

bullmer

The Machine For KW2000E Model Operation Instruction

Read a handbook please detailedly before handling a machine

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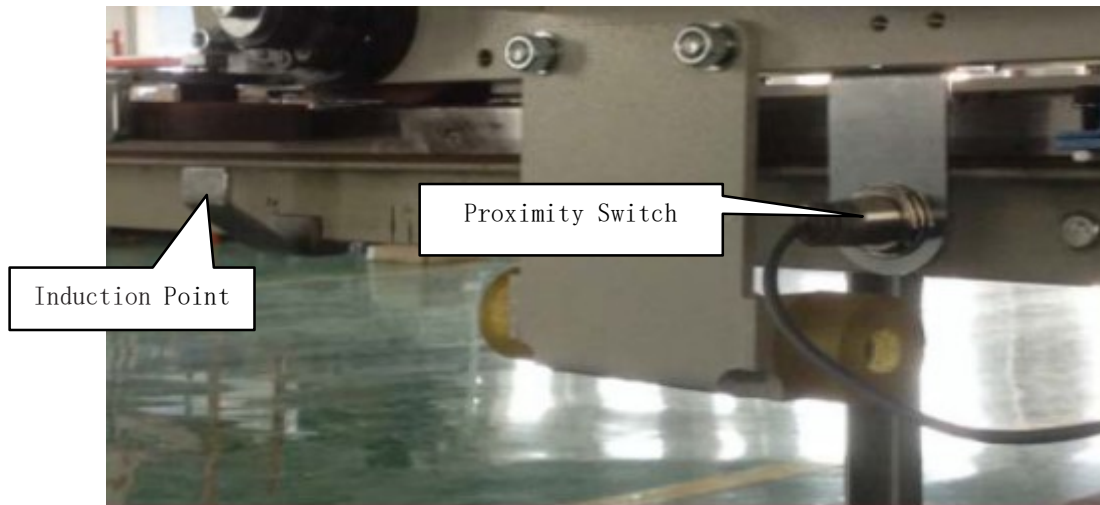
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Pay Attention To Before Operation:

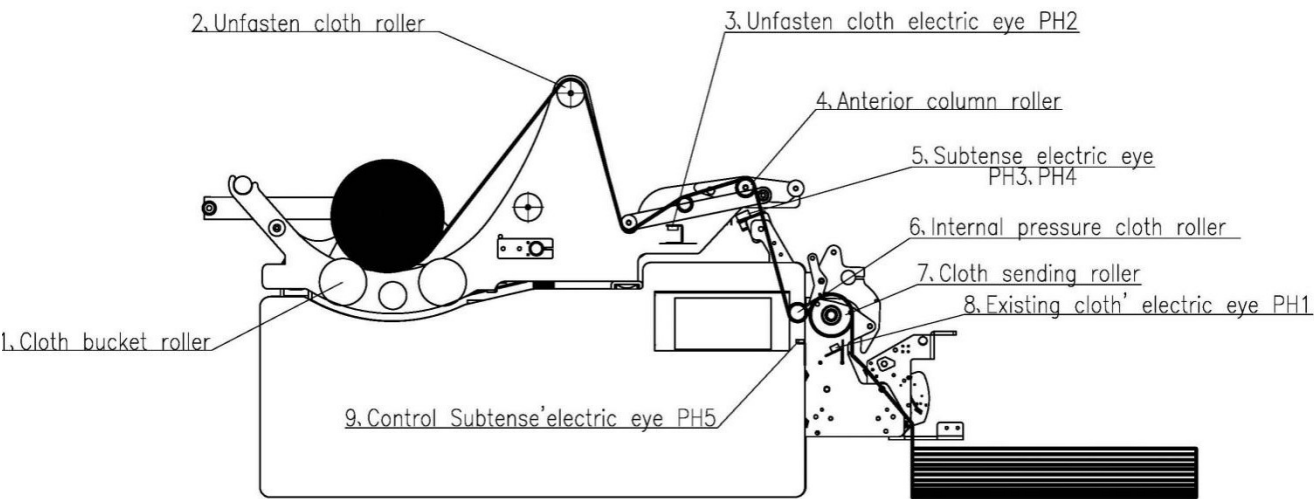
When proximity switch goes to left and passes through induction point, the current position returns to 0. This is the benchmark point of machine calculating position. returns to 0. This is the benchmark point of machine calculating position. Every time when proximity switch goes to left and passes through 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 again. The 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.

