



## Troubleshooting Aids

### “A” & “J” Hause Hydraulic

June, 2001

Trouble	Probable Cause	Check	Remedy
<b>Unit does not cycle</b>	No or low hydraulic supply pressure	Hydraulic supply not turned on	Correct – regulate for proper pressure – 300 to 500 p.s.i
		Electrical & hydraulic connections	Correct.
	Directional valve at hydraulic pump does not actuate	Check “O” rings in valve for swelling or sticking.	Replace and lubricate
	Hydraulic supply leaks	Check for leaks around fittings.	Tighten or replace
	No electric power to control circuit	Make sure electric system is on – check fuses. (Solenoid valve action is audible.)	Correct
	Switches not being actuated.	Levers & cam bars for proper adjustment	Re-adjust – Ref. Eng. Data Bul., Cam Bar Bul, & Lever Assy. Bul.
	Feed rate adjustments at manifold closed.	Make sure feed rate adjustments are open 4 or 5 turns.	Adjust – Ref. Eng. Data Bul.
<b>Directional valve at Hydraulic pump operates but spindle does not advance.</b>	Tool or spindle binding in external support	Disengage tool and/or loosen bracket containing support.	Re-align & cycle
	Advance feed rate adjustment at manifold is closed.	Make sure feed rate adjustment is open 4 or 5 turns.	Adjust – Ref. Eng. Data Bul.
	Plunger valve assembly on advance side of manifold closed.	Turn advance rapid travel length adjustment counterclockwise (clockwise for deep hole units) this action should make the lever arm depress the plunger of the plunger valve assembly.	If plunger does not depress, reset cam follower or lever arm on lever assy. Ref. Lever Assy. Bul.



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<b>Spindle does not retract</b>	Advance hydraulic solenoid valve at hydraulic pump not working.	Hydraulic pressure in retract supply line	Repair or replace.
	Switch actuators.	Check adjustment	Re-adjust
	Defective “O” rings	“O” ring seals in cylinder assy. And/or directional valve at pump.	Replace – Ref. Cylinder Assy. Bul.
<b>Directional valve at hydraulic pump operates but spindle does not retract.</b>	Tool or spindle binding in external support.	Disengage tool and/or loosen bracket containing support	Realign and cycle.
	Low hydraulic supply pressure	Hydraulic pressure should be between 300 and 500 p.s.i	Regulate
	Plunger valve assembly on retract side of manifold closed.	Turn retract cam bar knob to make lever arm depress plunger of plunger valve assembly.	If plunger does not depress – reset cam follower or lever arm on lever assembly. Ref. Lever Assy. Bul.
	Retract feed rate adjustment in manifold is closed.	Turn retract feed rate knob counterclockwise to open.	Adjust
	Drive shaft and spindle coupling bind	Remove spindle assy. And check spline tube for metal build-up	File drive spline & spline tube for free slip movement. Lubricate
<b>Spindle rapid advances beyond setting of advance rapid travel length adjustment.</b>	Seal on hydraulic piston in cylinder assy is worn or broken.	Complete lack of control of spindle travel.	Replace piston seal Ref. Cylinder Assy. Bul.
	Hydraulic piston section retaining ring in cylinder assembly, loose or broken.	Complete lack of control of spindle travel, oil leaks into drive shaft area.	Replace – Ref. Cylinder Assembly Bul.



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	Advance plunger assembly in manifold sticks due to defective “O” rings.	Plunger movement should follow lever movement.	Replace “O” ring or complete assembly – Ref. Manifold Assembly Bul.
	Oil too heavy in hydraulic system.	150-200 S.U.S. at 100→ F hydraulic oil recommended	Drain & refill
	Dirt in advance plunger valve assembly in manifold	Remove & inspect valve for dirt.	Clean & reinstall Ref. Manifold Assembly Bul.
<b>Erratic feed rate.</b>	Advance plunger valve assembly in manifold not closing.	Foreign material fouling valve.	Clean – Ref. Manifold Bul.
		Valve worn	Replace assembly Ref. Manifold Assembly Bul.
	Advance cam bar worn.	Check.	Replace – Ref. Cam bar bul.
<b>Feed rate slows</b>	Dirt in compensating feed valve assembly in manifold	Remove and inspect assembly for dirt.	Clean & replace 22093-2 filters – Ref. Manifold Assembly Bul.
	Feed rate adjustments at manifold closed.	Make sure feed rate adjustment is open 4 or 5 turns.	Adjust – Ref. Eng. Data Bul.
<b>Spindle surges on tool break through</b>	Hydraulic supply pressure too low.	Supply pressure should be between 300-500 p.s.i.	Regulate.
	Thrust required to advance tool at desired feed rate approaches or exceeds thrust developed by Holomatic.	Consult drilling speed, feed and thrust charts and compare with developed thrust of unit.	Decrease feed rate, increase input supply pressure. Stagger drill lengths. Decrease size or number of tools.