

Technical Information

Troubleshooting Procedure for Electro Cam PLS in a Gluing Application

The troubleshooting procedures listed below can be followed in the event a PLS is not performing properly. Most troubleshooting on an Electro Cam controller can be accomplished without the use of tools or a meter by referencing the onboard information the controller provides.

1. Controller does not operate at all, no LEDs or display is ON.

Check the supply power and the controller supply voltage fuse.
Check incoming power fuses (systems in enclosures).

2. Controller is working, but no outputs turn ON.

Check either the Channel LED or I/O Status Monitor to see if the controller logic is working and sending a signal to the outputs.
Check the supply voltage to the modules.
If the unit has SLIMLINE™ modules, check to see if the LED on the module is going OFF and ON.
If the unit has SLIMLINE™ modules, check output fuse.

3. Controller is working, but modes are not working properly.

Did you program a Group Enable Channel?
Is the input device working properly?
Is the input device turning ON fast enough?
Check the I/O Status monitor to see if the controller is seeing the input (6000 Series Controllers only).

4. Controller is working, one or more groups are at the proper position, but another group (or groups) is not.

Did you reprogram the Offset for one Group and not the rest? (Applies to Groups operating in Modes 0, 3, 4 and 5)

5. Controller is working and is OK at low speeds, but output appears erratic at high speeds.

Is the resolver connection to the shaft or timing belt slipping?
Is the gun solenoid fast enough to operate at the desired speed?
Is the glue viscosity correct for the equipment that is being used?

6. Controller is working and outputs turn ON consistently, but not at the proper position (Position lags as speed increases).

Increase the amount of Speed Compensation.

7. Controller is working, but timed outputs are turning OFF too soon.

The OFF Setpoint of the timed output is being reached before the timing is complete (Reprogram OFF Setpoint).

8. Controller is working, beads are in position, but bead width narrows as speed increases (Analog output to control pressure).

Retune the Analog output values (High RPM value is too high).

9. Controller is working, bead position is OK, but nozzle dribbles when not in motion (Analog output tuning).

Retune Analog output values (Increase the lower limit to maintain a slightly higher pressure at the gun/solenoid).

10. Controller and beads are OK, but appear to be inconsistent.

Check the nozzle for partial clogging.

11. When machine stops, gun continues to spray glue.

If not operating in Mode 5, apply Motion ANDing to the output channel.