of wooden pallets are not same with each other and there is mortar lefts over the wooden pallet.	Check the sizes of the wooden pallets and make all of them same size. Be careful with the cleaning of wooden pallets.
	Motor bearings or vibrator bearings are scattered.	Change the bearings.
	Pulley axis do not meet.	Set the pulley according to the user guide.
	Belts are too tight.	Set the tightness of the belts according to the user guide.
	Motor draws excessive current and stays with two phase.	Check the motor current and voltage.
	Vibrator bed has no oil.	Do the oiling.
Pump motor is active but machine can not do the movements.	There are cracks and breaks in the body of vibrator.	Change the vibrator body.
	Pump motor and pump wedge grip might be cut.	Change the wedge.
	There might be blockage in the valve.	Valve should be detached and cleaned.
	Valve coils are not working.	Coils should be brought to licensed electrician to measure the connection and it should be made proper.
	The oil which is used is not in the required specification.	Oil should be changed. Please check the user guide.
	Oil filter is blocked.	Change the oil filter.
	Wooden pallet finished.	Load new wooden pallets.
	Latest product come from the machines has not been taken out.	Take out the latest product from the machine
	Pump pressure pipe might have been taken out or cut.	Check the pump pressure pipe.
	Power supply might have problem.	Take help from Professional persons.

TABLE-2-

PROBLEM	POSSIBLE REASON	SOLUTION
Machine doesn't work when you start it.	There might be problem with electrical line.	Phase commutator and between the phases should be controlled.
	Main switch in not working.	Change the switch.
	Thermals might be off.	Activate the thermals.
	Emergency stop button is on.	Turn off the emergency stop button.
	Start button might be broken.	Change it after checking it.
There is slow down on the movements of piston.	Piston seals or O'ring gaskets might have been burst.	Change the seals and o'rings.
	There is blocking or leak on the hydraulic equipment.	Empty the oil inside the hydraulic and after filtering it fill it again.
	There might be blocking in the commanding valve or coils has problem.	Clean the commanding valve and change the coil after measuring it at a licensed electrician.
	There might not be enough oil in the storage.	Add oil until the point which is shown in the tank by controlling it.
	Oil pressure is lower than wanted.	Check the oil level and from manometer by controlling the oil pressure bring the pressure to the needed level as shown in the user guide.
	Oil cooler system is not working.	The air cooler system should be activated at 50°C and deactivated at 40°C. If the system is not working please call our company.
	Pump is worn-out.	Change the pump.
Machine is in the pressing situation but below mould and above mould can not the movement up together. Two moulds get jammed each other.	Cr coated shafts has been skewed because of stretching.	After checking it with water gauge or steel gauge call our company.
	There is breaking or cracking over main shaft beds.	After checking it call our company.
	There is bending and breaking on the balance scale arms.	After checking it call our company.
	There is loosening of bolts of moulds.	By controlling it please compress it.
	There isn't good enough emptiness between the above mould and below mould.	Measure the distance between mould and pressing and call our company.
	Below mould piston can not get over the above mould piston power.	Decrease the above piston turning back pressure.
Mortar car movement and wooden pallet movement.	The bearings or bolts inside the wheel of mortar car has been loosening.	Check the wheel connections and if needed please change them.
Vibrator motors are burning	Belts are too tight.	Set the tightening of belts.
	Cooling fans are not working.	Make the fans active by controlling them.
	When it is under loading feeding voltage is low.	Take help from Professional people.
	Contactors are stuck each other.	Change the contactors.
One of machine bearings has stopped in the middle.	One of the relay which is directing the PLC outline is stuck.	Change the relays places or change with a new one.
	Check the hydraulic felt.	Change the felt.
	Relay is active but the coil over the commanding valve burnt.	Because of valve coil burning the valve shaft inside the commander is half.
	There is some dirtiness inside command valve.	Command valve should be cleaned.
Machine is working but it mixes the processing turn.	PLC transfer can not be done.	Reset your PLC from the screen.
	Sensor has problem.	Check the sensor, when you bring a metal in front of the sensor lights will be turned on over them.
Electric is coming to the system but warning is coming to the screen.	There is connection problem between PLC and screen.	Check it, take it out and connect it again. If needed call some Professional person.
	Screen program might be needed to get installed again.	Take help from Professional persons.



