

Troubleshooting Manual

No.	Alarm problem	Solution
1	Low air pressure	1. Check the pressure switch value of the equipment to see if it is lower than the set value. If so, check the air source behind the equipment.
2	Coolant pump failure	1. Check if the water level in the coolant tank is below the line. If so, promptly add the appropriate coolant. 2. Check if the grinding water pipe is blocked. If there is a blockage, insert the air source from behind into the coolant joint and blow air for 1-2 minutes. 3. Replace the water pump.
3	Abnormal data transfer	1. Check if the NC file name contains Chinese characters. If it does, data transfer may not be possible. 2. Check if the equipment's network port and USB port are functioning properly. 3. Consider removing the sheet metal and directly using the network port and USB port on the controller.
4	Door open	1. If the equipment door is accidentally opened during operation, do not press the emergency stop button to clear the alarm. Instead, close the door and click the start button on the small screen.
5	Too large offset between the old and new tools	1. Re-perform the tool setting procedure. 2. Check if the tool is properly clamped in the spindle. If not, manually adjust the tool position in the spindle on the small screen interface.
6	A tool in the tool holder	1. Check if the tool holder switch is functioning properly. 2. Check if the pressure switch value is lower than the set value. 3. If the tool is stuck in the tool holder, you can use an 8mm wrench to loosen the tool holder and remove the tool.
7	Tool clamping failure	1. Check if there is a tool in the spindle. If there is no tool, use the small screen to manually clamp the tool.

8	Abnormal tool setting	1. Connect the equipment to a computer display, enter the corresponding account and password to access the manufacturer's settings, and click on manual operation. Manually press the tool setting instrument to check if there is a signal. If there is no signal, inspect the tool setting instrument's wiring for any disconnections.
9	Triggering positive or negative limit of the X, Y, or Z-axis	<ol style="list-style-type: none"> 1. You can resolve the issue by clicking the "return to origin" button (this applies to the X, Y, and Z-axis). 2. If you need to change the limit settings, please contact the manufacturer.
10	Wrong tool number or empty holder	<ol style="list-style-type: none"> 1. Check if the current tool number on the small screen matches the tool number to be replaced. If they are different, please modify it accordingly. 2. Check if the spindle is empty when setting the tool.
11	Multiple tool release failures	<ol style="list-style-type: none"> 1. Check if the tool holder can properly clamp and release the tool. 2. If the tool holder cannot clamp or release the tool, check if there is a signal for tool release on the controller, and inspect the spindle's tool holder for any jamming. If the tool holder is jammed, click the "clamp tool" button, and then use an 8mm wrench to loosen the tool holder.
12	X, Y, Z, or A-axis returning to the origin without a Z signal	<ol style="list-style-type: none"> 1. Check the corresponding axis wiring for any disconnections. 2. Replace the motor. 3. This procedure applies for X, Y, Z, or A-axis.
13	No-tool detection having a tool setting signal	1. Check if there is a tool in the spindle. If so, manually remove it and inspect the spindle's tool clamping and releasing mechanism. If the mechanism is functioning properly, check if the tool changer can properly exchange tools. If not, please contact the manufacturer.
14	Unsynchronized axis pulse and actual position	<p>1. Return to the origin. If this does not resolve the issue, proceed with the method below.</p> <p>Method: Connect the equipment to a computer display and enter the corresponding account and password to access the manufacturer's settings. Click on manual operation to check which axis is causing the problem. Based on the problematic axis, replace the corresponding drive.</p>