

# Trouble Shooting



Do not perform any inspection work until machine totally stops and set main switch QS1 OFF (○) that controls the right side of the electric-controlled box. Do not carry on any inspection until heating part temperature decreases to some extent enough not to get heat injury.

Below abnormality is recorded as below.

Since next page, reference related to mal-function part and disposal method is recorded. Please identify abnormality cause before entrust any one with repairing.



Beside, please refer to Chapter 6 “Maintenance and inspection” for filter disassembly.

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## The convey blower does not rotate

Searching for Abnormity	Solution	Notes
Please check that indication light HL1 is on or not.	Please turn primary power supply and main switch to ON  (I). Please press preparatory switch to turn it on.	Please refer to “Chapter 4. Preparation for operation -3. Power supply”
[MJ5-i-150~650]  Please open the gear of electric-controlled box and check if motor-protective circuit-breaker QM1 is ON (I) or not. Besides, please check if magnetic connection point of electromagnetism switch is fused or consumed.	If it is fused or consumed, or abnormal in make and break, please change a new contactor.	<u>The total number of repeated make and break is 2 million times.</u>
[MJ5-i-150~650]  Please check if blower overload occurs or not.	After fixing, please open the gear of electric-controlled box and turn black knob of motor-protective circuit-breaker QM1 to ON (I).	Please refer to this chapter “Blower is overloading, thermal relay trips” to identify the cause.
[MJ5-i-1500]  Please check if frequency convertor alarm occurs or not.	Please set main switch QS1 OFF (○) to remove alarm.	When inverter U2 inside of electric-controlled box does not work normally, please fix or replace it.
Please check if the limit switch of Jet Clone is on or not in the condition of discontented stuff.	When the limit switch is turned ON, please refer to “Chapter 6 Maintenance- <i>Jet Clone</i> inspecting” to adjust the limit switch.	If limit switch is not proper adjusted, though in the condition of contented stuff in Jet clone, feed-in convey yet not to stop, please pay enough attention to that.
Please check level switch and level sensor sensibility of feed-in convey side Jet Clone	Please refer to “Chapter 6. Maintenance-Sensitivity adjustment of level switch or level sensor” to adjust.	If limit switch is not proper adjusted, though in the condition of contented stuff in Jet clone, feed-in convey yet not to stop, please pay enough attention to that.

### Dry blower does not rotate

Searching for Abnormity	Solution	Notes
Please check preparatory switch is on or not.	Please set primary side power and main switch QS1 to on (I). Please press preparatory switch and indicator turns on.	Please refer to “Chapter 4. Preparation for operation-3. Power supply”
Please check if [  ] on “Home” is pressed and indicator turned on or not.	Please press [  ] if it's light is off.	Drying can be triggered in the condition of setting start timer after the set time is due.
Please make sure if blower overload alarms occurred or not.	After fixing, please open the gear of electric-controlled box and press reset button of thermal relay FR1A.	For its cause, please refer to “Blower undergoing overload, Thermal relay trips” on this chapter.
Please check if frequency convertor alarm occurs or not.	Please set main switch QS1 OFF (○) to remove alarm.	When inverter U1 inside of electric-controlled box does not work normally, please fix or replace it.

### Regeneration blower does not rotate

Searching for Abnormity	Solution	Notes
Please check if blower overload alarm occurred or not.	After fixing, please open the gear of electric-controlled box and press reset button of thermal relay FR1B.	For its cause, please refer to this chapter “The blower does overloaded operation and the thermal relay trips”
Please check if inverter alarm occurred or not.	Please set main switch when QS1 OFF (○) to eliminate the alarm.	When inverter U1 inside of electric-controlled box does not work normally, please fix and replace it.

