

GAMMA 333LCD

TROUBLESHOOTING GUIDE

NOTE: *The following tips are listed in the order of easiest to hardest. Also listing the most likely solutions first. Try one step at a time.*

DELTA DRIVE/SLIP ERRORS

Make sure the wire hasn't got caught up on anything prior to reaching the machine. Check for wire curl up between drive rollers and encoder. Check for wear/cleanliness of drive rollers, and encoder wheel. Slow down wire feed and acceleration speeds. Adjust the "Slip" (Parameters screen) to a higher number. This makes the anti-slip system less sensitive.

NICKING WIRE

Adjust the "DST" value (Teach screen) to a higher number. If nicking along the length of the strip, increase the "DWB" value(Teach).

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STRIPPING PROBLEMS

Increase gripper pressure to the side with the problem. Slow down the "Pull-off" speed (Parameters screen). Slowing down the "Cut-speed" and possibly adding a small "Cut-wait-time" (Para) could increase the quality of your strips if the blades are dull.

WIRE SLIPPING THROUGH THE GRIPPERS

Note: Wire slippage between the grippers will create an increased wire overhang. Thus causing your insertion depth to vary when addressing your station. Increase gripper pressure to the side with the problem. Check for wear/cleanliness of your grippers. Replace or clean as necessary. Slow down the "Pull-off" speed (Para) to the side with the problem.

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CRIMP FORCE MONITOR PROBLEMS

Re-Teach (Setup, CFA Reference) the crimp. Tighten down wire

straighteners. Slow down the swivel out speed (Para screen two or three). Turn off Press Optimization (Para) and slightly increase the wait-time before press fires. Increase Bad-Limit-Overall (On press OMI display, under setup CFA, limits). Reset CFA default settings, (OMI, Setup CFA, Options) then increase Bad Limit Overall.

LENGTH VARIATIONS Remove any tension that may be on the wire before it enters the machine. For example: pull wire out of the barrel, or off the spool, and lay it on the floor. Loosen the tension on the wire straighteners. Slow down the Wire Feed Speed/Acceleration (Para). Adjust drive roller pressure.