

# Trouble Shooting

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



## WARNING

**It is extremely dangerous in Control Box.**

Do not touch anywhere unless otherwise specified.



## CAUTION

If any of [EEE], [EE1], [EE2], [EE3], [EE4], or [EE5] shows up, Turn the power OFF and turn the power ON again **more than 5 seconds later**.

Call your dealer or Sankosha if the normal operation does not resume.

## Information

Please see the “Sensor Diagram” on the last page for the location of each cylinder sensor or button.

Error No.	1. Error Item
	2. Error Description
	3. Check Point
<b>E 1</b>	1. Emergency Stop Button
	2. The button is kept activating.
	3. (1) Emergency Stop Button is not released. Insuring safety, release Emergency Stop Button by turning the Button clockwise (→ direction), and press the Reset Button. (2) Wiring may be the cause if E1 displays even after releasing it. Check the Button itself or check if the wire is cut.
<b>E 2</b>	1. Tuck Left Press Safety Bar
	2. Tuck Left Press Safety Bar Switch is kept activating.
	3. (1) In the case of keep pushing safety bar, it will be shown “- - 2” if you release the bar. Please check whether the bar is kept pushing by something or not. If you push reset button after confirming the safety, the machine will return to its original position. (2) Even if it is not pressed button, if it is showing “E2” error, it is a switch problem. Please check whether switch is broken, shape change of safety bar, or wire connection is loose or disconnected. (3) The switch is activated due to heavy shock of press head. → Adjust speed controller of tuck press cylinder and sleeve arm cylinder. Check air pressure. (Sleeve Arm Air Pressure: <b>0.3MPa</b> , reference Page 14)
<b>E 3</b>	1. Tuck Right Press Safety Bar
	2. Tuck Left Press Safety Bar Switch is kept activating
	3. (1) In the case of keep pushing safety bar, it will be shown “- - 3” if you release the bar. Please check whether the bar is still being pushed by something or not. If you the push reset button after confirming the safety, the machine will return to its original position. (2) Even if it is not pressed button, if it is showing “E3” error, it is a switch problem. Please check whether switch is broken, shape change of safety bar, or a wire connection is loose or disconnected. (3) The switch is activated due to heavy shock of press head. → Adjust the speed controller of tuck press cylinder and sleeve arm cylinder. Check air pressure. (Sleeve Arm Air Pressure: <b>0.3MPa</b> , reference Page 14)

Error No.	1. Error Item
	2. Error Description
	3. Check Point
E 4	1. Shoulder Press Left Safety Bar
	2. Shoulder Left Press Safety Bar Switch is kept activating
	3. (1) In the case of keep pushing the safety bar, it will be shown “- - - 4” if you release the bar. Please check whether the bar is still being pushed something or not. If you push the reset button after confirming the safety, the machine will return to its original position. (2) Even if the button is not pressed, if it is showing “E4” error, it is a switch problem. Please check whether switch is broken, shape change of safety bar, or a wire connection is loose or disconnected. (3) The switch is activated due to heavy shock of press head. → Adjust speed controller of shoulder press cylinder.
E 5	1. Shoulder Press Right Safety Bar
	2. Shoulder Right Press Safety Bar Switch is kept activating
	3. (1) In the case of keep pushing the safety bar, it will be shown “- - - 5” if you release the bar. Please check whether the bar is still being pushed by something or not. If you push the reset button after confirming the safety, the machine will return to its original position. (2) Even if the button is not pressed, if it is showing “E5” error, it is a switch problem. Please check whether switch is broken, shape change of safety bar, or a wire connection is loose or disconnected. (3) The switch is activated due to heavy shock of press head. → Adjust speed controller of shoulder press cylinder.
E 6	1. Front Press Left Safety Bar
	2. Front Press Left Safety Bar Switch is kept activating
	3. (1) In the case of keep pushing the safety bar, it will be shown “- - - 6” if you release the bar. Please check whether the bar is still being pushed by something or not. If you push reset button after confirming the safety, the machine will return to its original position. (2) Even if the button is not pressed, if it is showing “E6” error, it is a switch problem. Please check whether switch is broken, shape change of safety bar, or a wire connection is loose or disconnected. (3) Check air pressure. (Front Press Slide Air Pressure: <b>0.3MPa</b> , reference Page 14)
E 7	1. Front Press Right Safety Bar
	2. Front Press Right Safety Bar Switch is kept activating.
	3. (1) In the case of keep pushing the safety bar, it will be shown “- - 7” if you release the bar. Please check whether the bar is kept pushing by something or not. If you push reset button after confirming the safety, the machine will return to its original position. (2) Even if it is not pressed button, if it is showing “E7” error, it is a switch problem. Please check whether switch is broken, shape change of safety bar, or wire connection is loose or disconnected. (3) Check air pressure. (Front Press Slide Air Pressure: <b>0.3MPa</b> , reference Page 14)

