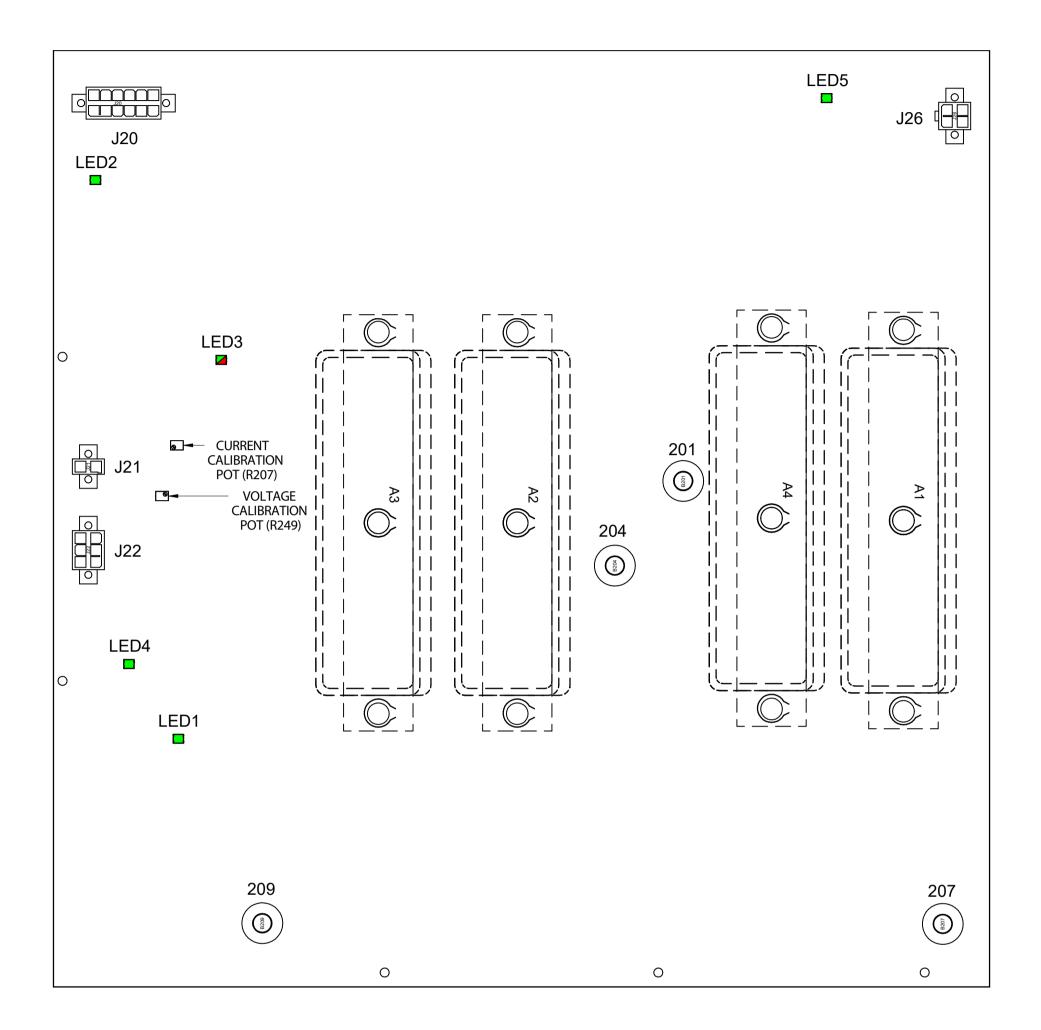


# SWITCHBOARD P.C. BOARD

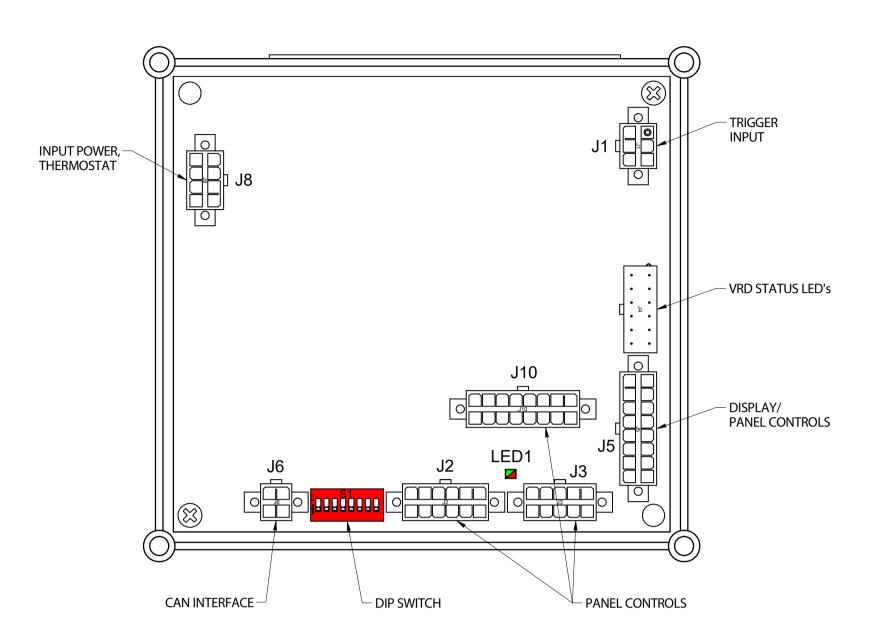


S28867-[] SWITCHBOARD				
LED#	COLOR	FUNCTION		
1	GREEN	+5V DC POWER SUPPLY "OK"		
2	GREEN	CAN POWER SUPPLY "OK"		
3	GREEN	STATUS "OK"		
3	RED	STATUS "ERROR" (CHECK CODE FOR SPECIFIC ERROR)		
4	GREEN	+15V DC POWER SUPPLY "OK"		
5	GREEN	FAN "ON"		

#### USING THE FLEXTEC 650 SWITCHBOARD STATUS LED

LIGHT	MEANING
<b>CONDITION</b>	
Steady Green	System OK.
Blinking Green	Occurs during startup or reset, and indicates that the switchboard is waiting for communication from the control board. Normal for the first 1-10 seconds after power is turned on.
Alternating Green and Red	A system fault has occurred. If the switchboard status LED is flashing any combination of red and green, errors are present.
