# bullmer

## **BULLMER SPREADER-KW2000E OPERATION MANUAL**



Respected customer, we will introduce the normal operation cutter machine, the explanation as follows:

Step 1 : Turn on machine with power **button-ON** 



Step 2 : Select language





If machine moved during power, please select select No, then go to Step4.

#### Step 4 : Reference machine



push the machine from front side to back side. To make proximity switch pass through induction point. Then the

machine can determine its own benchmark position.



Step 5 : Load fabric-Roll fabric







## Load fabric-folder fabric







### Step 6 : Setting parameters before spreading

Mode	Length/YD	+1 Count -1	Setting Plies		۸۱	ito	
3	-99. 9999	999	999			.10	
2	-99. 9999	999	999		9999		
1	-99. 9999	999	999	Γ	Taaaa	Tisht	1
Speed/Location	-99999.9	-99. 9999	Circle	_	Loose	11gnt	J
Right stop			Ø				
End stop					99	99	
0		$\geq$	Roll Fabric				

#### Operator interface:

Mode/Length/Plies:	Mode	Length/YD	+1	Count	-1	Setting Plies
	3	-99. 9999		999		999
	2	-99. 9999		999		999
	1	-99.9999		999		999



Close edge manually

Open edge manually Close edge manually



#### Emergency

*I*.*Emergency sensors are activated.* 

Anti-collision equipment on four sides. Machine will automatic stop when machine is

close to operator.

*If these sensors are activated, operator* 

can press button to continue spreading



*II*.*Emergency* cable line

Operator can pull emergency cable line during machine running, then machine will

stop.To continue spreading, operator can press button



Auto

# Basic trouble shooting:

Status	Reason	Countermeasure
Opposite cloth table does not move Unable to turn on the power	<ol> <li>1.Fuse F2 burnt</li> <li>2.Damaged circuit board</li> <li>3.Opposite motor failure</li> <li>1.Thermal electric translation tripping in electromagnetic contactor.</li> </ol>	<ol> <li>Check fuse</li> <li>Cover the sensor and measure whether there is</li> <li>Cover the sensor and measure whether there is</li> <li>V DC voltage on the opposite output plug. If</li> <li>not, replace the circuit board.</li> <li>This motor is not easy to break down without</li> <li>being hit.</li> <li>Use a multimeter to measure whether the input</li> <li>power of the transformer is 20V AC.</li> <li>Open the electromagnetic contactor shell and</li> <li>press the back return lever once.</li> <li>Use the electricity meter to measure along the</li> </ol>
	OP must be in On state	OP power supply via limit switch of emergency stop steel cable .
automatically unable to walk automatically	Press wire rope	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.
	Let OP power down	2.Screw
	OP continuous power off = unable to walk automatically	<ol> <li>Loosen the limit switch when the angle deviation is too large;</li> <li>The screw repins let the axis spring back to the original point.</li> </ol>
Can't sharpen the knife	<ol> <li>Fuse F2 is burnt</li> <li>Circuit board is damaged</li> <li>Grinding electromagnet failure</li> </ol>	<ol> <li>Check the fuse</li> <li>Measure whether the output plug of the sharpener has a DC voltage of about 24V after sharpening. If not, replace the circuit board.</li> <li>Electromagnets are not easy to fail.</li> <li>Use a multimeter to measure whether the input power of the transformer is 20V AC.</li> </ol>
Edge motor does not work	<ol> <li>Fuse F2 is burnt</li> <li>Circuit board is damaged</li> <li>Edge motor failure</li> </ol>	<ol> <li>Check the fuse.</li> <li>Open edge function measure whether there is about 24V DC voltage on the output plug of the dial. If not, replace the circuit board.</li> <li>Replace the flanging motor.</li> <li>Use a multimeter to measure whether the input power of the transformer is 20V AC.</li> </ol>

	1. Fuse F1 is burnt	1. Check the fuse.
		2. Press up to measure whether there is 220V
Lifting does not work	2. Circuit board is damaged	AC between circuit board 43 and 40, press down
		to measure whether there is 220V AC between
	3. Lifting motor failure	circuit board 43 and 41, or replace the circuit
		board if not.
		3. Check whether the circuit and motor are
		normal.
		4. Use a multimeter to measure whether the 220V
		power supply is AC 220V.
	1. Fuse F1 is burnt	1. Check the fuse.
Cloth pressing		2. When loosening, measure whether there is
mechanism does not	2. Circuit board is damaged	220V AC between circuit boards 12 and 11. When
work		pressing, measure whether there is 220V AC
	3. Lifting motor failure	between circuit boards 12 and 10. If not, replace
		the circuit board.
		3. Check whether the circuit and motor are
		normal.
		4. Use a multimeter to measure whether the 220V
		input power supply is AC 220V.
	1. Fuse F1 is burnt	1. Check the fuse.
		2. Open the brake and measure whether the brake
Brake does not work	2. Circuit board is damaged	output plug has about 220V AC voltage. If not,
		replace the circuit board.
	3. Electromagnetic brake failure	a 3. Check whether the circuit and brake power
		supply device are normal.
		4. Use a multimeter to measure whether the 220V
		input power supply is AC 220V.
L		

#### **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.



Figure1



Figure2



Figure3