



1. On subpanel inside of rh enclosure. Turn CB4 off and then back on. Check fuses FU3 and FU4 to make sure they are not blown. If blown replace and try machine.
2. With multimeter in AC voltage mode. Check voltage between L1 (35) and L2(36). You should have 220-240vac. This should match what your incoming voltage is. Incoming voltage_____vac. If there is no voltage here, then CB4 has been tripped and is not providing power. Is there voltage on the incoming side of CB4? If CB4 is not tripped and you have voltage on incoming side but not on outgoing side, replace CB4.
3. With multimeter in DC voltage mode. On the terminal block on the drive board there are terminals marked, Com, Sig, +15v, and -15V. Put black lead on Com and Red lead on +15v terminal. Meter should read +15v (Drive board + signal: _____vdc) Put black lead on Com and Red lead on -15v terminal. Meter should read -15v (Drive board – signal: _____vdc) If you do not get any voltage here and you have good AC voltage coming, the drive board needs to be replaced.
4. With multimeter in DC voltage mode. Put black lead on Com and Red lead on Sig. Press the footswitch. With machine in forward mode and pot at about halfway, you should see about 7.5vdc (Drive board voltage jog fwd:_____ vdc) If the direction is in reverse, then the voltage should read -7.5vdc (Drive board voltage jog rev: _____vdc) This should also be true if the run button was pressed only it will be maintained.
5. If you have voltage from step 3 but not in step 4 then there is a problem with the jog switches, the run relay or the fwd/reverse relay.
6. Check the run relay CR3. When you press the run button does CR3 click and stay? If not then check the photo eye relay CR2. With machine in fwd mode and you place your hand in the beam of the photo eye on the nip does CR2 click and the alarm turn on? If in reverse mode, and you place your hand in beam of photo eye on pull rolls does CR2 click and the alarm come on? If the CR2 and the alarm are working correctly but the run relay CR3 is not working you need to replace CR3.
7. FWD/REV relay CR4: Does this relay click and hold when the front and back fwd rev switches are actuated. If the light is on the machine is in reverse. If CR4 is not working replace it.

8. Jog switch: Find wires from jog switch and disconnect them from the terminals they are in. With meter in Continuity mode put black lead on one wire, red lead on other wire and press footswitch. Your meter should beep or somehow show you that you have continuity in the circuit when the foot switch is pressed. If you do not have continuity, then your footswitch needs to be replaced.