	Individual code digits are flashed in red with a long pause between digits. If more than one code is present, the codes will be separated by a green light.
	See Page 3 for an Error Code Troubleshooting Guide.

# CONTROL P.C. BOARD



		S28868 CONTROL P.C. BOARD
LED#	COLOR	FUNCTION
1	GREEN	STATUS "OK"
1	RED	STATUS "ERROR" (CHECK CODE FOR SPECIFIC ERROR)

# TEST MODE CONFIGURATION S1 TURN ON PIN FOUR TO ENABLE TEST MODES ALL SWITCHES ARE OFF BY FACTORY DEFAULT

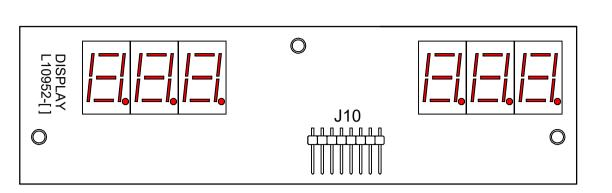
#### USING THE FLEXTEC 650 CONTROL BOARD STATUS LED

MEANING
System OK.
A system fault has occurred. If the Control Board status LED is flashing any combination of red and green, errors are present.
Individual code digits are flashed in red with a long pause between digits. If more than one code is present, the codes will be separated by a green light.

