

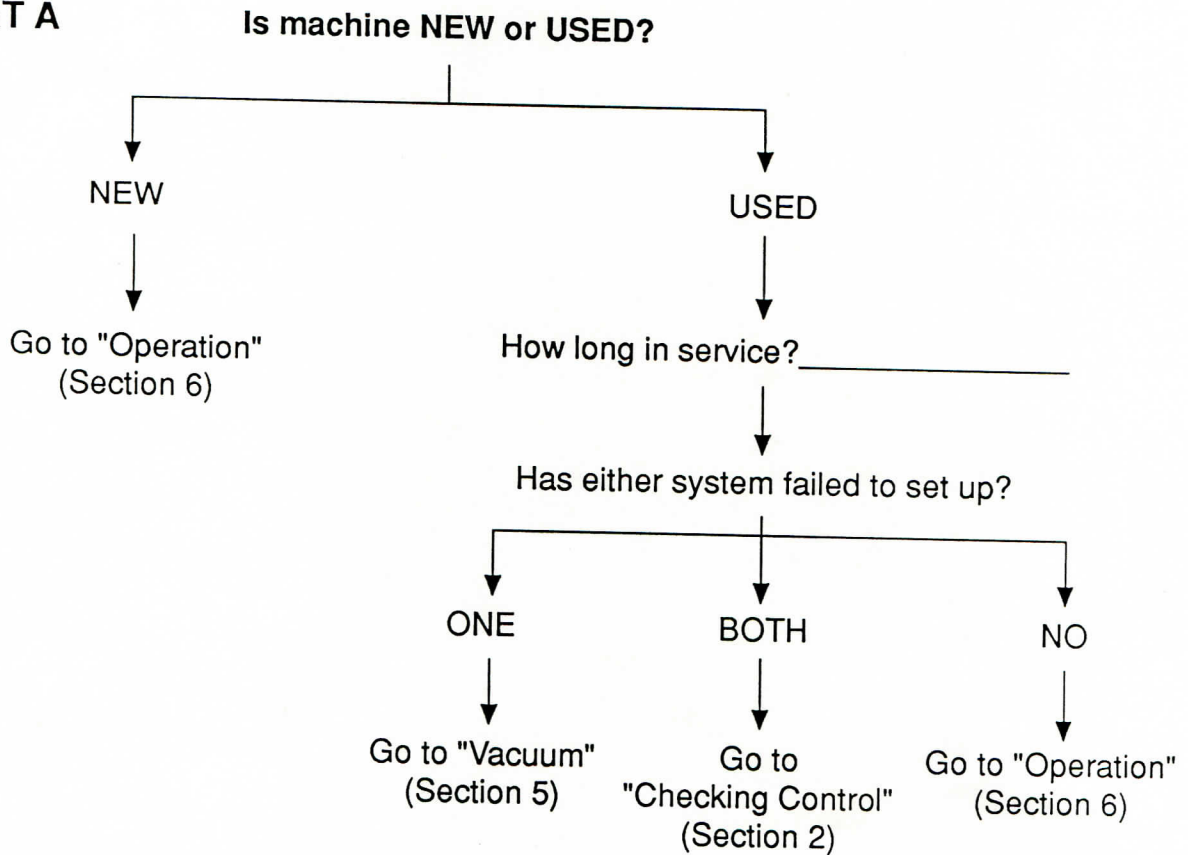
TROUBLE-SHOOTING
GUIDE

for
J&L Backfolding Systems

