

TROUBLESHOOTING GUIDE: GMP-025

| Problem | Possible Causes/ Areas To Check | Remedy |
|---|--|---|
| Unit will not run (ALWAYS remove power when servicing) | Check electrical supply | Verify that requirements are met (115/120v, 100' extension) |
| | Check motor controller fuses | Replace |
| | Motor / Gear box failure | Replace |
| | Switch in dispense assembly handle | Replace if unit runs when bypassed |
| Unit runs but no flow / low flow of materials | Improper material supply to pumps | Clear obstruction in tank bottom |
| | Desiccant canister | Unopened or blocked air vent holes |
| | Check chain drive | Tighten / replace drive chain |
| | Air in material supply | Tighten / seal all material fittings |
| | Ratio check NOT okay: | Clear / replace |
| | * Blockage of hoses | Clear / replace |
| | * Blockage in dispense assembly | Replace |
| | * Blockage in pump | Rebuild |
| | Plugged hoses or dispense manifold | Clear or replace |
| Worn Pumps | Verify that material being used is non-abrasive. | |

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|---------------------|---|--|
| Too much flow | Motor speed control | Reduce setting |
| | Check motor control speed setting | Adjust per controller manual |
| Irregular flow | Check valves sticking / blocked | Disassemble & Clean |
| | Blockage at pump inlet | Remove tank & inlet, clear |
| | Blockage in hoses | Clear / replace |
| | Blockage in static mixer nozzle | Replace |
| Material not curing | Material off ratio | 1.Check material by hand: mix a sample of A&B in the proper ratio 2.Do a system ratio check |
| | Timing sprockets wrong size? | Correct / replace |
| | A or B pump leaking seals | Rebuild Pump |
| | A or B check valves sticking (in dispense assembly) | Disassemble, clean, & rebuild; use new o-ring. |
| | Static mixer worn or plugged | Replace |
| | Static mixer does not have enough elements for proper mix | Increase mixer size |
| | Lead in one material coming out of dispense manifold; Air in material | Follow air bleed procedure |
| | Foreign object or cured material in pump or pump inlet | Remove tank & inlet, then clear or rebuild pump. |