

FB10000 Error Messages Troubleshooting

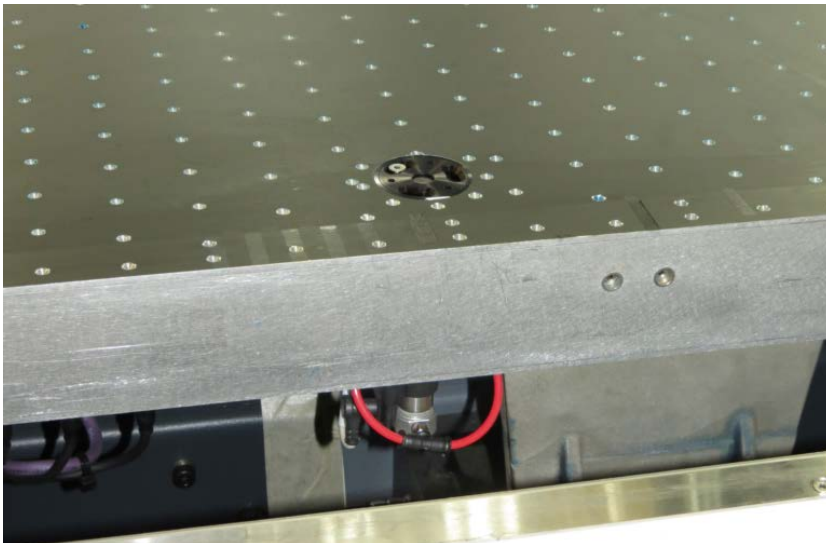
Error ID: 50080: M-Handling – Manual loading pins are unable to go down

Error Severity: **Error**

Possible Causes

