L-CONVEYOR				
Problem	**Symptoms**	**Cause(S)**	**Solution**	**Rank**
1. X-axis not working	1.1 Noise from motor 1.2 No “life”	1.1Shark fin(s) off from alignment with slits in x-axis covers, jammed underneath 1.2 Motor or cable failure	1.1 Widen slit where fin contacts cover by filing 1.2 Check components and replace	3
2. X-axis doesn’t find home	Noise from motor resulting from run into mech.stopper	Home sensor broken	Check and replace	7
3. Rotator doesn’t grab plate	No rotation,sucking noise	3.1 Plate bowed,warped 3.2 Rotator top too high or too low in relation to table top	3.1 None,conveyor is not designed to handle excessively distorted plates 3.2 Adjust rotator top to appr. 0.5mm above table top	2
4. Rotating angle off from 90°	Easy to see	Angle wrongly set at rotator	Remove disc,redo adjustment at two screws on back of rotator	1
5. Y-axis not working	5.1 Rattling noise 5.2 No”life” (dead) 5.3 Partial or no y-axis movement	5.1 Motor off from synchronization with driving pulses 5.2 Motor or cable failure 5.3 Pusher bar has jammed	5.1 Change speed (firmware) 5.2 Check and replace 5.3 Check the pusher bar for debris and obstructions and that the pusher ends	4

			are not jammed in their tracks.	
6. Y-axis doesn't find home	Noise from motor resulting from run into mech.stopper	Home sensor broken	Check and replace	8
7. Y-axis speed doesn't match with processor speed	Plate leading edge gets caught in chain mill or processor rollers, buckling the plate,if y-axis speed more than processor speed	Y-axis speed set wrong in firmware	Set speed to 5…10% lower than proc.speed	6
8. Table rising unevenly	Easy to see, looks ugly	Cylinder(s) at dragging side failing	Test cylinders separately and replace faulty ones	5