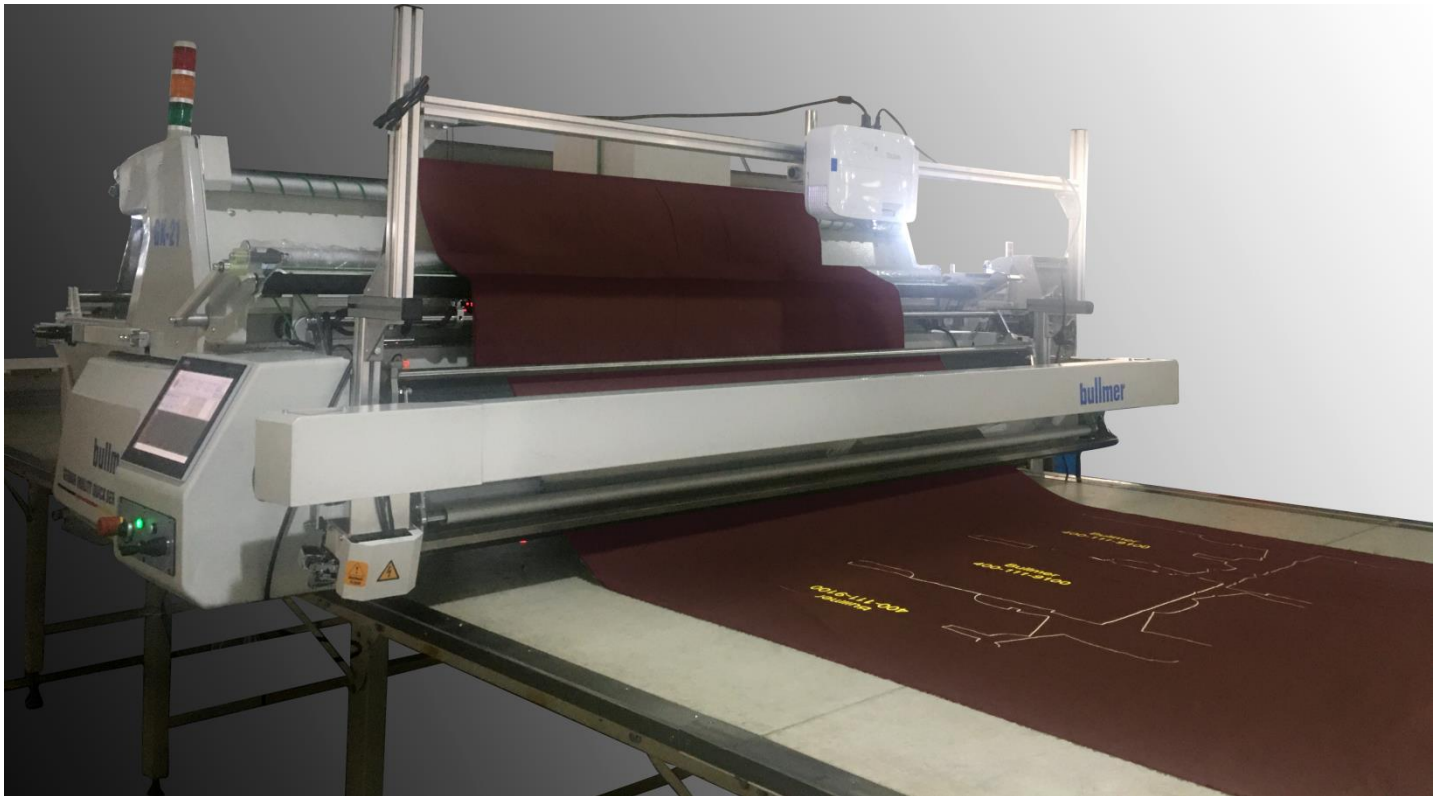


The Machine For GK Model

Operation Instruction



Read a handbook please detailedly before handling a machine

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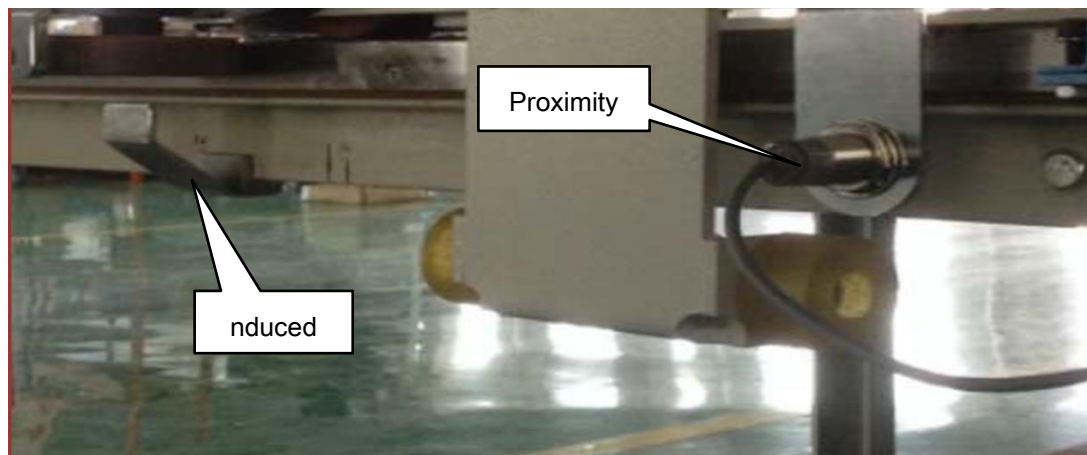
