

bullmer

The Machine For KW2000S Model Operation Instruction



Read a handbook please detailedly before handling a machine

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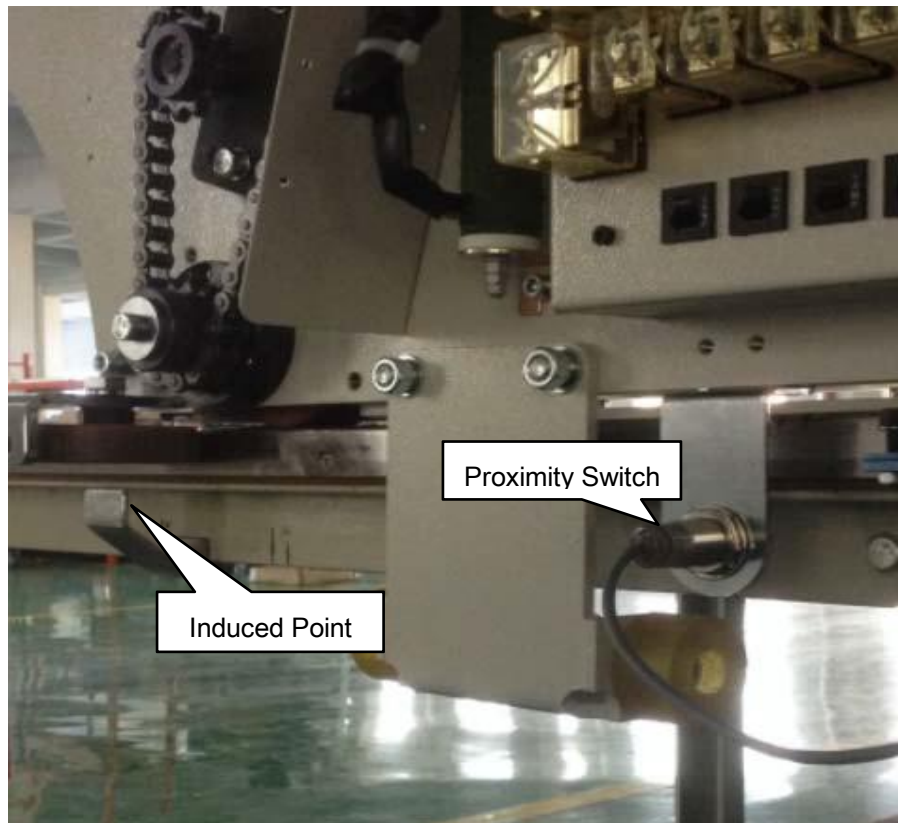
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Pay Attention To Before Operation :

