

UNDERPINNER TROUBLESHOOTING GUIDE

Fault	Possible Cause	Remedy
Wedges are too wide to load into the magazine	Wrong type of wedges	Only Universal type wedges can be used
	Faulty wedges	Check with wedge supplier
Both footpedals do nothing	Air supply is not connected or low pressure	Check pressure guage reads between 6-8 bar
		Turn compressor on & connect airline
	Safety Guard is not closed	Close guard (See page 9)
No wedge is inserted into the moulding	The wedge magazine is empty	Reload the magazine
	Wedge feeder not engaged	Release the nylon cord
	Wedge is jammed in cap	Clear the blockage (see page 10)
Fence does not slide	Build up of dirt	Lubricate the two sliding fence bars (part no. 60)
Pressure regulator outside of range 6-8bar	Air supply not connected	Turn compressor on & connect airline
	Pressure regulator not set correctly	Adjust the regulator by lifting and then turning the top cap. Clockwise increases the pressure, Anticlockwise decreases the pressure. Push down the top cap to lock the setting when finished.
Top clamp is marking the moulding	Wrong pressure pad fitted	Change to alternate shape pad
	Pressure pad is worn or damaged	Replace pad
	Air pressuse is too high	Use the regulator to lower the air pressure
Bad joint - Open joint	Bad mitre	Check mitring machine
	Moulding moving during pinning	Ensure the base of the moulding is flat
		Move the wedge position away from the back edge
Moulding is moving during pinning	Cap not flush with table	Remove cap and refit it (see page 10)
	Extension tables not flush with table	Reset the tables
	Top clamp not set correctly	Set gap between moulding and pressure pad to not more than 20mm
	Front clamp not set correctly	Set gap between moulding and clamp to not more than 25mm

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Wedges jam in cap	Wrong wedge size selected	Measure which size wedges have been loaded and check size selector is set correctly
	Wedges loaded incorrectly	Ensure wedges are loaded sharpened side up
	Excess build up of glue	Remove the cap and clean the mechanism
	The driver is damaged	Replace the driver
Wedges not fully inserted into moulding	Trip valve not set correctly	Reset the adjusting screw (see page 11)
	Top clamp not set correctly	Set gap between moulding and pressure pad to not more than 20mm
	Air supply insufficient	Check airline and pressure
Wedges being driven in too deep	Trip valve not set correctly	Reset the adjusting screw (see page 11)
Attempt at stacking fails	Fence is moving during cycle	Lock the fence when stacking (see page 6)
Stacking wedges break through side of moulding	Stack is too high	Use less or smaller size wedges
	Wedge position too close to edge	Move the wedge position away from the edge
	Wavy grain wood (particularly hardwood)	The wood species is not suitable for stacking
Wedge deforms when inserted	Hardwood	Use specific hardwood wedges
Driver does not return after cycle	Driver has come out of holder	Refit the driver into the holder (see page 11)
Top clamp does not return to start position	Top clamp not set correctly	Set gap between moulding and pressure pad to not more than 20mm
	Return Collar (part no. 79) has moved	With Extreme Caution: Use a tool to manually activate the trip switch. Now reset the return collar with 30mm between collar and bush housing (part no.50)
	Trip valve not set correctly	Reset the adjusting screw (see page 11)