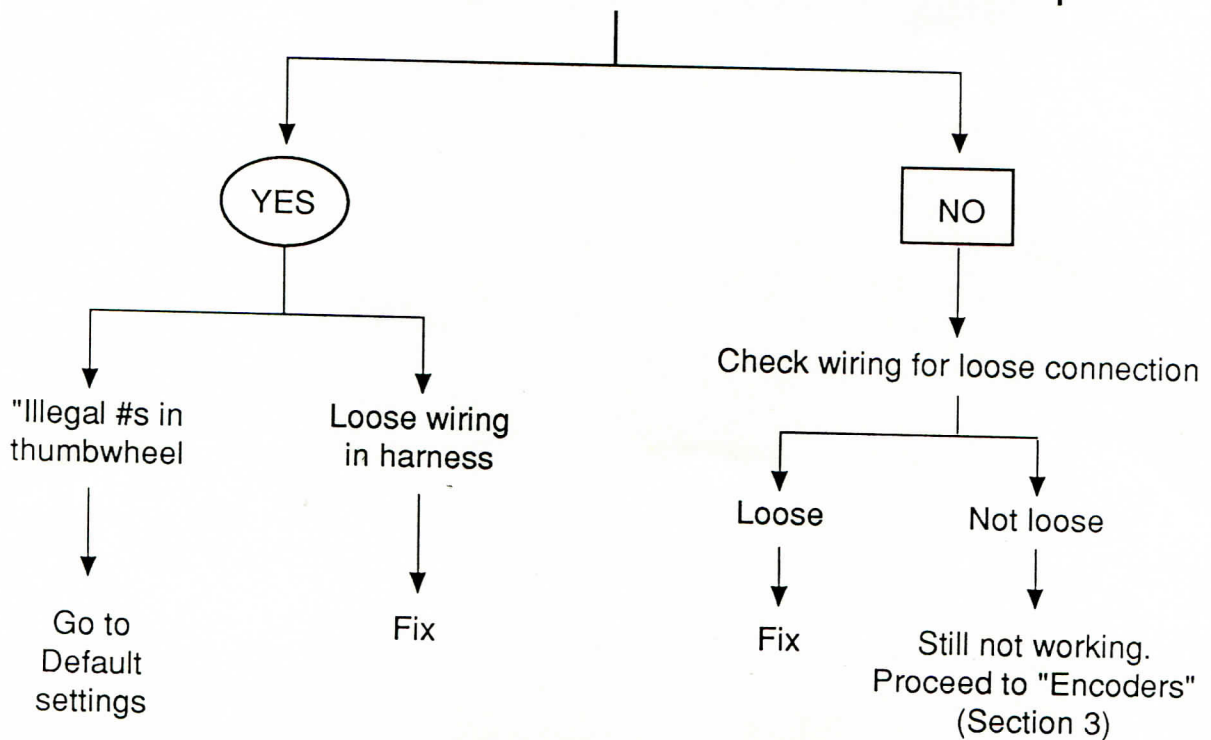
prepared by
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Section 1 INITIAL DIAGNOSTICS