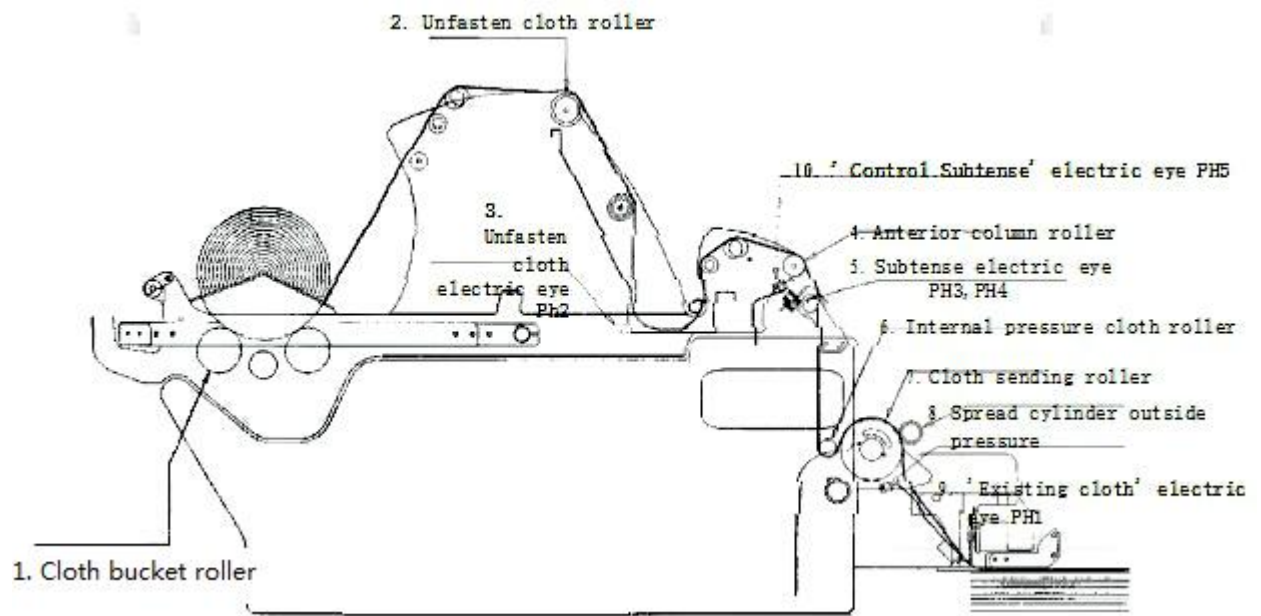


When proximity switch goes to left and passes through induction point, the current position returns to 0. This is the benchmark point of machine calculating position.returns to 0. This is the benchmark point of machine calculating position.Every time when proximity switch goes to left and passes through induction point, the current position will be returned to 0.When a machine uses more than two cutting beds, after moving by bed A to B,The first necessary action is : Connect power-power transmission-press it  (release the brake),Gently push the machine from the right to the left (from the front to the back) to make proximity switch pass through induction point.Then the machine can determine its own benchmark position.

For sudden power failure during operation, the machine will stop sliding under the weak status.So, the benchmark position will run away and not in the original position,for this situation, after again power transmission,Must let the machine return to original position by inch move way, and re-run againThe proximity switch passes through return-to-zero point from the right to the left to let machine re- determine its own benchmark position.

The machine will stop and not act as long as any switchch is faulty.

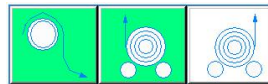
Normal Operation :



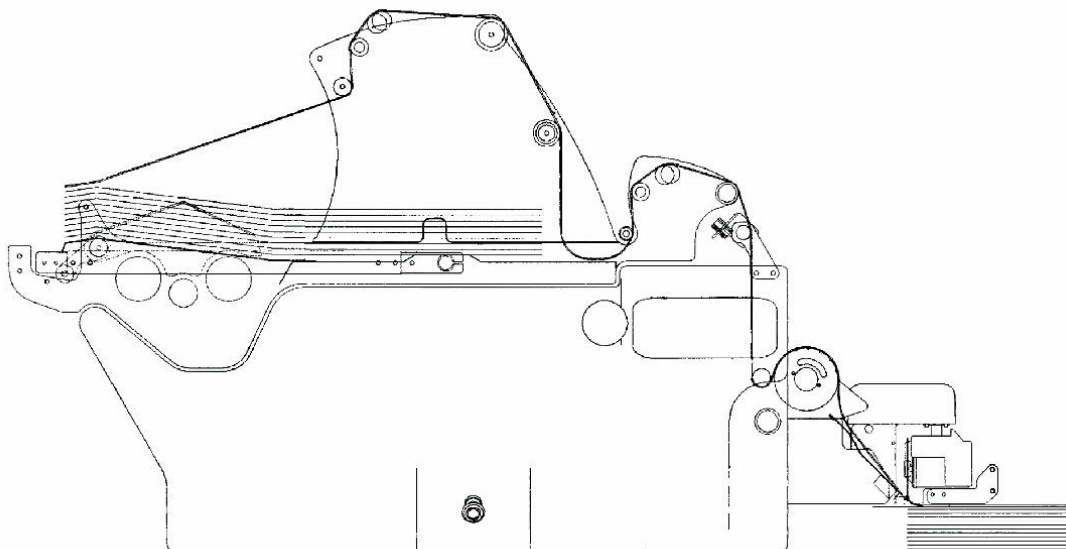
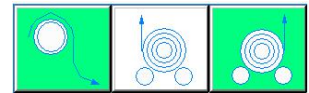
Rewinding Cloth:

Place as the above figure.

