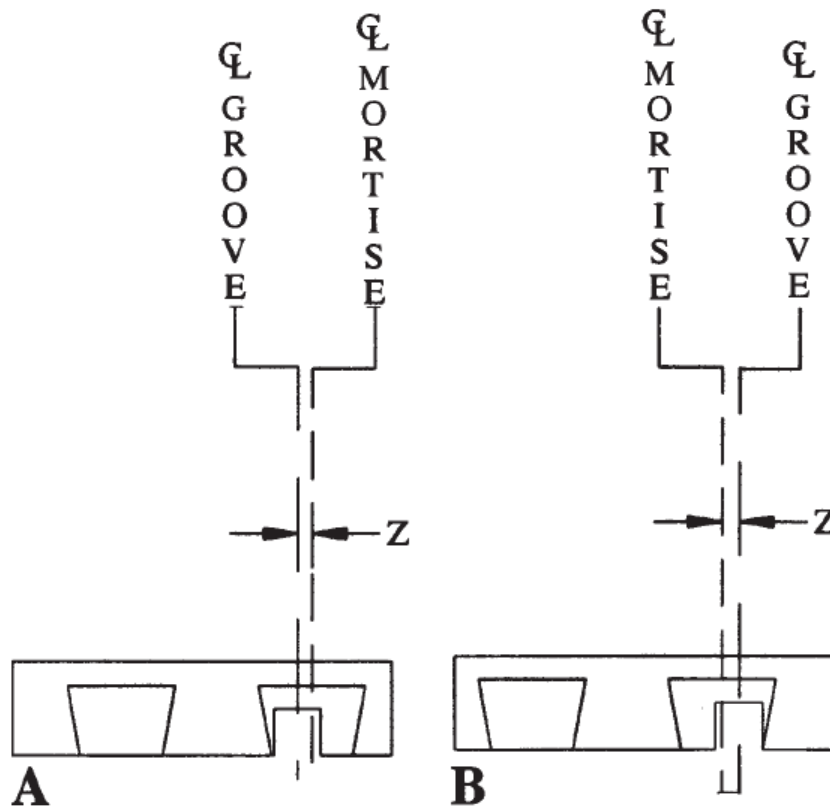


Troubleshooting

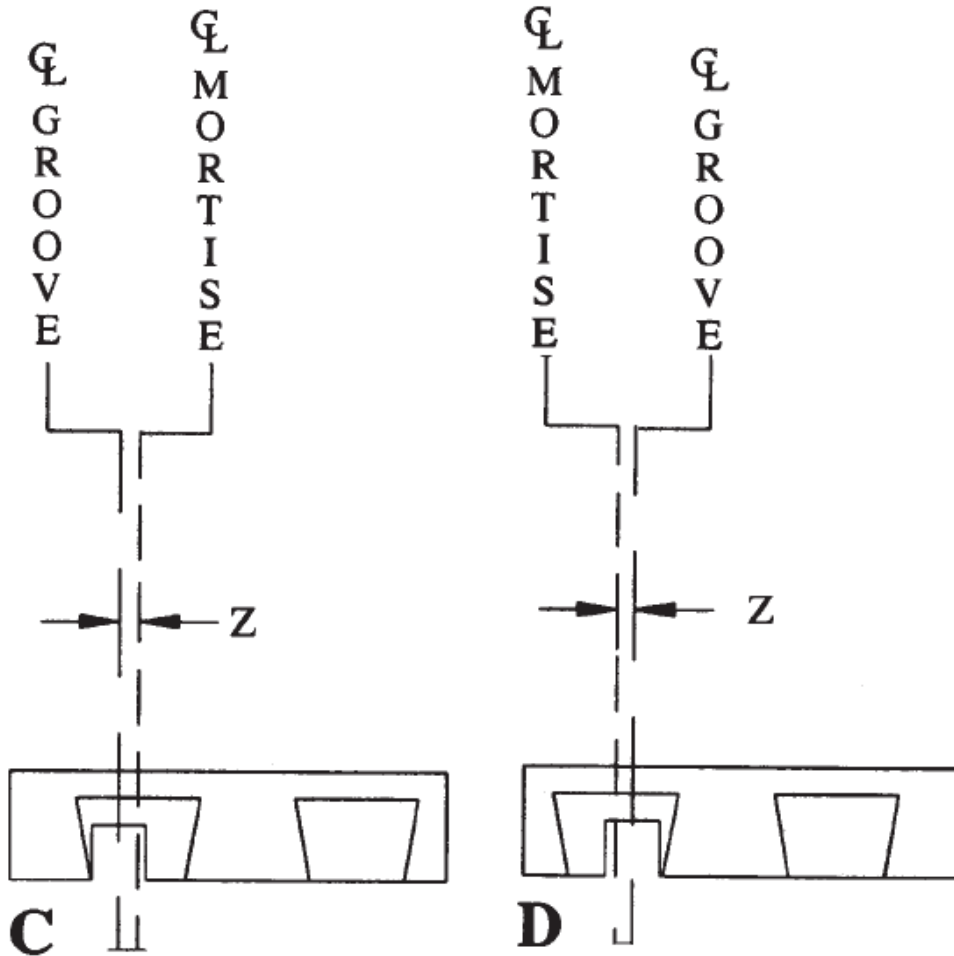
Initial Set-up

1. Set mortise offset {MORTOFF} to zero.
2. Enter the correct part dimensions at the console.
3. Run a part of the left-hand side guide. The groove should be exactly centered on the mortise.
4. If the result looks like example “A”, decrease the front/back X-offset by “Z”.
5. If the result looks like “B”, increase the front/back X-offset by “Z”.