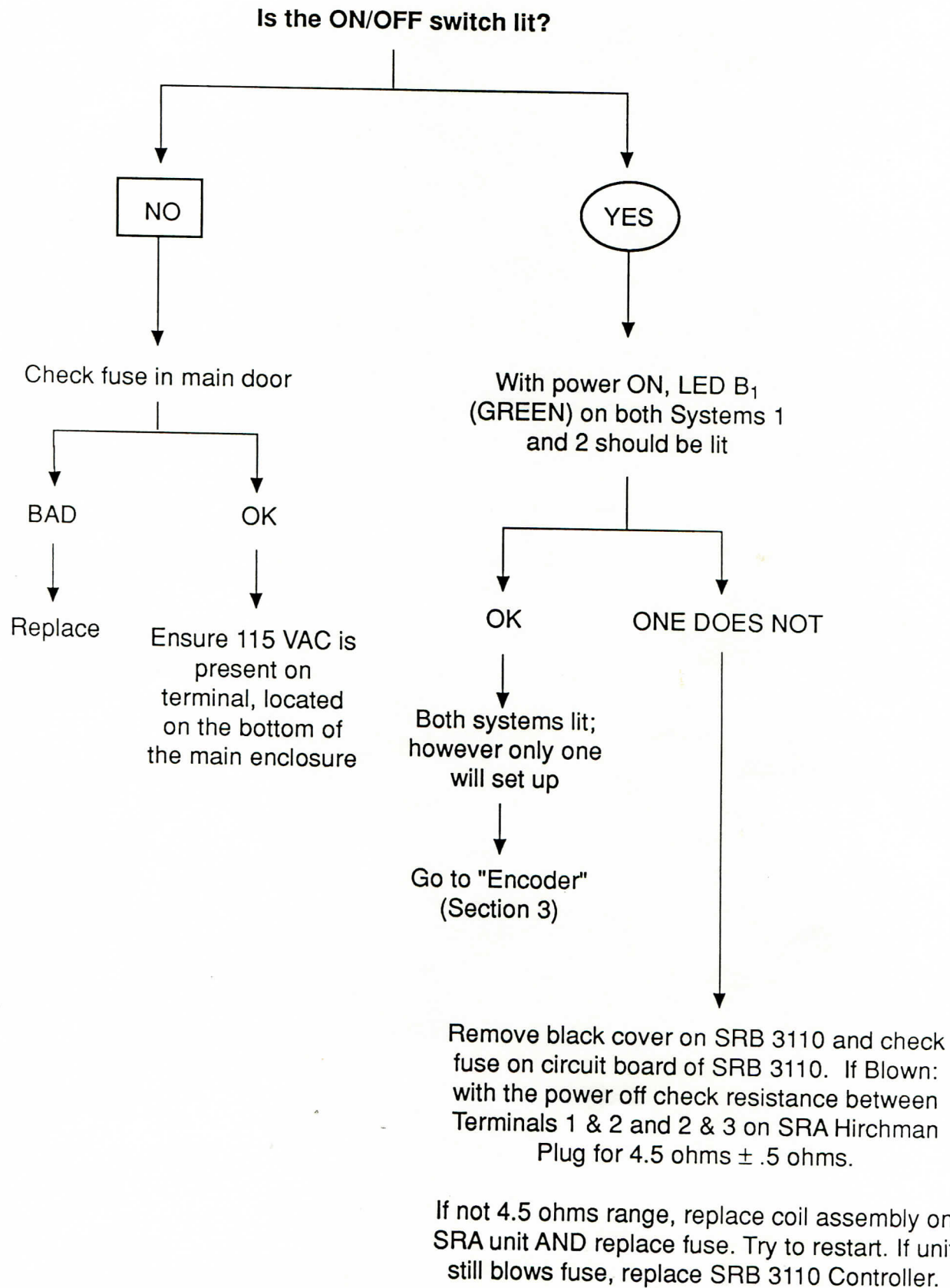
PART A



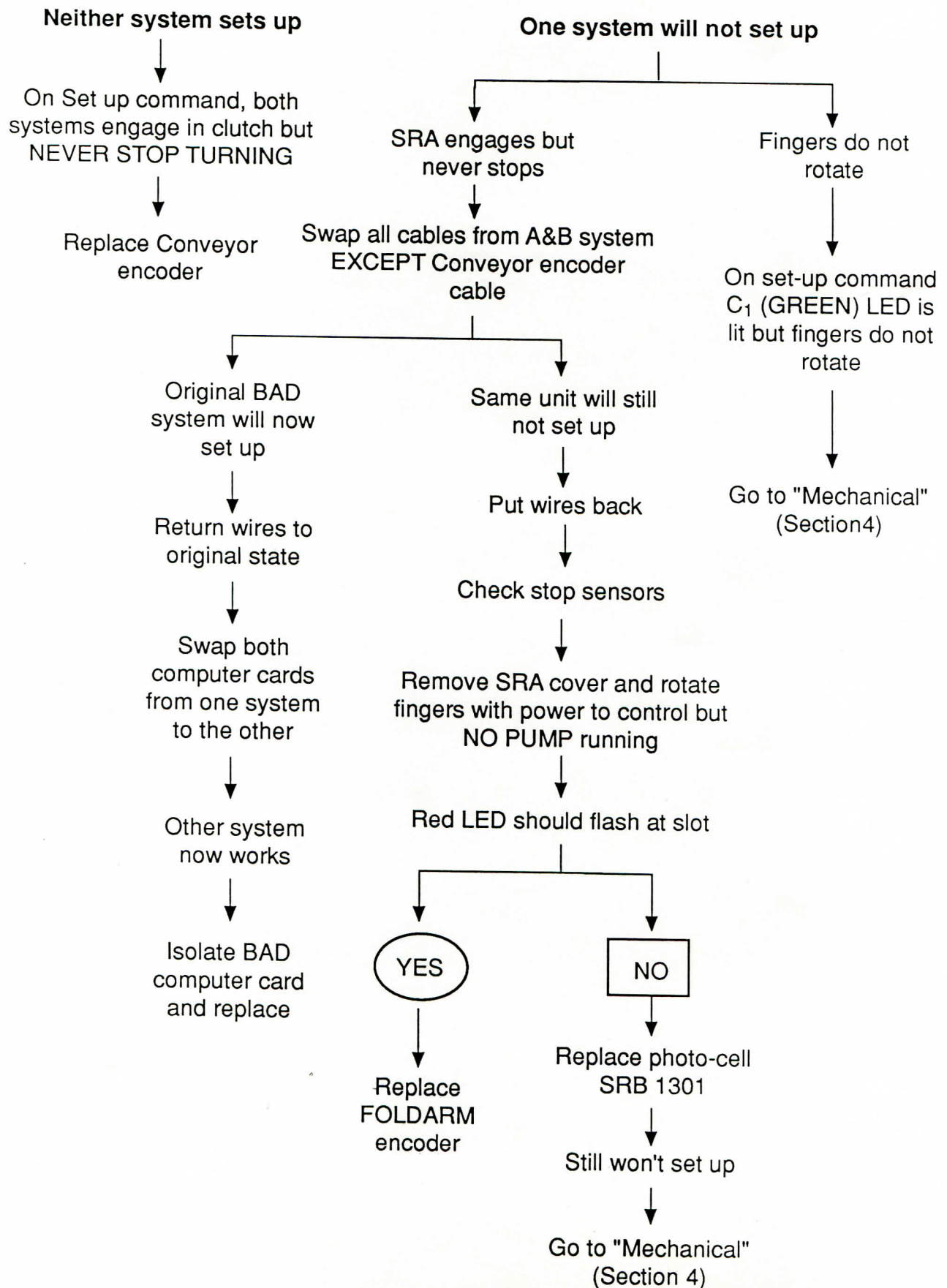
PART B On unit that will not set up, L₁, L₂, L₃ (RED) flash on Power up?



Section 2 CHECKING CONTROL



Section 3 ENCODERS



Section 4 MECHANICALS

HAS VACUUM CHECKED OUT OK?

YES

Without the power on, SRA unit should rotate freely, independent of input pulley. Power the control up. With B₁ lit (RED), Unit should be locked in brake.

NO

See Section 5

YES

On Setup command, with C₁ (GREEN) lit, SRA will either not engage, or it rotates without power or torque