The blower does overloaded operation and the thermal relay trips

Searching for Abnormity	Solution	Notes
Please take out the filter pot in the convey filter cover to check if there is blockage.	If there is blockage, please blow adherents on the inner side of filter pot away by clean dry air.	If the filter pot is too aging to remove the adherents, please change a new one.
Please take out the filter pot in the drying filter cover to check if there is blockage.	If there is blockage, please blow adherent on the inner side of filter pot away by clean dry air.	If the filter pot is too aging to remove the adherents, please change a new one.
Please take off regeneratin filter and check if there is any blockage.	If there is blockage, please blow adherent on the inner side of filter away by clean dry air.	If the filter is too aging to remove the adherent, please change a new one.
Please check if connection point of contactor KM2 inside of electric-controlled box is fused or consumed.	If it does not work properly, please replace it with a new one.	<u>The total number of repeated make and break is 2 million times.</u>
Please check if thermal relay inside of electric-controlled box is set nominal value or not.	Please refer to “The thermal relay setting value of every model” and set thermal relay the nominal value.	Please set primary side power “OFF”, before perform any operation.
Please check if inverter U1 or U2 works normally or not.	Please repair or replace it with a new one.	


### A little air flow rate of the blower

Searching for Abnormity	Solution	Notes
Please take out the filter pot in the convey filter cover to check if there is blockage.	If there is blockage, please blow adherent on the inner side of filter pot away by clean dry air.	If the filter pot is too aging to remove the adherent, please change a new one.
Please take out the filter pot in the drying filter cover to check if there is blockage.	If there is blockage, please blow adherent on the inner side of filter pot away by clean dry air.	If the filter pot is too aging to remove the adherent, please change a new one.
Please take off regeneration filter to check if there is blockage.	If there is blockage, please blow adherent on the filter away by clean dry air.	If the filter is too aging to remove the adherent, please change a new one.
Please check if the connecting tube inside the dehumidifying device, the dehumidifying device, and the connecting tube of drying hopper are broken or not, and if there are looses on connection.	If tubes are broken, please change new tubes. If there are looses on connection, please tighten up.	If being sure of air leakage, please stop the device. Start operation again after sufficient cooling down of temperature of the heating part.

\* This machine is equipped with wind volume optimization, as you can check it through [Power] on the "Home ".


### The change of the dry temperature is large

Searching for Abnormity	Solution	Notes
Please take out the filter pot in the drying filter cover to check if there is blockage.	If there is blockage, please blow adherent on the inner side of filter pot away by clean dry air.	If the filter pot is too aging to remove the adherent, please change a new one.
Please take off regeneration filter to check if there is blockage.	If there is blockage, please blow adherent on the filter away by clean dry air.	If the filter is too aging to remove the adherent, please change a new one.

When [  ] on the "Home" flickers, temperature drops, but this is normal.

## The drying temperature doesn't go up or go down

Searching for Abnormity	Solution	Notes
Please check if the connect tube inside the dehumidifying device, the dehumidifying deice, and the connecting tube of drying hopper are broken or not, and if there are looses on connection.	If tubes are broken, please change new tubes, If there are looses on connection, please tighten up.	If being sure of air leakage, please stop the device. Start operation again after sufficient cooling down of the heating part.
Please check if circuit-breaker FS3 used by drying heater power inside of the electric-controlled box is cut off or not.	Please connect the power supply of circuit-breaker FS3.	Please set primary side power "OFF" before performing any operations.
Please check if wire to dry heater is broken or not.	If wire is fused or consumed, please replace it with a new one.	Please set primary side power supply "OFF" after machine stop operation. Start operation again after sufficient cooling down of the heater.

\* When [  ] on the "Home" flickers, temperature drops, but that is normal.

## The resin moisture content does not go down

Searching for Abnormity	Solution	Notes
Please check if circuit-breaker FS3 used by drying heater power inside of the electric-controlled box is cut off or not.	Please connect power supply of circuit-breaker FS3.	Please set primary side power "OFF" before performing any operation.
Please check if circuit-breaker FS4 used by regeneration heater power inside of the electric-controlled box is cut off or not.	Please connect power supply of No.1 feed alarm No.1 feed alarm circuit-breaker FS4.	Please set primary side power "OFF" before performing any operation.
Please take out the filter pot in the drying filter cover to check if there is blockage.	If there is blockage, please blow adherent on the inner side of filter pot away by clean dry air.	If the filter pot is too aging to remove the adherents, please change a new one.
Please take off regeneration filter to check if there is blockage.	If there is blockage, please blow adherent on the inner side of filter away by clean dry air.	If the filter is too aging to remove the adherent, please change a new one.
Please check if the connect tube inside the dehumidifying device, the dehumidifying deice, and the connecting tube of drying hopper are broken or not, and if there are looses on connection.	If tubes are broken, please change new tubes, If there are looses on connection, please tighten up.	If being sure of air leakage, please stop the device. Start operation again after sufficient cooling down of the heating part.
Please check if wire to regeneration heater is broken or not.	If wire is fused or consumed, please replace it with a new one.	Please set main switch "OFF" after machine stops operation. Start operation again after sufficient cooling down of the heater.