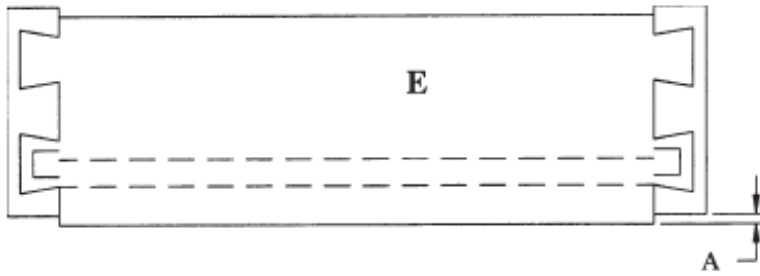


Troubleshooting

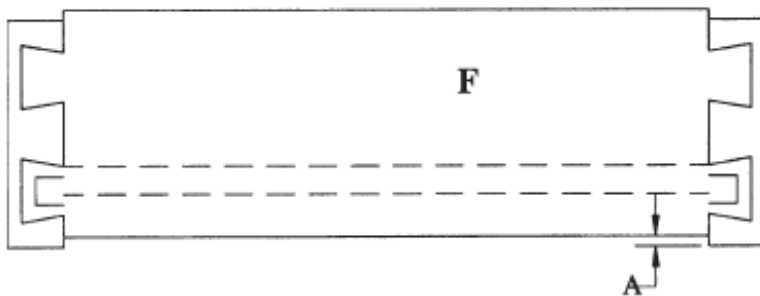
6. Run a part on the right hand guide. The groove should be exactly centered on the mortise.
7. If the result looks like “C” increase the distance between the guides by “Z”.
8. If the result looks like “D”, decrease the distance between the guides by “Z”.



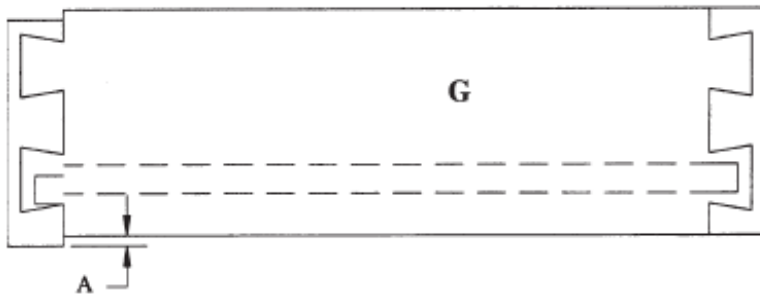
Troubleshooting



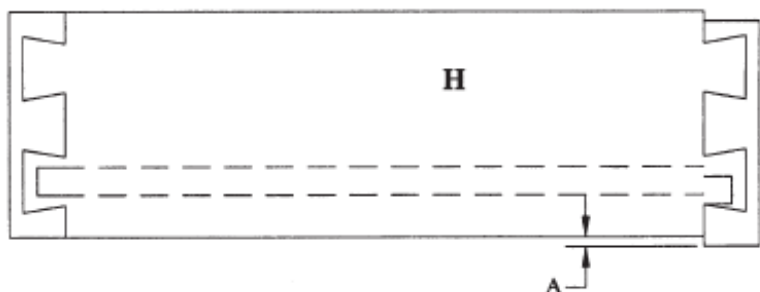
Increase sides
X-offset by "A".



