

Problem - Traverse motor not working

Possible Cause	Checkout Procedure	
Traverse speed knob at zero	A. Turn traverse speed knob to 20	Traverse motor works Yes -- End trouble shooting No-- Go to Step B. next
Traverse Clamp is un-clamped	B. Rotate red handle to engage belt	Traverse motor works Yes -- End trouble shooting No-- Go to Step C. next
No Power at Traverse Drive Control.	C. Go to troubleshooting screen or jog screen. Move Grinding head to middle of travel and disengage belt. Press travel left to sensor button. Look for Power light on the traverse board	Power light on Traverse board is on. Yes -- Light is on. Skip to step G. No-- Light is off. Go to step D. next
Relay Y8 not working	D. Look for light on Relay Y8 to be on.	Power light on Y8 is on. Yes -- Light is on. Go to step E. next No-- Light is off. Skip to Step F.
Check power into TDC	E. Check for 120VAC into TDC at L1 and L2.	Remove wire to TDC. Check power at wires 46TDCL1 to 58TDCL2 for AC voltage 115 VAC -- L1 to L2. Replace TDC No-- Replace Relay Y8.
No signal from PLC	F. Check for a light on PLC at Y8.	Output light on PLC-Y8 is on. Yes -- Light on PLC Y8 is on and Relay Y8 is off. Replace Realy Y8. No-- Light at PLC Y8 is off. Check Control, try other direction on Screen.

Possible Cause**Checkout Procedure**

Check Power out of TDC	G. Check for power out of TDC. With the motor on (See step C) measure power out of TDC.	Remove Wire from TDC at A1 and A2. Measure output of TDC at terminals A1 and A2 on TDC for DC Voltage 20-60 VDC out--Skip to Step J. 0-3 VDC- Go to step H. next
Check Potentiometer	H. Turn off Travesre! Remove speed control (Potentiometer) wires from TDC, and disconnect Black wire. Measure between wires.	Turn off Travesre! Remove wires from TDC and test Speed Control (Potentiometer). Measure between wires. White (35TDC-SO) to Black (35TDC-BL) - 10K ohms Yes-- continue No-- Replace Traverse Speed Potentiometer. White (35TDC-SO) to RED (35TDC-S2) - 0 ohms full CCW, 10K ohms Full CW Yes-- continue No-- Replace Traverse Speed Potentiometer. White (35TDC-SO) to Black (35TDC-BL) - 0 ohms full CCW, 10K ohms Full CW Yes-- go to Step I. No-- Replace Traverse Speed Potentiometer.
Relays Y2 or Y3 not working	G. Connect wire from step H. Turn traverse motor on from screen. Turn Speed control Full CW (maximum speed). Check for Light on realy Y2 (travel right) or Y3 (travel left).	If one direction works but other does not, try changing realys Y2 and Y3. Press on tab on relay to remove. Light comes on depending on direction (Y2 and Y3)but both directions do not work. Replace TDC Lights come on, one direction works and changes when relays are changed. Replace bad relay.
Bad Traverse Motor	J. Check brushes in Travesre motor.	Remove Traverse motor brushes one at a time and maintain orientation for reinsertion. Measure brush length, must be greater than 3/8" (10mm). Motor brushes short -- replace motor brushes Motor brushes are longer than 3/8"(10mm) - replace Motor.