

Picker Troubleshooting Guide

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Error No.	Name	Content	Cause	Troubleshooting
1	Main arm vacuum error	Air pressure less than 0.4kg	1. Intake-tube too small	Change intake-tube
			2. Insufficient gas flow	
			3. Discharge pressure of air compressor too small	Check air compressor
		Leakage of vacuum	4. Vacuum not suck the product	Adjust vacuum position
			5. Vacuum break	Change vacuum
			6. Vacuum tube broken	Change vacuum tube
		Poor contact	7. Relay board LV1 poor contact	1. Rewiring 2. Change relay board
			8. Relay board SV1 poor contact	
		Solenoid valve bad	9. Main arm suction solenoid valve jam	1. Clean solenoid valve
			10. Main arm suction solenoid valve coil impassability	2. Change solenoid valve
		Vacuum generator bad	11. Vacuum generator jam	Change solenoid valve
				1. Clean vacuum generator
		Hand controller bad	12. Vacuum generator micro switch bad	2. Change vacuum generator
				Change micro switch
13. Hand controller no main suck valve output	Change hand controller			
14. Hand controller cannot receive the suck signal				
4	Main arm grip error	Air pressure less than 0.4kg	1. Intake-tube too small	Change intake-tube
			2. Insufficient gas flow	
			3. Discharge pressure of air compressor too small	Check air compressor
		Leak air	4. Grip not touch the product	Adjust grip position
			5. Grip seal ring bad	Change seal ring
			6. Air tube break	Change air tube
		Poor contact	7. Relay board LG1 poor contact	1. Rewiring 2. Change relay board
			8. Relay board SG1 poor contact	
		Solenoid valve bad	9. Main arm grip solenoid valve jam	1. Clean solenoid valve
			10. Main arm grip solenoid valve coil impassability	2. Change solenoid valve
		Air pressure detection group bad	11. Air pressure detection jam	Change solenoid valve
				1. Clean air pressure detection
		Hand controller bad	12. Air pressure detection micro switch bad	2. Change air pressure detection
				Change micro switch
Hand controller bad	13. Hand controller no main grip valve output	Change hand controller		
	14. Hand controller can't receive main grip signal			
Grip group bad	15. Grip piece's gap too large	Change grip head		



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5	Secondary arm grip error	Air pressure less than 0.4kg	1. Intake-tube too small	Change intake-tube
			2. Insufficient gas flow	
			3. Discharge pressure of air compressor too small	
		Leak air	4. Grip not touch the product	Adjust grip position
			5. Grip seal ring bad	Change seal ring
			6. Air tube break	Change air tube
		Poor contact	7. Relay board LG2 poor contact	1. Rewiring 2. Change relay board
			8. Relay board SG2 poor contact	
		Solenoid valve bad	9. Secondary arm grip solenoid valve jam	1. Clean solenoid valve
			10. Secondary arm grip solenoid valve coil impassability	2. Change solenoid valve
		Air pressure detection group bad	11. Air pressure detection jam	1. Clean air pressure detection
			12. Air pressure detection micro switch bad	2. Change air pressure detection group
		Hand controller bad	13. Hand controller no main grip valve output	Change hand controller
			14. Hand controller can't receive main grip signal	
		Grip group bad	15. Grip piece's gap too large	Change grip head
14	Arm transfer out error	Air pressure less than 0.4kg	1. Intake-tube too small	Change intake-tube
			2. Insufficient gas flow	
			3. Discharge pressure of air compressor too small	
		Speed	4. Speed too slow	Adjust speed
		The switch is not bright	5. Switch position not correct	Adjust switch position
			6. Relay board LC0 poor contact	1. Rewiring 2. Change relay board
			7. Relay board SC0 poor contact	
		Solenoid valve bad	8. Switch burn out	Change switch
			9. Main arm transfer out and transfer in solenoid valve jam	1. Clean solenoid valve
		Hand controller bad	10. Main arm transfer out and transfer in solenoid valve coil impassability	2. Change solenoid valve
			11. Hand controller no transfer out valve output	Change hand controller
		12. Hand controller can't receive transfer out signal		
15	Arm transfer in error	Air pressure less than 0.4kg	1. Intake-tube too small	Change intake-tube
			2. Insufficient gas flow	
			3. Discharge pressure of air compressor too small	
		Speed	4. Speed too slow	Adjust Speed
		The switch is not bright	5. Switch position not correct	Adjust switch position
			6. Relay board LC1 Poor contact	1. Rewiring 2. Change relay board
			7. Relay board SC1 Poor contact	
		Solenoid valve bad	8. Switch burn out	Change switch
			9. Main arm transfer out and transfer in solenoid valve jam	1. Clean solenoid valve
		Hand controller bad	10. Main arm transfer out and transfer in solenoid valve coil impassability	2. Change solenoid valve
			11. Hand controller no transfer in valve output	Change hand controller
		12. Hand controller can't receive transfer in signal		



