Problem	Symptoms	Cause(S)	Solution	Rank
Wedgemaster fails to lower /raise	Firmware reports that it failed to lower/raise the wedgemaster	1. Air cylinder is seized 2. Sensor is broken 3. Sensor is not being tripped properly 4. Solenoid valve is unplugged	1. Make sure the air cylinder is extending. 2. Check to make sure the up sensor is undamaged. 3. Make sure the main vacuum airlines do not hinder the motion. 4. Plug in the valve and ensure no wires are broken. Note: The Wedgemaster must be free to fall under its own weight. It is designed so the cylinder can not push down, only pull it up.	
Low vacuum on Wedgemaster	Firmware reports that there is low vacuum at the wedgemaster	1. Slip sheet may be stuck 2. Firmware threshold could be set incorrectly.	1a. Make sure all the 3/8" hoses are pushed fully into their fittings. 1b. Make sure all the hoses are cut absolutely square. 2. Set threshold to?? (check with Carl V)	1

		3. Machine pressure could be too low due to insufficient air supply. *4.Ocup and or Icup could be aimed in the wrong direction due to mechanical failure.	3. Make sure there is enough air getting to the machine according to the site prep document. *4. Check the icup and ocup alignment. Move the picker inside the bay. First, lower the wegemaster, ocup and icup by typing: 'picker ss down' 'picker ss ocup down' 'picker ss icup down' The flat part of the ocup should lie approximately flat on the plate stack when the bay is half full (10mm of plates). The icup should opening should be lined up with the ocup Opening. Diagnois tool: Test the vacuum by turning the vacuum on using 'picker ss vac on' Then, put your hand over the opening. It should suck quite hard…you'll definitely	

			feel it.	
Pcup arm fails to raise/lower		1. Air cylinder is seized 2. Sensor is broken 3. Sensor is not being tripped properly 4. Solenoid is unplugged	1. Replace cylinder 2. Replace the sensor 3. Make sure the sensor tab is tripping the sensor properly. 4. Check the soleniod valve wiring for loose connections etc. Note: The pcup arm must be free to fall under its own weight. It is designed so the cylinder can only pull it up	
Pcup arm drops plates	Plate is not getting lifted probably resulting in a plate not detected on picker error	1. Insufficient air flow to the pcups 2. Plate is somehow stuck in the bay 3. Plates aren't being	1. Make sure the machine is getting enough compressed air according to the site preperation document. 2. Make sure the plates aren't pinned in the bays. 3. Check the air knives in	2

		separated by the air knives 4. P-cups don't swivel properly. 5. Pcup arm does not travel far enough to pick the last plate in the bay.	the bays. None of the holes should be plugged and they should separate the plates when they are on. 4. Make sure the pcups are free to swivel around. They should hang pretty much straight down under their own weight. 5. Remove hose or other obstruction that may be blocking motion	
Picker won't initialize	Firmware reports that picker failed to initialize	1. The gate or drop leaf isn't closed	1.1 Make sure the gate is closed. 1.2 Make sure the drop leaf is up.	
Ejector fingers fail to raise or lower	Firmware reports error that the ejector finger failed to raise/lower	1. Picker may have been crashed causing damage 2. Sensor may be not working or getting tripped	1. Make sure the mechanism has not been damaged by a picker crash. 2. Replace the sensor.	

		correctly 3. Hose blocking motion and preventing fingers from raising 4. Cylinders are seized	 3. Move hoses out of way 4. Replace the ejector finger assembly	
Vacuum cups fail to raise or lower	Firmware reports that plate vacuum is low on the picker	1. Either the vacuum cups aren't raising, or the vacuum is not working.	1.1 Make sure the mechanism is not damaged. 1.2 Make sure the cylinders aren't seized. 1.3 Make sure there are no hoses that are blocking the motion. 1.4 Make sure the vacuum is working 1.5 Make sure they go up and down properly. 1.6 Make sure the vacuum cups aren't ripped or damaged.	