

## Kombi Rapper Troubleshooting Guide

**Models: KRI, IC1620**

### **CASE: Tunnel runaway heat (over heating)**

Possible cause: on board power triac failure. External SSR installation suggested. Conversion kit with installation instruction is available.

### **CASE: Tunnel not heating.**

#### **Possible cause:**

- 1) Front heater fuse (20A) and/or fuse holder bad (only early models). Eliminate that fuse by pulling off the wires from the fuse holder, cutting off the QC terminals, stripping and twisting the wires together with a wire nut. That fuse holder was eliminated on later models.
- 2) Power triac failure, see above
- 3) Overheating safety circuit tripped. The main board must be re-programmed. Open the control panels back cover. Turn power switch on, RUN switch in cool-down.

**WARNING: Shock Hazard! Exposed electrical terminals and parts carry line voltage. Do not have any tools in your hands. Do not touch any other parts then the push buttons.**

Machines with software version 1.1 or 1.3 (sticker on micro-processor): press the center button, just below the 3-digit display, until you reach the Diagnostic Parameter #31. Now press the left button to display the value. If it is non-zero, press the right button (Left and right together) until you reach 00 value. Release all buttons and wait 10-14 seconds until the display goes dark. Turn off power with the main switch. Machine is now ready for operation.

Machines with software version 1.5 or higher (sticker on micro-processor): press the center button, just below the 3-digit display, until you reach the Diagnostic Parameter #26. Now press the left button to display the value. If it is non-zero, press the right button (left and right together) until you reach 00 value. Release all buttons and wait 10-14 seconds until the display goes dark. Turn off power with the main switch. Machine is now ready for operation.

TIP: If the Software Version sticker is missing, press the center button once, to reach parameter #1 Next press the left button to display the software version.

Watch the tunnel for possible runaway heat. If that occurs again, see case 1 above.

## **CASE: Tunnel Conveyor runs at high speed, no control**

Possible cause: Speed Control Plug-In board failure due to bad motor and over-fusing. Service or replace the Speed Control Plug-In board. Service or replace the conveyor motor. Replace the conveyor fuse with 1.5A Fast Blow only. Failure to install the correct fuse and/or service the motor will result in repeated Speed Control Plug-In board failure.

## **CASE: Tunnel Conveyor not running**

### **Possible cause:**

- 1) Blown fuse. Replace conveyor fuse with 1.5A Fast Blow only
- 2) If fuse blows again, bad motor. Read “Troubleshooting Sealer and Tunnel Conveyors” guide
- 3) Worn motor brushes. Service motor
- 4) Bad Speed Control Plug-In board. Service or replace
- 5) Main Control Board failure due to over fusing with a larger (slow-blow) fuse. Send the Main Control Board for repair.

## **CASE: Blower motor not running**

### **Possible cause:**

- 1) Motor seized or burnt. Service motor.
- 2) Motor fuse blown. Replace motor fuse (front panel)
- 3) Check diagnostic parameter (see case #2)
- 4) Check machine identifier parameter. Machines with software version 1.1 or 1.3 parameter 51=00 Machines with software version 1.5 or higher parameter 46=00
- 5) Main Control Board failure. Send PCB for service

## **CASE: L-Bar Sealer not sealing**

### **Possible cause:**

- 1) Pulse switch (inside the control panel) out of adjustment or broken
- 2) Check machine identifier parameter (see above)

## **CASE: Magnets do not engage**

### **Possible cause:**

- 1) On board fuse (5A AGC) bad due to shorted or burned-out magnets. Check magnet resistance (terminals 11 & 12). Pull off the wires and measure resistance with Ohmmeter. Should read about 300 Ohms. Check continuity to ground. One terminal, 11 or 12 to chassis. No continuity to ground should be present. Replace Magnet if open or shorted. Send PCB for repair if test is OK.

## **CASE: Magnets do not release or stick**

### **Possible cause:**

- 1) L-bar return spring broken, out of adjustment or worn. See also “Sealer Set-Up” guide. Return spring is attached to the rear part of the l-bar. Magnet won’t release even by force: Turn off power switch. If the magnet releases, the magnet-control circuit is broken. Send PCB for service.

**For poor seals read the “L-Bar Sealer Troubleshooting Guide”**