Even though set primary side electricity power supply "ON", touch screen controller still does not show anything.

Searching for Abnormity	Solution	Notes
Please check main switch QS1 on side of the electric-controlled box is ON (   ) or not.	Please set it "ON"	The total number of repeated make and break is 10 thousands times. Please replace main switch when the opening and shutting function doesn't operate normally.
Please check if every miniature circuit-breaker FS5~8 inside of the electric-controlled box is OFF or not.	Please check conductor configuration and components inside of electric-controlled box and set them ON after that.	Please set primary side power supply "OFF" before performing any inspection.

### Equipment power supply protector or breaker trips.

Searching for Abnormity	Solution	Notes
Please check if there is short cut in the electric circuit.	Please get rid of the short cut.	To avoid any danger or accident, please do not ask anyone who do not have the sufficient electricity knowledge, therefore , please entrust Matsui with this task.

### The overheat alarm occurs

Searching for Abnormity	Solution	Notes
Please check if there is deviation on the set value of drying overheat preventor in the electric -controlled box. Set value of drying overheat preventor: drying temperature +20°C(36°F)	Please make correction if deviation exists.	To avoid electricity shock, please set primary side power supply "OFF" before inspection.
Please take out filter pot in the dry filter cover to check if there is blockage.	If there is blockage, please blow adherent on the inner side of filter pot away by clean dry air.	If the filter pot is too aging to remove the adherent, please change a new one.
Please take off regeneration filter to check if there is blockage.	If there is blockage, please blow adherent on the filter away by clean dry air.	If the filter is too aging to remove the adherent, please change a new filter pot.
Solid state socket connector V1[V10,V11] inside of the electric-controlled box has been conditioned to OUTPUT.	Solid state socket connector may not function properly.  Please check and replace it with a new one if need to.	To avoid any danger or accident, please do not ask anyone who don't have a sufficient knowledge of electricity, therefore, please entrust us with this task.

The thermal relay setting value of every model (A)

Model Power	MJ5-i-150			MJ5-i-350		
	Drying blower FR1A	Regeneration blower FR1B	Convey blower QM1	Drying blower FR1A	Regeneration blower FR1B	Convey blower QM1
AC200V 50/60Hz	1.0A	1.0A	4.8/6.2A	1.9A	1.0A	4.8/6.2A
AC220V 60Hz	0.9A	0.9A	5.8A	1.9A	0.9A	5.8A
AC380V 50Hz	0.5A	0.5A	2.8A	1.1A	0.5A	2.8A
AC400V 50Hz			2.9A			2.9A
AC415V 50Hz			3.1A			3.1A
AC440V 60Hz	0.5A	0.5A	3.1A	1.2A	0.5A	3.1A

Model Power	MJ5-i-650			MJ5-i-1500		
	Drying blower FR1A	Regeneration blower FR1B	Convey blower QM1	Drying blower FR1A	Regeneration blower FR1B	Convey blower U2
AC200V 50/60Hz	5.0A	1.9A	4.8/6.2A	11.7A	5.0A	10.0A
AC220V 60Hz	4.6A	1.9A	5.8A	10.9A	4.6A	9.2A
AC380V 50Hz	2.6A	1.1A	2.8A	6.4A	2.6A	5.3A
AC400V 50Hz			2.9A	6.2A	2.6A	5.1A
AC415V 50Hz			3.1A	6.1A	2.5A	5.0A
AC440V 60Hz	2.5A	1.2A	3.1A	6.0A	2.5A	4.8A