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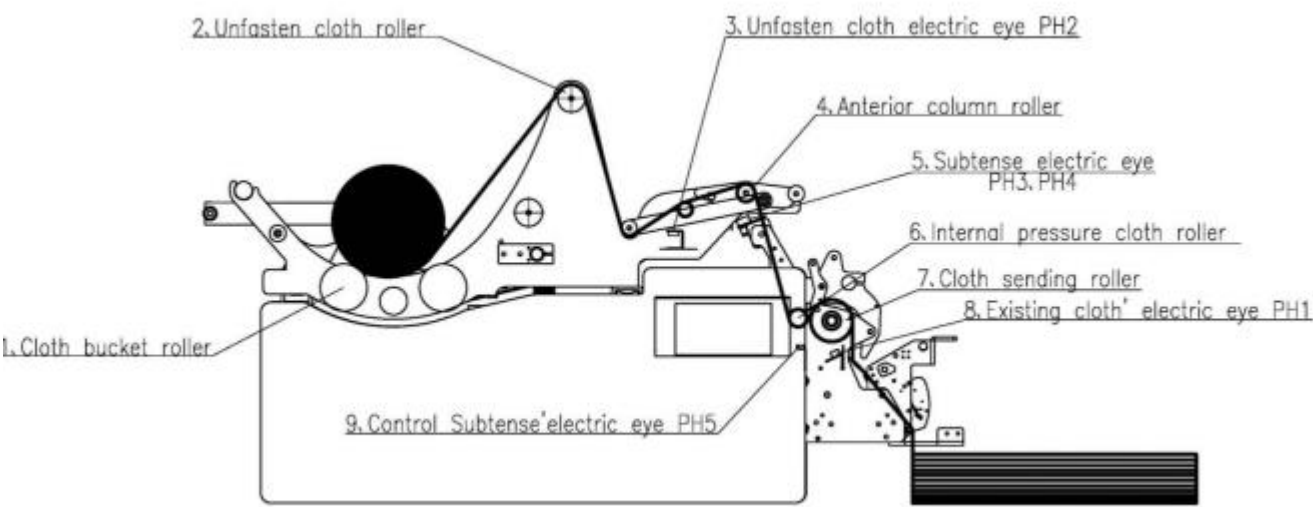
Pay Attention To Before Operation :

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 switch is faulty.

