

TB0257 Fault Finding Gripper Slip

Checklist of root causes for gripper slip issues

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Technical Bulletin

TB Number:	257
Originator:	Gareth Green
Machine:	All
Date:	11/07/14
Circulate to:	Service
Title:	Gripper Slip

Symptoms

Code	Description
	Accuracy Issues Gripper moving no profile
	Gripper Slip Error Message
	Slots wrong length
	Operation in wrong place
	Bar missing from queue
	Incorrect bar length measurement
	Bar does not eject properly
	Piece length wrong

Actions / Checks

Code	Description	Tick
	Is it on all profiles	
	Is gripper bent or worn Is gripper loose	
	Clean teeth? Recently Replaced	
	Prior to problem? Collision	
	Check rollers free to turn and clean	

	Blunt tools / correct tools	
	Clamp pressures	
	Gripper positions correct for profile	
	Zip gate and clacker heights ok	
	Bits of machine caught in V notch (esp rear)	
	Clutch / clutch relay stuck on	
	Faulty gripper sensor	
	Loose gripper heel / insert	
	Spirol pin in zip gates sticking up	
	Gripper pressure	
	Gripper datum position correct / G axis parallel	
	Water in Air system	
	Split air pipe / air leak Faulty gripper cylinder	
	Incorrect gripper for profile	
	Faulty Valve	
	Gasket of profile catching	
	Gripper sensor wire	
	Check profile spec - web where gripper sits	
	Profile too cold and shatters	
	Profile too wet and slips	
	Correct profile loaded	
	[A2001-A2004 Sturtz Grippers] Clevis pin is floating causing lock-up	

Root Causes

Code	Description	Tick
	Gripper bent	