## **VRD Setup**

Input Voltage	Control Board
(3 phase, 50/60Hz)	DIP Switch Configuration
380V	S1
460V	
575V	

## DISPLAY P.C. BOARD



#### CONSTANT VOLTAGE TEST MODE

To enable Constant Voltage test mode:

- Set dip switch #4 to ONSet "WELD TERMINALS" switch to "

  "
- Set "MODE SELECT" knob to "GTAW"
- Set "LOCAL/REMOTE" switch to "LOCAL"
  Set "ARC CONTROL" knob to "+10"
- Turn on input power.
- Use the "OUTPUT CONTROL KNOB" to adjust the setpoint to a desired value on the right display
- Use the "WELD TERMINALS" switch to enable and disable output

#### CONSTANT CURRENT TEST MODE

To enable Constant Current test mode:

- Set dip switch #4 to ON
- Set dip switch #4 to ONSet "WELD TERMINALS" switch to " "
- Set "MODE SELECT" knob to "GTAW"Set "LOCAL/REMOTE" switch to "LOCAL"
- Set LOCAL/REMOTE switch to LOC
  Set "ARC CONTROL" knob to "-10"
- Turn on input power.
- Use the "OUTPUT CONTROL KNOB" to adjust the setpoint to a desired value on the right display
- Use the "WELD TERMINALS" switch to
- enable and disable output

### ACCESS ERROR LOG

To access the Error Log:

- Set dip switch #4 to ONSet "WELD TERMINALS" switch to "ON"
- Set "MODE SELECT" knob to "GTAW"
- Set "LOCAL/REMOTE" switch to "LOCAL"
- Set "OUTPUT CONTROL KNOB" to "MIN"
- Set "ARC CONTROL" knob to "-10"
- Set "HOT START" switch to "ON"Turn on input power. The display will show
- "8.8.8" "8.8.8" and "THERMAL LED" will light
- The displays will then go to "- - " "- -" and "THERMAL LED" will go out.
- Toggle the "WELD TERMINALS SWITCH" switch "OFF" and "ON" to step through menus
- Step C00 to C14 are control board error logs in chronological order.
  Step S00 to S14 are switch board error logs in chronological order.
- Step 500 to \$14 are switch board error logs in chronologic
   To clear error logs set the "LOCAL/REMOTE" switch
- to "Z" then back to "LOCAL"