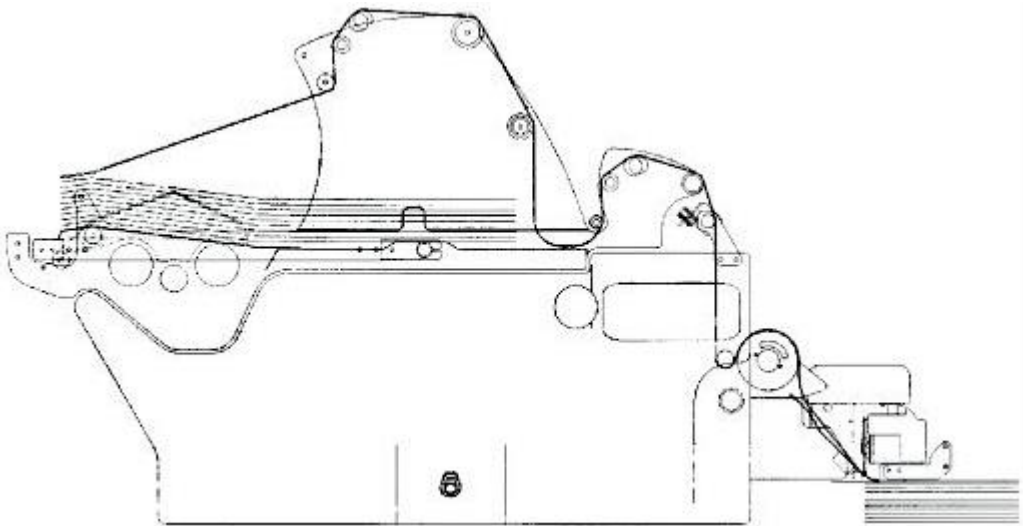
Normal Operation :



Rewinding Cloth:

Place as the above figure.

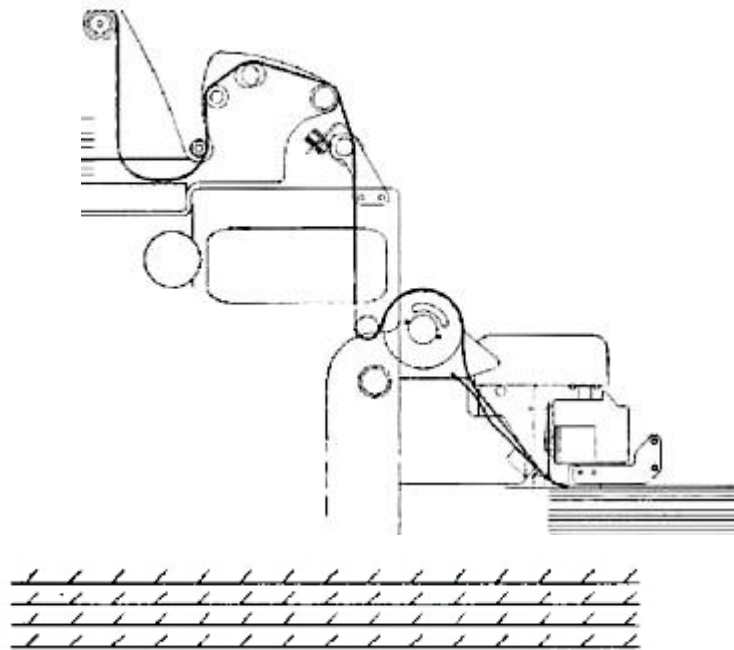
When spreading the necessary keys  are 



Folding yard cloth:

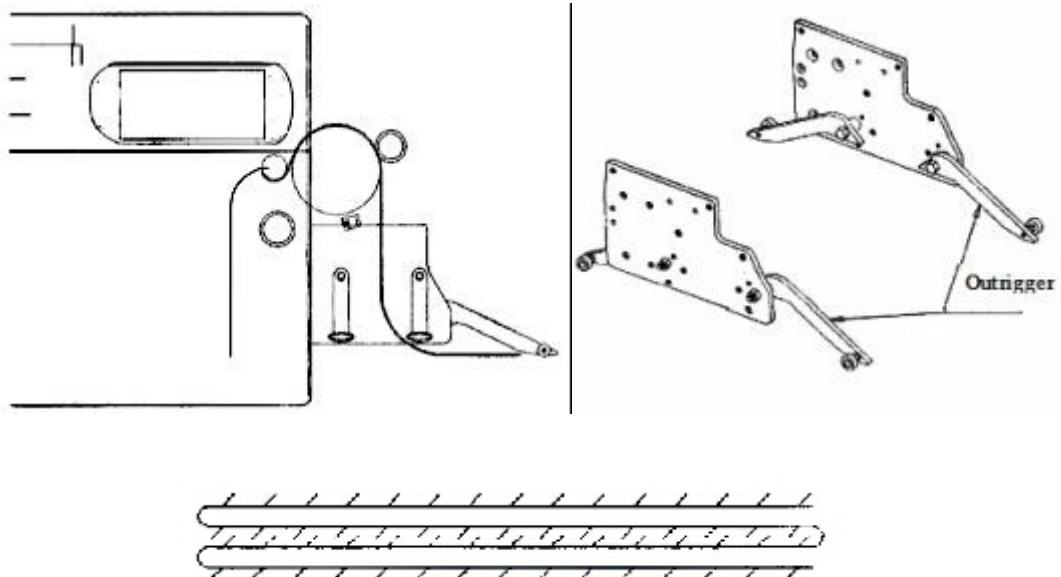
place as the above figure. When spreading the necessary keys are:





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 「Pause button」 : Press the machine to pause any action。

SW3 「Cloth sending roller」 : Counterclockwise rotate button manually.

