

# **Trouble Shooting Guide**

## **PLC Water Level Control**

Any unit manufactured after 1-08 has a PLC system installed. This is a computer based system that controls a majority of functions on the pulping system.

The PLC now controls what the air pump, pressure switch, snubber, air lines, and stand pipe used to control.

Initial fill is determined by a proximity switch located inside the pulper tank. When the water level reaches a specified height, the green 'ready' light turns on indicating a ready to run status for the pulper. Make-up water is also controlled by the PLC. This action is done by a timer method. Average systems are set for 15 seconds of fill and 15 seconds of water off. This setting can be adjusted, please call the factory for support.

If for any reason there is a green light and no water in the tank, ensure the bottom of the sensor is clean. If debris is allowed to build up on the sensor it will give false readings to the PLC and possibly clog lines or cause other damage to the machine.