

Fornax T

Service Manual Fornax T



330.00001

BEGO  

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Contents

General Information

E 01 - No cooling water.....	Page 2
E 02 - Lid magnetic lock defective.....	Page 3
E 04 - Lid safety switch defective.....	Page 3
E 22 - Communication generator <-> Controller board not ok.....	Page 3
E 23 - Generator message – Temp. cooling water >70°C.....	Page 4
E 24 - Generator message – Current too high.....	Page 4
E 25 - Generator message – Current too low.....	Page 4
E 27 - Generator message – Melting process timeout > 5 minutes.....	Page 5

Take note:

None of these generator messages means that the generator is definitively defective.
Further tests are required to locate possible defects.

E 01 No cooling water (blue light “cooling water” flashes)

The cooling water pressure is controlled by the **pressure switch 13385** . Minimum water flow should be 1 l/min .
If the flow is lower the blue water indicator flashes with a beeping .

Check water pressure flow and/or pressure switch .
If the flow is < 1 l/min check the water pressure and/or the cooling system.
If the flow is > 1 l/min check the pressure switch .

Take note :

After switching on the Fornax the water cooling and the fan only starts after lifting the coil up to start the melting process .
The cooling water and the fan will be automatically turned off in the standby modus after 10 minutes without using.

E 02 Magnetic lock (Lid) defective

To start the melting process the lid must be closed and locked .Responsible for the locking is the **magnetic lock 39453** .The magnetic lock activates inside a microswitch .
If after closing the lid (lid control switch is activated see E 04) this microswitch is not activated the error message will be generated .

Check the magnetic lock .

E 04 Lid switch defective

The close lid is controlled by the magnetic lock (see E 02) and the **safety switch 15354**
The switch change after closing the lid over from a closed to a open position .
This changing is controlled by the **PCB 17597** .

Check the switch **15354** and / or the inputs “Deckel NC ,Deckel NO “ at the **PCB 17597**
pushing the switch manually .

E 22 No communication between PCB and generator

During the process the generator communicates with the **PCB 17597** .
If the generator does not respond after a command the error message 22 generates after
10 sec.

Check if the automatic fuse **F 5** is released (Fornax rear side) .
If after fuse activation the unit works and the fuse release again after some castings
please check the main voltage and/or the alloy weight .
Please read in the manual about the max. weight of alloys .
Check the interface cable connection from generator > PCB .
Check the generator power supply connection.
Check if the fuse at the generator is blown .

E 23 Temperature too high

After arriving 70 °C on the generator the Fornax will be switched off and
Error message E 23 will be generated .

Check the cooling system (minimum 1,2 l/ min) .
Check the temp. of the cooling water (circulation unit “Termico“).
If necessary change the water .

E 24 Generator over current

If the generator output current is too high the Fornax will switch off .

Mostly the generator output is defective .
Change the generator **17596** .

E 25 Generator current too low

Every 10 sec. the generator output current will be controlled .
If the min. of current is not arrived the generator will switch off.

Check the connections between copper piece and generator output cable . Check also if the capacitor group is correctly mounted and if all screws are well tightened .Also if maybe some capacitors are defective .

Check the crucible coil .Are the windings free ?? Is there any contact ??

Change generator **17596**

E 27 Generator timeout

For security reasons the generator will get switched off after 5 minutes continuously heating .