When spreading the necessary keys are:

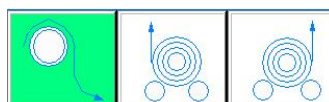


Or

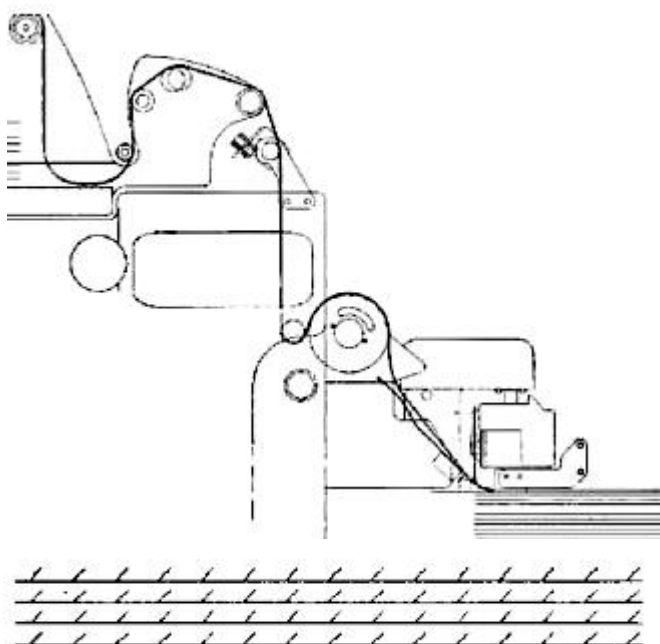


Folding yard cloth:

place as the above figure. When spreading the necessary keys are:

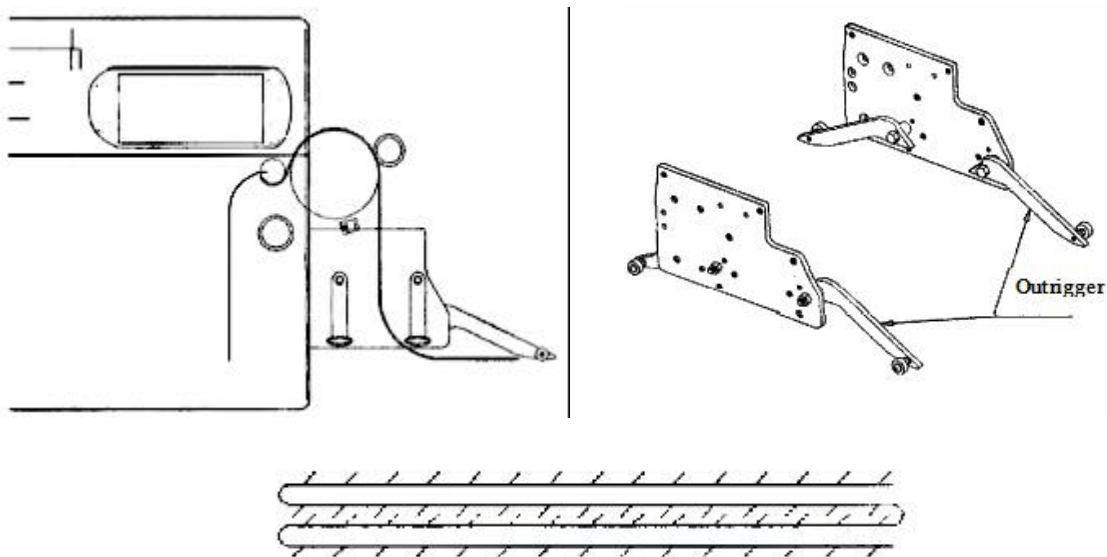


Normal Operation:



Single Spreading

Hang up cutting group and plug connector, the spreader will automatically enter into Single Spreading mode, and don't have to do any other setting.

