Q-Box Series IV
Troubleshooting Flowchart

To use this troubleshooting flowchart, make sure that the soldering handle is attached to the Q-Box and the transformer switch is set to internal.

Q-Box soldering only on low power.

Q-Box not soldering at all.

Check power to Q-Box. → No power. → Check for external disconnect switch or tripped circuit breaker.

Power is OK.

Check fuse inside Q-Box. → Fuse is blown. → Replace fuse. 115V Q-Box: ABC 10 230V Q-Box: ABC 5

Fuse is OK.

Check 24VDC power supply inside Q-Box. → Light is off. → Check for loose wires and connectors on power supply. Replace power supply if needed.

Light is on.

Make sure that 24VDC is present at all power supply terminals. → 24VDC not present at all terminals. → Check for loose wires and connectors on power supply. Replace power supply if needed.

24VDC is present at all terminals.

Check speed switch (IFMR) "In" light inside Q-Box. → "In" light is not blinking. → Check for loose wires on Internal/External switch. Check for loose wires and connectors on speed switch. Replace speed switch if needed.

"In" light is blinking.

Try to solder a terminal while checking speed switch "Out" light. → "Out" light is not blinking. → Check settings on speed switch. Check for loose wires and connectors on speed switch. Replace speed switch if needed.

"Out" light is blinking.

Make sure PLC "Run" light is on. → "Run" light is not on. → Move switch to "Off" position, then to "On" position, and finally to "Term" position.

"Run" light is on.

Make sure PLC relay output card is functioning. → Line voltage not present at terminal NC7 (wire #8). → Replace relay output card on PLC.

Line voltage present at terminal NC7 (wire #8).

Check for loose wires on watt-second transducer. → Wires are loose. → Tighten loose wires.

Wires are tight.

Contact Antaya Technologies Corp. for further technical assistance.

ANTAYA TECHNOLOGIES® CORPORATION