



Moving Head  
Travel Error

Start

Adjust Head Timing

Cleaner and Oil  
Head are Timed  
Properly

Cleaner and Oil  
Head Bars are Well  
Lubricated

Identify Code and  
Verify Wiring is Secure.  
Correct as Needed

Replace Motor  
P/N  
158-1605

Change Fuse-2.25A  
P/N  
154-1266

Fuse Tests Good

Lubricate Both Cleaner  
and Oil Head Bars

Stepper Driver  
Has Red Light Fault

Stepper Motor  
Tests Good

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Experts

Reconnect and/or  
Tighten Loose Wire

Wire on Fuse  
Holder Loose or  
Disconnected

Fuse Holder Tests  
Good

Wire to Motor  
Loose or Damaged

PLC Output  
100ch04 Tests Good

PLC Output  
100ch05 Tests Good

Replace Fuse Holder  
P/N  
153-1028

Re-Attach Loose Wire  
or Replace Damaged  
Wire

Replace PLC  
P/N  
158-1610P

Replace PLC  
P/N  
158-1610P

No

Yes

Yes

No

Yes

No

No

Yes

No

No

Yes

Yes

Yes

No

Yes

No

Yes

No

No