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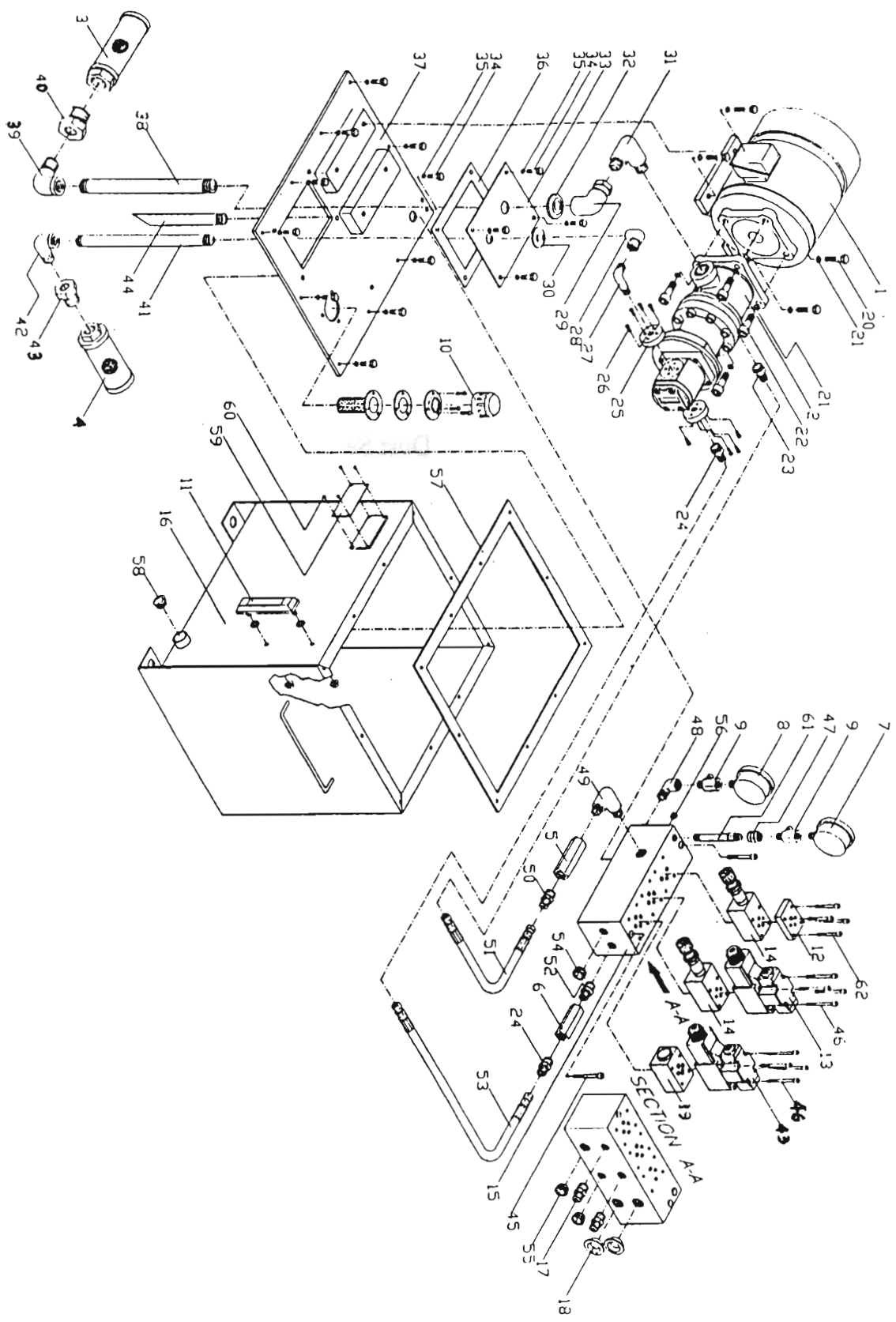
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NO AUTO DOWNFEED TROUBLESHOOTING FOR AGS-1020 ~ 1632AHD

1. Turn on the hydraulic pump. Set the machine in auto plunging mode and start auto downfeed. The pressure should be 10-12 kg/cm², (see page 80.)
2. Check 2 solenoid valves on hydraulic system. One solenoid valve light should stay on all the time for the cylinder of the clutch #52 (see page 57.) The other solenoid valve light should be on-off / on-off continuously for cylinder for #54 cylinder feed.
3. Take out the cover #53, double check the #72 spring to see if it is broken or not.
4. Take out the cover #53 and make sure the cylinder #52 should push way out to fully engage.
5. Make sure the #54 feed cylinder can push up and bring down by the spring every time.
6. Make sure the #37 transmission claw is engaged to #40 the ratchet gear once you set the increment by #28 preset dial.
7. Make sure the solenoid valve coil is working #13. Use the ohm voltage meter to check. Sometimes the solenoid valve cylinder is stuck with particles. You can use a nail to push the center of the cylinder of the solenoid valve to see if it is moving or not.

HYDRAULIC PUMP UNIT ASS'Y (1020AHD,1224AHD)



Downfeed Ass'y for Left Hand Thread Screw

