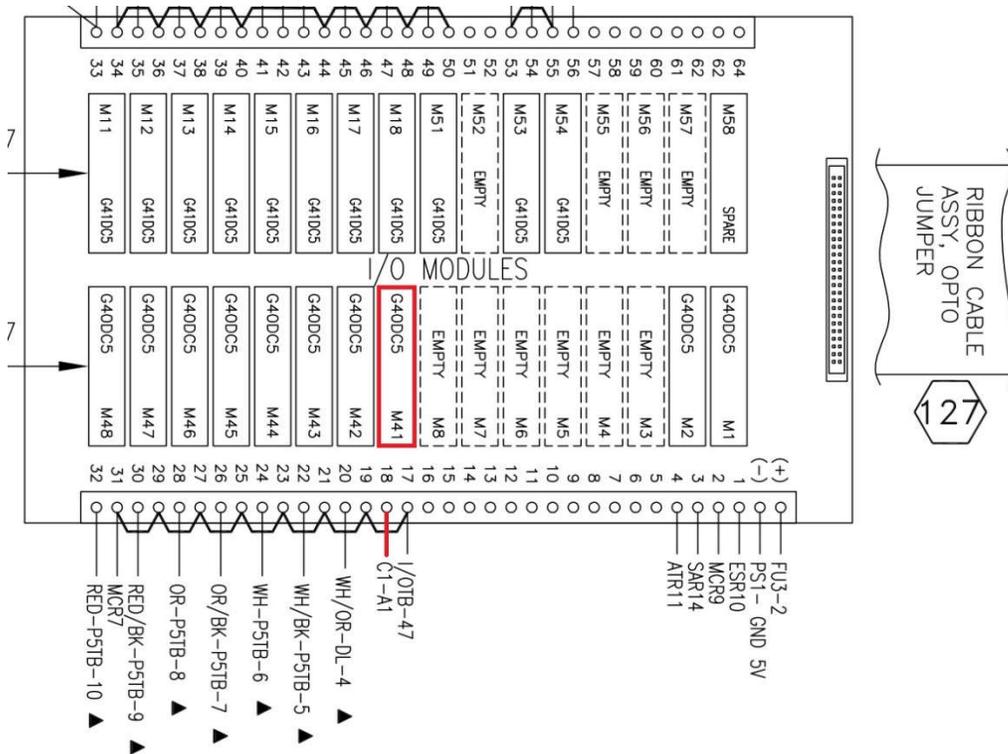


# BLADE START BUTTON DOESN'T WORK

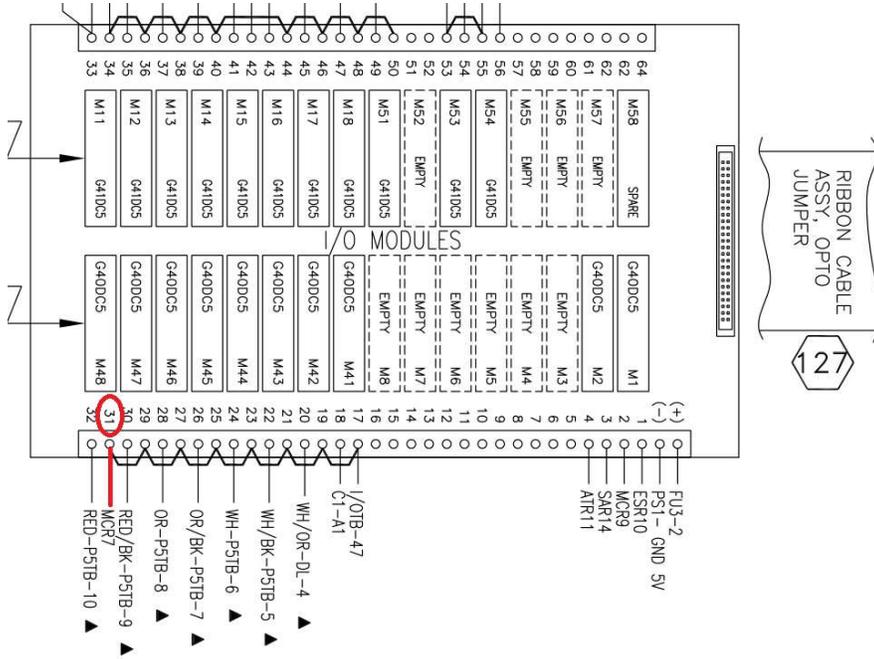
- 1) Check that power button is turning ON by checking for green light in the saw program.
- 2) Check that ESR, MCR, SAR are all ON (Note, ATR comes on only when blade start is pressed)
  - a. If saw program says power is off still, it may be that the cage door circuit is broken, use "Door lock troubleshooting guide"
- 3) Has the C1 contactor pulled in? The contactor should pull in when the green power button is pressed.
 

