

Tray Sealing Machines TS400 / TS400N

Fault	Possible cause	Action
Temperature controller displays FFF	Broken probe PT100	Replace probe
	Defective cable in probe supply cable	Replace cable
	Plug and socket connection fault	Check connection
Temperature does not increase, or decreases without reheating	Microfuse switched off	Turn on the microfuse
	Defective cable in tool	Contact the VC999 Customer Service Department
	Defective heating cartridge	Replace heating cartridge
	Defective semiconductor relay	Replace semiconductor
Die Maschine schaltet nicht ein	Machine is not connected to the mains.	Insert the plug of the connecting cable into the mains socket.
	Main fuse is defective.	Replace defective fuse.
	Connecting cable to the mains is damaged.	Replace cable.
	Microfuse defective	Replace microfuse
	The main switch is set to position 0.	Turn the main switch to position 1.
The tool closes and reopens immediately.	Rear proximity switch is set incorrectly	Position the proximity switch a little closer to the carriage
The cycle does not start after inserting the carriage.	Defective limit switch	Contact the VC999 Customer Service Department
	The carriage seal is damaged or has become loose.	Change seal or refit correctly.
The vacuum pump does not work	The vents in the chamber are blocked.	Clean the vents.
	The oil in the pump is below the minimum level or is soiled.	Refill or change oil..
	Thermal relay tripped	Switch on the thermal relay.
The START button is ineffective.	Insufficient compressed air.	Check the compressed air supply line, maybe the valve at the compressed air maintenance unit is open.
	Defective START button.	Replace button.
	Magnetic switch on the lifting cylinder "front tool" is positioned incorrectly (only with option "autom. Tray insertion")	Check PLC input: 01.04 has to light up. Replace if defective.
The START button is ineffective	Upper proximity switch in the control box is positioned incorrectly	Check PLC input: 01.01 has to light up. Replace if defective.
	Defective valve-intake	Check EMERGENCY OFF Input 01.00 has to light up, possibly unlock EMERGENCY OFF Close door Check EMERGENCY OFF contactor, possibly replace auxiliary contact block. Check position of proximity switch "top tool" E01.02 has to light up, if not replace proximity switch.
	Defective 24V fuse	Replace

	Flow control valve at cylinder "input" closed or defective (only with option "autom. tray insertion")	Check magnetic valve with manual operation. Replace valve connector or coil if functioning. Check flow control valve and set, possibly replace
The pump is working but the set negative pressure is not achieved..	The suction pipe between the chamber and the pump is damaged or not connected	Connect the pipe or contact the Customer Service Department
	Leakage	Seal the vacuum circuit
Pre-selection sealing: Tool closes but there is no sealing and no cut	No sealing pressure	Set sealing pressure
	No sealing time	Set sealing time
	Defective sealing valve or no sealing pressure available	Check with manual operation, possibly replace
Sealing is insufficient	The tool has not reached the set sealing temperature yet.	Wait until the tool has reached the target temperature.
	Sealing time is insufficient	Increase sealing time
	The sealing temperature set at the temperature controller is too low.	Increase the sealing temperature at the temperature controller.
	The edge of the tray is soiled.	Make sure that the edge of the tray is clean when the carriage is inserted.
	The seal in the chamber is worn out or damaged.	Replace seal.
	The seal is stretched too much.	Re-insert the seal, without pulling it during insertion.
	The pressure of the compressed air is insufficient..	Make sure that the connection machine – compressed air supply is correct.
	Sealing plate soiled	Clean with copper brush
Tool does not open after sealing	Defective valve	Check, possibly replace