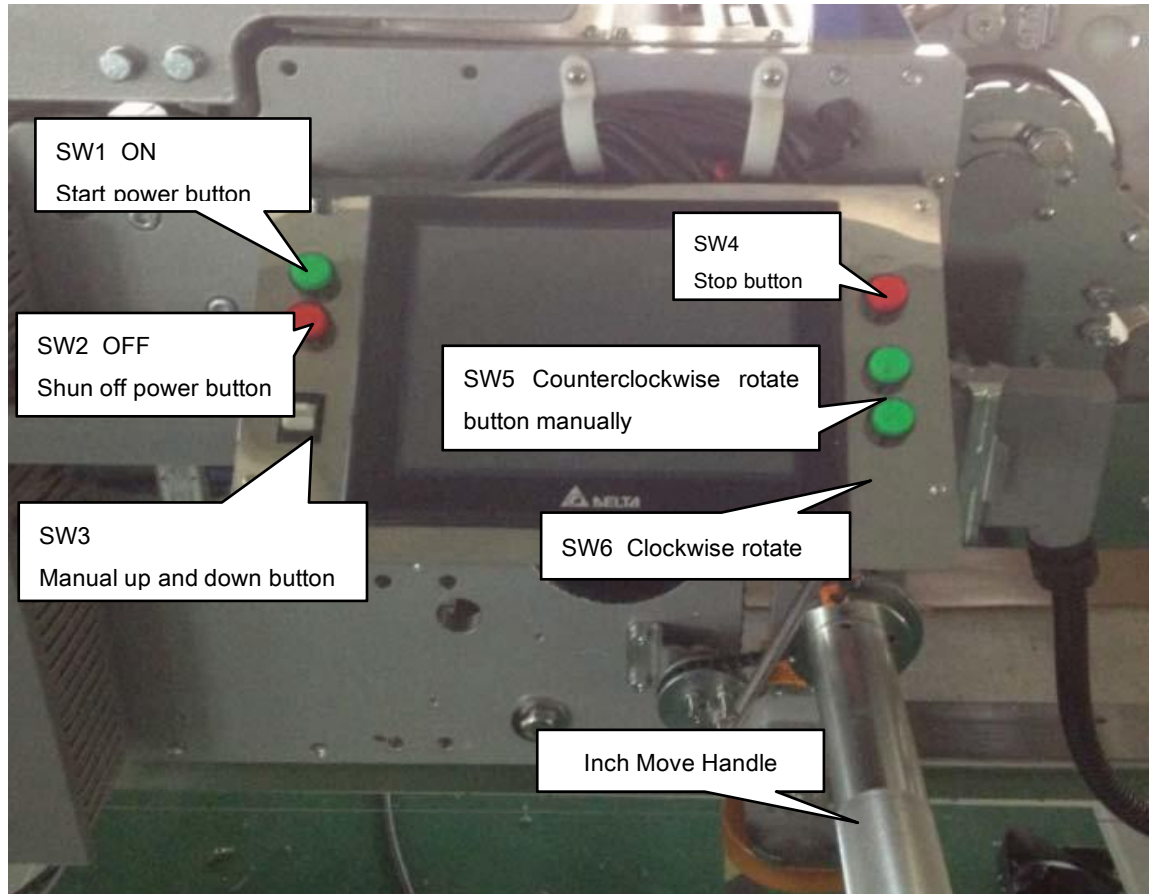


Double Spreading

Remove the cutting group and install the outrigger, the spreader will automatically enter into Double Spreading mode.

Doublespreading : needs to use two-end pressure device, the back-end device should push forward and be fixed the front point with bolt. (For single spreading, not needs back-end device, when double spreading should pull to bottom and be fixed the back point.)

Normal Operation:



Sw1 「Start power button」 : Start power.

Sw2 「Shut off power button」 : Power-off and shut down. when the machine stopped for a certa time, it will power off automatically.

Sw3 「Manual lifting」 : Pull upwards-rise; Pull downwards-fall.

Sw4 「Stop button」 : Stop button.Besides,two sides of cutting bed have set stop cables, pulling the cables is the same with pressing stop button.(Stop cables are the most commonly used stop devices)

Sw5 「Cloth sending roller」 : Counterclockwise rotate button manually.

Sw6 「Cloth sending roller」 : Clockwise rotate manually.

During spreading, the cloth sending roller will rotate with the machine's movement. Under the static status, if need to rotate cloth sending roller, please use these two buttons.

