



# Trouble Shooting

- ⊙ During the operation, if something is wrong, an error number will show up at the Display Window on the Operation Panel. Check the below List and take the necessary action. Call your dealer or Sankosha if normal operation does not resume.

 <b>WARNING</b>	<p><b>It is extremely dangerous in Control Box.</b></p> <p>Do not touch anywhere unless otherwise specified.</p>
--	--

<b>Information</b>	<ul style="list-style-type: none"> <li>• Please see the “Sensor Diagram” on the last page for the location of each cylinder sensor or button.</li> <li>• You can make sure of the cylinder sensor or button through “Input Test 1” in Service Menu. (Page 25)</li> </ul>
--------------------	--

 <b>CAUTION</b>	<p>If any of [EEE], [EE1], [EE2], [EE3], [EE4], or [EE5] shows up, turn the power OFF and then turn the power ON again <b><u>more than 5 seconds later.</u></b></p> <p>Call your dealer or Sankosha if the normal operation does not resume.</p>
--	--

Error No.	1. Error Item
	2. Error Description
	3. Check Point
E1	1. Emergency Stop Button
	2. Emergency Stop Button is being pressed.
	3. (1) Release the Emergency Stop Button by turning the Button clockwise (to the “→” direction). Display shows “- - 1”. Press Reset Button. (2) Wiring may be the cause if E1 displays even after releasing it. Check the Button itself or check for a possible short circuit in the wire.
E2	1. Left Safety Bar
	2. Left Safety Bar Switch is being pressed.
	3. (1) If you hold the safety guard, error is released when you remove your hand away from it. (“- - 2” shows up on the display window) Make sure the Switch is being pressed due to a hitch of the Safety Guard. (2) The switch may be out of order if E2 displays even though you don’t hold it. Check the Switch itself or check wire (short circuit)
E3	1. Right Safety Bar
	2. Right Safety Bar Switch is being pressed.
	3. (1) If you hold the safety guard, error is released when you remove your hand away from it. (“- - 3” shows up on the display window) Make sure the Switch is being pressed due to a hitch of the Safety Guard. (2) The switch may be out of order if E3 displays even though you don’t hold it. Check the Switch itself or check wire (short circuit)

Error No.	1. Error Item
	2. Error Description
	3. Check Point
E10	1. Inverter Error
	2. Something is wrong with Inverter
	3. If the machine stops because of an inverter problem, turn the power off. Then leave the machine until inside of the inverter has cooled. <b>(More than 2 minutes)</b> Turn the machine on again. The inside parts of inverter get hot. If the power turns ON immediately, the problem could happen again. If the inverter does not work (Error is not released) even after the above operation, call your dealer or Sankosha.
E11	1. Upper Press Arm Close Time Error (Too fast)
	2. Upper press arm closes too fast.
	3. (1) Make sure if the air pressure is set at the required level (0.6MPa) Check and adjust the regulator referring to “Provide Air” of Operation Procedures on page 15. (2) Check the oil amount of the oil damper. (See page 36 “Daily Maintenance 7. Oil Quantity Check for Oil Damper”.) (3) Adjust speed by turning the rod side speed controller of upper press arm cylinder clockwise. If speed does not change even after this adjustment, speed controller may be broken.
E12	1. Upper Press Arm Close Time Error (Too slow)
	2. Upper press arm closes too slowly.
	3. (1) Make sure if the air pressure is set at the required level (0.6MPa) Check and adjust the regulator referring to “Provide Air” of Operation Procedures on page 15. (2) Check if the air does not leak from upper press arm cylinder or solenoid valve (No.4). (3) Adjust speed by turning the rod side speed controller of upper press arm cylinder counterclockwise. If speed does not change even after this adjustment, speed controller may be broken.
E13	1. Upper Press Head Close Time Error (Too slow)
	2. Upper Press Head closes too slowly.
	3. (1) Make sure if the air pressure is set at the required level (0.6MPa) Check and adjust the regulator referring to “Provide Air” of Operation Procedures on page 15. (2) Check if the air does not leak from upper press arm cylinder or solenoid valve (No5) (3) Adjust speed by turning the rod side speed controller of upper press cylinder counterclockwise. If speed does not change even after this adjustment, speed controller may be broken.

