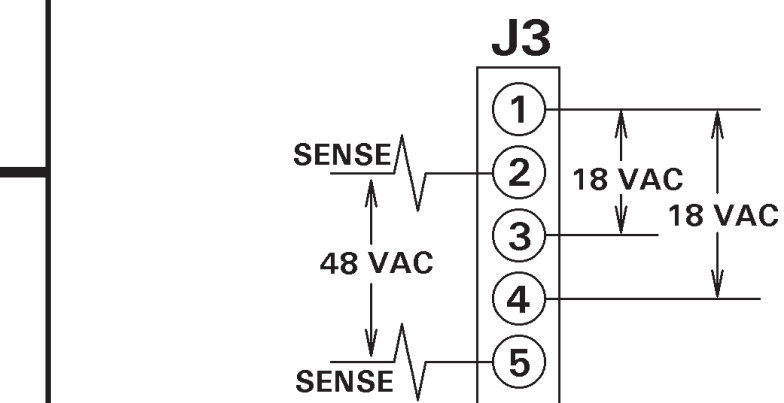


TROUBLE SYMPTOM	SEE NOTE #
A. Power Light Off	14
B. Power Light Off, Weld Light On	16
C. Weld Light On	8, 3, 7
D. One or more Solenoid Valves Energized	12
E. Blowing fuse F1	10, 13, 14, 15
F. No Initiation	18, 19
G. Control goes through sequence but electrodes do not close.	11, 12, 19
H. Control and machine go through sequence but there is no current and Weld Light does not come on.	18, 19
J. Control and machine go through sequence but there is no weld current. Weld light comes on.	1, 4
K. Blowing Valve Fuses	12
L. Tripping Circuit Breaker	9, 17, 19
M. High Voltage between Welding Electrodes and Ground.	2
N. Welding Current occasionally drops to a low level.	1, 4
P. Erratic Sequence or Valve operation	17, 19
R. Sequence will not advance beyond Squeeze. (Electrodes remain closed, no Weld Current)	18
S. Error 26 displayed immediately when power is turned on.	3, 5, 8
T. Error 14 displayed on Front Panel.	18
U. Jumper A on TS3-1 to -2. Provides normal operation of Valve 3. Jumper B provides bypass operation of Valve 3, some EFs and POs will not work without Jumper B in place.	20
V. When external valve power source (24-240 VAC) is used, it connects here. Remove and insulate connections to TS3-VL1 and -VL2.	21



⚠ DANGER

HAZARDOUS VOLTAGE FROM ONE OR MORE SOURCES
Turn off all voltage sources before touching any components. Electrical shock or flash will cause severe injury or death.

Trouble Symptoms that cannot be corrected by checking the items listed above on the right, may be caused by a failure within the control board or the terminal strip board. Please contact your Original Equipment Manufacturer or ENTRON Controls directly for further assistance - 864-416-0190.

A	ECN 2535	CONN. AT T1-1 WAS LABELED J3-5 IS J3-4.	2/25/99 RHL
ORIGINAL RELEASE			
REV	AUTH	DESCRIPTION	CRM BY DATE CHKD BY DATE
ENTRON			
SCALE	DATE	DRAWN BY	CHK'D BY
	11/12/98	RHL	
TOLERANCE UNLESS SPECIFIED		REVISED	
ANGLES:	± 1/2°	REV LTR	APPROVED BY
DECIMALS:	± .010	A	
FRACTIONS:	± 1/64	DATE	2/25/99 RHL
TROUBLE SHOOTING GUIDE, EN1000-SERIES CONTROLS			
NEXT ASSM/USED ON		DRAWING NUMBER	REV
		451014	A