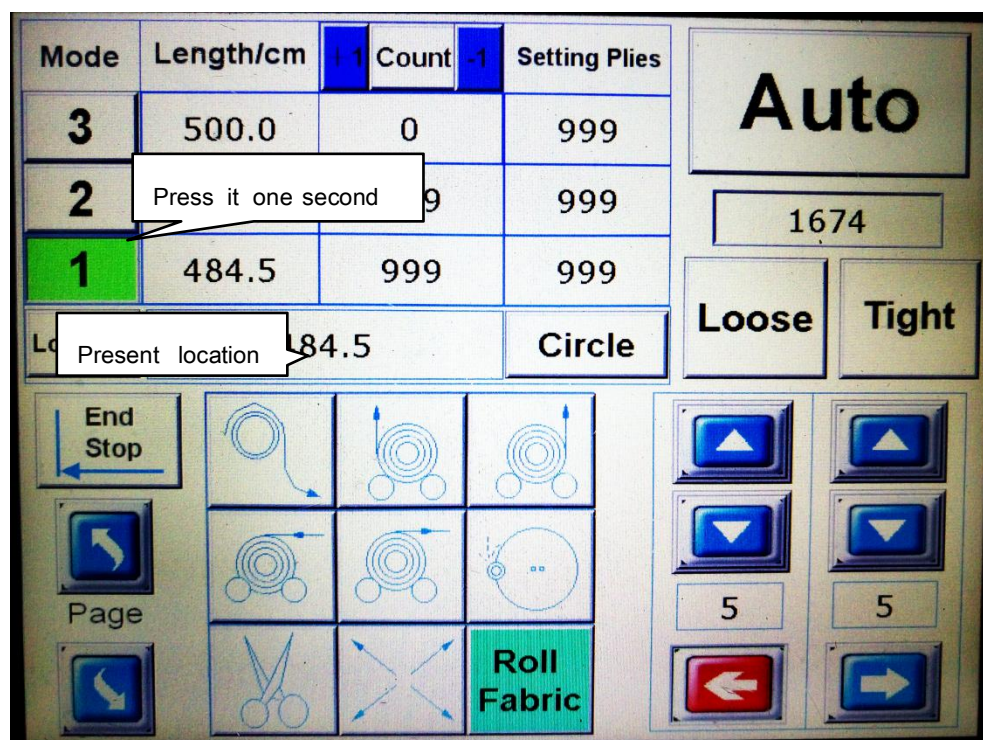


Press it and display digital keyboard as the right figure, input the desired figure and press

ENTER , 「Spreading length」 Unit: cm 1M=100cm 1inch=2.54cm

Single spreading mode: When 「COUNT」 achieves 「WANTED」 value, the machine will stop.

Continuous spreading mode: When all 「COUNT」 achieve 「WANTED」 value, the machine will stop.



Techning mode : Set spreading length : when doesn't know the exact spreading length ,

press modefor 1 second after moving the machine to the desired position , as

shown in the figure , and now , the position value will be set in mode spreading

Length. Mode and can be set in spreading length according to this method.

Normal Operation:

Mode	Length/cm	+1	Count	-1	Setting Plies
3	####.#		123		###
2	####.#		123		###
1	####.#		123		###
Location	1234.5				Circle

Auto

####

Loose

Tight

End Stop

0-1



###

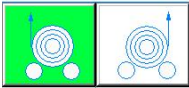
Speed




Width

Height

Page

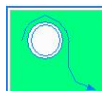
Rewinding cloths are placed into bucket and controlection by  or 




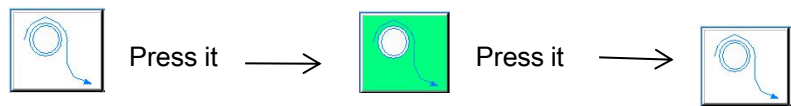
The piece of cloth will not use buckettion key  →  

and cancel ON to make bucket not operate.



 → Under the cloth sending status, when the machine moves, the cloth sending roller will send out cloth downwards by rotation.

 → Not sending cloth,though the machine moves, but the cloth will not be sent out.



Press automatic key and the spreader will enter into automatic spreading status. When the cloths are all set, confirm the direction be correct and then press the key to spread.

