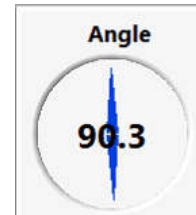


E-STOP STUCK ON / SCREEN SAYS DOOR IS OPEN WHEN DOORS ARE CLOSED



STEP 1) Check that the computer is communicating with the saw. Look for the blade angle indicator. If it displays a number, the saw IS communicating. Go to next step. If the angle indicator displays “NAN”, go to PMAC/Clipper communication guide.

STEP 2) Check that you have 24V DC. Use a meter to test for 230V AC going into the power supply and 24V DC coming out. Please note that the “DC OK” light may not be a valid indicator on output voltage. (Power supplies may vary, generally the phoenix contact is in place)

If there is no 24v power out of power supply, try turning off the black single pole breaker.

If there is 24v out of power supply, follow 24V down to the black single pole breaker, check voltage coming out of the breaker (bottom), then for Websaws check at the 60TB on terminals 59 & 60, for XL-Saws check at the red dinnectors labeled “24V”. If there is power, continue.

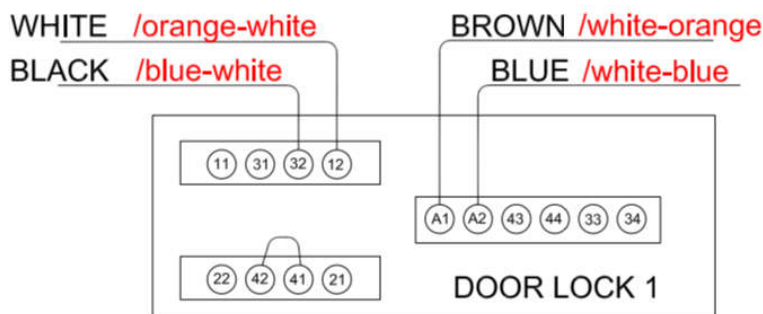


CAUTION BEFORE CONTINUING:
Secure saw area to prevent injury to personnel!
Never disable locks on a machine in service.

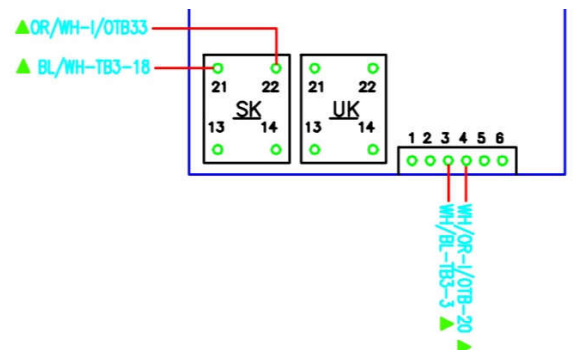
STEP 3) Remove actuator from door, and firmly insert it into the lock. (KLM Lock is shown) Do this with one lock at a time, start with the back door. If pressing the actuator in firmly works. Readjust actuator on its mount to get better insertion into lock. Doors may become warped due to lumber being thrown by blade.



STEP 4) Check that the lock is operational by placing a jumper wire by hand across the below wires. Do this with one lock at a time, start with the back door. No need to screw wire in place, just hold jumper across the contacts. If screen displays “Door Closed” when jumper is placed then KLM will need to be replaced -or- Euchner will need to be rebuilt. If “Door Open” does not change, call a TCT technician for further instructions.



KLM: Jumper across #12 and #32



Euchner: Jumper across #22 and #21