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17	Standby position error	No air pressure	1.No action	Open air source
		position not correct	2.Standy position not correct	Press stop key to reset
21	Main arm up error	Air pressure less than 0.4kg	1.Intake-tube too small	Change intake-tube
			2.Insufficient gas flow	
			3.Discharge pressure of air compressor too small	Check air compressor
		Speed	4.Speed too slow	Adjust Speed
		The switch is not bright	5.switch position not correct	Adjust switch position
			6.Relay board LZ1UPoor contact	1.Rewiring 2. Change relay board
			7.Relay board SZ1DPoor contact	
			8.Switch burn out	Change switch
		Hand controller bad	9.3core wire break	Change 3core wire
			10.Hand controller no main arm up down valve output	Change hand controller
		Solenoid valve bad	11.Hand controller can't receive up signal	
12.Main arm up down solenoid valve jam	1.Clean solenoid valve			
13.Main arm up down solenoid valve coil impassability	2.Change solenoid valve			
22	Main arm down error	Air pressure less than 0.4kg	1.Intake-tube too small	Change intake-tube
			2.Insufficient gas flow	
			3.Discharge pressure of air compressor too small	Check air compressor
		Speed	4.Speed too slow	Adjust Speed
		Poor contact	5.Relay board SZ1DPoor contact	1.Rewiring
		Hand controller bad	6.Hand controller no main arm up down valve output	2.Change relay board
			Solenoid valve bad	7.Main arm up down solenoid valve jam
		8.Main arm up down solenoid valve coil impassability		2.Change solenoid valve
		Falling proof cylinder's guide rod does not leave the down fixed plate	9. The frost of the falling proof cylinder	Change solenoid valve
			10. falling proof cylinder jam	Arrange falling proof cylinder tube
23	Main arm forward error	Air pressure less than 0.4kg	1.Intake-tube too small	Change intake-tube
			2.Insufficient gas flow	
			3.Discharge pressure of air compressor too small	Check air compressor
		Poor contact	4.Relay board SY1F poor contact	1.Rewiring
		Hand controller bad	5.Hand controller no main arm crosswise valve output	2.Change relay board
			Solenoid valve bad	6.Main arm crosswise solenoid valve jam
		7.Main arm crosswise solenoid valve coil impassability		2.Change solenoid valve
24	Main arm back error	Air pressure less than 0.4kg	1.Intake-tube too small	Change intake-tube
			2.Insufficient gas flow	
			3.Discharge pressure of air compressor too small	Check air compressor
		Poor contact	4.Relay board SY1F poor contact	1.Rewiring
		Hand controller bad	5.Hand controller no main arm crosswise valve output	2.Change relay board
			Solenoid valve bad	6.Main arm crosswise solenoid valve jam
		7.Main arm crosswise solenoid valve coil impassability		2.Change solenoid valve