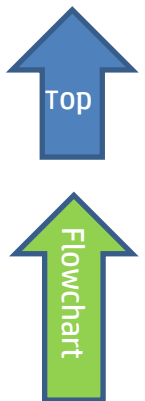
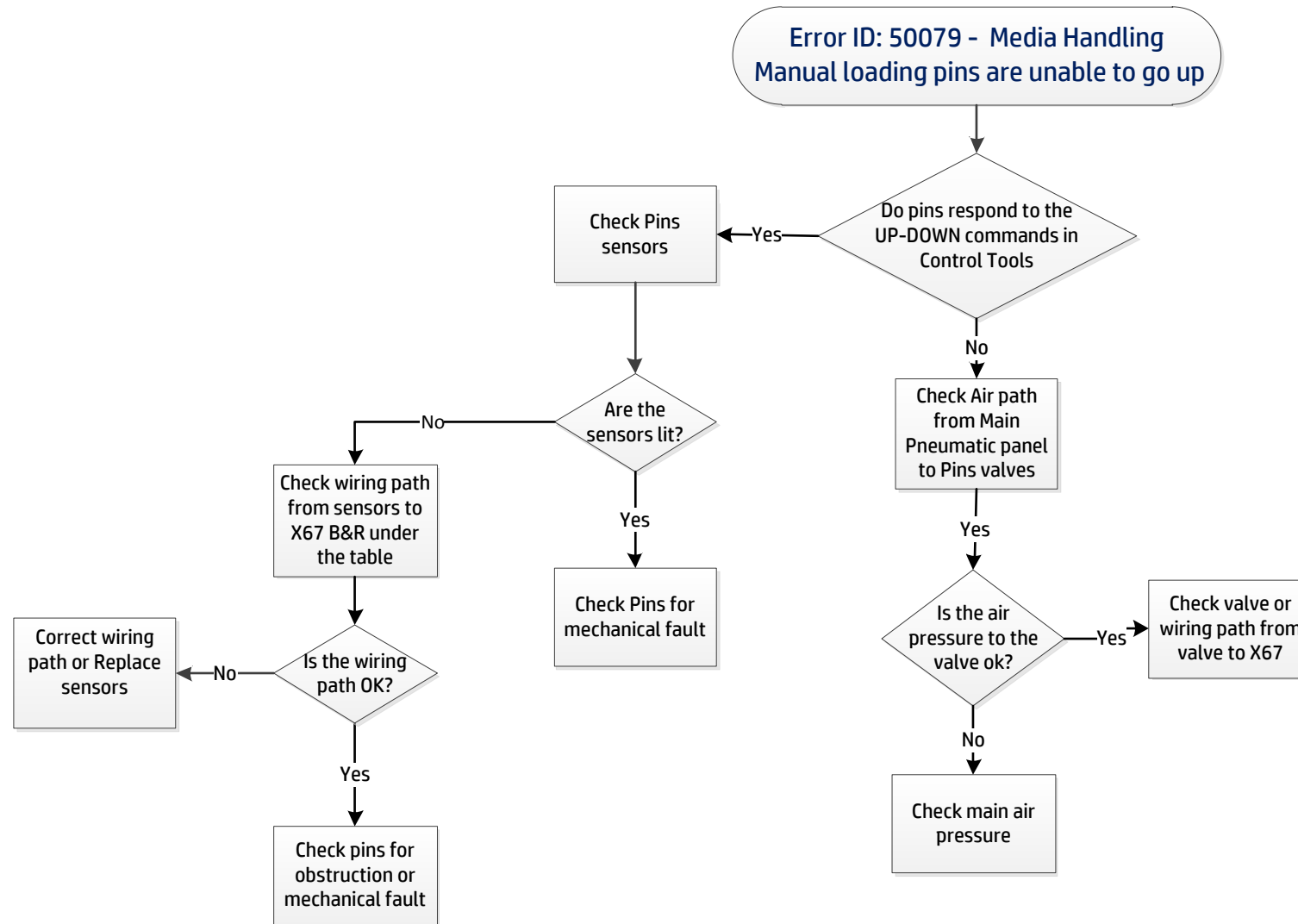
This error may be triggered due to one of the following electronic, mechanical or communication failures.