Decrease sides
X-offset by "A".



Increase
distance
between
guides by "A".

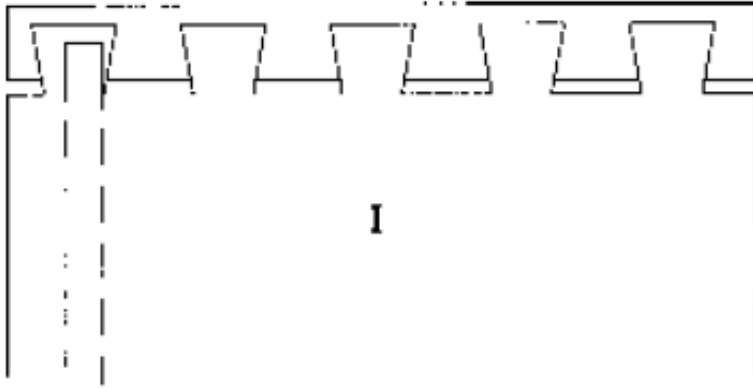


Increase the
front/back
X-offset by "A".

Troubleshooting

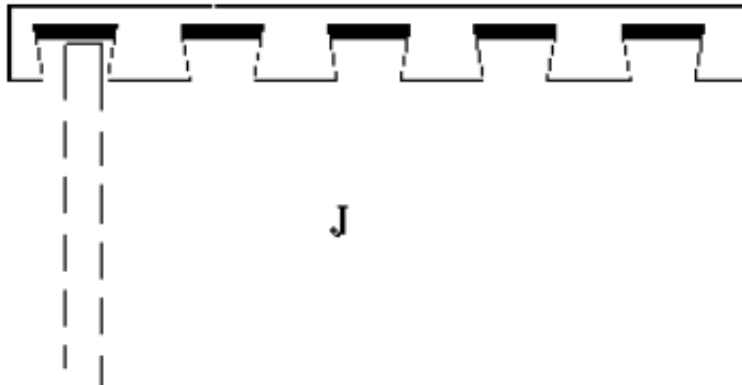
If the front/back is warped, more than the flatness tolerance of .020 per 12 inches raise the sides table or lower the front/back table.

Front / Back is Warped



If the sides is not fed to table-top, then lower the sides table or raise the front/back table

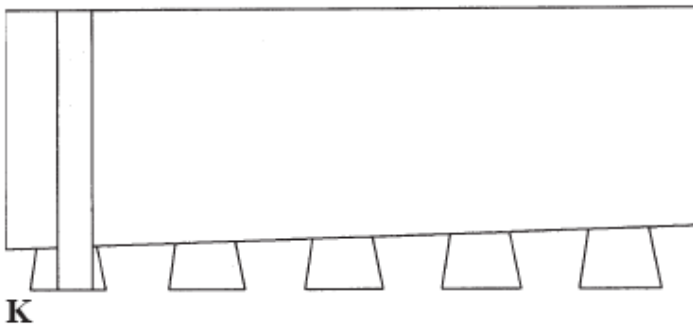
Front / Back is Warped



Troubleshooting

If the piece looks like “K”:

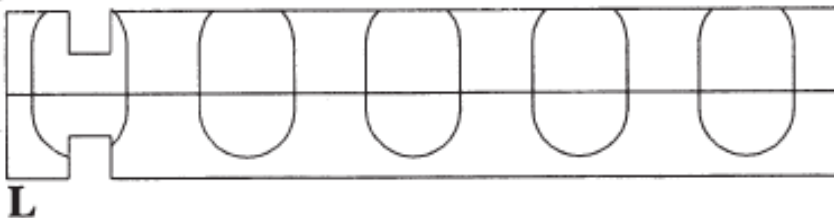
Warped Pieces



Possible reasons may be:

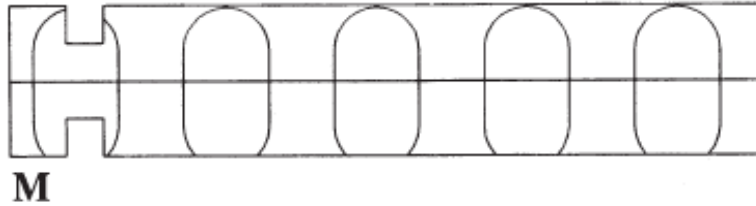
1. The piece was not fed flush to the table or the guide may be less than 90 degree to the table.
2. The table may not be level or perpendicular to the spindles.
3. The piece of material may not be square to a squareness tolerance of .015” per 12”.