# **ERROR CODE TROUBLESHOOTING GUIDE**

Description Peak current through the transformer primary has exceeded threshold (140 amps). Possible Solution 1 Possible Solution 2 Possible Solution 3 Replace defective main transformer, Possible Solution 3 Replace defective main transformer. Possible Solution 1 Description 1 Possible Solution 3 Possible Solution 3 Replace defective switchboard assembly (S28443). Possible Solution 3 Replace defective main transformer and output feelfier heat sink or embedded in transformer has tripped. Possible Solution 1 Possible Solution 3 Replace defective ambient transprature or duty cycle limits. Possible Solution 1 Possible Solution 2 Possible Solution 2 Possible Solution 2 Replace defective switchboard assembly (S28443).  Possible Solution 3 Replace defective switchboard assembly (S28443).  Possible Solution 4 Possible Solution 5 Replace defective switchboard assembly (S28443).  Possible Solution 6 Replace defective switchboard assembly (S28443).  Possible Solution 7 Replace defective switchboard assembly (S28443).  Possible Solution 8 Replace defective switchboard assembly (S28443).  Possible Solution 9 Replace defective switchboard assembly (S28443).  Possible Solution 1 Replace defective switchboard assembly (S28443).  Possible Solution 1 Replace d		
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Possible Solution 3  Possible Solution 3  Replace defective switchboard assembly (S28443).  CAN Communication Timeout  Cascipition  Possible Solution 1  Possible Solution 1  Possible Solution 2  Possible Solution 3  Replace defective switchboard assembly (S28443) or control board and switchboard.  Possible Solution 3  Replace defective switchboard assembly (S28443) or control board (S28454).  Possible Solution 3  Replace defective switchboard assembly (S28443) or control board (S28454).  Possible Solution 1  Possible Solution 2  Possible Solution 2  Possible Solution 2  Possible Solution 3  Replace defective switchboard assembly (S28443) or control board (S28454).  Possible Solution 1  Possible Solution 2  Possible Solution 2  Possible Solution 3  Replace defective switchboard assembly (S28443).  Possible Solution 3  Possible Solution 3  Possible Solution 4  Possible Solution 5  Possible Solution 5  Possible Solution 6  Possible Solution 7  Possible Solution 9  Possible Solution 9  Possible Solution 1  Possible Solution 1  Possible Solution 1  Possible Solution 2  Possible Solution 3  Replace defective switchboard assembly (S28443).  Possible Solution 1  Possible Solution 3  Replace defective switchboard assembly (S28443).  Possible Solution 3  Replace defective switchboard assembly (S28443).  Possible Solution 1  Possible Solution 1  Possible Solution 3  Replace defective switchboard assembly (S28443).  Possible Solution 1  Possible Solution 3  Replace defective switchboard assembly (S28443).  Possible Solution 1  P		
Possible Solution 3 Replace defective switchboard assembly (S28443).  CAN Communication Timeout CAN communication between switchboard and control board has timed out. Possible Solution 1 Possible Solution 2 Possible Solution 3 Replace defective switchboard and switchboard. Possible Solution 3 Replace defective switchboard assembly (S28443) or control board and switchboard.  Possible Solution 3 Replace defective switchboard assembly (S28443) or control board (S28454).  Misconnection - Switchboard Supply Voltage too High Description Possible Solution 1 Possible Solution 1 Possible Solution 3 Replace defective switchboard suspile Voltage to High Switchboard auxiliary supply voltage is higher than 62 VDC at machine power-up. Possible Solution 2 Possible Solution 3 Replace defective switchboard assembly (S28443).  Misconnection - Switchboard Supply Voltage too High Switchboard auxiliary transformer or intermittent "A" lead connection. Verify 42 VAC output at 14 pin connector to determine the source of the problem.  Possible Solution 1 Possible Solution 1 Possible Solution 1 Possible Solution 3 Replace defective switchboard auxiliary supply voltage is lower than 42 VDC at machine power-up. Possible Solution 3 Replace defective switchboard supply Voltage too Low Possible Solution 3 Replace defective switchboard auxiliary transformer or intermittent "A" lead connection. Verify 42 VAC output at 14 pin connector to determine the source of the problem.  Possible Solution 1 Possible Solution 3 Replace defective switchboard assembly (S28443).  Possible Solution 3 Replace defective switchboard assembly (S28443).  Possible Solution 3 Replace defective switchboard assembly (S28443).  Possible Solution 1 Possible Solution 1 Possible Solution 2 Replace defective control board has been placed in the incorrect position.  Possible Solution 1 Possible Solution 2 Replace defective control board has experienced a critical internal error and cannot continue.  Possible Solution 1 Replace defective control board assembly (S28454).  Possi	Possible Solution 2	
