

The following trouble shooting guide is for your reference only. Lotos Technology will NOT take any liability or responsibility for any injury or damage caused in such action(s). Always turn off electrical power and air supply before performing inspection and reconnection.

**CAUTIONS:** Only qualified technicians are authorized to undertake the repair of this equipment in the case of machine failure.

Faults	Possible Causes/Solutions
1. The power pilot light is off, the fan doesn't work, and there is no cutting voltage output.	<ol style="list-style-type: none"> <li>1. The power switch is broken.</li> <li>2. There is no electrical power.</li> <li>3. The input cable is short-circuited.</li> </ol>
2. The power switch is on, the fan doesn't work. No voltage is indicated on the front panel.	<ol style="list-style-type: none"> <li>1. There is an improper connection to the plug or the plug is improperly connected to the 380V power supply, causing over-voltage protection. For latter case, wait for 8 minutes, reconnect to 220V power supply, and restart the machine.</li> <li>2. The transformer is broken.</li> <li>3. Voltage deficiency protection has been activated.</li> <li>4. The wire from the switch to the bottom board has loosened. Tighten it.</li> <li>5. The relay on the bottom board is damaged. Replace with a new relay.</li> </ol>
3. The fan is on, the abnormal pilot light is not on, cannot start the arc.	Contact the manufacturer or certified service personnel.
4. The abnormal pilot light is off, no cutting voltage output.	<ol style="list-style-type: none"> <li>1. The welding cable is broken.</li> <li>2. The ground is improperly connected to the work piece.</li> <li>3. The "+" output terminal is not properly connected.</li> </ol>
5. The problem pilot light is not on.	<ol style="list-style-type: none"> <li>1. The nozzle is oxidized or too far away. Remove the oxidization on the surface, or shorten the distance to 1 mm.</li> <li>2. Otherwise, contact the manufacturer or certified service personnel.</li> </ol>
6. The abnormal pilot light is on.	<ol style="list-style-type: none"> <li>1. Over-current protection may have initialized. Either wait for 2 or 3 minutes for the problem to go away, or turn off the power, wait until the abnormal pilot light is off, and restart (machine will recover automatically).</li> <li>2. Otherwise, contact the manufacturer or certified service personnel.</li> </ol>
7. The output current is not stable.	<ol style="list-style-type: none"> <li>1. Check connections on the front panel.</li> <li>2. Otherwise, contact the manufacturer or certified service personnel.</li> </ol>
8. The machine does not cut metal properly, or the arc is not stable.	<ol style="list-style-type: none"> <li>1. The input voltage is too low.</li> <li>2. The ground cable is not well-connected.</li> <li>3. The air pressure is too high or too low.</li> <li>4. The nozzle and electrode of the torch do not fit well, or the input current is too low.</li> </ol>