- [One of the loading pins sensor is disconnected or faulty](#)
- [A cable along the wiring path from the sensor to the X67 B&R is disconnected](#)
- [One of the valves under the table is faulty](#)
- [The pneumatic panel does not supply the appropriate air pressure to the valves](#)
- [One of the pins is damaged or obstructed](#)
- [The Ethernet X2X cable under the vacuum table to X67 B&R under table is disconnected](#)



Troubleshooting Flowchart

Troubleshooting Flowchart

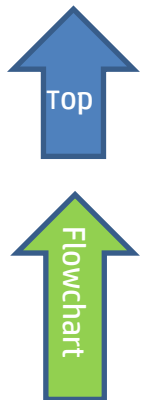


Recommended Actions

This error may be triggered due to three types of failures: Electronic, Communication or mechanical.

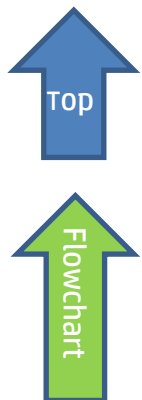
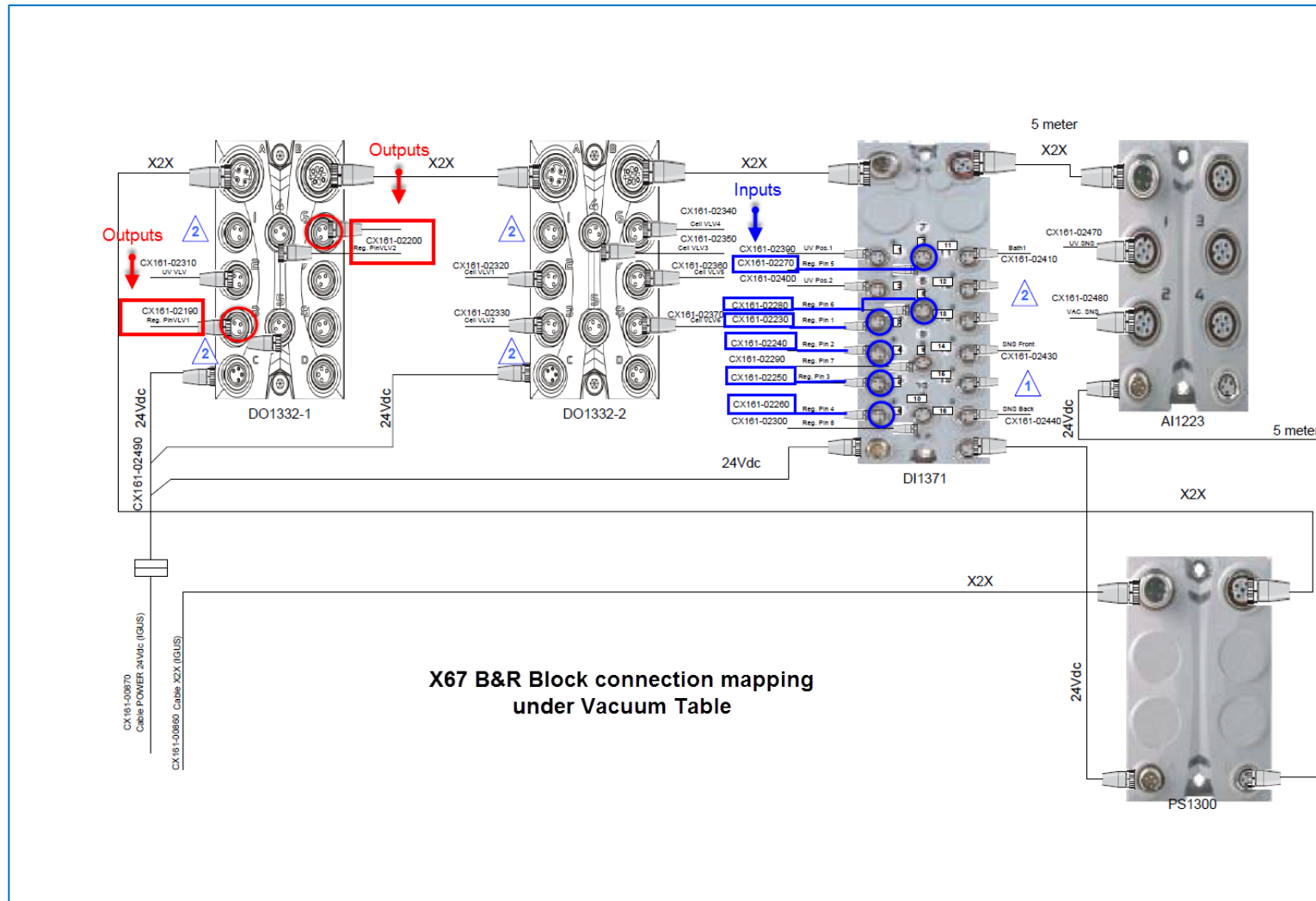
One of the loading pins sensor is disconnected or faulty

1. Open Control Tools and activate the three front positioning pins while you monitor their movement (Bug in Control Tools – always show 4)
2. Repeat this action on the three rear positioning pins while you monitor their movement.
3. Check individually each pin sensor under the table to ensure that they are all properly fixed.
4. Check each of the six positioning pins Molex connectors and ensure they are all tightly attached to the cable leading to the X67 B&R block.
5. Tighten the circular plugs in the X67 B&R block under the table (see X67 B&R Block connections under vacuum table below).



