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## Hot Melt Gear Pump Troubleshooting Guide

PUMP IS NOT OPERATING	SOLUTIONS
Motor on/off switch is off on control panel.	Check motor on/off switch.
Temperature is below threshold of set points.	Pump will not turn on until all set points have reached temperature. Check temperature set points and adjust temperature if necessary. If the system was up to temperature and then dropped below the tolerance it will stop the pump and wait for temperature to come back within tolerance.
No incoming electrical power.	If the ASU is also not heating up, check the incoming supply voltage.
System is not ready.	Wait until temperature light is steady ON.
PUMP IS RUNNING BUT THERE IS NO ADHESIVE	SOLUTIONS
ASU is out of adhesive.	Add adhesive to hopper.
Moto leads have been reversed.	Check motor wiring to schematic.
PUMP IS RUNNING BUT THERE IS LIMITED ADHESIVE	SOLUTIONS
Filter(s) is clogged.	Check filter and replace if necessary.
Adhesive is too viscous.	Increase temperature. Check with adhesive provider to ensure current lot is within viscosity tolerance
Clogged hose.	Eliminate fluid pressure, then disconnect fluid connection of hose and turn pump on. If adhesive flows from manifold there is a clog in the hose or applicator
Clogged applicators.	Eliminate fluid pressure, then disconnect fluid connection of applicator and turn pump on. If adhesive flows from the hose, the applicator is clogged.