

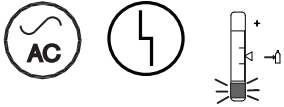
**Troubleshooting guide**

See *System tests* on page 5-18 for detailed test procedures.

It is important to note, when troubleshooting a problem on the Powermax45, how the front panel LEDs operate. To help diagnose transient problems, an illuminated or blinking LED, including the bottom bar on the gas pressure bar, may continue to illuminate or blink for 10 to 20 seconds after the system is powered OFF. Once the system is powered ON, the LED should not illuminate or blink if the fault has been cleared.

**NOTE:** On rare occasions, toggling the power switch ON/OFF very quickly (a “quick reset”) on 480 V CSA power supplies may cause the Power ON LED light to flash for approximately 10 seconds. This flashing does not indicate a fault condition and will clear automatically. In such cases, you can safely continue to operate the torch while the LED is flashing.

Also, note that there is no static gas pressure reading. So the gas pressure LEDs may not indicate a low pressure situation if the gas was not connected when the system was powered ON. Attempting to fire the torch without the gas connected will cause the bottom yellow gas pressure LED to blink.

<b>Problem</b>	<b>This may mean</b>	<b>Cause</b>	<b>Solution</b>
<p>The ON/OFF power switch is set to ON (I), but the power ON LED is not illuminated.</p>	<p>There is insufficient voltage to the control circuits or a short-circuited power component.</p>	<ul style="list-style-type: none"> <li>▪ The system has no incoming voltage or an improper incoming voltage.</li> <li>▪ The power board is faulty.</li> </ul>	<ul style="list-style-type: none"> <li>▪ Check to see that the system is plugged into an appropriately-sized circuit and that the circuit breaker has not been tripped.</li> <li>▪ Perform <i>Test 1 – voltage input</i> on page 5-18 to check the incoming voltage and the power switch.</li> </ul>
<p>The power ON LED is illuminated, the fault LED is illuminated, and the bottom LED on the gas pressure bar is illuminated yellow and is blinking.</p> <div style="text-align: center;">  </div>	<p>There is insufficient gas pressure to the machine.</p>	<ul style="list-style-type: none"> <li>▪ There is no gas attached to the system.</li> <li>▪ The gas supply line has a restriction or the air filter element is dirty.</li> <li>▪ The reading at the pressure transducer is below the minimum acceptable gas pressure.</li> </ul>	<ul style="list-style-type: none"> <li>▪ Ensure that the gas supply is connected correctly.</li> <li>▪ Check the gas supply line for restrictions or damage.</li> <li>▪ Check the air filter element and replace it if necessary.</li> <li>▪ Perform <i>Test 9 – pressure transducer</i> on page 5-28 to verify that the pressure transducer functions correctly.</li> </ul>