SW4 「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.

SW5 「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)

【Inch rocker】 : Manually move the rocker for the machine. Pull right travel (forward) to the right; pull left travel (backward) to the left, and move forward in the direction of the rocker at a constant speed. Pull upwards-rise; Pull downwards-fall.

Normal Operation :

Exit

Machine No

001

Order No

Starting Time

2020-12-17

Marker length

Preset layers

0

Spreading layers

-

0

+

Operator No

admin

Cloth No

Over Time

2021-10-11 14:11:00

Current length

0

Length(mm)

0

Execute scanning settings

Finish order

订单号	订单日期	面料编号	长度
99911	2020-03-21 9:51	323435	7777
8888	2020-05-25 22:13	676767	8888
12314	2020-06-19 8:47	888787	222
2432432	2020-12-23 11:35		334
20201223	2020-12-23 11:41	基布	1222

Left stop

Right stop

Type the length of the tab

Defect records

Save defect

Confirm the defective

↑

↓

0

0

←

→

Automatic

Loose

Tight

Exit

Machine No

001

Order No

Starting Time

2020-12-17

Marker length

Preset layers

0

Spreading layers

-

0

+

Operator No

admin

Cloth No

Over Time

2021-10-11 14:03:00

Current length

0

Length(mm)

0

Execute scanning settings

Finish order

14:01:37 Connect:Failed to connect PLC, please check the network is connected

1

2

3

Backspace

4

5

6

0

Cancel

7

8

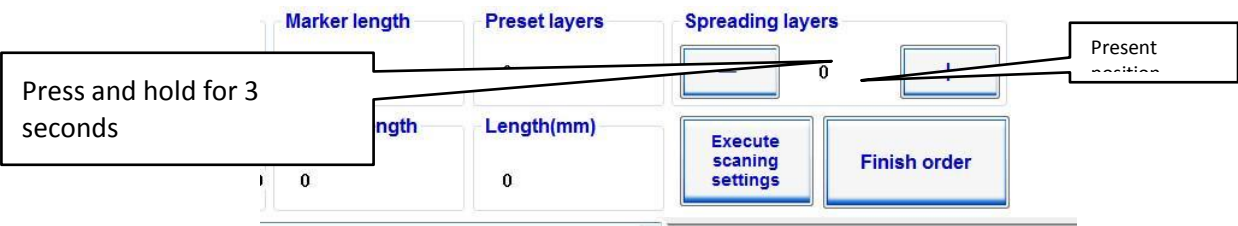
9

.

OK

Click at the version length to display the numeric keypad. After typing the desired number, press enter to determine the "pull length". Unit: mm 1m = 1000mm

Click at the number of layers to display the numeric keypad. After typing the required number, press enter to confirm the number of layers.



Teaching mode: set the cloth length. When you don't know the exact cloth length, move the machine to the desired position, as shown in the figure, After holding the current position for three seconds, the current position will be set to the length of the page.

Normal Operation:

Exit

Machine No

001

Order No

Starting Time

2020-12-17

Marker length

0

Preset layers

0

Spreading layers

0

Operator No

admin

Cloth No

Over Time

2021-10-11 14:11:00

Current length

0

Length(mm)

0

Execute scanning settings

Finish order

订单号	订单日期	面料编号	长度
99911	2020-03-21 9:51	323435	TTTT
8888	2020-05-25 22:13	676767	8888
12314	2020-06-19 8:47	888787	222
2432432	2020-12-23 11:35		334
20201223	2020-12-23 11:41	蓝布	1222

Left stop

Right stop

卷布

Defect records

Save defect

Confirm the defective

0

0

Automatic

0

Loose

Tight

Rewinding cloths are placed into bucket and controlection



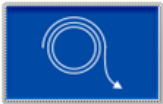
by , or



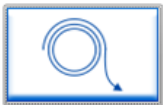
The piece of cloth will not use buckettion key ON to make bucket not operate.



