

# Rionfuser Machine Error Codes

CODE	PROBLEM	RESOLUTION
100	The barcode was scanned successfully, however the processor cannot decode the information into valid fusion parameters.	This is not a wand error or scanning problem. Verify that the barcode is an ISO standard 24 digit fitting barcode.
101	Ambient temperature is out of range.	Verify the temperature displayed in the CONNECT LEADS SCREEN is reasonable and within the range specified in the specification table. If the temperature displayed differs significantly from the actual temperature then there is a processor problem and it must be returned for service.
102	Measured resistance does not match resistance identified in the barcode.	Check output cable connectors and adapters for excessive wear and/or damage. If the output connectors and adapters are in good condition, reattach the processor to the fitting and try again. If the problem persists, there is more than likely a calibration or output cable malfunction.
103	Shorted Coil in Fitting.	Check for a short stab or a shorted coil.
105	Can't maintain output voltage.	Verify the output ends are clean, the power supply is sized correctly for the fitting you are fusing, and that the power supply is operating correctly.
108	The power supply was shut off during the previous fusion.	This could be anything from an improperly sized generator to someone switching the unit off during a fusion.
109	Reference voltage out of tolerance.	Unit must be returned for calibration. You cannot fuse if this error is detected.
110	STOP pressed during previous fusion.	Do not press the STOP button during the fusion unless it is an emergency situation.
111	Fusion complete with no other errors.	There were no problems with this fusion.
112	Fitting disconnected.	Current drops close to 0 during the fusion. If the problem persists there is more than likely an output cable problem and the processor should be returned for service.
113	The calibration date has expired.	Send the processor in for calibration.
114	There is no valid calibration date set.	Send the processor in for calibration.
115	The processor is not capable of outputting the current required to fuse this fitting.	As long as the fitting's fusion requirements are within the specified output range of the processor, this could be an output cable error or a calibration error. Try cleaning the Output Adapters. If the problem persists, the processor will need to be returned for service.
116	The processor is not capable of outputting the voltage required to fuse this fitting.	
117	Input voltage is out of range and the fusion cannot start.	Verify that the input voltage/frequency displayed in the CONNECT LEADS SCREEN are reasonable and within the range specified in the Specification Table. If the parameters displayed differ significantly from the actual input, then there is a processor problem and it must be returned for service.
118	Frequency is out of range and the fusion cannot start.	
119	Internal processor temperature is out of range	Allow the processor to cool before fusing again. This error can be seen if multiple large fittings are fused one after the other.
120	A time of 0 seconds for the fusion was entered or calculated.	This is more than likely a temperature measurement problem. Verify the temperature displayed in the CONNECT LEADS SCREEN is reasonable and within the range specified in the Specification Table. If the temperature displayed differs significantly from the actual temperature, then there is a processor problem and it must be returned for service.

# Rionfuser Machine Error Codes continued

CODE	PROBLEM	RESOLUTION
121	Invalid Operator ID card scanned.	Verify the system date is correct and if so, contact the agency that issued the Operator ID card.
122	Not an Operator ID card.	Contact the agency that issued the Operator ID card.
123	The Operator ID card scanned does not contain privileges for the functions this machine is capable of performing.	
124	Current offset is out of spec.	Processor must be returned for calibration. You cannot fuse if this error is detected.
125	Resistor ID fusion cannot be completed because the value was not decoded into a valid fusion time.	Verify that the fitting and the processor both support the Resistor ID method. If so, the problem is with the fitting, the output cable or the processor calibration. If the problem persists with multiple fittings, the processor will have to be returned for service.
130	The fitting was disconnected before the specified cooling time.	Do not disconnect the fitting before the manufacturer's recommended cooling time has expired.
131	An undefined error was received before the fusion time was completed.	Processor must be returned for service.
132	Processor supports voltage control only and fusion specified is not voltage control.	Not all processors support current or energy control. Attach a fitting that requires voltage control or contact an authorized representative at <a href="mailto:oriontechs@wattswater.com">oriontechs@wattswater.com</a> to see if an update is available for your processor.
138	The fitting was disconnected before the specified countdown time elapsed.	Do not disconnect the fitting before the manufacturer's recommended countdown time has expired.
140	The fusion was shutoff to protect the processor from damage due to extremely high fusion current.	This is typically caused when a direct short is made across the output leads. If there are no obvious problems with the fitting or the output cable, then the processor will need to be returned for service.
141	The ambient temperature is too low to fuse fittings of this type.	Same as Error 101.
142	The processor believes that the same fitting was fused twice.	Do not fuse a fitting more than two times unless directed so by the fitting manufacturer.
143	The fitting was disconnected before the specified heat soak time was observed.	Do not disconnect the fitting before the manufacturer's recommended heat soak time has expired.
144	The output is cycling and cannot be controlled to the requested level.	This is more than likely caused by a fluctuating power supply. Eliminate all extension cords and ensure that the processor is the only device operating on the circuit.
145	There is an error communicating with the USB Flash Drive.	Be sure the drive is formatted as FAT or FAT32 with a cluster size of 512 bytes.

**Warranty:** Our products are carefully inspected for manufacturing defects. However, it is not always possible to detect hidden defects. Our products are warranted only to the extent that we will replace them without charge if they are proved to have manufacturing defects within one year of the date of delivery to the site where they are to be used, or installed, and provided we have been given an opportunity to inspect any product alleged to be defective and the installation or use thereof.

**NO WARRANTY IS INCLUDED AGAINST ANY EXPENSE FOR REMOVAL, REINSTALLATION OR OTHER CONSEQUENTIAL DAMAGES ARISING FROM ANY DEFECT. THE WARRANTIES SET OUT ABOVE ARE THE ONLY WARRANTIES MADE AND ARE EXPRESSLY IN LIEU OF ALL OTHER WARRANTIES, EXPRESSED OR IMPLIED, INCLUDING THE WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE.**



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