

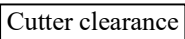
Troubleshooting & Remedies

This chapter describes troubleshooting for the standard product.
Please check before request for repair.





Stop the operation and cut off the primary power supply before checking work start.

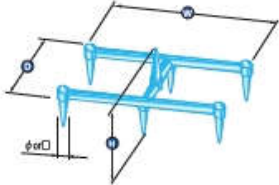
Abnormal sound during operation is generated. Lowering of granulating ability.

Check point	Remedy	Precaution
Check whether the feed hopper and cutting chamber of granulator are clamped securely.	Tighten the clamp of each part securely.	The hopper should be assembled firmly.
Check mixing of the foreign material in the feed hopper and granulator.	Remove foreign material. Then, replace when there is a damaged part.	Perform work after the primary power supply cut off. To purchase parts or for replacement, make sure to contact Service division.
Check whether the adjustment of the interval for rotating cutters and fixed cutters is correct.	<p>※ Cutter assembly and clearance</p> <p>Please refer to the drawing  in Chapter3.</p> <p>Manual rotation handle is on the side of the big rotary cutter. Insert it into the hole for manual rotation, and rotate it slowly in anti-clockwise direction, and insert shim gauge to check the following clearance gap.</p> <ul style="list-style-type: none"> • Clearance gap between the fixed cutter and the small-rotating cutter A 0.2 mm shim gauge can be inserted. • Clearance gap between the fixed cutter and the big-rotating cutter A 0.2 mm shim gauge can be inserted. • Clearance gap between the big-rotating cutter and the bed crashing cutter A 0.2 mm shim gauge can be inserted. • Clearance gap between the scraper and the small-rotating cutter A 0.3 - 0.4 mm shim gauge can be inserted. 	<p>Perform work after the primary power supply is cut off.</p> <p>Refer to Chapter 7. Maintenance and check, 5-3 How to gap adjust the rotating cutters and fixed cutters.</p>
Check whether the edge of the fixed cutters and rotating cutters is exhausted or is deficient.	Replace the fixed cutters or rotating cutters.	Please refer to our after-service department.
Check whether the granulating room is full of crushed material.	Check whether the receive box in the lower part of granulator, etc. become full and whether bridge condition occur. And then remove the cause of such problem.	Check whether the conveyor is working properly

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Granulator does not start.		
Check point	Remedy	Precaution
Check whether the feed hopper is securely closed. And, check whether foreign material in the clamp part of the feed hopper is caught.	<ul style="list-style-type: none"> Remove foreign materials, and completely close the feed hopper. Fasten up the rotary lock. Completely screw up the rotary knob of safety lock of feed hopper. 	<p> WARNING</p> <p>Please switch off your power supply before any check and remedy. Carry out any work after making sure that the device is not in operation.</p>
Check whether the drawer is securely closed.	<ul style="list-style-type: none"> Loosen the fixation rotary knob on the drawer. Holding the drawer handle and slowly open it. Holding the handle of drawer, slowly close it. Please well lock the fixation rotary knob on the drawer. 	<p> WARNING</p> <p>Inserting hand and finger into the closing part is forbidden. Laceration and fracture will be caused if hand or finger get pinched.</p> <p>To repair or replace the limit switch, make sure to contact our after-sale division.</p>
Please check if the collection box is well assembled.	Loosen the lock of collection box, and withdraw it (KKB/SKB/receiving box). Please insert the collection box (KKB/SKB/receiving box) back, and screw up the lock to prevent it from sliding out.	Contact to our after-sale division about the repair and the replace for operation box.
Operation box	Check and maintenance should be carried out by a person with sufficient electric knowledge in your company.	

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Overload operation, fan motor trip		
Check point	Remedy	Precaution
<p>Check whether overload is caused by feeding too many runners.</p> <p>Check whether too many runners are being thrown into the feed hopper.</p> 	<p>Please check whether the runners exceed the maximum standard size.</p> <p><Sprue runner max. cross section: φ or □></p> <p>Standard cutter 5*5---7 mm</p> <p>Standard cutter 5*6---9 mm</p> <p>Please remove the runners inside the feed hopper.</p>	<p>Perform work after the primary power supply is cut off.</p> <p>When exceeding max. standard runner size, request us to do the granulation test.</p> <p><u>(Use the moment max. load electric current at below twice motor rating.)</u></p> <p>Insert runner in batches in each molding period.</p>
<p>Check if there is foreign material in the feed hopper and granulator. (Note 1)</p>	<p>Remove the foreign material. Particularly, check if metals other than a granulating runner are mixed.</p> <p>If they are mixed, immediately stop the device, and remove all. Also remove materials in the secondary side.</p> <p>If there is any damaged component, replace it.</p>	<p>Perform work after the primary power supply is cut off.</p> <p>If any metal is mixed, stop all operations, remove crushed materials and store them. Then search for reason.</p> <p>To purchase parts or replace, make sure to contact Service division</p>
<p>Check whether the granulating ability has lowered, and whether there is buzz and rattle.</p>	<p>Please eliminate the cause of the granulating ability lowering.</p>	<p>Refer to this chapter. "Abnormal sound during operation is generated. Lowering of granulating ability."</p>
<p>Check whether the bearing of the driving part is in an overheating condition.</p> <p>Check whether the drive motor properly starts.</p>	<p>Check whether it turns smoothly without the abnormal with handle for manually.</p> <p>If it hardly rotates or cannot rotate, the bearing or drive geared motor is damaged. Then repair or replace the bearing or drive geared motor.</p>	<p>Perform work after the primary power supply is cut off.</p> <p>Contact our Service division about the purchase and the replace of bearing and motor.</p>
<p>Check whether the power supply cord of the motor is disconnected.</p> <p>Check whether there is looseness in the connection part.</p>	<p>Tighten the connection part of the power supply.</p> <p>Replace the power supply cord.</p>	<p>Perform work after the primary power supply is cut off.</p>

※When the thermal tripped, always, removing the cause of over load, restarts it after passing for above

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about 5 minutes and the motor temperature's falling sufficiently.

Motor damage will be caused when the device is restarted before the temperature falling down.

IMPORTANT

(NOTE 1) When foreign material mixes, please be sure to find out the cause, make a judgement if the device could be resumed.

Many defectives are in granulated products, and materials are bridged in collection box		
Check point	Remedy	Precaution
Some PP, PE materials and soft materials may not be suitable for the low-speed granulator, depending on its grade.	Check whether materials are bridged in the lower receiving (suction) box, or whether there is a problem in the conveying line. If there is problem, please use middle-speed or high-speed granulator.	Please contact our Service division.
Nylon material containing glass may be bridged in the lower receiving (suction) box, depending on its grade.	Check whether materials are bridged in the lower receiving (suction) box and if transportation failure has been caused.	