

Blade will not start & have Saw Blade Error 3220

The following points are all true, which is normal when the saw is ready to operate:

- BLADE IN MOTION light is not on
- BLADE STOPPED light is on
- VFD FAULT and OVERLOAD, and E-STOP lights are off
- There are no errors on the HMI.
- Motion module is working.

Error window appears:

Intermediate circuit DC voltage is not sufficient due to missing supply voltage phase, blown fuse, rectifier bridge internal fault, or braking resistor overload (RT1P).

If the E-stop was activated just prior to this error, check to ensure SR1 delay setting = 10 seconds.

Causes:

1. Missing supply voltage phase
2. Blown fuse
3. Rectifier bridge internal fault
4. Estop condition
5. Brake resistor overload is tripped (RT1P) (see graphic on next pg)
 - RT1P yellow dial should always remain set to 4.1 amps
 - The reset button (red dial) should be on A-O so it will automatically reset when the system cools down. Prior to frame 38, they were set to M-O requiring a manual reset. To move the reset, they will need to push in the red dial with a screw driver and turn to A-O. It should pop back out. If it does not, push it in again till it pops out.