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25	Secondary arm up error	Air pressure less than 0.4kg	1.Intake-tube too small	Change intake-tube		
			2.Insufficient gas flow			
			3.Discharge pressure of air compressor too small		Check air compressor	
		Speed	4.Speed too slow	Adjust speed		
		The switch is not bright	5.switch position not correct	Adjust switch position		
			6.Relay board LZ2U poor contact	1.Rewiring 2. Change relay board		
			7.Relay board SZ2D poor contact			
			8.Switch burn out	Change switch		
		Hand controller bad	9.3core wire break	Change 3core wire		
			10.Hand controller no Secondary arm up down valve output	Change hand controller		
			11.Hand controller can't receive up signal	Change hand controller		
Solenoid valve bad	12. Secondary arm up down solenoid valve jam	1.Clean solenoid valve				
	13. Secondary arm up down solenoid valve coil impassability	2.Change solenoid valve				
26	Secondary arm down error	Air pressure less than 0.4kg	1.Intake-tube too small	Change intake-tube		
			2.Insufficient gas flow			
			3.Discharge pressure of air compressor too small		Check air compressor	
		Speed	4.Speed too slow	Adjust speed		
		Poor contact	5.Relay board SZ2DPoor contact	1.Rewiring		
		Hand controller bad	6.Hand controller no Secondary arm up down valve output	2.Change relay board		
				Change hand controller		
		Solenoid valve bad	7. Secondary arm up down solenoid valve jam	1.Clean solenoid valve		
			8. Secondary arm up down solenoid valve coil impassability	2.Change solenoid valve		
		Falling proof cylinder's guide rod does not leave the down fixed plate	9. falling proof cylinder impassability	Change solenoid valve		
			10. falling proof cylinder jam	Arrange falling proof cylinder tube		
27	Secondary arm forward error	Air pressure less than 0.4kg	1.Intake-tube too small	Change intake-tube		
			2.Insufficient gas flow			
			3.Discharge pressure of air compressor too small		Check air compressor	
		Poor contact	4.Relay board SY2F poor contact	1.Rewiring		
		Hand controller bad	5.Hand controller no Secondary arm crosswise valve output	2.Change relay board		
				Change hand controller		
		Solenoid valve bad	6. Secondary arm crosswise solenoid valve jam	1.Clean solenoid valve		
			7. Secondary arm crosswise solenoid valve coil impassability	2.Change solenoid valve		
		28	Secondary arm back error	Air pressure less than 0.4kg	1.Intake-tube too small	Change intake-tube
					2.Insufficient gas flow	
					3.Discharge pressure of air compressor too small	
Poor contact	4.Relay board SY2F poor contact			1.Rewiring		
Hand controller bad	5.Hand controller no secondary arm crosswise valve output			2.Change relay board		
				Change hand controller		
Solenoid valve bad	6. Secondary arm crosswise solenoid valve jam			1.Clean solenoid valve		
	7. Secondary arm crosswise solenoid valve coil impassability			2.Change solenoid valve		
				Change solenoid valve		

31	Mold full opened error	No mold full opened signal	1. IMM function on computer not open	Open robot function
			2. External relay bad, not work properly	Change relay
			3. Relay board LMO poor contact	1. Rewiring 2. Change relay board
			4. Hand controller can't receive mold full opened signal	Change hand controller
			5. IMM mold closed signal instability	1. Adjust IMM 2. Add mold full opened lock by
32	Medium plate mold error	No medium plate mold signal	1. Relay board LMM poor contact	1. Rewiring 2. Change relay board
			2. Hand controller can't receive mold full open signal	Change hand controller
			3. Medium plate mold switch position not correct	Adjust switch position
			4. Medium plate mold switch bad	Change switch
33	The safe door is open	No safe door signal	1. External relay bad, not work properly	Change relay
			2. Relay board LMD poor contact	1. Rewiring 2. Change relay board
			3. Hand controller can't receive safe door signal	Change hand controller
			4. Injection molding machine safe door not closed	Check IMM
*	IMM can't open and close mold	Mold close control impassability	1. Hand controller no mold close control output	Change hand controller
			2. Hand controller no mold open control output	Change hand controller
			3. Relay board MO、MC relay bad	Change relay
			4. IMM signal connect line loose	Reconnect
			5. IMM can't receive cycle start and permit mold signal	Check IMM
34	Injection signal error	Robot receives the injection signal error from IMM	1. Injection signal error	/
35	Quantity finished	The production quantity has reached	The production quantity has reached	Enter into the TIME screen and reset the quantity
36	Waster	Robot receives the waster signal from IMM	1. Waster signal error	/
37	Mold close signal error	Not get the full mold close signal	1. Not receive the full mold close signal before full mold open	Check full mold close signal
			2. Relay board LMD poor contact	1. Rewiring 2. Change relay board
			3. Hand controller can't receive the full mold close signal	Change hand controller
			4. IMM doesn't have full mold close signal	Check IMM
38	Ejector signal error	Ejector is confirmed to open, arm up, but not receive the ejector back to position signal	1. Relay board Poor contact	Check relay board wiring
			2. IMM doesn't have the ejector back to position signal	Check IMM
39	Full-automatic signal error	The robot lost the full-automatic signal during the full-automatic action	1. Relay board LMA poor contact	Check relay board wiring
			2. The IMM doesn't have full-automatic signal	Check IMM
43	Module error	The present module can't operate	1. The present module no teach.	Remake teach module



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44	Teach action failed	Teach action failed	1.Not back to the original position	Check the teach action
45	The automatic wait is too long	Exceed the setting value of "Mold open over time"	1.Over time of mold open is too short	Revise the over time of mold open
			2.IMM no full mold open signal	Check IMM
51	IMM error	IMM emergency stop signal error	1.IMM LME signal error	Check relay board wiring
			2.IMM no emergency stop signal	Check IMM
52	Emergency stop error	Robot's hand controller emergency stop error	1.Robot emergency stop signal error	Reset hand controller emergency stop button
53	Over use times!	Over use times	1.The tryout times of non-payment is over	Please contact after sales department