

BRAZING MACHINE TROUBLESHOOTING

TROUBLE	PROBABLE CAUSE	REMEDY
Main disconnect is closed but pump motor and weld transformer contactor not operating.	No line voltage	Check for proper voltage at source.
	Main disconnect fuses (F1 & F2) are blown.	Check for short in primary lines are blown from disconnect to contactor to weld transformer and replace.
	Control transformer primary fuses and (F3 & F4) are blown.	Check control transformer and wires for short or overload and replace.
	Control transformer secondary fuse (F5) is blown.	Check pump motor and replace. Check contactor coil and replace, Check low voltage wiring for short and replace.
Main disconnect closed, Contactor operates but pump motor does not.	Open line from main terminal strip to motor.	Check for broken wire and replace.
	Open in motor.	Replace motor.
Main disconnect closed. Pump motor operates but contactor does not.	Open line between main terminal strip and foot switch or foot switch and contact coil.	Check for broken wire and replace.
	Foot switch faulty.	Replace foot switch.
	Open in motor.	Replace motor.
Main disconnect closed. Pump motor operates but contactor does not.	Open line between main terminal strip and foot switch or foot switch and contact coil.	Check for broken or loose wire and replace.
	Foot switch faulty.	Replace foot switch.
	Open in contact coil.	Replace coil.
Main disconnect closed. Pump motor and contactor operating but weld transformer not operating.	Power transformer switch on transformer in OFF position	Switch to desired power position.
	Open line between contactor and power transformer.	Check for loose connection and repair.
	Open in lead (s) to tongs.	Replace lead (s)
Brazer functions properly except part being welded does not heat fast enough.	Weld transformer on too low a tap setting.	Turn transformer to higher tap setting.
	Carbons worn badly.	Replace carbons.
	Leads defective.	Replace leads.

Main disconnect closed. All components operate but tongs and/or leads overheat.	Pump motor turning wrong direction.	Change wiring in motor for proper rotation.
	Pump worn.	Replace pump.
	Low coolant level.	Fill holding tank to proper level.
Main disconnect closed. All components operate but tongs and/or leads overheat.	Screen on pump pickup tube clogged.	Clean screen and coolant tank and replace coolant.
	Coolant temperature too high.	Let stand to cool or replace coolant. (Heavy duty cooling system available.)
	Plugged pump filter.	Clean or replace pump filter.
	Plugged radiator.	Flush or replace radiator.
	Contaminated and/or dirty coolant.	Drain tank, clean thoroughly and replace coolant (This should be done at least once a year.)
	Plugged and/or damaged leads or tongs.	Replace tongs and/or leads.
	Plugged transformer.	Flush or replace transformer.
	Suction leaks on suction side of pump.	Replace damaged lines and/or fittings.
	Pump drive motor failure.	Replace drive motor.
Coolant should flow 1 gallon in 45-50 seconds If slow. Check.	Contaminated (dirty) coolant.	Drain tank, clean thoroughly and replace coolant.
	Pump drive motor failure.	Replace drive motor.
	Plugged transformer.	Clean or replace transformer.
	Worn Pump.	Replace Pump.
	Plugged and/or damaged leads or tongs.	Replace leads and/or tongs.
	Suction leaks on suction side of pump.	Replace damaged lines and/or fittings.
	Plugged tank filter.	Clean or replace tank filter.
	Plugged pump filter.	Clean or replace pump filter.
	Plugged radiator.	Flush or replace radiator.