



# Fornax T

## Service Manual Fornax T



330.00001 ....

**BEGO**  

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# Contents

## General Information

E 01 - No cooling water.....	Page 2
E 02 - Lid magnetic lock defective.....	Page 3
E 04 - Lid safety switch defective.....	Page 3
E 22 - Communication generator <-> Controller board not ok.....	Page 3
E 23 - Generator message – Temp. cooling water >70°C.....	Page 4
E 24 - Generator message – Current too high.....	Page 4
E 25 - Generator message – Current too low.....	Page 4
E 27 - Generator message – Melting process timeout > 5 minutes.....	Page 5

### **Take note:**

None of these generator messages means that the generator is definitively defective.  
Further tests are required to locate possible defects.

### **E 01 No cooling water (blue light “cooling water” flashes)**

The cooling water pressure is controlled by the **pressure switch 13385** . Minimum water flow should be 1 l/min .  
If the flow is lower the blue water indicator flashes with a beeping .

Check water pressure flow and/or pressure switch .  
If the flow is < 1 l/min check the water pressure and/or the cooling system.  
If the flow is > 1 l/min check the pressure switch .

### **Take note :**

After switching on the Fornax the water cooling and the fan only starts after lifting the coil up to start the melting process .  
The cooling water and the fan will be automatically turned off in the standby modus after 10 minutes without using.

### **E 02 Magnetic lock ( Lid ) defective**

To start the melting process the lid must be closed and locked .Responsible for the locking is the **magnetic lock 39453** .The magnetic lock activates inside a microswitch .  
If after closing the lid ( lid control switch is activated see E 04 ) this microswitch is not activated the error message will be generated .

Check the magnetic lock .

#### **E 04 Lid switch defective**

The close lid is controlled by the magnetic lock ( see E 02 ) and the **safety switch 15354**  
The switch change after closing the lid over from a closed to a open position .  
This changing is controlled by the **PCB 17597** .

Check the switch **15354** and / or the inputs “Deckel NC ,Deckel NO “ at the **PCB 17597**  
pushing the switch manually .

#### **E 22 No communication between PCB and generator**

During the process the generator communicates with the **PCB 17597** .  
If the generator does not respond after a command the error message 22 generates after  
10 sec.

Check if the automatic fuse **F 5** is released ( Fornax rear side ) .  
If after fuse activation the unit works and the fuse release again after some castings  
please check the main voltage and/or the alloy weight .  
Please read in the manual about the max. weight of alloys .  
Check the interface cable connection from generator > PCB .  
Check the generator power supply connection.  
Check if the fuse at the generator is blown .

#### **E 23 Temperature too high**

After arriving 70 °C on the generator the Fornax will be switched off and  
Error message E 23 will be generated .

Check the cooling system ( minimum 1,2 l/ min ) .  
Check the temp. of the cooling water ( circulation unit “Termico“ ).  
If necessary change the water .

#### **E 24 Generator over current**

If the generator output current is too high the Fornax will switch off .

Mostly the generator output is defective .  
Change the generator **17596** .

## **E 25    Generator current too low**

Every 10 sec. the generator output current will be controlled .  
If the min. of current is not arrived the generator will switch off.

Check the connections between copper piece and generator output cable . Check also if the capacitor group is correctly mounted and if all screws are well tightened .Also if maybe some capacitors are defective .

Check the crucible coil .Are the windings free ?? Is there any contact ??

Change generator **17596**

## **E 27    Generator timeout**

For security reasons the generator will get switched off after 5 minutes continuously heating .