

# Whirlwind Basic Troubleshooting Guide

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Please note, the following troubleshooting tips apply to stand alone machines only, and some older models may vary in the components and pneumatic connections!

## **Machine will not Cycle:**

Check for air out of the foot pedal, should be blowing only with pedal depressed

Check for air out of the one shot valve, 2-3 seconds normally then should stop

Check for air out of the amp, also 2-3 seconds normally then should stop

Check for air out of the sensor, light flow on black return line to the Amp

Crimp airline (red) going to roller valve, possible roller valve stuck or leaking

Check exhaust flow controls for leakage, if leaking, cylinder needs repaired/replaced

Open the top flow control ½ turn then try to cycle machine again

## **Saw cycles once and will not cycle again:**

The foot pedal is leaking not allowing the one shot valve to reset, repair/replace the foot pedal valve

## **Saw cycles when you first turn the air on:**

The foot pedal is stuck sending air to the one shot beginning the cut cycle, repair/replace foot pedal valve

**Saw cycles with no material under the work present sensor:**

Disconnect the black line at the amp, if it does not cycle now, then the sensor is bad and needs replaced

If it still cycles with the black line disconnected, then the amp is bad and needs replaced.

**Work present sensor is blowing air all of the time:**

The foot pedal is leaking and/or stuck, repair or replace the foot pedal valve

**Cycle speed cannot be controlled by the exhaust flow control valve:**

Need to repair/replace cylinder

**Saw slams or bangs into the table:**

Make sure maximum air pressure does not exceed 90 psi.

Roller valve is out of adjustment, should be set ¼" below table

One shot valve is blowing all the time, replace the one shot valve

The cylinder is leaking out of the rod end of the cylinder, repair/ replace cylinder

**Saw does not cut all of the way thru the material:**

Need to adjust the one shot valve for 2-3 seconds of air (depending on the material being cut) the slower the cycle, the more seconds needed to finish cut

Make sure exhaust flow controls are not clogged

Open top exhaust flow control ½ turn counter clockwise

Try to lubricate the cylinder

**Saw stays up and guard stays down:**

Take the green line off, if the saw goes down, then the foot pedal is leaking, repair/replace foot pedal valve

If the saw does not fall, the bottom exhaust flow control could be clogged, clean flow control and try again

If the saw still does not fall, then the pilot valve could be stuck or bad, clean, lube and/or rebuild/replace pilot valve

Check for mechanical binding

**On the older model 1000 machines, they had a double pilot valve with a guard valve and you would have to tap the foot pedal and the saw would return to the down position**