T12 CAN Communication Timeout  Description  CAN communication between switchboard and control board has timed out.  Possible Solution 1  Possible Solution 3  Replace defective switchboard assembly (\$28443) or control board (\$28454).  T13 Misconnection - Switchboard Supply Voltage too High  Description Switchboard auxiliary supply voltage is higher than 62 VDC at machine power-up.  Improper input voltage configuration. Verify primary reconnect position, measure input soltage level and check three phase operation.  Possible Solution 2  Possible Solution 3  Replace defective switchboard auxiliary transformer or intermittent "A" lead connection. Verify 42 VAC output at 14 pin connector to determine the source of the problem.  Possible Solution 1  Possible Solution 1  Possible Solution 2  Possible Solution 3  Replace defective switchboard assembly (\$28443).  Misconnection - Switchboard Supply Voltage too Low  Description Switchboard auxiliary supply voltage is lower than 42 VDC at machine power-up.  Improper input voltage configuration. Verify primary reconnect position, measure input voltage level and check three phase operation.  Possible Solution 1  Possible Solution 3  Replace defective switchboard assembly (\$28443).  T15 Switchboard auxiliary supply voltage is lower than 42 VDC at machine power-up.  Improper input voltage level and check three phase operation.  Possible Solution 3  Replace defective switchboard assembly (\$28443).  T15 Switchboard auxiliary supply voltage is lower than 42 VDC at machine power-up.  Possible Solution 1  Description Switchboard auxiliary transformer or intermittent "A" lead connection. Verify 42 VAC output at 14 pin connector to determine the source of the problem.  Possible Solution 1  Possible Solution 2  Possible Solution 3  Replace defective switchboard assembly (\$28443).  T16 Switchboard auxiliary transformer or intermittent "A" lead connection. Verify 42 VAC output at 14 pin connector to determine the source of the problem.  Possible Solution 3  Replace defective switchboard	Possible Solution 3	• •
Description CAN communication between switchboard and control board has timed out. Possible Solution 1 Check the physical wiring and connections between control board and switchboard. Possible Solution 2 Replace defective switchboard assembly (\$28443) or control board and switchboard.  **Possible Solution 1 Switchboard assembly (\$28443) or control board (\$28454).  **Possible Solution 2 Switchboard auxiliary supply voltage is higher than 62 VDC at machine power-up. Improper input voltage econfiguration. Verify primary reconnect position, measure input voltage level and check three phase operation.  **Possible Solution 2 Damaged auxiliary transformer or intermittent "A" lead connection. Verify 42 VAC output at 14 pin connector to determine the source of the problem.  **Possible Solution 3 Switchboard auxiliary supply voltage is lower than 42 VDC at machine power-up. Improper input voltage econfiguration. Verify primary reconnect position, measure input voltage level and check three phase operation.  **Possible Solution 1 Improper input voltage configuration. Verify primary reconnect position, measure input voltage level and check three phase operation.  **Possible Solution 2 Damaged auxiliary transformer or intermittent "A" lead connection. Verify 42 VAC output at 14 pin connector to determine the source of the problem.  **Possible Solution 3 Replace defective switchboard assembly (\$28443).  **Possible Solution 3 Replace defective switchboard assembly (\$28443).  **Possible Solution 4 Damaged auxiliary transformer or intermittent "A" lead connection. Verify 42 VAC output at 14 pin connector to determine the source of the problem.  **Possible Solution 1 Damaged auxiliary transformer or intermittent "A" lead connection. Verify 42 VAC output at 14 pin connector to determine the source of the problem.  **Possible Solution 2 Verify input voltage level, frequency, and quality. Verify that tine is not too soft. Possible Solution 1 Replace defective switchboard assembly (\$28454).  **Possible Solution 2 Replace defective c		