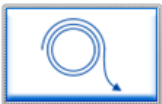
Cloth Sending Button



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



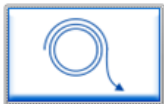
→ Not sending cloth, though the machine moves, but the cloth will not be sent out.



→
Press it



→
Press it



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:

Exit

Machine No

001

Order No

Starting Time

2020-12-17

Marker length

Preset layers

0

Spreading layers

-

0

+

Operator No

admin

Cloth No

Over Time

2021-10-11 14:11:00

Current length

0

Length(mm)

0

Execute scanning settings

Finish order

订单号	订单日期	面料编号	长度
99911	2020-03-21 9:51	323435	7777
8888	2020-05-25 22:13	676767	8888
12314	2020-06-19 8:47	888787	222
2432432	2020-12-23 11:35		334
20201223	2020-12-23 11:41	蓝布	1222

Left stop

Right stop

卷布

Defect records

Save defect

Confirm the defective

0

0

Automatic

0

Loose

Tight




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  make the head return to fixed position. When press the cutting button for manual cutting, the layer number value is unchanged.



Call buck Inch move



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

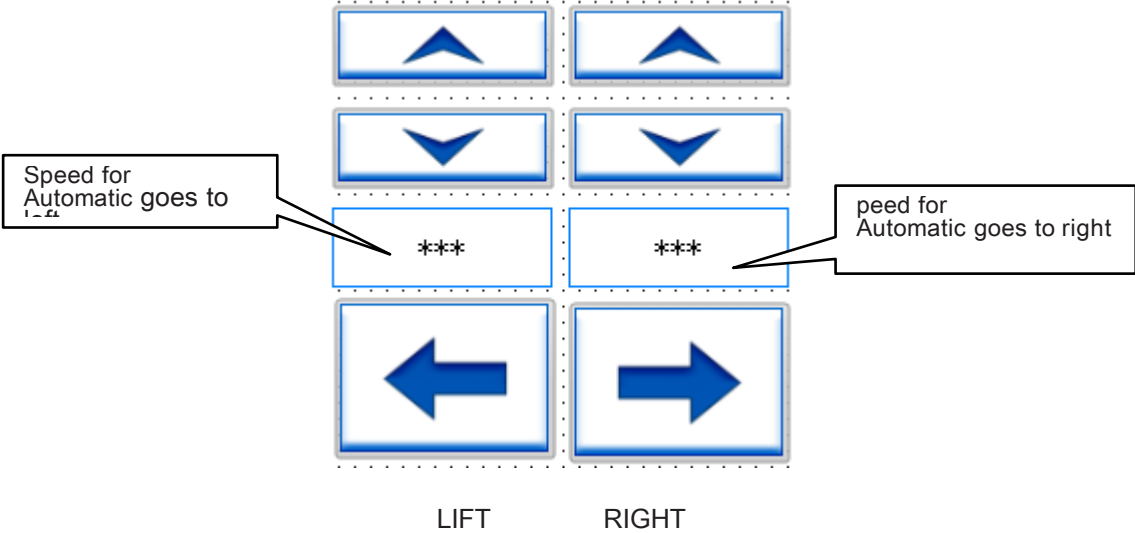
Press  →  The blade rotates and then gently millstone to sharpen according to the set time.



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.



Normal Operation:

Exit

Machine No

001

Order No

Starting Time

2020-12-17

Marker length

Preset layers

0

Spreading layers

-

0

+

Operator No

admin

Cloth No

Over Time

2021-10-11 14:11:00

Current length

0

Length(mm)

0

Execute scanning settings

Finish order

订单号	订单日期	面料编号	长度
99911	2020-03-21 9:51	323435	7777
8888	2020-05-25 22:13	676767	8888
12314	2020-06-19 8:47	888787	222
2432432	2020-12-23 11:35		334
20201223	2020-12-23 11:41	蓝布	1222

Left stop

Right stop

Defect records

Save defect

Confirm the defective

0

0

Automatic

0

Loose

Tight

Exit

Machine No

001

Order No

Starting Time

2020-12-17

Marker length

Preset layers

0

Spreading layers

-

0

+

Operator No

admin

Cloth No

Over Time

2021-10-11 14:11:00

Current length

0

Length(mm)

0

Execute scanning settings

Finish order

Left stop

Right stop

Defect records

Save defect

Confirm the defective

0

0

Automatic

0

Loose

Tight

Layer

Inttic

1. Press Layer number grid for 3 second to let all layer number grids return to 0.

Normal Operation:

Exit

Machine No

001

Order No

Starting Time

2020-12-17

Marker length

Preset layers

0

Spreading layers

-

0

+

Operator No

admin

Cloth No

Over Time

2021-10-11 13:24:00

Current length

0

Length(mm)

0

Execute scanning settings

Finish order

订单号	订单日期	面料编号	长度	层数	操作
99911	2020-03-21 9:51	353435	7777	777	执行订单
8888	2020-05-25 22:13	676767	8888	888	执行订单
12314	2020-06-19 8:47	888787	222	111	执行订单
2432432	2020-12-23 11:35		334	123	执行订单
20201223	2020-12-23 11:41	蓝布	1222	222	执行订单

Left stop

卷布

Defect records

Save defect

Confirm the defective

0

0

0

Automatic

Loose

Tight

Dispatched job order

Marker

Warning

Function

IOT

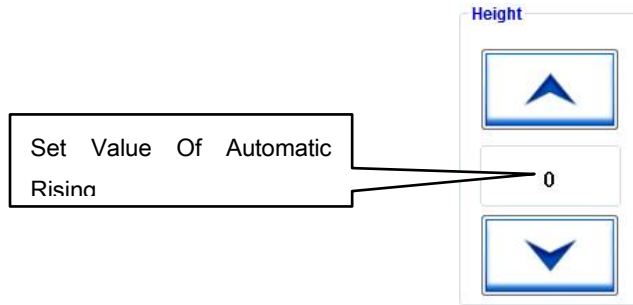
上布通讯



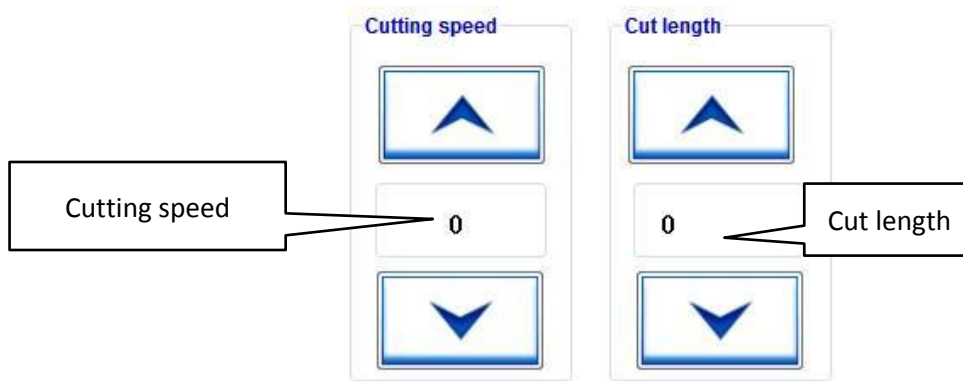
Left-end Point Stop Key



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.



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 single pull mode.



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



Press this button to double pull and double cut mode.



This interface is the operation interface.



This interface is the interface of some function switches and general parameters.



This interface is the view layout interface, which can view the clipping layout data.



This interface is the parameter interface.



This interface is an alarm interface, which can check the status of each input and output port of PLC and whether each alarm signal is triggered.

Function interface:

Single pull right spit cloth0MS

Double pull right spit cloth time0MS

Double pull left recovery distance0MM

Automatic sharpening time0MS

Single pull left reclaim0MS

Double pull left spit cloth time0MS

Double pull right recovery distance0MM

Automatic sharpening layer0Layers

12345678910

Uniform speed0000000000

Bucket accelerat0000000000

Bucket decelera0000000000

Height

Cutting speed

Cut length

0

0

0

0

0

0

Cable start switch

Edge drawing device switch

The secondary

Automatic knife sharpening switch

Monitor lift switch

parameter

Adjustable tension switch

Return

Left stop

Right stop

Single pull right speed distance

Defect records

Save defect

Confirm the defective

Single pull left speed distance

Automatic

Tight

Single pull right spit cloth0MS

Double pull right spit cloth time0MS

Double pull left recovery distance0MM

Automatic sharpening time0MS

Single pull left reclaim0MS

Double pull left spit cloth time0MS

Double pull right recovery distance0MM

Automatic sharpening layer0Layers

12345678910

Uniform speed0000000000

Bucket accelerat0000000000

Bucket decelera0000000000

Height

Cutting speed

Cut length

0

0

0

0

0

0

Cable start switch

Edge drawing device switch

The secondary

Automatic knife sharpening switch

Monitor lift switch

parameter

Adjustable tension switch

Return

Left stop

Right stop

Single pull right speed distance

Defect records

Save defect

Confirm the defective

Single pull left speed distance

Automatic

Loose

Tight

Single pull right spit cloth

In single pull mode, when this button is triggered, the cloth laying set moves to the right, spits out more cloth at the end, and starts laying cloth.