OR

If Unit misses sometimes or appears sluggish

OR

If Unit tends to miss folds

OR

If the Unit has been in service 1+ years and performance is suspect

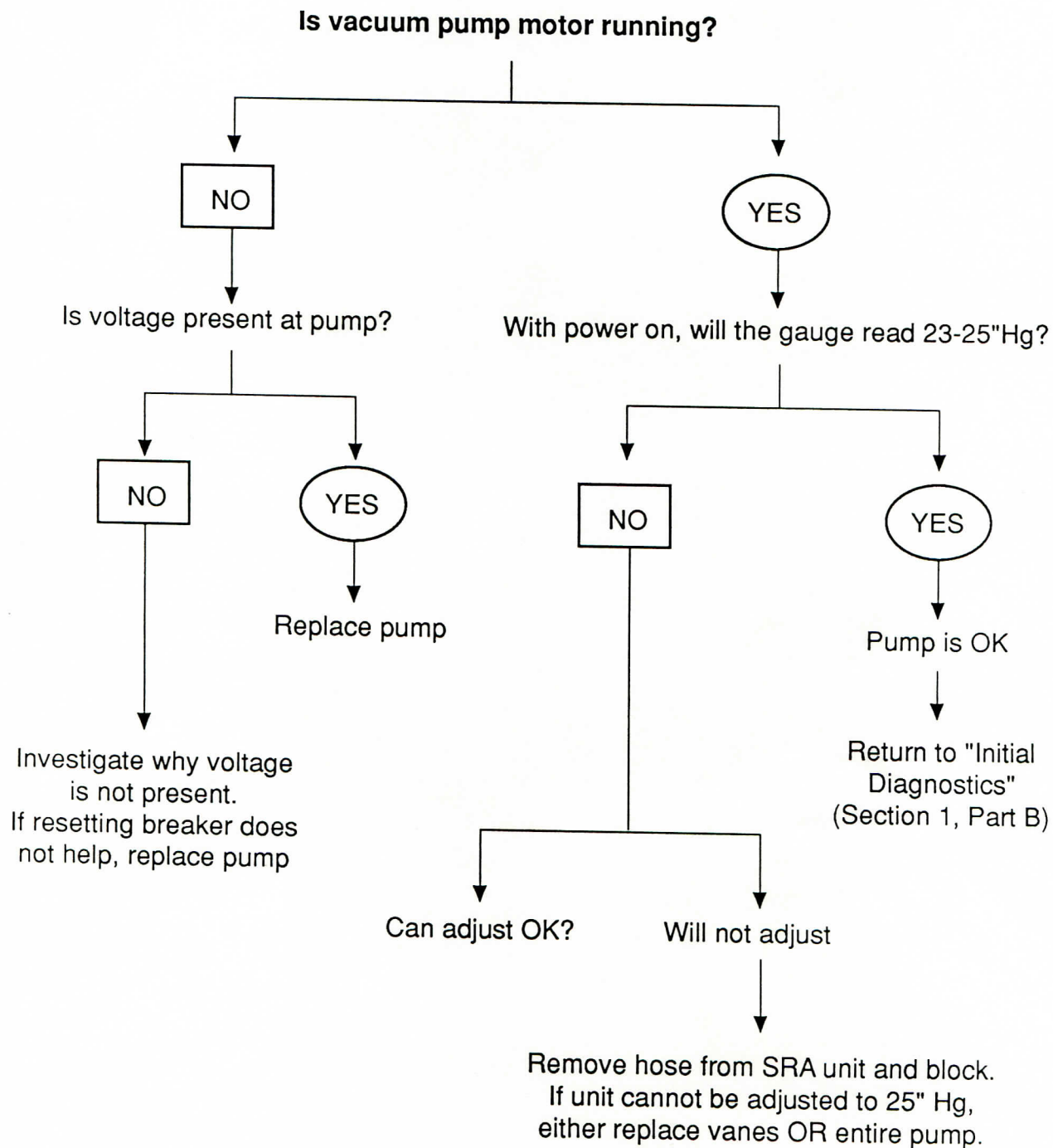
REPLACE STEP UNIT

NO

REPLACE STEP UNIT

Note:
In all cases of SRA Replacement,
remember to re-time the stop sensor.

Section 5 VACUUM



Section 6 OPERATION

Only one system is the problem.
While running, check the following:

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	ERROR
Is L ₁ ON?	Impact distance is too short
Is L ₂ ON?	Theta 1 is too small
Is L ₃ ON?	(Theta 2 - Theta 1) is too small

↓

Readjust thumbwheels

↓

If still unsatisfactory,
REPLACE SRA UNIT
and adjust stop sensor

**Both systems set up; however,
cannot fold boxes properly**

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If first-time user, contact J&L
or OMT. Review for proper
procedure

If neither system will fold properly, contact the factory