Normal Operation:

Mode	Length/cm	+1	Count	-1	Setting Plies
3	####.#		123		###
2	####.#		123		###
1	####.#		123		###

Location1234.5Circle

Auto

####

LooseTight

End Stop

Page

0-1
#.##

Speed


Width

Height



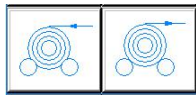
Cutting Button

When the machine stops, press  to carry out cutting action for one time.

If the cutter head doesn't stop at fixed position due to emergency stop, press  ake the head return to fixed position.

When press the cutting button for manual cutting, the layer number value is unchanged.

Call back Inch move



Cloth bucket roller "Manual" key

When press

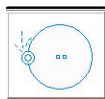


the cloth will roll back with low speed.

When press

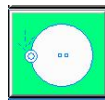
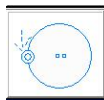


the cloth will roll out with low speed.



The key of knife stone

Press



The blade rotates and then gently press millstone to sharpen according to the set time.

Normal Operation:



Release Brake key

Press



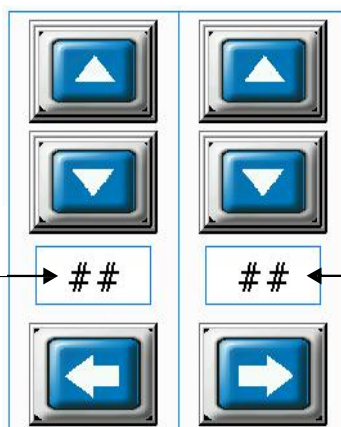
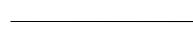
Release brake, can gently push and move machine by hands.

Press



Brake locks and need to big strength to push machine.

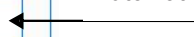
Speed for Automatic goes to left



LIFT

RIGHT

Speed for Automatic goes to right



Normal Operation:

Mode	Length/cm	+1	Count	-1	Setting Plies
3	####.#		123		###
2	####.#		123		###
1	####.#		123		###
Location	1234.5		Circle		

Auto
 #####

Loose

Tight

End Stop

Page

0-1

###

Height

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Speed

##

##

Width

##

##

Layer number grid

Mode	Length/cm	+1	Count	-1	Setting Plies
3	0.0		0		0
2	0.0		0		0
1	0.0		0		0
Location	0.0		Circle		

Figure grid

Auto
 0

Loose

Tight

End Stop

Page

Roll Fabric

1. Press Layer number grid for 0.5 second to let all layer number grids return to 0.
2. Press Figure grid for 0.5 second to let the grid return to 0. Please input 0 for unused mode default grids.

Mode	Length/cm	+1	Count	-1	Setting Plies
3	####.#		123		###
2	####.#		123		###
1	####.#		123		###
Location	1234.5		Circle		

Auto

####

Loose

Tight

End Stop

0-1
#.#

Speed

Width

Height

Page

Roll Fabric

For single mode spreading, please use Mode 1. Spreading mode: when spreading length has long and short yards, can preset Mode 2-3 length and layer number.

Mode	Length/cm	+1	Count	-1	Setting Plies
3	0.0		0		0
2	0.0		0		0
1	0.0		0		0
Location	0.0		Circle		

Auto

0

Loose

Tight

End Stop

Roll Fabric

Page

Start coherent spreading functions, the machine will pass through all modes of having set preset value according to mode 123, then stop.

Normal Operation:

Mode	Length/cm	+1	Count	-1	Setting Plies
3	####.#		123		###
2	####.#		123		###
1	####.#		123		###

Location1234.5Circle

Auto

####

LooseTight

End Stop

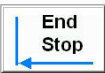
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#.#