Description CAN communication between switchboard and control board has timed out. Possible Solution 1 Check the physical wiring and connections between control board and switchboard. Possible Solution 2 Replace defective switchboard assembly (S28443) or control board and switchboard.  **Till Misconnection - Switchboard Supply Voltage too High Description Switchboard auxiliary supply voltage is higher than 62 VDC at machine power-up. Improper input voltage configuration. Verify primary reconnect position, measure input voltage level and check three phase operation.  Possible Solution 2 Damaged auxiliary transformer or intermittent "A" lead connection. Verify 42 VAC output at 14 pin connector to determine the source of the problem.  Possible Solution 1 Switchboard auxiliary supply woltage is lower than 42 VDC at machine power-up. Improper input voltage even auxiliary supply woltage is lower than 42 VDC at machine power-up. Improper input voltage configuration. Verify primary reconnect position, measure input voltage level and check three phase operation.  Possible Solution 1 Improper input voltage configuration. Verify primary reconnect position, measure input voltage level and check three phase operation.  Possible Solution 2 Damaged auxiliary transformer or intermittent "A" lead connection. Verify 42 VAC output at 14 pin connector to determine the source of the problem.  Possible Solution 3 Replace defective switchboard assembly (S28443).  **Till Description Switchboard auxiliary supply woltage momentarily drops below 20 VDC.  Description Switchboard auxiliary supply woltage momentarily drops below 20 VDC.  Damaged auxiliary transformer or intermittent "A" lead connection. Verify 42 VAC output at 14 pin connector to determine the source of the problem.  Possible Solution 1 Damaged auxiliary supply woltage momentarily drops below 20 VDC.  Possible Solution 2 Verify input voltage level, frequency, and quality. Verify that line is not too soft.  Possible Solution 1 Replace defective control board has been placed	712	CAN Communication Timeout
Possible Solution 1 Possible Solution 2 Possible Solution 3 Possible Solution 1 Possible Solution 1 Possible Solution 1 Possible Solution 1 Possible Solution 2 Possible Solution 2 Possible Solution 2 Possible Solution 3 Possible Solution 4 Possible Solution 5 Possible Solution 6 Possible Solution 9 Possible Solution 9 Possible Solution 1 Possible Solution 2 Possible Solution 3 Possible Solution 4 Possible Solution 5 Possible Solution 6 Possible Solution 7 Possible Solution 8 Possible Solution 9 Possible Solution 9 Possible Solution 9 Possible Solution 1 Possible Solution 2 Possible Solution 1 Possible Solution 2 Possible Solution 2 Possible Solution 2 Possible Solution 3 Replace defective switchboard assembly (S28443) Possible Solution 1 Possible Solution 2 Possible Solution 3 Replace defective switchboard assembly (S28454) Possible Solution 1 Possible Solution 1 Possible Solution 2 Possible Solution 2 Possible Solution 3 Replace defective switchboard assembly (S28454) Possible Solution 1 Possible Solution 1 Possible Solution 1 Possible Solution 2 Replace defective control board has been placed in the incorrect position. Possible Solution 1 Possibl		
Possible Solution 2 Verify power supply to control board and switchboard.  Possible Solution 3 Replace defective switchboard assembly (\$28443) or control board (\$28454).    Tild		
Possible Solution 3   Replace defective switchboard assembly (S28443) or control board (S28454).   T13		· · ·
Possible Solution 1   Possible Solution 2   Damaged auxiliary supply voltage is higher than 62 VDC at machine power-up.		
Description   Switchboard auxiliary supply voltage is higher than 62 VDC at machine power-up.		
Description   Switchboard auxiliary supply voltage is higher than 62 VDC at machine power-up.	713	Misconnection - Switchboard Supply Voltage too High
Possible Solution 1 Improper input voltage configuration. Verify primary reconnect position, measure input voltage level and check three phase operation.  Possible Solution 2 Damaged auxiliary transformer or intermittent "A" lead connection. Verify 42 VAC output at 14 pin connector to determine the source of the problem.  Possible Solution 3 Replace defective switchboard assembly (\$28443).  714 Misconnection - Switchboard Supply Voltage too Low  Description Switchboard auxiliary supply voltage is lower than 42 VDC at machine power-up. Improper input voltage configuration. Verify primary reconnect position, measure input voltage level and check three phase operation.  Possible Solution 2 Damaged auxiliary transformer or intermittent "A" lead connection. Verify 42 VAC output at 14 pin connector to determine the source of the problem.  Possible Solution 3 Replace defective switchboard assembly (\$28443).  715 Switchboard undervoltage Lock Out Description Switchboard auxiliary supply woltage momentarily drops below 20 VDC.  