Stoppage – Trouble shooting – Actions

Fault	Cause	Action
The machine does not start when pressing the start button.	The main switch is in the off-position.	Turn the main switch to the on-position.
	The main fuse of the building is defective.	Inspect the electrical wirering, replace the main fuse.
The hydraulic unit and the coolant pump runs but the die head does not rotate at start up.	The machine has been overloaded. The electrical current limit of the frequency control has been exceeded.	Wait for the frequency control to reset or press ”reset” on the panel for the frequency control. (machine cabinet A1).
No coolant expelling from the coolant nozzle when the machine is operating.	The protective motor switch is in off-position (Enclosure 2 – F3)	Reset the protective motor switch.
	Coolant level too low.	Refill with coolant.
	The filter of the coolant pump is clogged.	Clean the filter.
	The hose connected to the coolant pump is damaged.	Replace the hose.
The workpiece does not stay fixed in the clamp during threading.	The button for closing the clamp (S11) ⏤ has not been depressed long enough.	Keep the button depressed for 1-2 seconds after the workpiece is placed in the gripping jaws.
	Hydraulic oil level too low.	Refill hydraulic oil (VG32 or VG46).
	The surface of the bar consists of oxide scales or other impurities. The bar is not round.	Use a better shaped workpiece with a better surface.

Fault	Cause	Action
The workpiece does not stay fixed in the clamp during thread cutting.	The hydraulic pressure is too low.	Increase the hydraulic pressure by turning the adjustment screw under valve cap 230 (See enclosure 3). When the clamp is closed by pressing the first push-button to the left of the controlpanel (S14) ⩸ , the hydraulic pressure should be 60 - 80 bar.
	Stop valve not functional (See enclosure 3, valve 810).	Clean or replace the stop valve.
The thread is irregular and possibly has damaged flanks and tops.	One of the dies is not correctly installed/ centered.	Inspect the position of the thread dies by means of the setting gauge (see 3.2)
	Incorrect cutting angle.	Adjust the cutting angle according to the recommendations in enclosure 3.
	The material of the workpiece is unsuitable for cutting machining.	Use material suitable for cutting machining.
	The greasing properties of the coolant is unsuitable for the material.	Use a coolant with greasing properties suitable for the material.
The profile of the thread is incomplete.	The thread dies was installed in incorrect order.	Install the thread dies as instructed in section 3.2.

Fault	Cause	Action
The profile of the thread is incomplete.	Thread dies from different sets has been installed.	Install thread dies from the same set.
	The sled has been force fed in incorrect rate.	Let the thread freely guide the sled after after cutting 2 - 4 threads. Make sure the sled travels with ease on the linear guide ways.
The threads are unsymmetrical.	The clamping dies are not centered to the die head.	Inspect the position of the clamping dies and adjust them heightwise if necessary. Inspect the position of the clamp on the sled and adjust it sideways if necessary.
	The workpiece is not sufficiently straight or round.	Use a sufficiently straight/round workpiece.
The threads are tapered. The profile of the threads might be incomplete.	The spring that works to switch the adjustment ring and the die holders from opened to closed position is not stressed enough.	Adjust the prestress as instructed in section 3.1.
	The spring that works to switch the adjustment ring and the die holders from opened to closed position is completely compressed to the bottom.	Replace the spring as instructed in section 3.1.