



Integrated Manufacturing Systems Troubleshooting

Troubleshooting Exercises Version 1 – Answers

Exercise	Answer
2	Full Depth Limit Switch - or Broken Wire or Mechanical Actuator - or
3	Adapter Fault or Blown Output card
4	Output Card Fuse
5	E-stop PB - or open Wire - or
6	Bad Input Module
7	Bad Output solenoid - Stuck Dir. Valve. Or Mechanical Jam or -
8	Return Limit switch Stuck or Shorted or -

Remember:

- Watch out for missing Power or Air or Hydraulics
- It makes a difference if the machine just quit... or it could never be started. (Permissives)
- If a problem is not fixed on one shift... the next shift may face 2 problems.





**Multi-State
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PRIMARY DEVELOPER: Glenn Wisniewski – Henry Ford College

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