Possible Solution 1 Damaged auxiliary transformer or intermittent "A" lead connection. Verify 42 VAC output at 14 pin connector to determine the source of the problem.  Possible Solution 2 Verify input voltage level, frequency, and quality. Verify that line is not too soft.  Possible Solution 3 Replace defective switchboard assembly (\$28443).  717 Control Board Misconfiguration  Description A jumper on the control board has been placed in the incorrect position.  Possible Solution 1 Verify that the wiring to connector 5 on the control board matches the machine wiring diagram.  Possible Solution 2 Replace defective control board assembly (\$28454).  21, 24, 716, 718 Internal Control Board Error  The microprocessor on the control board has experienced a critical internal error and cannot continue.  Possible Solution 1 Cycle power to the machine.  The microprocessor on the switchboard has experienced a critical internal error and cannot continue.	Description	
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Possible Solution 3  Possible Solution 3  Replace defective switchboard assembly (S28443).  T14  Misconnection - Switchboard Supply Voltage too Low  Description  Possible Solution 1  Possible Solution 2  Possible Solution 2  Possible Solution 3  Possible Solution 3  Possible Solution 3  Replace defective switchboard susperventure input voltage level and check three phase operation.  Possible Solution 3  Possible Solution 3  Replace defective switchboard assembly (S28443).  T15  Switchboard Undervoltage Lock Out  Description  Possible Solution 1  Possible Solution 1  Possible Solution 1  Possible Solution 2  Possible Solution 3  Replace defective switchboard intermittent "A" lead connection. Verify 42 VAC output at 14 pin connector to determine the source of the problem.  Possible Solution 1  Possible Solution 1  Possible Solution 2  Replace defective switchboard undervoltage Lock Out  Damaged auxiliary transformer or intermittent "A" lead connection. Verify 42 VAC output at 14 pin connector to determine the source of the problem.  Possible Solution 1  Possible Solution 3  Replace defective switchboard assembly (S28443).  T17  Control Board Misconfiguration  Possible Solution 1  Possible Solution 1  Possible Solution 2  Replace defective control board has been placed in the incorrect position.  Verify that the wiring to connector J5 on the control board matches the machine wiring diagram.  Replace defective control board assembly (S28454).  11  12  12  13  14  15  16  17  17  17  18  18  18  18  19  19  19  19  19  10  19  10  10  10	Possible Solution 1	
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Possible Solution 1 Cycle power to the machine.  Possible Solution 2 Replace defective control board assembly (S28454).  The microprocessor on the switchboard Error  Description The microprocessor on the switchboard has experienced a critical internal error and cannot continue.  Possible Solution 1 Cycle power to the machine.	Possible Solution 1 Possible Solution 2 Possible Solution 3  715 Description Possible Solution 1 Possible Solution 2 Possible Solution 2 Possible Solution 3  717 Description Possible Solution 1 Possible Solution 1 Possible Solution 2	Misconnection - Switchboard Supply Voltage too Low  Switchboard auxiliary supply woltage is lower than 42 VDC at machine power-up.  Improper input woltage configuration. Verify primary reconnect position, measure input voltage level and check three phase operation.  Damaged auxiliary transformer or intermittent "A" lead connection. Verify 42 VAC output at 14 pin connector to determine the source of the problem.  Replace defective switchboard assembly (S28443).  Switchboard Undervoltage Lock Out  Switchboard auxiliary supply woltage momentarily drops below 20 VDC.  Damaged auxiliary transformer or intermittent "A" lead connection. Verify 42 VAC output at 14 pin connector to determine the source of the problem.  Verify input voltage level, frequency, and quality. Verify that line is not too soft.  Replace defective switchboard assembly (S28443).  Control Board Misconfiguration  A jumper on the control board has been placed in the incorrect position.  Verify that the wiring to connector J5 on the control board matches the machine wiring diagram.  Replace defective control board assembly (S28454).