Speed

Width

Height



Left-end Point Stop Key

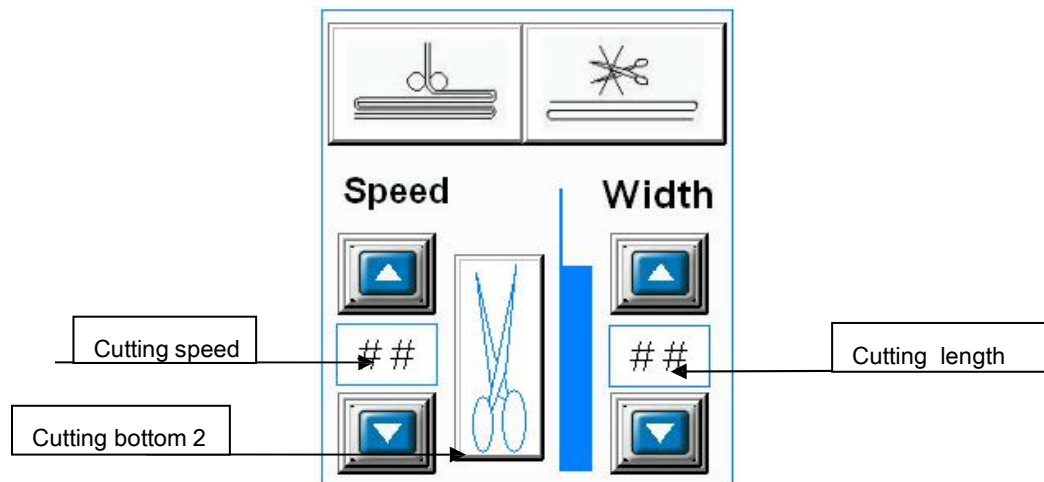
If you need to stop operation when completing the next cloth, press  and the machine will stop at left-end point after completing this cloth.

O-1
#.#

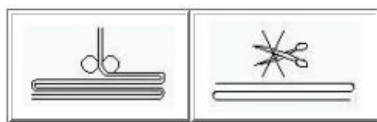
Height

Set Value Of Automatic Rising

Automatic rising quantity.
According to cloth thickness to set automatic rising quantity to make rising height is consistent with cloth stack height.
Automatic rising will automatically rise one time when completing cutting during automatic spreading.



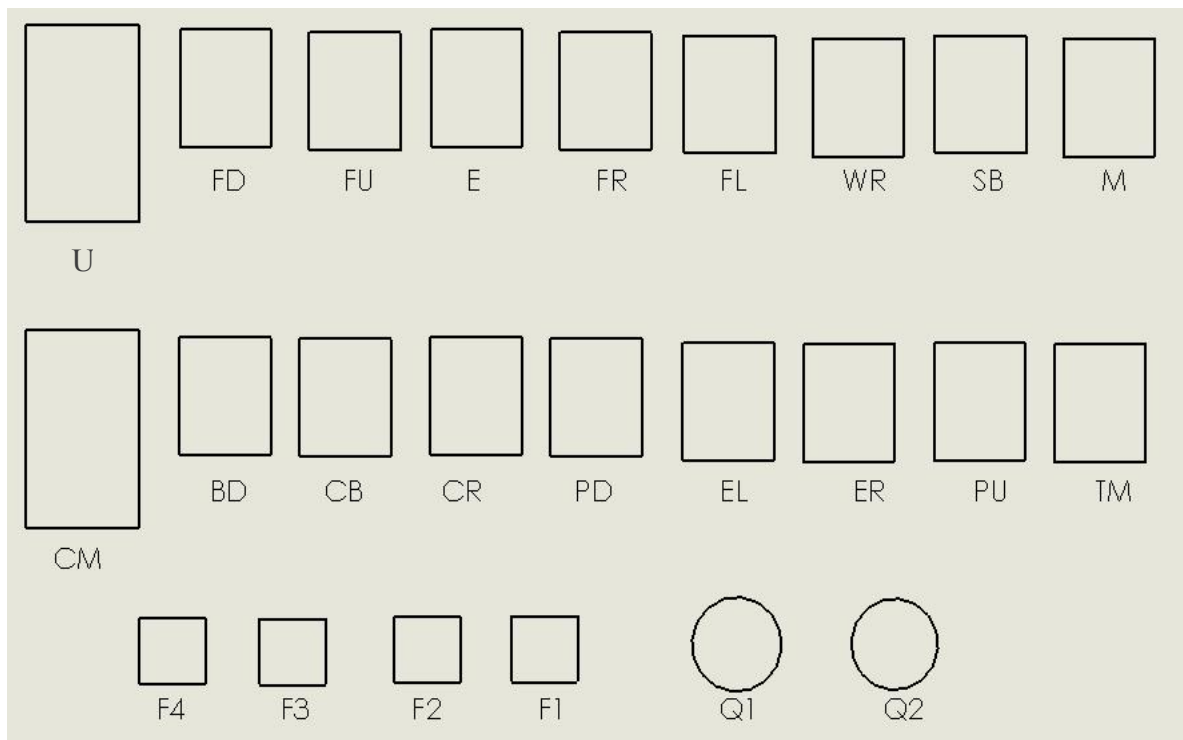
Cutting button 2: Press this button for manual cutting, the layer number will add 1. According to cloth nature and width to set cutting speed and length to make them well cooperate with.



