Samsung SM series Feeder maintenance instruction--by
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Error message	Reason and processing method
Index error	the cylinder doesn't retract within specified time, check if reel is blocked, and if feeder gear is blocked
Led on feeder is yellow	The sensor dosen't sense it's sensor block, adjust cylinder stroke screw and check the sensor work normally
Led on feeder is green but doesn't work	check contact pin, check solenoid valve, check cylinder work normally
Open error (no movement on cylinder)	cylinder doesn't work, check compressed air → check cylinder → check contact pin is good → check solenoid valve → check cable wire connecting with solenoid valve → check control pcba
Open error (cylinder moves half stroke, forwards but can't retract, or retracts but can't forward)	replace the sensor
feeder gear does not turn or the speed is not sensitive	check if foreign material in feeder gear, check the cylinder is located securely, check the air pressure is normal, check feeder tape guide works normally
Led on feeder does not light	check the control pcba, re-plug or replace → check contact pins
feeder gear retract a bit when push it by hand	adjust the stroke screw of gear