

# 8 Troubleshooting

Symptom	Possible Cause	Location
Furnace stays in warm-up mode for more than 15 min.	Gas flow contrary to zone temperatures	Adjust gas flow. See p. 108
Temperature runaway cannot be controlled by changing setpoints	The SCR has failed or needs calibrating	Calibrate SCR. If problem persists, replace SCR. See p.66
Zone Temperature fluctuates erratically	Poorly adjusted PID parameters	Adjust PID settings. See p.100
Over or under temperature alarm	Possible thermocouple malfunction	Replace thermocouple. See p.72
Hydrogen igniter alarm	Burnt our igniter	Replace igniter
#### appears in process screen where data normally appears	Computer not communicating with Controller	Check Ethernet card in PC and in Controller. Check Ethernet connectors
Data appears frozen in process screen	I/O modules not communicating with PLC	Check that RUN and REC LED's are on. The TRX LED should flash periodically. Try swapping relays or I/O module.
Transport speed error	Slipping clutch	Tighten clutch. See p.83
Belt speed fluctuates	Worn or misaligned drive sprockets	Adjust and lubricate. See p.82
Transport motion fault	Motion sensor not working	Clean or replace motion detector gear and sensor.