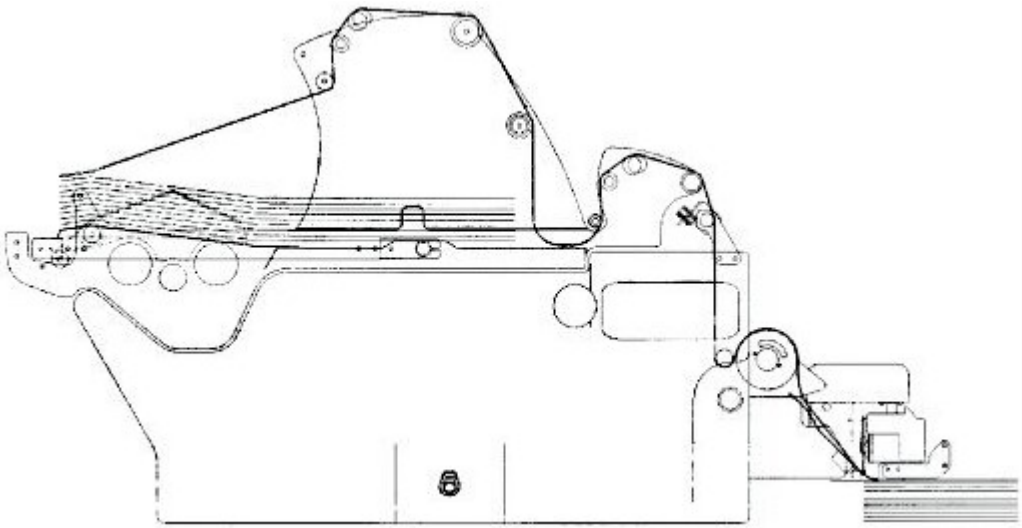
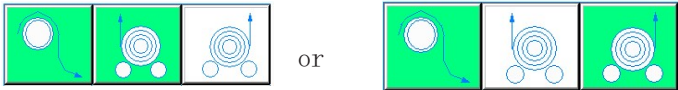
Normal Operation :



Rewinding Cloth:

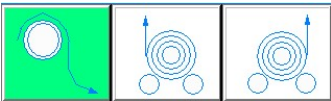
Place as the above figure.

When spreading the necessary keys are

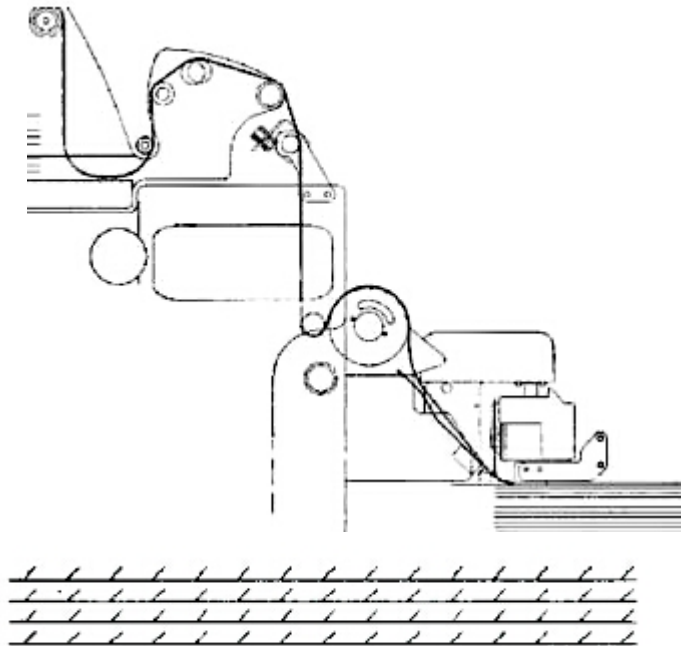


Folding yard cloth:

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

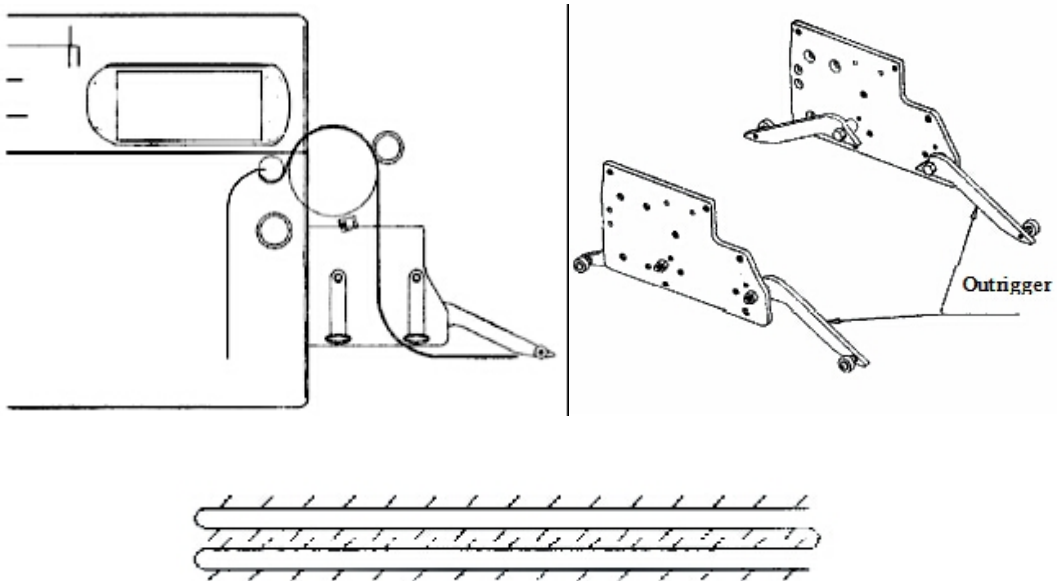


Normal Operation:



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.

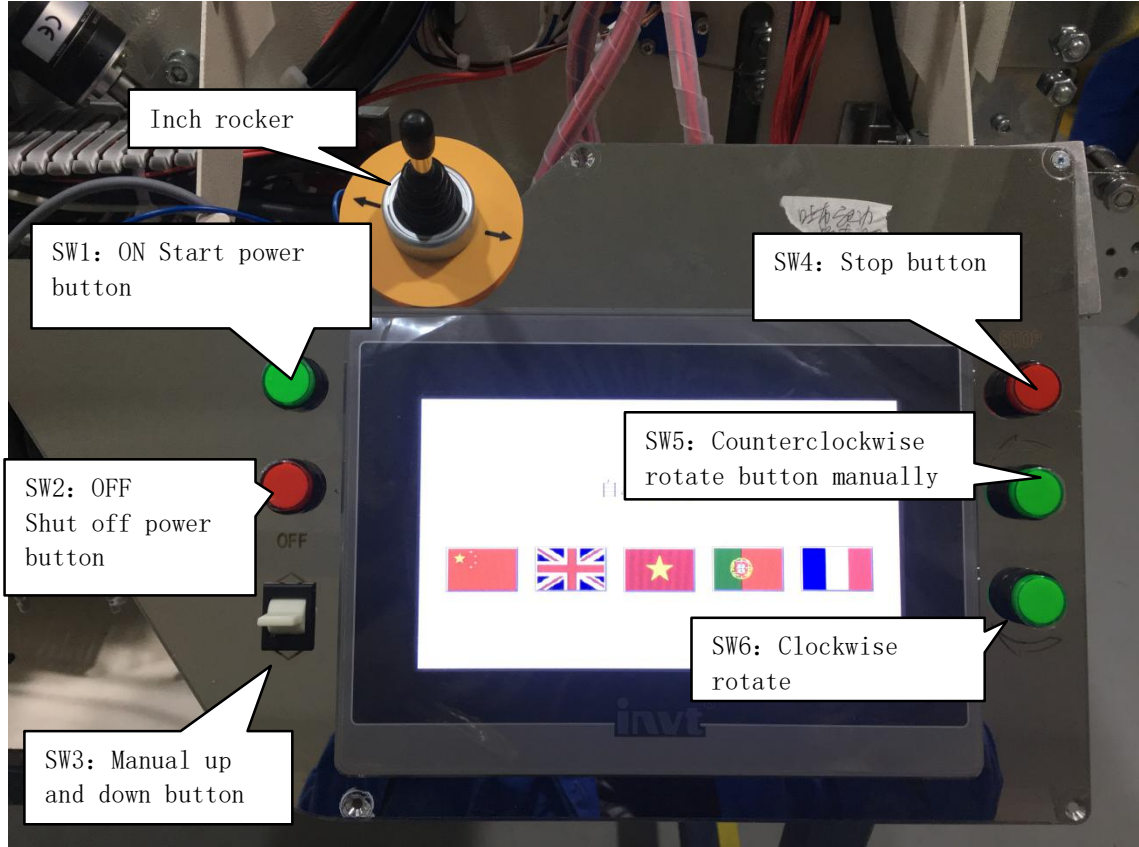


Double Spreading

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

Double spreading: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 certain 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)

