

“Waiting on Air Valve” Alarm

Introduction

This is a common alarm with an easy fix. This alarm means your High/Low Roller System is trying to change gears, but the switches are not reading back to the control.



Causes:

1. The air is off to your machine
2. One of the switches is not reading

Troubleshooting

You can use the codes, “S.1” and “S.2” to change from High to Low gear. Go into diagnostics and see if the bits are changing as you change the gears.

To enter diagnostics, at the ENTER NEXT COMMAND prompt type “DI”, then on the next line type “DS”. To exit, press X. Use the S.1 & S.2 commands to move the rollers from high to low gear and see if the switches are changing.

As you can see in this example (see Figure 1), the Low Idler is engaged and the higher roller is not. With the S.1 and S.2 commands in MDI, you should be able to see the states change from one to zero and zero to one.



Figure 1

Solutions

A very common reason for this alarm is simply forgetting to turn the air on for your machine. Other than no air to the cylinders, the alarm would have to be due to either the 1040 Mill Interface card or a bad switch in the Idler unit.

The upper switch is a Hall Effect switch and the lower switch is a Reed switch, so you’ll want to know which you have before you order the replacement. We stock them all.

Still need help?

If you become stuck or confused, don’t panic. Simply contact us at 208.855.9426 and one of our friendly service technicians will be happy to assist you.

Instructions written by CNCPros.com. We put in hundreds of hours of hands-on experience in the field each year.