A cable along the wiring path from the sensor to the X67 B&R is disconnected

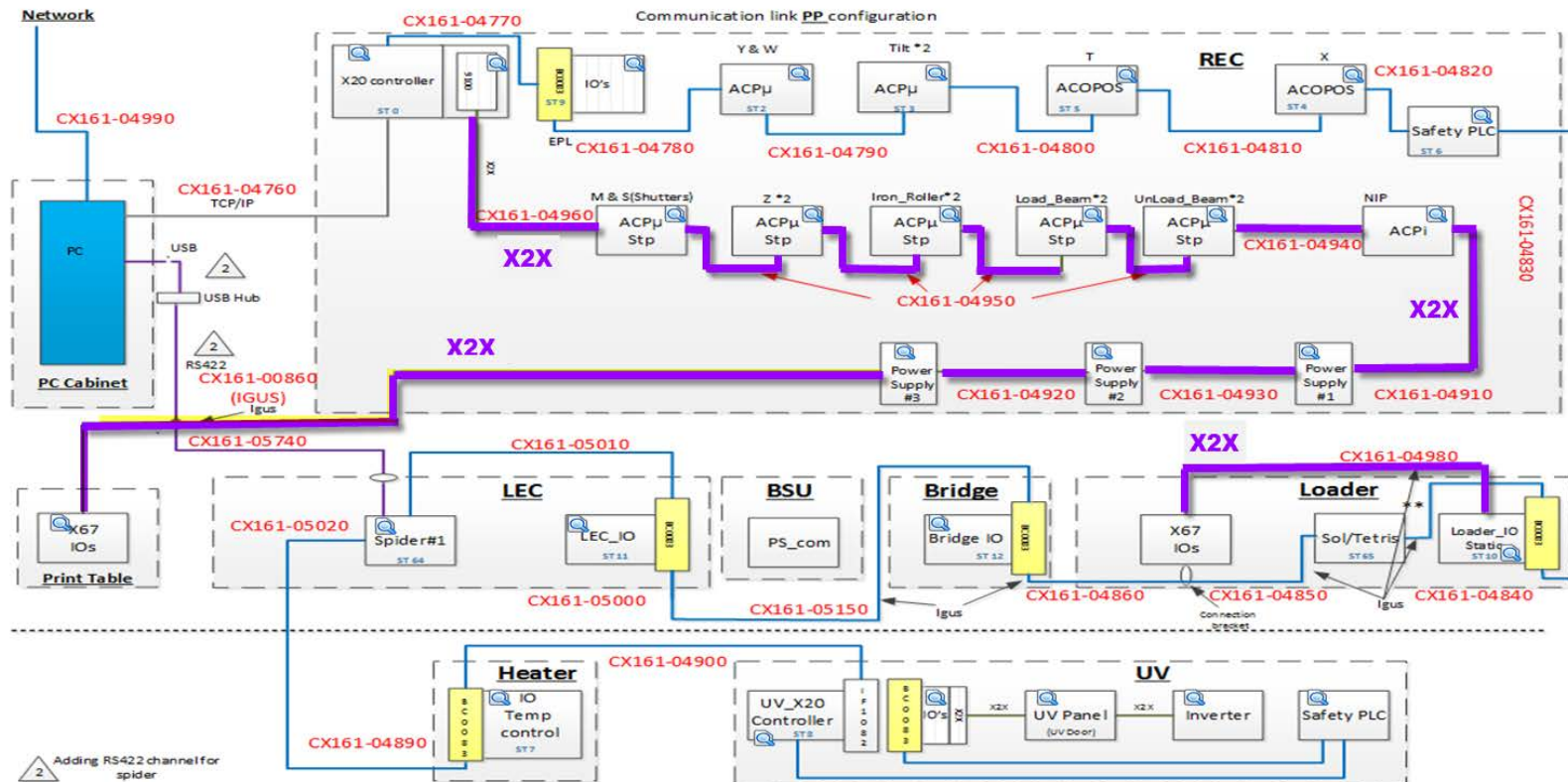
1. If the wiring path is ok then try replacing the sensor of the faulty positioning pin sensor.
2. If the error persists, continue to the next possible cause.



The Ethernet X2X cable under the vacuum table to X67 B&R under table is disconnected

1. Inspect the X2X Ethernet cable (violet) path. Start from the X67 B&R block under the table as described in the diagram below. (A diagnostic test on the X2X connectivity has already been written and will be implemented in the coming months).

B&R Connections



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One of the positioning pins valves under the table do not function properly

1. Check the valves of each of the six positioning pins by raising them up and lowering them down through Control Tools.
2. If any of them does not move smoothly, replace it.

The pneumatic panel does not supply the appropriate air pressure

1. Verify that the pneumatic panel supplies 7 bar to the pancake and to the positioning pins valves\
2. If the vacuum works, then the air supply to the table is ok.
3. Inspect the air tubes to the valves to ensure that none of them leaks.

One of the positioning pins is damaged or obstructed

1. Inspect the pins for physical obstruction.
2. Inspect the pins for physical damage.

