

PUSHER ASSEMBLY

Problem Observe	Alarm	Possible Cause	Solutions
Pusher not moving	Cylinder Fault	1: Cylinder not actuating	1: Check SCADA output
			2: Check solenoid valve
	Air Pressure Low	2: Insufficient air	1: Check FRL pressure
	Solenoid Fault	3: Valve not working	1: Check coil signal
			2: Replace if faulty
	Sensor Fault	4: Position not detected	1: Check sensor input
			2: Adjust
	Mechanical Jam	5: Obstruction	1: Stop machine
2: Remove jam			
Timing Issue	6: Delay mismatch	1: Adjust SCADA timing	
Guide Misalignment	7: Improper alignment	1: Adjust guides	