Error No.	1. Error Item
	2. Error Description
	3. Check Point
<b>E30</b>	1. Front Press Press Position Sensor Error
	2. It is not detected Front Press Press Position sensor (SQ3) even if press head is at position.
	3. (1)When you touch magnet to sensor at the rod side (left) of cylinder, the red light of sensor ①does light   ... it is considered wrong position of sensor. Please loosen the band of it, and find lighting zone. Please place center of lighting zone and fix it. ②doesn't light ... it is sensor problem. Check sensor is broken, or wire connection (such as looseness or disconnection). (2) Check air pressure. (Front Press Slide Pressure: <b>0.3MPa</b> , reference Page 14)
<b>E31</b>	1. Front Press Open Sensor Error
	2. It is not detected Front Press Open sensor (SQ01) even if press is activated.
	3. (1)When you touch magnet to sensor at the head side of cylinder, the red light of sensor ... ①does light   ... it is considered wrong position of sensor. Please loosen the band of it, and find lighting zone. Please place center of lighting zone and fix it. ②doesn't light ... it is sensor problem. Check sensor is broken, or wire connection (such as looseness or disconnection). (2) Check air pressure. (Main Pressure: <b>0.6MPa</b> , reference Page 14)
<b>E32</b>	1. Reset Button Error
	2. Reset Button keeps activated when the main power is ON, or machine is at the original position.
	3. (1) In the case of keep pushing button, please release the button. Also, please remove anything which is pushing button. If you press the button again, the machine will return to its original position. (2) Even if the button is not pressed, if it is showing "E32" error, it is a switch problem. Please check whether the switch is broken or a wire connection is loose or disconnected.
<b>E33</b>	1. Front Press Left Brake Sensor Error
	2. It is not detected Front Press Left Brake Sensor (SQ4) and is detected Left Position Sensor (SQ3) even if Front Transfer is moving correctly.
	3. When you touch magnet to second sensor from rod side of cylinder, it is sensor problem if red light doesn't light. Check sensor is broken, or wire connection (such as looseness or disconnection).
<b>E34</b>	1. Front Press Right Brake Sensor Error
	2. It is not detected Front Press Right Brake Sensor (SQ5) and is detected Original Position Sensor (SQ6) even if Front Transfer is moving correctly.
	3. When you touch magnet to second sensor from head side of cylinder, it is sensor problem if red light doesn't light. Check sensor is broken, or wire connection (such as looseness or disconnection).

Error No.	1. Error Item
	2. Error Description
	3. Check Point
<b>E35</b>	1. Left Cuff Clamp Button Error
	2. (1) Cuff Clamp Button keeps activated if the button is kept pressing by something when the main power is ON, or the machine is at the original position. (2) Cuff Clamp Button is kept pressing for more than 5 seconds even if you release the button.
	3. (1) In the case of a button being pushed by something, the error will be released if you release it from the button and push the reset button. (2) Even if it is not pressed button, if it is showing “E35” error, it is a switch problem. Please check whether the switch is broken or a wire connection is loose or disconnected.
<b>E36</b>	1. Press Start Button Error
	2. Press Start Button keeps activated when the main power is ON, or the machine is at the original position.
	3. (1) In the case of a button being pushed by something, the error will be released if you release it from the button and push the reset button. (2) Even if it is a not pressed button, if it is showing “E36” error, it is a switch problem. Please check whether switch is broken or a wire connection is loose or disconnected.
<b>E37</b>	1. Short Button Error
	2. Short Button keeps activated when the main power is ON.
	3. (1) In the case of a button being pushed by something, error will be released if you release the button and push the reset button. (2) Even if it is not a pressed button, if it is showing “E37” error, it is a switch problem. Please check whether switch is broken or a wire connection is loose or disconnected.
<b>E38</b>	1. Foot Pedal Error
	2. Foot Pedal keeps activated when the main power is ON, or machine is at the original position.
	3. (1) In the case of keep pushing button, please release the pedal. Also, please remove anything which is pushing the pedal. If you press the Reset button again, the machine will return to its original position. (2) Even if the button is not pressed, if it is showing “E38” error, it is a switch problem. Please check whether the switch is broken or a wire connection is loose or disconnected.
<b>E39</b>	1. Shoulder Press / Slide Start Button Error
	2. (1) Shoulder Press / Slide Start Button keeps activated by something when the main power is ON, or the machine is at the original position. (2) Shoulder Press / Slide Start Button is kept pressing for more than 5 seconds even if you release the button.
	3. (1) In the case of a button being pushed by something, the error will be released if you release it from the button and push the reset button. (2) Even if it is not pressed button, if it is showing “E39” error, it is a switch problem. Please check whether switch is broken or a wire connection is loose or disconnected.