Error No.	1. Error Item
	2. Error Description
	3. Check Point
E20	1. Left Start Button Error (When DIP 3 is OFF)
	2. Left Start Button remains ON more than 0.5 seconds.
	3. (1) Check if the Button is being pressed. (2) Check the Button itself or if there could be short circuit in the wire.
E21	1. Reset Button Error
	2. Reset Button remains ON more than 15 seconds.
	3. (1) Check if the Button is being pressed. (2) Check the Button itself or if there could be short circuit in the wire.
E22	1. Left Start Button Error (When DIP 3 is ON)
	2. Left Start Button remains ON more than 15 seconds.
	3. (1) Check if the Button is being pressed. (2) Check the Button itself or if there could be short circuit in the wire.
E23	1. Right Start Button Error
	2. Right Start Button remains ON more than 15 seconds.
	3. (1) Check if the Button is being pressed. (2) Check the Button itself or if there could be short circuit in the wire.
E24	1. Steam Pedal Error
	2. Steam Pedal remains ON more than 15 seconds.
	3. (1) Check if the Pedal is being pressed. (2) Check the Button itself or if there could be short circuit in the wire.
E25	1. Left Vacuum Pedal Error
	2. Left Vacuum Pedal remains ON more than 3minutes.
	3. (1) Check if the Pedal is being pressed. (2) Check the Button itself or if there could be short circuit in the wire.
E26	1. Blower Pedal Error
	2. Blower Pedal remains ON more than 3minutes.
	3. (1) Check if the Pedal is being pressed. (2) Check the Button itself or if there could be short circuit in the wire.
E27	1. Right Vacuum Pedal Error
	2. Right Vacuum Pedal remains ON more than 3minutes.
	3. (1) Check if the Pedal is being pressed. (2) Check the Button itself or if there could be short circuit in the wire.

Error No.	1. Error Item
	2. Error Description
	3. Check Point
E41*	1. Upper Press Arm Close Time Error (Fast) ※Although an error number shows up, you can run the machine.
	2. Upper press arm closes faster than normal.
	3. (1) Make sure if the air pressure is set at the required level (0.6MPa) Check and adjust the regulator referring to “Provide Air” of Operation Procedures on page 15. (2) Check oil amount of the oil damper. (See page 36 “Daily Maintenance 7. Oil Quantity Check for Oil Damper”.) (3) Adjust the speed by turning the rod side speed controller of upper press arm cylinder clockwise. If speed does not change even after this adjustment, speed controller may be broken.
E42*	1. Upper Press Arm Close Time Error (Slow) ※Although error number shows up, you can run the machine.
	2. Upper press arm closes slowly than normal.
	3. (1) Make sure if the air pressure is set at the required level (0.6MPa) Check and adjust the regulator referring “Provide Air” of Operation Procedures on page 15. (2) Check if the air does not leak from the upper press arm cylinder or the solenoid valve (No.1). (3) Adjust the speed by turning the rod side speed controller of upper press arm cylinder counterclockwise. If speed does not change even after this adjustment, the speed controller may be broken.
E43*	1. Upper Press Close Time Error (Slow) ※Although error number shows up, machine operation is possible.
	2. Upper Press closes more slowly than normal.
	3. (1) Make sure if the air pressure is set at the required level (0.6MPa) Check and adjust the regulator referring “Provide Air” of Operation Procedures on page 15. (2) Check if the air does not leak from upper press arm cylinder or solenoid valve (No2) (3) Adjust the speed by turning the rod side speed controller of upper press cylinder counterclockwise. If speed does not change even after this adjustment, the speed controller may be broken.
E98	1. Display board external input error
	2. Input of the display board failed to work properly.
	3. (1) Confirm whether or not the entry connector doesn't have a malfunction by the display board. (2) Confirm whether or not there is not garbage on the display board. Clean a board by air blow-dry and so on. (3) It is necessary to exchange a display substrate when even if it does not improve (1),(2).
E99	1. 24V Error
	2. Either safety bar operated in an instant in the vibration and so on.
	3. The error will be released when you press the reset button. When occurring many times, adjust a speed controller at the part where the impact is big.

**\*E41~E43**

Although these errors show up, you can continue to operate the machine. When the upper press arm returns to its initial position, the error is released. The error is also released when the Reset Button is pressed.