ASTA Troubleshooting Guide

Situation	Possible Solution
The drawer will not open.	Possibility #1: Bad Relay 1. Pull both relays and check pins. If pins are bent or broken, replace relay (part #420) and reseat. 2. If pins appear fine, reseat the relays switching which port they came from. (If it came out of right port, put it in the left and vice versa.) If the drawer opens, you need a new relay (part #420). Possibility #2: Proximity Switch 1. Remove the backside panel then take the cover off the taper drawer. 2. Then examine the drawer rack and locate the two sliders, one on each side of the drawer, and a push bar in the center. 3. On the push bar there is a Proximity Switch with two lights. When the drawer is open and the power is on the light facing the front of the machine should be on. When the drawer is closed the light facing the back should be on. If the light is not on when in these positions, replace the Proximity Switch.
Air pressure is low. (Air Pressure Gauge should read 6 bar (90 lbs.)	Possibility #1: Air Supply 1. Check the air supply source to make sure it is good. 2. Check all connections Possibility #2: Pressure Gauge 1. Remove the back of the taper. 2. Locate the air pressure gauge on the right side of the machine. 3. Lift the blue cap and turn clockwise until it reaches 6 bars.

Situation	Possible Solution
The conveyor belt will not move.	Possibility #1: Bad Relay 1. Pull both relays and check pins. If pins are bent or broken, replace relay (part #420) and reseat. 2. If pins appear fine, reseat the relays switching which port they came from. (If it came out of right port, put it in the left and vice versa.) If the conveyer moves, you need a new relay (part #420). Possibility #2: Belt Motor 1. If the relays are fine but the belt is still not moving than your motor is probably bad. Take the back off the taper. 2. Facing the back of the machine look to the right about half way up the taper until you see the motor. Remove and replace V2A-484/485 (motor with gear).
Tape backing (paper) gets caught up between the tape and the belt.	Possibility #1: Clutch Needs Adjustment 1. Take back cover off taper. 2. Locate the Tape Spool Shaft (gear with a nut and spring) in the left bottom corner. 3. Tighten the nut all the way in and then back it off about 1/8 to 1/4 of a turn.
Neither cylinder head is working.	Possibility #1: Bad Relay 1. Pull both relays and check pins. If pins are bent or broken, replace relay (part #420) and reseat. 2. If pins appear fine, reseat the relays switching which port they came from. (If it came out of right port, put it in the left and vice versa.) If the cylinder head works, you need a new relay (part #420).

Situation	Possible Solution
Both cylinder heads are going down but the tape is not being cut completely on one or both lenses.	1. Remove cylinder cover on drawer. 2. Disconnect air hoses from cylinders (it is a good idea is to mark your hoses and were they connect to before disconnecting). Be sure not to lose the little white washers because if you do it will cause a vacuum leak. Blow air through lines to clear them. 3. Continue working your way to the back of the machine, disconnecting each connection and blowing it out with air. 4. Once you are done, reconnect all your lines making sure that you get your lines connected to the right spot.
The vacuum gauges on the front of the taper doesn't read 45-50 or one of the following happens: • the tape is not cut all the way around the lens • the tape is not securely adhered to the lens • the tape has a rippled look around the edge.	Possibility #1: Blocked Vacuum Lines 1. Remove cylinder cover on drawer. 2. Disconnect air hoses from cylinders (it is a good idea is to mark your hoses and were they connect to before disconnecting them). Be sure not to lose the little white washers because if you do it will cause a vacuum leak. Blow air through lines to clear them. 3. Continue working your way to the back of the machine, disconnecting each connection and blowing it out with air. 4. Once you are done, reconnect all your lines making sure that you get your lines connected to the right spot.

ß

Practical Systems, Inc.
11617 Prospect Road
Odessa, FL 33556
Phone: 727-376-7900 or 800-237-8154
fax: 727-372-1900 or 800-330-3800
email: support@LookToPSI.com
www.LookToPSI.com