

Troubleshooting

Symptom	Cause	Action
MANO CLAMP malfunction	Air supply is insufficient.	Check the supply pressure.
	A MANO CLAMP part is damaged.	The part must be repaired.
	The actuator is damage.	Replace the actuator.
	The solenoid valve is damaged.	Replace the solenoid valve.
	The air tube is damaged.	Replace the air tube.
	The internal seal is worn out.	Replace the part.
	Foreign matter is included.	Overhaul MANO CLAMP.
Insufficient jaw stroke	A MANO CLAMP part is damaged.	Replace the part.
	The internal seal is worn out.	Overhaul MANO CLAMP.
Slipping of workpiece	MANO CLAMP malfunction items	Take action for each item.
	Cutting conditions have been changed.	Reduce the amount of cut-in.
	The shaped jaws are worn out.	Refinish or replace the jaws.
	The maximum number of revolutions is exceeded.	Reset the maximum number of revolutions to an appropriate value.
	If cutting conditions are changed.	Reduce the amount of cut-in.
Low machining precision	Workpiece elements (material and process)	Check the work elements to take the appropriate action.
	Mechanical elements	Check the mechanical elements to take an appropriate action.

If the above troubleshooting does not settle your problem, contact us.