If it has not pulled in:

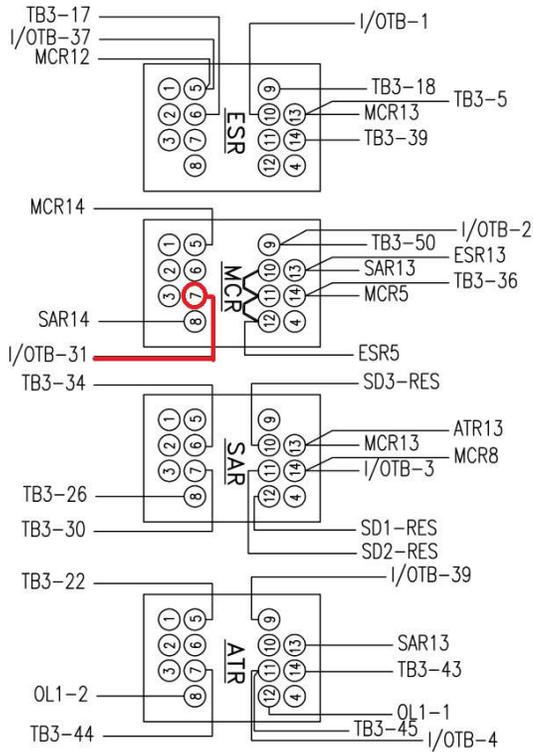
  - a. Check that terminal A2 on the C1 contactor is connected to ground at the TB3.
  - b. If not, check for power at the I/OTB-18. Is the red module light on?



c. If no power, then check for 24VDC @ I/OTB-31

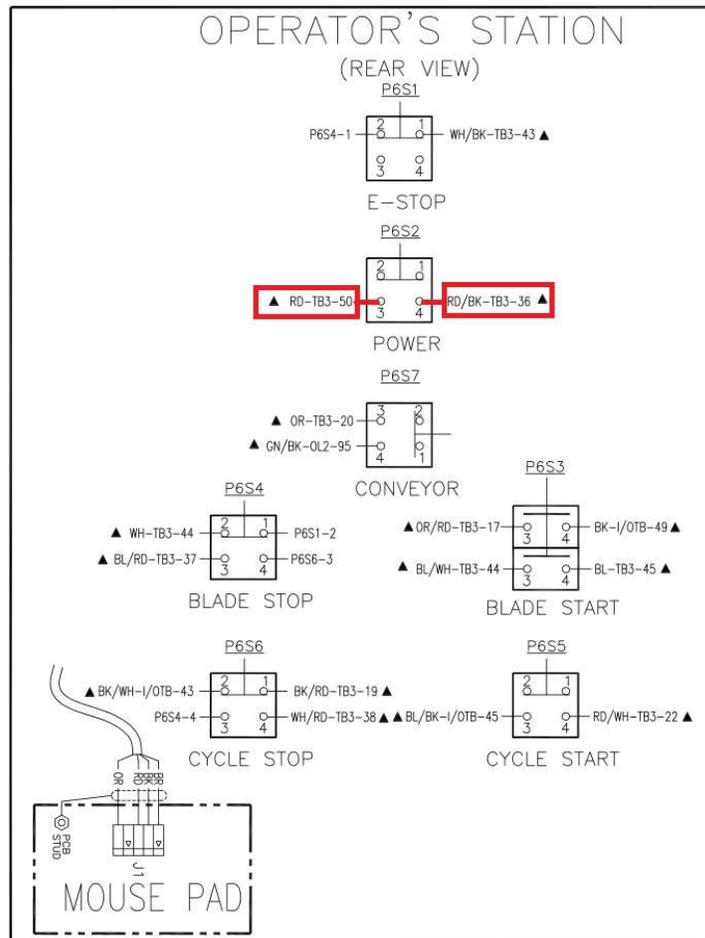


d. If no power at I/O TB-31, then check for 24VDC at MCR-7 (Motor Control Relay)



If the contactor has pulled in:

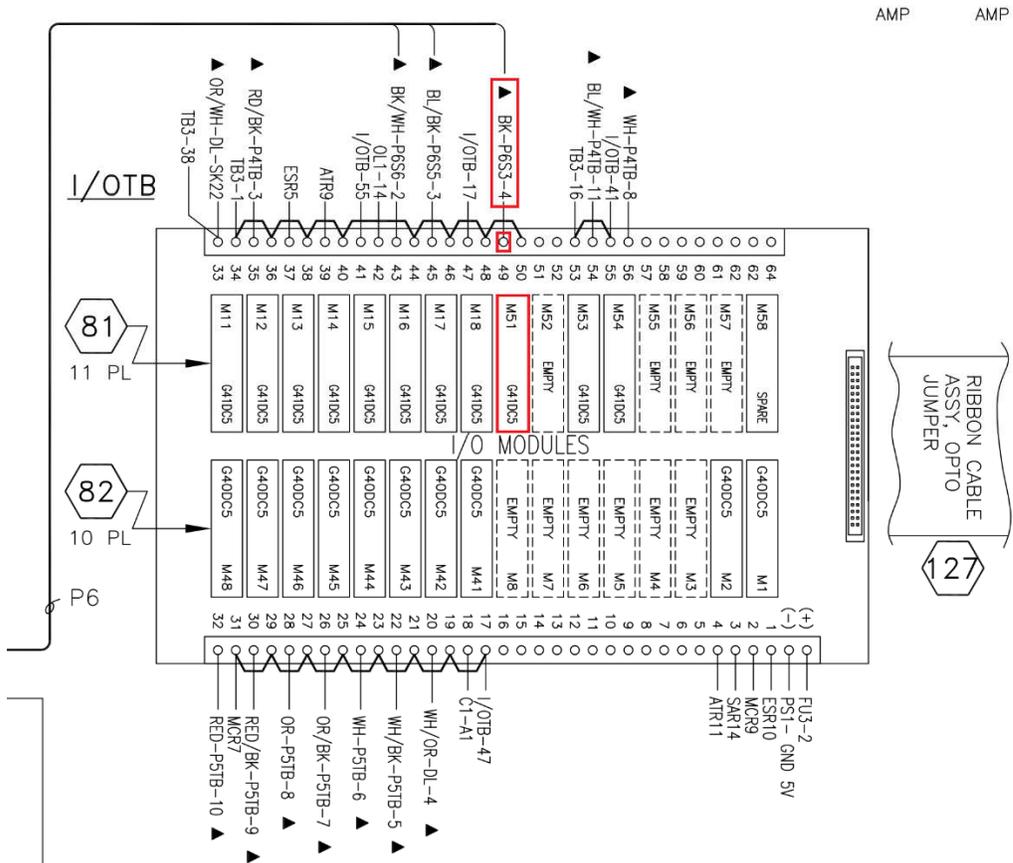
- a. Check for power at bottom of contactor (T-1, T-2, T-3)
- b. If power at bottom of Contactor, check for power at ACTech (L1, L2, L3)  
If there is power at the ACtech, but the drive displays nothing, the ACtech is dead and needs replaced. Call TCT for further instructions from here.
- c. Check connection at button. Check continuity across the button terminals.



- 4) Check VFD status for fault codes. Idle state should have three dashes " - - - "(Grey SCF Series), or "STOP" (Blue SMVector Series)
  - a. If a code other than three dashed is displayed use "SMV or SCF Error Code List" Call TCT for further assistance.
- 5) Check ATR (AcTech relay), should be illuminated when blade start is pressed.
  - a. If the relay does not light up, try swapping relays with neighboring relay and or replace with new relay.
  - b. If replacing relay does not make the ATR (AcTech Relay) come on when blade start is pressed, check that the white input module M51 is coming ON while the blade start button is pressed. See I/O board diagram below.
  - c. Try swapping or replacing the M51 module with another good white input module.
  - d. If M51 module is still not coming on, check for 24Vdc power at the blade start button, terminal 3 (P6S3-3) See Operator Station diagram below.
  - e. If no power at P6S3-3, Check for Power at TB3-17 on main panel, this is where the 24V power to the button comes from. If there is power there, but no power at P6S3-3, then there is a short in

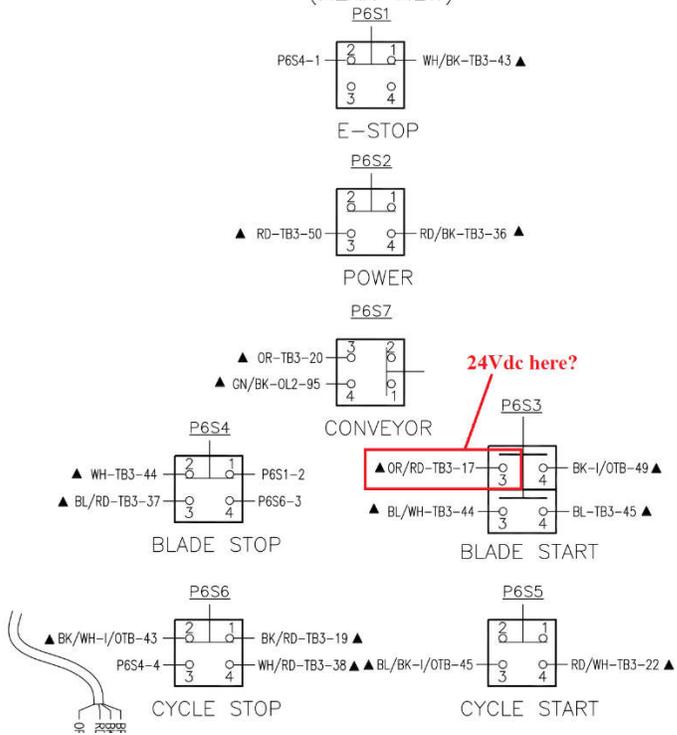
the wire, replace wire. If no power at TB3-17, check for 24Vdc power at 24V breaker and or check power directly at the 24V power supply.