Press this button for the double spreading mode

Double spreading mode of hanging cutter group not automatically cut, and spreading mode of cylinder cloth using double-roller device.

Faults:



F1—Round knife motor Circuit protector

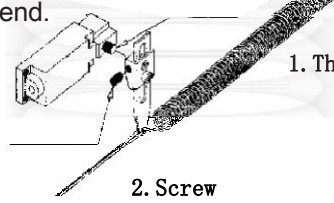
F2—DC24V Circuit protector

F3—Opposite side motor Circuit protector

For overcurrent, the circuit protector will jump, after pressing back and again tries out, if not jump, can safely continue to operate.

If over and over again jump, maybe have a short circuit, or the circuit protector itself has faults.

Simple trouble removal :

Problem	Cause	Countermeasures
Cutter blade doesn't rotate	1.Circuit protector F1 jumps 2.Relay CR connection point is burned 3.Motor carbon or rotor is brush	1.Press back and again try out, if normal, continue to use. If over and over again jump, maybe have a short circuit, Or the circuit protector itself has faults. 2.Change relay
Clothtable of oppositeside doesn't operate	1.Circuit protector F3 jumps 2.Relay ER EL connection points are burned	1.Press back and again try out, if normal, continue to use. If over and over again jump, maybe have a short circuit, or the circuit protector itself has faults. 2.Change relay 3.Under the situation of not been hit,
Can not start power	1.Electromagnetic contactor thermal overload relay jumps 2.Machine external power circuit	1.Open electromagnetic contactor's peripheral, press and then return pole. 2.Measure and check with ammeter following the circuit.
Press RUN but can't toggle autorun	During power transmission, OP must be in ON (magnetic absorption) state. press cables ↓ let OP interrupt ↓ Machine stop ↓ OP continues to interrupt and can not toggle autorun	Countermeasures: OP power comes from limit switch of emergency stop cables end.  1. The axle center 2. Screw 1. Check whether the cloth cutting package or trolley, etc. are press the cables. 2. Angle deviation of cables end limit switch is too large or fault. 3. Refer to P/14 to check whether has breakage following the circuit, loosen when the angle deviation of limit switch is too large. The screw of Figure 2 is again re-bolted. The axle center of Figure 1 is again jumped back to the origin.

Maintenance:

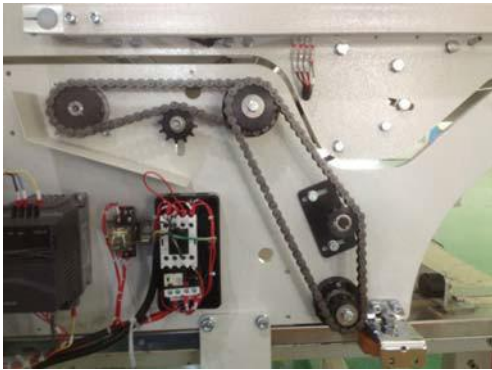


Figure 1



Figure 2



Figure 3

Basic Maintenance :

1.Chain: Add Lubricant And Adjust Elasticity

For lubricant of chain, 40# machine oil is advisable, adding once every 2 months, note not excessive to avoid greasy dirt.

If lacking of oil, the chain is easy to wear. (The above figure's chain is the chain must add oil, don't add for the other chains)

2.Clean Dust

One week at least clean once with air gun and cleaning is the first step of high-quality work.

3.Clean surface dirt of wheels

The surface dirt of wheels is attached dirt, more dirt easily causes slip to make length not accurate.