If the piece looks like “L” you can correct it by changing the sides Y-offset.

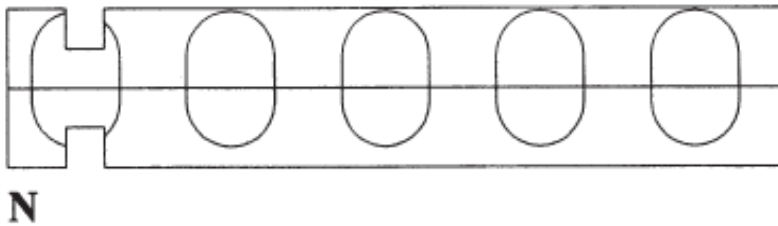


Troubleshooting

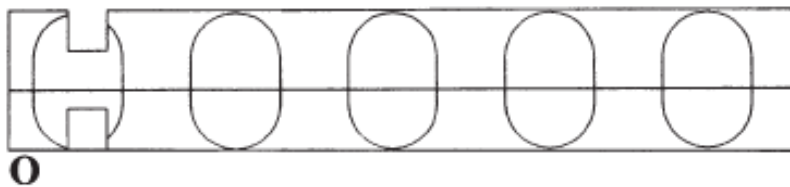
If the piece looks like “M”, then you correct the problem by decreasing the thickness.



If the piece looks like “N”, then you correct the problem by increasing the thickness.



If the piece looks like “O”, then you correct the problem by correcting the location.



Bit diameter: Adjust the bit diameter in the set up screen.

If the joints are too loose then the bit diameter value needs to be increased until the joint is tight enough to meet specifications. The bit diameter value cannot exceed .5660.

If the joints are too tight, the bit diameter value needs to be decreased until the joint is loose enough to allow for assembly with no break out on the tenons.

Actual tool size: The largest diameter tooling can be when it is new or re-tipped, is .558 to allow for any run out in the tool or the spindle. The number of sharpenings that can be done before the tooling needs re-tipping will be determined by how much material is removed each time the tools are sharpened. It is common to be able to sharpen a tool three (3) times before it has to be re-tipped.

Troubleshooting

1105 Electrical Troubleshooting

Operator Screen Does Not Power Up

1. Check the following circuit breakers – CBs #2, #3, #4, #5, #6, and #7 (if used). Reset any circuit breakers that have blown. The circuit breakers are in the following locations.

CB2 Between the transformer and the 460 line voltage.

CB3 Between the transformer and the computer power switch.

CB4 Between the transformer and the 24 VDC power supply.

CB5 Between 24 VDC power supply and the control circuit.

CB6 Bus voltage to the axis drive.

CB7 Bus voltage to the axis drive.

See the electrical drawings for more information.

Troubleshooting

Is the E-stop is pulled? Check all E-stops to make sure that they are pulled out.

Dovetail will not attempt to “HOME”

Is there a circuit breaker tripped? Check F7 and F3, if these fuses are present in your machine.

Is there a bad connection? Check all connectors.

Check the operation of the proximity switches, possibly the home or limit switches. Adjust or replace the defective switches.

Dovetailer attempts to home but does not find home

Axis began with limit switch on? Manually adjust the axis off of the limit switch.

Check for proper air pressure to the machine.

Spindle motor fails to start

Has the motor overload been tripped? Reset.

Has the spindle motor been disabled in the software? If the red light on the top black output device, #7, is off, then the spindle has been disabled.

Troubleshooting

Is an E-stop pushed in? Pull out all the E-stops.

Dovetailer will not run the routine

Is the spindle motor off? Start the spindle motor.

Is the wrong photoeye being activated? Check whether the machine is in Sides or Front/Backs mode.

Are the photoeyes not seeing the part? Clean the photoeyes (PE F/B) and if this doesn't solve the problem then adjust and/or replace the photoeyes.

Is there a communications error? Restart the power up sequence.

Operator screen won't accept input

Is the air pressure correct? Connect and/or adjust the air pressure.

Clamps are not activating

Is there a problem with the photoeyes (#1-5)?
Clean, adjust or replace the photoeyes.