Possible Solution 2 Replace defective control board assembly (S28454).  The microprocessor on the switchboard has experienced a critical internal error and cannot continue.  Possible Solution 1 Cycle power to the machine.	Description Possible Solution 1 Possible Solution 2 Possible Solution 3  715 Description Possible Solution 1 Possible Solution 2 Possible Solution 3  717 Description Possible Solution 1 Possible Solution 1 Possible Solution 2 21, 24, 716, 718	Misconnection - Switchboard Supply Voltage too Low  Switchboard auxiliary supply voltage is lower than 42 VDC at machine power-up.  Improper input voltage configuration. Verify primary reconnect position, measure input voltage level and check three phase operation.  Damaged auxiliary transformer or intermittent "A" lead connection. Verify 42 VAC output at 14 pin connector to determine the source of the problem.  Replace defective switchboard assembly (S28443).  Switchboard Undervoltage Lock Out  Switchboard auxiliary supply voltage momentarily drops below 20 VDC.  Damaged auxiliary transformer or intermittent "A" lead connection. Verify 42 VAC output at 14 pin connector to determine the source of the problem.  Verify input voltage level, frequency, and quality. Verify that line is not too soft.  Replace defective switchboard assembly (S28443).  Control Board Misconfiguration  A jumper on the control board has been placed in the incorrect position.  Verify that the wiring to connector J5 on the control board matches the machine wiring diagram.  Replace defective control board assembly (S28454).
719 Internal Switchboard Error  Description The microprocessor on the switchboard has experienced a critical internal error and cannot continue.  Possible Solution 1 Cycle power to the machine.	Description Possible Solution 1 Possible Solution 2 Possible Solution 3  715 Description Possible Solution 1 Possible Solution 2 Possible Solution 3  717 Description Possible Solution 1 Possible Solution 1 Possible Solution 2 21, 24, 716, 718	Misconnection - Switchboard Supply Voltage too Low  Switchboard auxiliary supply voltage is lower than 42 VDC at machine power-up. Improper input voltage configuration. Verify primary reconnect position, measure input voltage level and check three phase operation.  Damaged auxiliary transformer or intermittent "A" lead connection. Verify 42 VAC output at 14 pin connector to determine the source of the problem.  Replace defective switchboard assembly (S28443).  Switchboard Undervoltage Lock Out  Switchboard auxiliary supply voltage momentarily drops below 20 VDC.  Damaged auxiliary transformer or intermittent "A" lead connection. Verify 42 VAC output at 14 pin connector to determine the source of the problem.  Verify input voltage level, frequency, and quality. Verify that line is not too soft.  Replace defective switchboard assembly (S28443).  Control Board Misconfiguration  A jumper on the control board has been placed in the incorrect position.  Verify that the wiring to connector J5 on the control board matches the machine wiring diagram.  Replace defective control board assembly (S28454).  Internal Control Board Error  The microprocessor on the control board has experienced a critical internal error and
Description The microprocessor on the switchboard has experienced a critical internal error and cannot continue.  Possible Solution 1 Cycle power to the machine.	Description Possible Solution 1 Possible Solution 2 Possible Solution 3  715 Description Possible Solution 1 Possible Solution 2 Possible Solution 3  717 Description Possible Solution 1 Possible Solution 1 Possible Solution 2 Possible Solution 2 Description Possible Solution 1 Possible Solution 2	Misconnection - Switchboard Supply Voltage too Low  Switchboard auxiliary supply voltage is lower than 42 VDC at machine power-up. Improper input voltage configuration. Verify primary reconnect position, measure input voltage level and check three phase operation.  Damaged auxiliary transformer or intermittent "A" lead connection. Verify 42 VAC output at 14 pin connector to determine the source of the problem.  Replace defective switchboard assembly (S28443).  Switchboard Undervoltage Lock Out  Switchboard auxiliary supply voltage momentarily drops below 20 VDC.  Damaged auxiliary transformer or intermittent "A" lead connection. Verify 42 VAC output at 14 pin connector to determine the source of the problem.  Verify input voltage level, frequency, and quality. Verify that line is not too soft.  Replace defective switchboard assembly (S28443).  Control Board Misconfiguration  A jumper on the control board has been placed in the incorrect position.  Verify that the wiring to connector J5 on the control board matches the machine wiring diagram.  Replace defective control board assembly (S28454).  Internal Control Board Error  The microprocessor on the control board has experienced a critical internal error and cannot continue.
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