# WPD Fault Finding Guide Summary (Revised)

Marshalls – WPD Fault Finding Guide – Revised Summary

Issue: SOFT UNITS  
Possible Causes:  
- Under Pressed:  
 - Cycle time too short  
 - Encoder not set correctly  
- Wet Mix:  
 - Excess water from poor Hydronix calibration  
 - Incorrect mix timing  
- Poor Water Removal:  
 - Blocked vacuum slots in die head  
 - Faulty or leaking vacuum hoses  
 - Full or blocked water trap  
- Vacuum System Performance:  
 - Check WTO system pressure and vacuum draw

Issue: BOWING / TAPER  
Possible Causes:  
- Drain bed wear or blockage  
- Former plates or die heads not parallel  
- Incorrect slew speed  
- Bucket offset or misalignment

Issue: INCORRECT SIZE  
Possible Causes:  
- Mix consistency (too wet or too stiff)  
- Pressing pressure or cycle misconfigured  
- Issues with weigh system or bucket fill  
- Improper encoder calibration

Issue: CRACKS / PLUCKING  
Possible Causes:  
- Dirty or damaged vacuum plates  
- Over-vacuum during pressing  
- Misaligned ejection or worn head seals