Single pull left reclaim

In the single pull mode, when this button is triggered, the cloth laying set will walk to the left, spit out more cloth at the end, and start cloth laying.

Cable start switch

When this button is triggered, pull the cable switch for 3 seconds and the machine will automatically pause. If this button is not triggered, it will be in an emergency stop state.

Automatic knife sharpening switch

When this button is triggered, the machine will grind the tool according to the set number of automatic grinding layers, and the grinding time is controlled by the automatic grinding time.

Adjustable tension switch

When this button is triggered, the machine will automatically adjust the tightness value according to the fabric tightness reading to make the cloth laying effect better.

Edge drawing device switch

When this button is triggered, the edge setting device will automatically run edge setting according to the machine motion state.



Monitor lift switch

When this button is triggered, the lifting height can be monitored.

Two way cloth spreading right spreading time: in double pull mode, the cloth spreading shall travel to the right and more spreading time shall be given to the end, and the cloth shall be spread to the left at the beginning.

Left spreading time of two-way spreading: in the double pull mode, the spreading time shall be more when walking to the left and reaching the end point, and the spreading time shall be to the right at the beginning.

Two way paving right recovery distance: in the two-way paving mode, the distance before the end point of the right row of paving is recovered first, and the cloth is paved to the left after reaching the end point.


Left recovery distance of two-way paving: in the two-way paving mode, the distance before the end point of the left row of paving is recovered first, and the cloth is paved to the right after reaching the end point.

自动 Sharpening time: set the sharpening time when the automatic sharpening button is enabled.

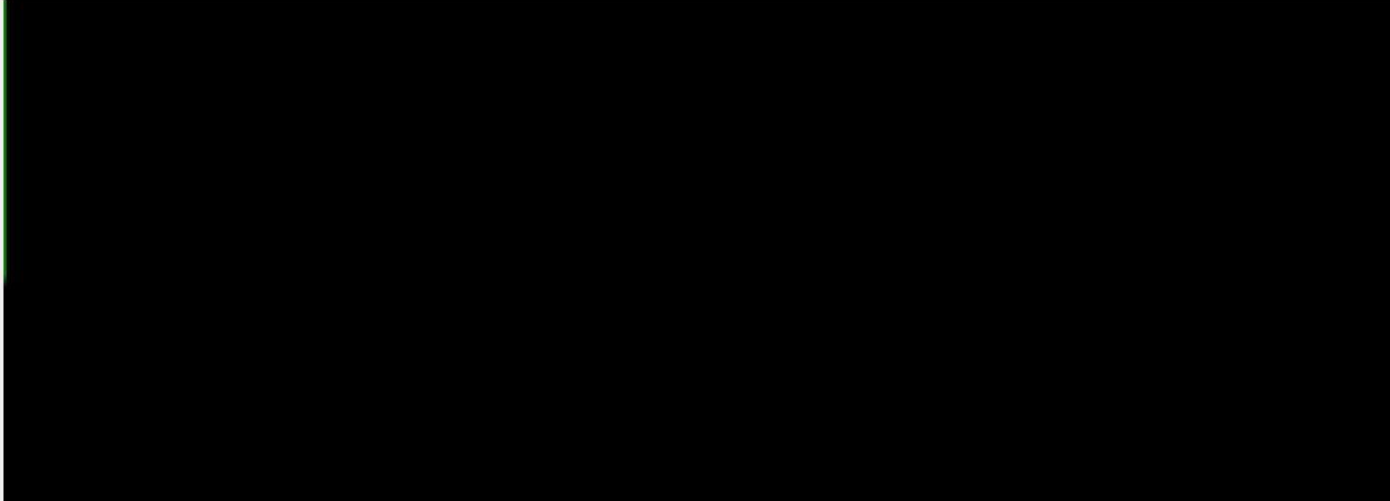
Automatic sharpening layers: when the automatic sharpening button is enabled, set the number of cloth cutting layers before sharpening once.

