

Supervisor Use Only

ACE 200-400-600 *plus*

All 888888 's are displayed.	Possible reason is the memory has been lost or erased. Reprogram the unit following the Channel Setup Guide.
Power LED is out on the I/O board on the inside of the enclosure.	The power light is GREEN on the I/O board on the inside of the enclosure. Check and make sure that the unit is plugged into the correct power source. (110 - 220) Then check the 1 Amp fuse on the I/O board, if both are ok then replace the power supply.
Relay LED's do not light	The LED's illuminate when the unit is in STOP or when an error has occurred. If the LED's do not turn on at all, replace the front panel. If they do not turn on when an ERROR occurs, check your limits setting.
Display shows SIGNAL	When the force reading is below PL 003 during the learn time, the unit will show SIGNAL. This indicates that there is no work in this station, or the force sensor is bad.
The unit will not count Unit Stays in LRN The CAM LED will not go off and on.	For the ACE unit to count it needs to have a CAM or Proximity sensor input. Check the Cam where the proximity sensor is mounted, make sure it changes from on to off metal and the LED on the sensor also changes. Check to make sure you have +12 volts DC at the input of the I/O board. Check to make sure the sensor is not more than 1/4" from the metal flag or can cam.
The ACE unit stays in TEST	You will need to set the TOTAL counter. Not setting the TOTAL counter, the unit will not go to LRN

ACE Trouble Shooting Guide

Force Sensor Replacement

- If the ACE monitor displays a reading of PL 003 or lower, indicates that the force sensor needs to be replaced or the work from the sensor is too small. You may want to verify this by running a different job or check to ensure that there is in fact work being performed in that station.
- First remove block or the wedge that the sensor is mounted. By using a hammer and small chisel chip out the old sensor and its epoxy, also remove the wire that was attached to the sensor.
- Second mix the 2 part epoxy (Hardman Double Bubble Epoxy or Fast weld) in the bottom of the sensor pocket, then very carefully push the sensor into the epoxy allowing the sensor to be covered by the epoxy. You may need to mix more epoxy to cover the wire and the sensor completely. Once the epoxy is dry, make sure the epoxy is cleaned so that it is not higher than the face of the block. Reassemble the machine, the epoxy should cure for 24 hours before running the machine.

Proximity Sensor Re-placement

- Turn off all power
- First locate the proximity: this might be on the cam shaft, ram, or any other 1:1 ratio device.
- Jog the machine so that there is metal in front of the Proximity Sensor. Remove the defective sensor and replace with a new Proximity sensor.

From the Sensor

White: cut and remove
Black: cam or prox. In
Brown: +12 volts DC
Blue: ground

To the Extension Wire

Green or White: cam in
Red: +12 volts DC
Black: ground

Front Panel Replacement

- If there is a need to replace the front panel on the ACE, remove all 4 screws on the front panel and unplug the 15 pin connector from the front panel. With the new front panel plug in the 15 pin connector to the new front panel and reinstall the 4 screws. Make sure there are no wires that can be cut and install the front panel into the enclosure. You will need to check the program before using the unit.

ACE products are manufactured and serviced by:



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