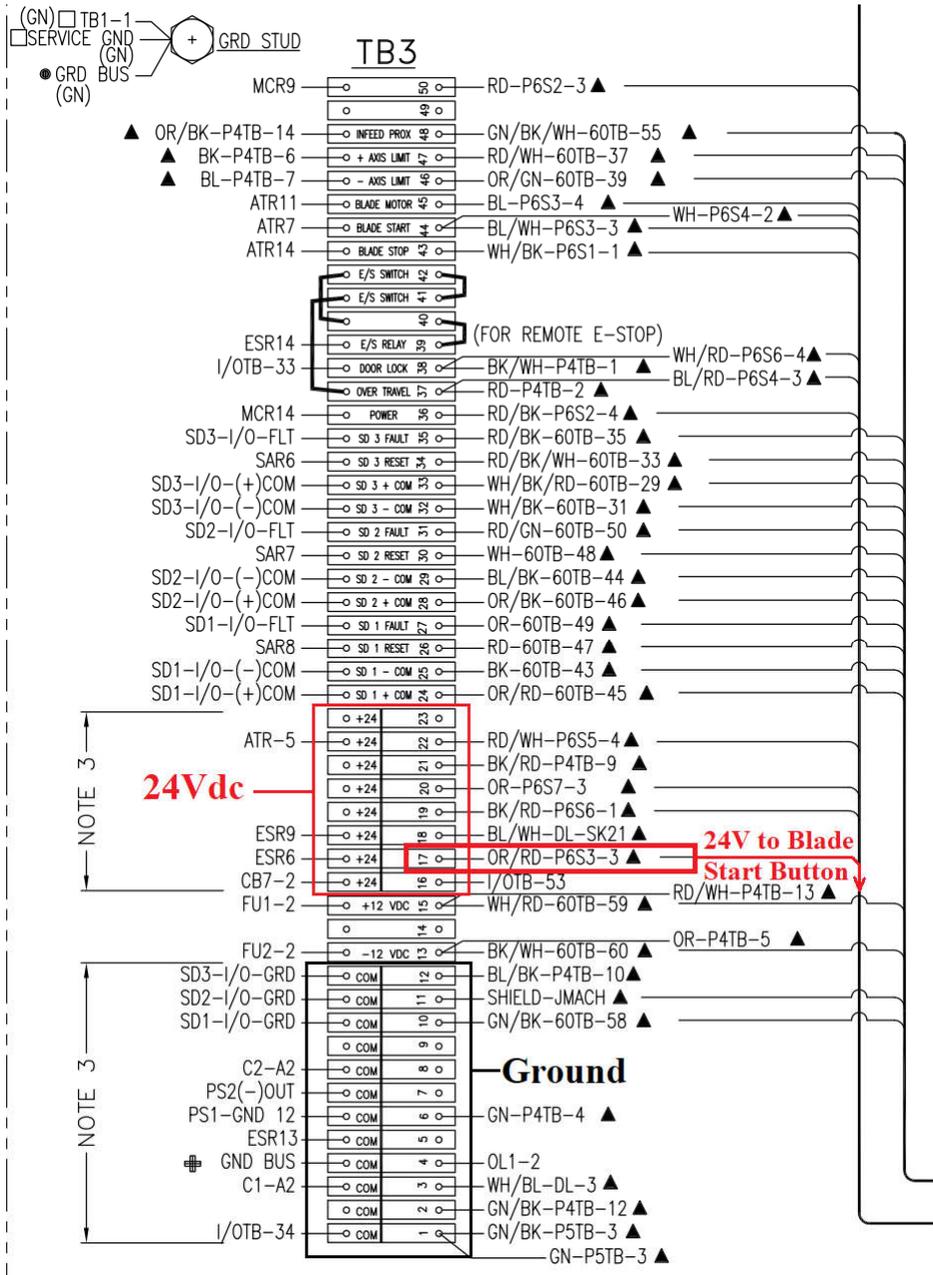
- f. If there is power at the Blade start button, P6S3-3, then check for continuity across the button. There should be 24V at P6S3-4 when the blade start button is pressed.



# OPERATOR'S STATION

(REAR VIEW)





## CYCLE START BUTTON DOESN'T WORK

- 1) Check sensors "IF SENSOR"
- 2) Check connection at button. Check continuity across the button terminals.