

The solve method list for electro problems of CNC fully hydraulic die forging hammer

Problem	Reason	Solve method
1. The motor can't start	①PLC not working. ②Overload protection action. ③The oil level of oil tank lower than sensor. ④The air pressure of safe pin is low to alarm. ⑤ The oil temperature is too hot $>60^{\circ}\text{C}$ 。 ⑥Oil temperature too low $< 20^{\circ}\text{C}$ 。 ⑦The fuse of main return road failure. ⑧The air switch not close or tripping. ⑨ The power supply of PLC is short circuit.	① Check the power supply and the front transformer and fuse of PLC. ② Check the working current and the loading of motor. ③ Rise the oil level to the control range of sensor. ④ Check the system pressure and check is there air leak or not. ⑤ Check the working condition of the cooling pump. ⑥ Check the working condition of the heating device. ⑦Check and change. ⑧Close the air switch. ⑨ Check the PLC and the outer wire line.
2. The fuse failure	①The loading short circuit or overloading. ②Poor contact of fuse.	① Check the loading. ② Screw tight the terminal screw.

<p>3.The contactor shock strong when closed</p>	<p>① Poor contact of coil terminal line. ② Is there objects embed in the attracting iron core. ③The short circuit ring of iron core come off or not.</p>	<p>① Screw tight the terminal screw. ② Remove it. ③Check the contactor</p>
<p>4. The common problem of temperature measurement system</p>	<p>① The wire connect of temperature gauge not right.</p>	<p>① Right the wire connect. ② Check the temperature gauge and conversion module.</p>
<p>5.system fault of testing pressure</p>	<p>① Connection of pressure sensor is wrong.</p>	<p>① Right connection. ② Check pressure sensor and conversion die is Ok or not.</p>
<p>6.system fault of ejection</p>	<p>① approach switch of hammer head is not work. ② magnetic valve of ejection part is blocked.</p>	<p>① right connection. Check whether approach swich loose or fault. ②Check, change.</p>
<p>7.circle purmp is not work</p>	<p>① overcurrent protection operation</p>	<p>① check motor work and load condition。 ② check and change filter</p>

	② Differential pressure switch operation。	element.
8.hitting valve is not work.	①not in running state ② approach switch of hammer head is not work. ③ approach switch of safety pin is not work.	①put the key in running state ② check approach switch connection and installation. ③ check working condition of safety pin and approach switch connection and installation.
8.others	① under adjustment status,slow down valve is not work. ②motor can't be started	①approach switch of safety pin is not work, chech whether mechanical blocked in safety pin, air pressure low, connection of approach switch. ② the key is not in adjustment status.

Attention in operation and maintainance:

A、 When motor working, don't operate circuit breaker of electric cabinet,otherwise it will bring load operation, electrical components burnout.

B、 Please cutting all of electricity when checking.