

The Most Common Reasons the Express EX Press Will Not Print

NOTE: the Carousel Home Proximity Switch must be engaged at all times with the platform guide rod or the press will not function.

- 1. The press finishes the print but the Carousel Does Not Drop Down:**
 - a. The head back limit switch is not engaged.
 - b. The wire on the limit switch terminal has been pulled out and not making an electrical connection.
 - c. The index retract home switch is not engaged (located by the shock absorber)
- 2. The press flood strokes, the platen rises up, but the press will not print:**
 - a. The Carousel Up Proximity Switch is not engaged
- 3. The press will not index or the press will stop indexing in the middle of a rotation cycle:**
 - a. The sleeve up limit switch (#3) is not engaged. This switch must stay engaged until the index home limit switch is engaged.
 - b. The index home limit switch is defective
 - c. The wire on the terminal is not connected or the wire going to the switch is broken.
- 4. The index arm will not return home, the carousel will not drop down:**
 - a. The sleeve down limit switch (#2) is not engaged.
 - b. The sleeve down limit switch is bad.
 - c. The wire on the terminal strip is not connected (or bad connection) or the wire going to the sleeve down limit switch is broken.
- 5. The press will flood stroke but the carousel will not rise:**
 - a. The head forward proximity switch is not engaged.
 - b. The index extend limit switch (by the shock absorber) is not engaged.
 - c. The Shuttle Flash curing head is not depressing (engaging) the flash home position switch, the flash unit on the PLC is turned to the on position but the communication cable is not plugged into the press or the Shuttle Flash on/off toggle switch is turned off (it needs to be turned on if the PLC flash switch is turned on)
- 6. The press will make multiple print cycles when it is not supposed to:**
 - a. Check the Index and Heads Menu to make sure parameters are set correctly.
- 7. The carousel platform (platens) go up and down and up and down:**
 - a. If the contact between the platform guide rod and the proximity switch is broken, the carousel will start to drop to the bottom resting position. The platform will go up and down when the switch loses contact with a portion of the rod but establishes contact again before touching the bottom home position. This up and down motion will continue until the operator turns the press off and the carousel stops on the home position switch. If this cycling occurs on only one platform rod, adjust the rod. If this happens on multiple rods, adjust the proximity switch.

Express EX Trouble Shooting - Con't:

- 1. Press has no response when foot pedal is depressed.**
 - a. Be sure the master on/off switch is turned on.
 - b. Make sure air is being supplied to the press.
 - c. Be sure one print head is turned on.
 - d. Check head back limit switches. Be sure all of the rear limit switches are depressed. Even if the print head is turned off, the print carriage may have come off the rear limit switch.
 - e. Make sure the carousel home position switch is engaged.
 - f. Make sure flood speed controller is not shut off.
 - g. Be sure PLC controller has power.

- 2. Print heads flood, platens rotate, but the carousel does not raise:**
 - a. Make sure carousel home limit switch is depressed.
 - b. Check to see if head forward limit switches are depressed. All head forward switches must be depressed before carousel will raise.
 - c. Check auto flash condition/position.
 - d. The index extend switch is not engaged (by shock absorber)

- 3. Print heads flood, carousel raises and then stops. No print stroke.**
 - a. Make sure carousel up limit switch is depressed.
 - b. Make sure print speed controller is not shut off.
 - c. The stroke valve is not shifting (working) or the index valve is not working.

- 4. Press goes through print cycle but carousel does not lower.**
 - a. Check head back limit switches. They all must be depressed before the carousel will lower.
Be sure the limit switch bracket is not tilted and thus not making the correct contact.
 - b. Index retract home position switch not being depressed. (Input #6 light).
 - c. In the rare occasion, the lift cylinder "guide post" may not have retracted into the tube support and will physically hold the carousel in the up position. See the trooper lift cylinder page.

- 5. Press goes through one complete cycle and then has no response after foot pedal is depressed.**
 - a. Make sure that the Index Parameters relating to the foot pedal are set correctly. Go to the Index menu, the options are: Start, Skip, Pause
 - b. The carousel down limit switch is not being engaged.

- 6. The indexer pin sleeve does not lift when switching to the auto index mode.**
 - a. Make sure carousel home position proximity switch is engaged.
 - b. Make sure indexer retract limit switch is depressed.

- 7. The indexer pin sleeve does not lower at the end of the index.**
 - a. The indexer sleeve is binding. Never use grease. Lubricate with machine oil.
 - b. The sleeve up/down valve is sticking.

- 8. The indexer does not return after indexing.**
 - a. The sleeve down limit switch (#2) is not engaged.
 - b. The sleeve down limit switch is defective.
 - c. The wire on the terminal strip is not connected (or bad connection) or the wire going to the sleeve down limit switch is broken.

Express EX Trouble Shooting - Con't:

9. **The press will go through the flood cycle, but not index.**
 - a. The indexer sleeve up limit switch is not depressed, or the wire is not connected
 - b. The indexer sleeve cylinder is faulty – (pin did not raise).
 - c. The sleeve up/down valve is sticking.
 - d. The indexer valve is sticking.

10. **The squeegee will not shift to the print position when the carousel raises.**
 - a. The cylinder rod is dry or dirty and needs a drop of 3-in-1 oil, or cleaning.
 - b. The squeegee flip valve is not shifting.
 - c. The Chopper Pressure switch should be set in the on position.
 - d. The pressure regulator in the control box needs to be set around 65 psi.

11. **The carousel will not raise in set-up mode.**
 - a. Check head back proximity switches. They must all be engaged.
 - b. Make sure the carousel is in the home position and/or the carousel home position proximity switch is engaged.
 - c. Make sure the carousel down limit switch is depressed.

12. **Ink flood coat is heavier on one side of the screen than the other side.**
 - a. Be sure the flood bar insert can swivel on the mount.
 - b. Be sure the screen is parallel to the platen on all four corners.

13. **The platens are moving up when the squeegee starts to print.**
 - a. The carousel up limit switch is being depressed too early.
 - b. The lift cylinder cushion may need to be adjusted.

14. **The carousel registration bearings are hitting the tab locators hard.**
 - a. Be sure the entire top head plate did not rotate.
 - b. Be sure the spring on the main carousel lift cylinder did not break.
 - c. Be sure the detent locator-bearing device is not broken.

15. **The squeegee will flip or loose print pressure during a print stroke:**
 - a. There may not be enough air pressure being supplied to the Chopper (check air pressure regulator inside the bottom control panel).
 - b. Check to make sure the Chopper cylinder is not leaking air.