

GWT TROUBLESHOOTING

DO NOT open or clear the Crimper without first shutting down electrical power and air.

SYMPTOM

PROBABLE CAUSE

SOLUTION

Contacts not feeding

Crimper in grip position or arm is not at top (up to top sensor)

Flip the "RUN-OFF-CAL" switch to cal and back to on.

A Contact in Crimp head

Remove contact by cycling press & CALB.

Dirty Crimper Sensor or Sensor out of Adjustment

Clean sensor by opening funnels and inserting a pipe cleaner. Or refer to Section 6.3 for sensor adjustment.

Crimp head Sensor Damaged

Replace Fiber Optic Sensor.

Contact feeds but doesn't get to Crimp head.

Contact stuck in the feed tube

Turn OFF machine, shake feed tube to loosen contact.

Feed tube obstruction

Remove & clean tube, and inspect shuttle at tube connection.

Escapement jam
Contacts are not sliding
Down escapement

Refer to Maintenance Section 6.2. clean track with dry rag or Q-tip.

Bowl is overfilled

Turn OFF machine, remove excess contacts and clear exit for proper shuttling.

Feed tube came off

Reconnect feed tube.

<u>SYMPTOM</u>	<u>PROBABLE CAUSE</u>	<u>SOLUTION</u>
Loss of air	Low air pressure or air air switch is off	Check air supply, hoses, air filter element, and air valve. Replace if needed.
Contact jammed in Crimper	Wire pushed in crimper before crimper was ready	(1) Toggle the "RUN-OFF-CAL" switch a few times between OFF and CAL pausing 1-2
	Loss of air pressure	Cycle Press Machine Toggle CALB Switch.
	Arm didn't get to bottom complete cycle	Check Press travel or shunt height.
	Sert-a-crimp (Crimper Ratchet) didn't complete cycle	Check to see if all indenters are back.
	Indenter Spring Broke	Check Air pressure and lines
Funnel does not open	Loss of air	Check air supply hoses, air filter element and air valve. Replace, if needed.
	Dirty Crimper Sensor or Sensor out of Adjustment	Clean sensor by opening funnels and inserting a pipe cleaner. Or refer to Section 6.3 for sensor adjustment.
Machine will calibrate but will not fire contact when switched to run	Dirty Crimp head Sensor or Sensor out of adjustment	Clean sensor by opening funnels and inserting a pipe cleaner. Or refer to Section 6.3 for sensor adjustment.
	A Contact in Crimp head	Remove contact by cycling press & CALB.
	Crimper in grip position or arm is not at top (up to top sensor)	Flip the "RUN-OFF-CAL" switch to cal and back to on.

SYMPTOM**PROBABLE CAUSE****SOLUTION**

After crimping contact, Funnels stay open and machine will not run.

Dirty Crimp head Sensor or Sensor out of adjustment

Clean sensor by opening funnels and inserting a pipe cleaner. Or refer to Section 6.3 for sensor adjustment.

Machine rattles real loud when contact is selected

Feeder bowl is set to close to Escapement

Reset bowl gap according to section 3.1

Contact stuck between bowl and Escapement

Remove contact from between bowl and Escapement. Check Setting according to section 3.1

Bowl does not move contacts up to escapement

Bowl vibration is low

Amplitude adjustment may need to be adjusted to factory setting.

Bowl mounting bolt not tight.

Bowl vibration does not come on

Check power
Check Sensor

Check sensor to bowl controller, supply, switches, and Bowl driver fuse. Fuse is located in electrical box on the bowl controller, #6005.1.