Error No.	1. Error Item
	2. Error Description
	3. Check Point
<b>E40</b>	1. Shoulder Press Close Sensor Error
	2. It is not detected Shoulder Press Close sensor (SQ08) even if press is activated.
	3. (1) When you touch magnet to sensor at the rod side of cylinder, the red light of sensor ... ①does light ... it is considered wrong position of sensor. Please loosen the band of it, and find lighting zone. Please place center of lighting zone and fix it. ②doesn't light ... it is sensor problem. Check sensor is broken, or wire connection (such as looseness or disconnection). (2) Check air pressure. (Main Pressure: <b>0.6MPa</b> , reference Page 14)
<b>E41</b>	1. Shoulder Press Open Sensor Error
	2. It is not detected Shoulder Press Open sensor (SQ07) even if press is activated.
	3. (1)When you touch magnet to sensor at the head side of cylinder, the red light of sensor ... ①does light ... it is considered wrong position of sensor. Please loosen the band of it, and find lighting zone. Please place center of lighting zone and fix it. ②doesn't light ... it is sensor problem. Check sensor is broken, or wire connection (such as looseness or disconnection). (2) Check air pressure. (Main Pressure: <b>0.6MPa</b> , reference Page 14)
<b>E42</b>	1. Long Button Error
	2. Long Button keeps activated when the main power is ON.
	3. (1) In the case of a button being pushed by something, the error will be released if you release the button and push the reset button. (2) Even if it is not a pressed button, if it is showing "E42" error, it is a switch problem. Please check whether switch is broken or a wire connection is loose or disconnected.
<b>E49</b>	1. Front Press Close Sensor Error
	2. It is not detected Front Press Close sensor (SQ2) even if press is activated.
	3. (1)When you touch magnet to sensor at the rod side of cylinder, the red light of sensor ... ①does light ... it is considered wrong position of sensor. Please loosen the band of it, and find lighting zone. Please place center of lighting zone and fix it. ②doesn't light ... it is sensor problem. Check sensor is broken, or wire connection (such as looseness or disconnection). (2) Check air pressure. (Main Pressure: <b>0.6MPa</b> , reference Page 14)
<b>E50</b>	1. Front Press Original Position Sensor Error
	2. It is not detected Front Press Original Position sensor (SQ6) even if press head is at position.
	3. (1)When you touch magnet to sensor at the head side of cylinder, the red light of sensor ①does light ... it is considered wrong position of sensor. Please loosen the band of it, and find lighting zone. Please place center of lighting zone and fix it. ②doesn't light ... it is sensor problem. Check sensor is broken, or wire connection (such as looseness or disconnection). (2) Check air pressure. (Front Press Slide Pressure: <b>0.3MPa</b> , reference Page 14)

Error No.	1. Error Item
	2. Error Description
	3. Check Point
<b>E51</b>	1. Vacuum Motor Thermal Switch
	2. Thermal of Magnetic Contactor KM01 for Vacuum Motor works.
	3. Green trip of Magnetic Contactor is retracted and you can't see it when it works. In case of Thermal of Magnetic Contactor works, it is considered overload by wire cutting or continuous motor running under the high temperature. Fix the problem first and press blue Reset Bar of Magnetic Contactor. The error will be released when you press the reset button.
<b>E52</b>	1. Error on unused terminal (XO 02)
	2. Unused terminal(XO 02) is short-circuited.
	3. Check if wirings are short-circuited.
<b>E53</b>	1. Cuff Unit Go-up Button Error
	2. The button is ON when the power is ON.
	3. (1) Check if the button is caught or being press for some reason. (2) The button is malfunctioned. Check if the button is damaged or if there is a short circuit in the wire.
<b>E54</b>	1. Cuff Unit Go-down Button Error
	2. The button is ON when the power is ON.
	3. (1) Check if the button is caught or being press for some reason. (2) The button is malfunctioned. Check if the button is damaged or if there is a short circuit in the wire.
<b>E55</b>	1. Short Sleeve Button Error
	2. The button is ON when the power is ON.
	3. (1) Check if the button is caught or being press for some reason. (2) The button is malfunctioned. Check if the button is damaged or if there is a short circuit in the wire.
<b>E56</b>	1. Size Adjustment Button Error
	2. The button is ON when the power is ON.
	3. (1) Check if the button is caught or being press for some reason. (2) The button is malfunctioned. Check if the button is damaged or if there is a short circuit in the wire.

Error No.	1. Error Item
	2. Error Description
	3. Check Point
<b>E60</b>	1. Inverter error
	2. Inverter irregularities.
	3. If the machine stopped due to an inverter error, turn the power off till the inside of the inverter gets cool, then turn it back on. If you turn it on before the inverter gets cool, the machine may stop again. If the inverter does not work despite the above please contact your local Sankosha dealer or Sankosha USA, Inc.
<b>E90</b>	1. Model Name Error
	2. The program does not match the model name written in the nonvolatile memory.
	3. Check if correct program is written for the product.
<b>E91</b>	1. Error in DIP switches for model identification.
	2. DIP switches are not correctly set.
	3. Check if the program is written correctly. If it is written correctly, check DIP switch settings. (Setting Value 0x03 DIP 1~6: OFF, DIP7•8: On)
<b>-E99</b>	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. (Portion of operation when especially an error occurs).
<b>EC-1</b>	1. Warning for cover change timing.(Standard)
	2. Time to change covers. You have done 25,000 presses/finishes since last time.
	3. Press and hold Reset Button for more than 1 second. Buzzer and error message will be cancelled. After cover change, be sure to reset the cover counter referring to “About the Cover Counter” of page 26.