## MOTOR INFORMATION

### PERFORMANCE

Returns, Power Factor, Efficiency, Moving Motor  
Current  
400 V, 50 Hz Torque Values

3 phase, 400 V, 50 Hz

Service type : S1 (continuous)

Saving level : IP 55 (TEFV)

Isolation class : F (105K)

Warming increase : Class B (80K)

OUT POWER	TYPE	FULL LOAD DATA							Inertia moment J	Weight B3	Suitable connecti on for section NYY mm <sup>2</sup>
		RETUR N	CURRENT I <sub>N</sub>			Tork M <sub>N</sub>	Power Factor	Efficiency □			
			A					□			
Kw		n min <sup>-1</sup>	At 380V	At 400V	At 415V	Nm	Cos □	At 4/4	At 3/4	Kg/m <sup>2</sup>	kg

### 2 pole, 3000 return/minute

0.37	AGM	71	2a	2800	1.10	1.05	1.02	1.26	0.73	67.8	67.5	0.00026	5.1	3*2.5
0.55	AGM	71	2b	2780	1.30	1.27	1.25	1.90	0.84	73.5	73.2	0.00034	6.3	
0.75	AGM	80	2a	2780	1.80	1.90	1.80	2.60	0.83	71.6	71.3	0.00053	7.8	3*2.5
1.5	AGM	90	S2	2800	3.45	3.30	3.30	5.10	0.84	79.2	79.0	0.0011	11.4	
2.2	AGM	90	L2	2840	4.90	4.65	4.60	7.40	0.84	81.6	81.5	0.0014	13.8	3*2.5
3	AGM	100	L2	2850	6.60	6.10	6	10	0.87	83.2	83.1	0.0024	17.3	3*2.5
4	AGM	112	M2	2850	8.20	7.80	7.70	13.4	0.87	84.8	84.8	0.0039	27	3*2.5
5.5	AGM	132	S 2a	2870	11.3	11	10.8	18.4	0.84	85.9	85.8	0.0090	33	3*2.5
7.5	AGM	132	S 2b	2890	15.4	14.7	14.3	24.8	0.85	87.6	87.5	0.012	39	4*4
11	GM	160	M2a	2935	22.4	21.5	21	36	0.84	88.5	88.5	0.026	96	4*6
18.5	GM	160	L2	2940	35	34	33	60.4	0.87	90.5	90.5	0.041	122	4*10

### 4 pole, 1500 return/minute

0.37	AGM	71	4b	1390	1.20	1.15	1.15	2.54	0.69	70.0	70.0	0.00054	5.9	3*2.5
0.55	AGM	80	4a	1365	1.60	1.60	1.55	3.90	0.71	70.9	70.8	0.00083	7.6	3*2.5
0.75	AGM	80	4b	1370	2.10	2.00	2.00	5.20	0.74	72.2	72.2	0.0011	8.7	3*2.5
1.5	AGM	90	L4	1390	3.60	3.50	3.40	10.3	0.78	78.6	78.5	0.0024	13.6	3*2.5
2.2	AGM	100	L4a	1400	5.30	5.10	5.20	15	0.77	81.3	81.2	0.0040	17.3	3*2.5
3	AGM	100	L4b	1405	6.60	6.45	6.35	20.4	0.81	82.9	82.9	0.0052	20.8	3*2.5
4	AGM	112	M4	1420	8.70	8.20	8.20	27	0.82	84.7	84.7	0.0092	28.7	3*2.5
5.5	AGM	132	S4	1430	11.8	11.3	11	36.7	0.82	86.2	86.2	0.019	39	3*2.5
7.5	AGM	132	M4	1430	15.8	15.3	15	50	0.80	87.4	87.2	0.026	47	4*4
11	GM	160	M4	1455	22.5	21.5	21	72.2	0.84	88.6	88.5	0.054	108	4*6
18.5	GM	180	M4	1460	38	36	35	121	0.82	90.1	90.1	0.11	160	4*10