

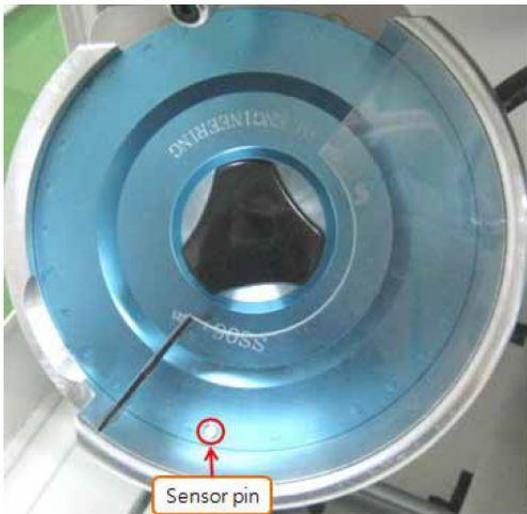
# Error 027 / 035 PF Positioning Fail

The Error 027 (PF Positioning Fail) message is indicating that for some reason that the Left Hoppers Parts feeder sensor stud is not being seen by the sensor. A few possible reasons for this are outlined below. Most commonly the issue is either the Sensor pin in the plate is not flush with the plate's surface, or the wheel knob is not secure.

**An Error 027 deals with the left hopper and Error 035 is dealing with the right hopper.**

## 1) The Sensor Pin is not pushed flush with the parts feeder plate.

Behind the parts feeder is a sensor that detects the metal stud that is inserted into the plate. The sensor detects this metal stud magnetically, so if the pin is too far away from the sensor, the sensor will not be able to magnetically sense the pin. Make sure that the metal stud (PIN) is pushed flush with the surface of the plate.



Find the Sensor pin on your Parts Feeder plate and ensure that it is flush with the surface of the plate.



Sensor that detects the Sensor pin.

## 2) The Parts Feeder Wheel Knob is not secured and the plate does not spin so The sensor never gets to sense the sensor pin.

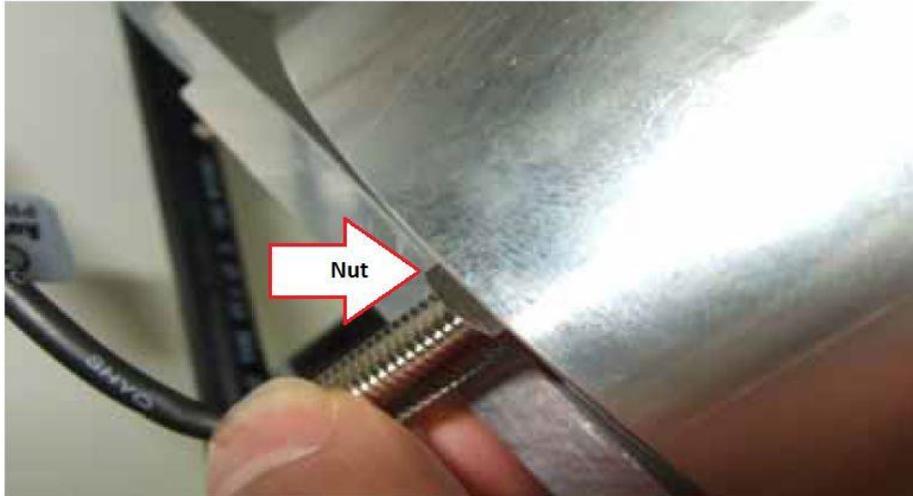
**Do not over tighten the wheel knob as it will be nearly impossible to loosen it, just make sure it is snug against the plate and when you turn the wheel knob, the plate spins with you.**



Ensure the Wheel knob is secure.

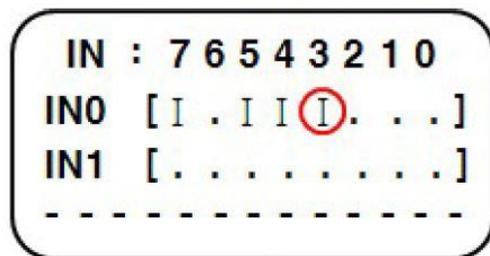
3) The Sensor itself is down too far in the hopper that it cannot detect the sensors pin from the parts feeder Plate.

The sensor itself is secured to the hopper by being screwed into it. And it is held in place by a nut at the rear of the hopper, if this nut became loose then the sensor (Being threaded like a screw would be) can turn slightly, becoming further away from the pin or stud that is inserted into the plate.



PF Sensor as seen from the rear of the hopper. As you can see it is threaded just like a screw would be, at the top is a nut that holds the sensors position. If this nut is loose then it is possible that the sensor is now slightly too far away from the sensors pin in the plate and it cannot detect it.

You can test to see if the sensor does detect the sensors pin, by going to INPUT menu, and you should see an "I" under the #3, and when the sensor pin of the plate is lined up over top of the sensor, this "I" turns into a dot.

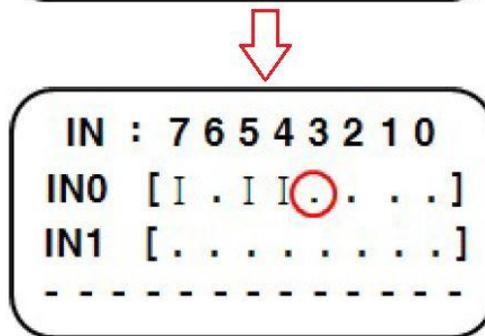


To test to see if the sensor is detecting the pin in the plate:

- 1) Go to INPUT and press SET
- 2) There should be an "I" under #3 for Left Hopper and an "I" under the #2 for the right hopper.
- 3) Rotate the plate by hand and line up the sensors pin with the sensor.
- 4) When sensor pin moves over the sensor, the "I" should go out.

*If the "I" does go out then the sensor and pin are detecting each other correctly.*

*If the "I" does not go out, then either the sensor pin is not flush with the plate or the sensor is too low and needs to be adjusted.*



If the "I" does not go out then we need to check to ensure the sensor pin is flush with the side of the plate you are working from (Rhinestone side or Nail head side). If it is and the "I" still does not go out, then we need to bring the sensor up slightly closer so the sensor detects the pin.

- 1) With the Parts Feeder plate installed and the wheel knob secure, rotate the plate by hand so that the sensor pin lines up with the sensor.
- 2) Go to the INPUT menu and you will be watching the "I" on #3 if your issue is Error 027, For Error 035, you will be doing this on the right hopper so you will watch the "I" under the #2 to go out as you adjusts the sensor.
- 3) Loosen the Sensors nut and turn the sensor so it screws further up into the plate.  
(Turning the sensor by its threading to the left brings the sensor up higher towards the Plates Sensor pin, turning it to the right brings it further away)
- 4) SLOWLY turn the sensor until you see the "I" go out under the #3 of your INPUT menu.
- 5) Once the "I" goes out, hold the sensor with one hand and secure the nut so the position stays And the "I" is still out.

***Do not over tighten the nut as you can break the sensor, just snug it up.***

