

# PK User Manual / Troubleshooting

## 6.Common faults and troubleshooting

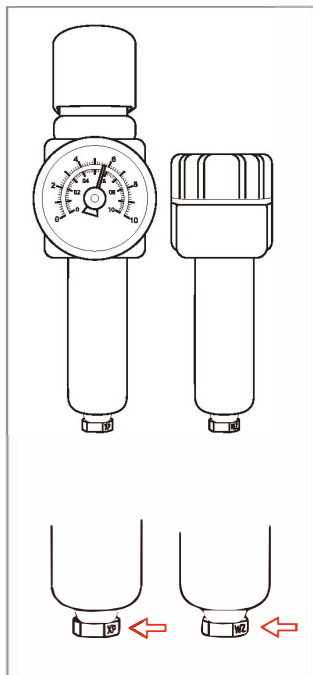
	Faults	Possible reason	Trouble shooting
1	No Power	<ol style="list-style-type: none"> <li>1. Power plug loose</li> <li>2. Air compressor no power</li> <li>3. Pressure switched off after turning off air source</li> </ol>	<ol style="list-style-type: none"> <li>1. Check power cable</li> <li>2. Check air compressor working status</li> <li>3. Check air source</li> </ol>
2	Material loader doesn't move or reports "No material" when switched on	No material on material loader	Put material
3	Emergency stop when switched on	Emergency stop button is pushed	Reset Emergency stop button and restart machine
4	Cannot feed material	<ol style="list-style-type: none"> <li>1. Vacuum pump no working</li> <li>2. Material loader height is too low, suction cups are too far to materials</li> <li>3. Inaccuracy of height detection due to material cocked</li> <li>4. Suction cup not lowered enough due to air source anomaly</li> <li>5. No enough waiting time</li> </ol>	<ol style="list-style-type: none"> <li>1. Whether switched on vacuum pump</li> <li>2. Check material loader height</li> <li>3. Eliminate factors which can affect height detection</li> <li>4. Check suction cups lowering</li> <li>5. Try to modify waiting time</li> </ol>
5	Material stick together when feeding	<ol style="list-style-type: none"> <li>1. Not aligned with air blow point</li> <li>2. Suction cup touches directly breathable material</li> </ol>	<ol style="list-style-type: none"> <li>1. Regulate height to have top layer at the same level</li> <li>2. Use backward function</li> <li>3. Regulate material loader height to have distance between suction cup and material around 1mm</li> </ol>
6	While using appears "Waiting for PLC to be ready"	When feeding, material loader is in reset process	When material loader finished reset, click confirm
7	Have burrs cutting with graphic blades	<ol style="list-style-type: none"> <li>1. Too long blade length exposed</li> <li>2. Blade rotation not flexible</li> <li>3. Broken blade</li> </ol>	<ol style="list-style-type: none"> <li>1. Need to adjust blade length according to different thickness material</li> <li>2. Change blade holder or blade</li> </ol>
8	Sharpedge cutting not smooth with graphic blade	X eccentric wrong set up	Check X eccentric parameter
9	Cut quality issue with start point of graphic blade when cut for the first time	Machine doesn't memorize drag knife direction for the first cut, it will automatic adjust after cutting	Cut a short line before drawing cut

## 7. Maintenance

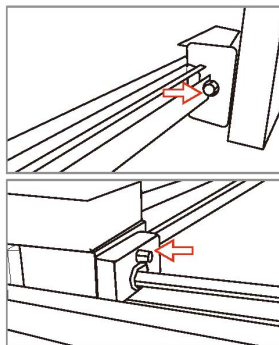
### Maintenance Item Table

Maintenance Item	Method	Period	Related
Graphic blade holder clean	Check and clean debris inside blade holder	Every time before use	Depending by cut material
Check pressure valve and water level	Make sure pressure valve in normal condition, open tank to release water	Every day	Pic. E
Water separator	Make sure pressure is in accepted range, and check for water level	Every day	This water separator is with automatic water release (Pic. A)
Felt cleaning	Use air gun or vacuum cleaner	Every day	No sundries or bumps on surface
Lubricating oil in linear rail guide	Add lubricating oil for X,Y rail guide	Every six months	Pic.B
Lubricating oil in creasing tool axis	Add right amount of lubricant manually	Every six months	Pic.C
Lubricating oil in oscillating tool axis	Add right amount of lubricant manually, and inject grease in oil hole with oil gun	Every six months	Pic.D Pic.F

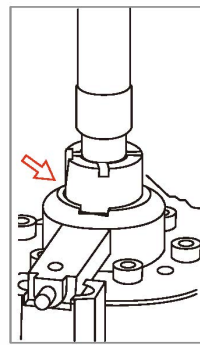
**\*Note :** Lubricating oil,suggest use "Mobil 1 5W-30"; Lubricating grease, suggest use "Mobil grease MP"



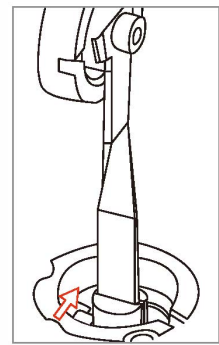
Pic. A



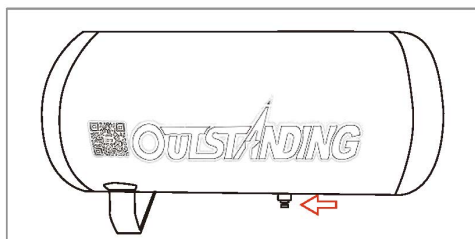
Pic. B



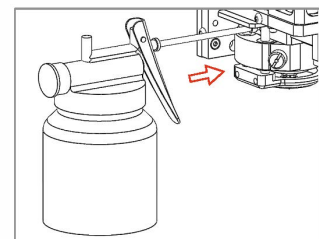
Pic. C



Pic. D



Pic. E














Pic. F

# PK User Manual / Common Parts








## 8.Common Parts

### 8.1 Consumables replacement period

Pic			
Name	Separation clip	Suction disc	EOT blade tight nail ( plus Model)
Type	43*15*0.1	38*13*1	M5*3
replacement period	500h	1000h	10 times disassemble
Pic			
Name	0.9mm knife	1.5mm knife	10° EOT blade
Type	E15-01	E15-02	E19-2
replacement period	50h	50h	50h
Pic			
Name	30° EOT blade	knife holder 09	knife holder 15
Type	E19-3	(dia14) black	(dia14) red
Replacement period	50h	3000h	3000h
Pic			
Name	Felt	Felt	
Type	0604	0705	
Replacement period	3000h	3000h	

## PK User Manual / Common Parts

### 8.2 Consumable list included in machine

Pic	Name	Type	Quantity
	Separation clip	43*15*0.1	18
	Suction disc	38*13*1	4
	EOT blade tight nail (plus Model)	M5*3	20
	0.9mm knife	E15-01	5
	1.5mm knife	E15-02	5
	10° EOT blade	E19-2	5 (plus model)
	30° EOT blade	E19-3	5 (plus model)