Layout interface:

Exit

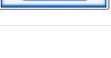







Machine No	Order No	Starting Time	Marker length	Preset layers	Spreading layers
001	2432432	2021-10-11 14:16:33		0	<div>— 0 +</div>
Operator No	Cloth No	Over Time	Current length	Length(mm)	
admin		2021-10-11 14:19:00	0	0	<div>Execute scanning settings Finish order</div>



Left stop





Right stop





Defect records

Save defect

Confirm the defective



0 0




Automatic

0

Loose Tight

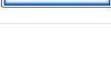

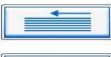



Exit



Machine No	Order No	Starting Time	Marker length	Preset layers	Spreading layers
001	2432432	2021-10-11 14:16:33		0	<div>— 0 +</div>
Operator No	Cloth No	Over Time	Current length	Length(mm)	
admin		2021-10-11 14:19:00	0	0	<div>Execute scanning settings Finish order</div>

Left stop

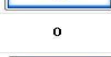



Right stop





Defect records

Save defect

Confirm the defective



0 0



Automatic

0

Loose Tight

19



Press this button to jump to the dispatch list interface.



When the layout is open, when the defect point is detected, the machine will run to the defect point position and roll back the fabric, and the machine will be in a suspended state. When the customer presses this button, the machine will automatically cut the cloth and run forward. The front of the cutting piece involved in the defect point will be laid and patched, and then continue to lay the cloth.



Press down to lay cloth automatically.



Select a defective piece in the layout, and the selected defective piece will be green. Click this button to save the defective piece record.

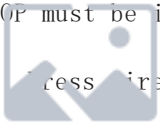


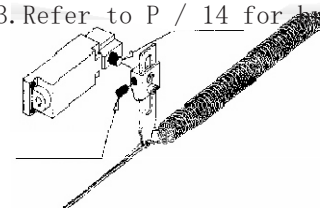


Click this button to view all defect information



Click this button to select the cutting layout of the paved fabric.

Simple troubles hooting:

Status	Reason	Countermeasure
Cutting blade does not rotate	1.Fuse F2 burnt 2.Amaged circuit board 3.Worn motor brushes or rotors	1.Check the fuse. 2.Open the cutter to measure whether the cutter output plug has a DC voltage of about 24V. If not, replace the circuit board. 3.The service life of the motor is about 1.5-3 years. It is recommended
Opposite cloth table does not move	1.Fuse F2 burnt 2.Damaged circuit board 3.Opposite motor failure	1.Check fuse 2.Cover the sensor and measure whether there is 24V DC voltage on the opposite output plug. If not, replace the circuit board. 3.This motor is not easy to break down without being hit
Unable to turn	1.Thermal electric translation tripping in 2.Open circuit of power	1.Open the electromagnetic contactor shell and press the back return lever
<div style="border: 1px solid black; width: 40px; height: 20px; margin: 0 auto;"></div> Press automatically unable to walk automatically	OP relay is abnormal. OP must be in On state.  Press wire rope  Press OP power down Machine stop  OP continuous power off = unable to walk automatically	OP power supply via limit switch of emergency stop steel cable . 1.Check if there is any cloth cutting bag or trolley pressing on the wire rope. 2.The angle deviation of the limit switch at the end of the steel cable is too large or fails. 3.Refer to P / 14 for broken wire.  1. axis 2. Screw 1. Loosen the limit switch when the angle deviation is too large; 2、The screw repins let the axis spring back to the original point

Safety precautions:

1. The machine can only be operated after being trained by our technical service personnel; Please read this manual carefully before operating the machine.
2. When operating the machine, the operator must pay attention to the yellow warning sign on the machine and shall not extend his hand to the dangerous area.
3. When the machine is running, do not move within 0.5m from both sides of the machine.
4. When operating a machine without an anti-collision sensor, do not move in the area within the limits of the front and rear of the machine.
5. During the automatic operation of the machine, it is forbidden to increase or decrease the speed of the section. If this operation is required, it needs to be operated in manual mode.
6. The line shall not be dismantled or replaced without the permission of relevant technicians of our company. In case of any accident, bear the consequences!

Maintenance:



Figure1



Figure2



Figure3

Basic Maintenance:

1.Chain:Add Lubricant And Adjust Elasticity

For lubricant of chain, 40# machine oil is advisable,addingonceevery2 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.