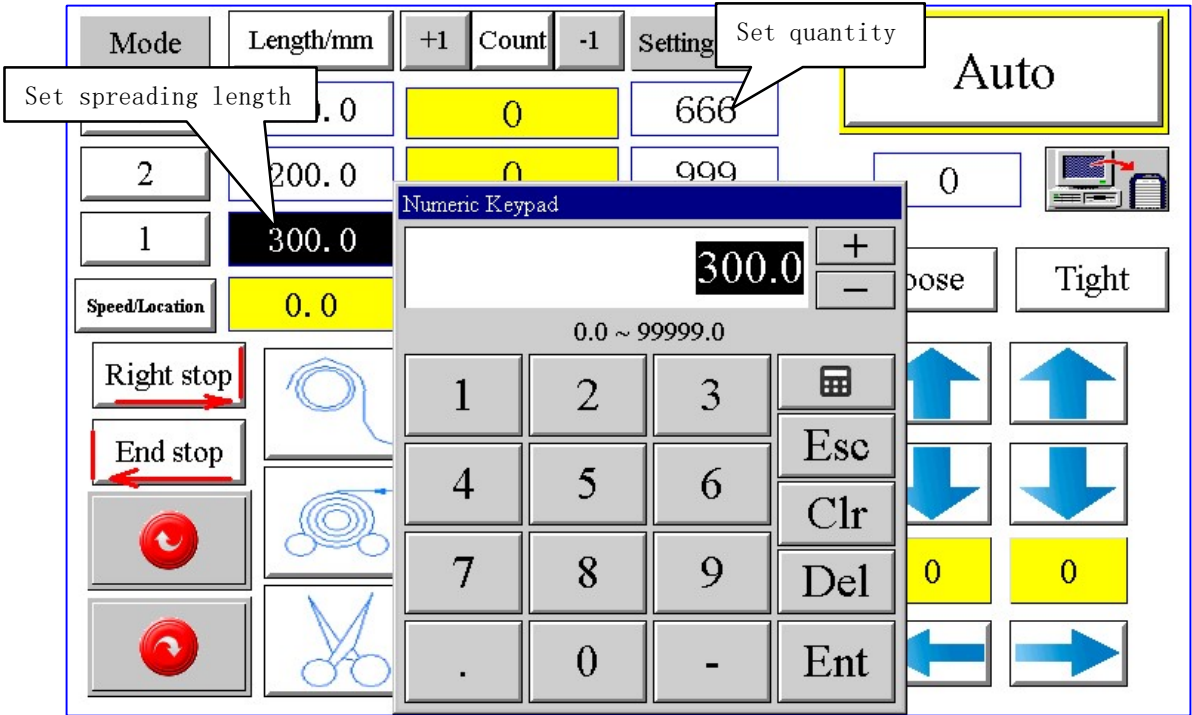
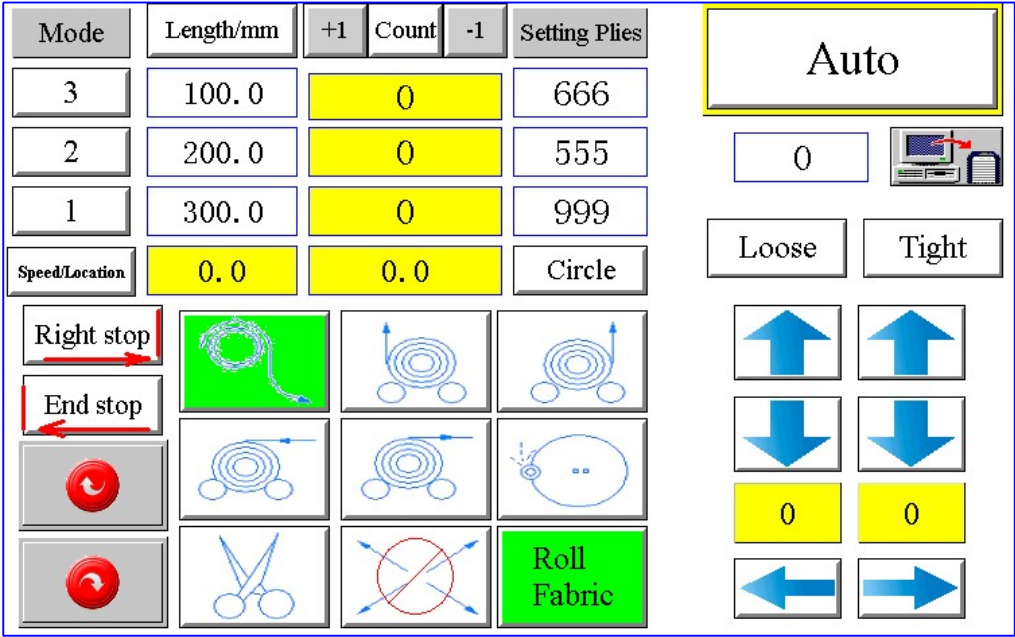
Sw5 「Cloth sending roller」 : Counterclockwise rotate button manually.

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.

【Inch rocker】 "Manual" rocker for moving the machine. Pull right row (forward) to the right; pull left row (backward) to the left, and move forward to the direction of the rocker at a constant speed

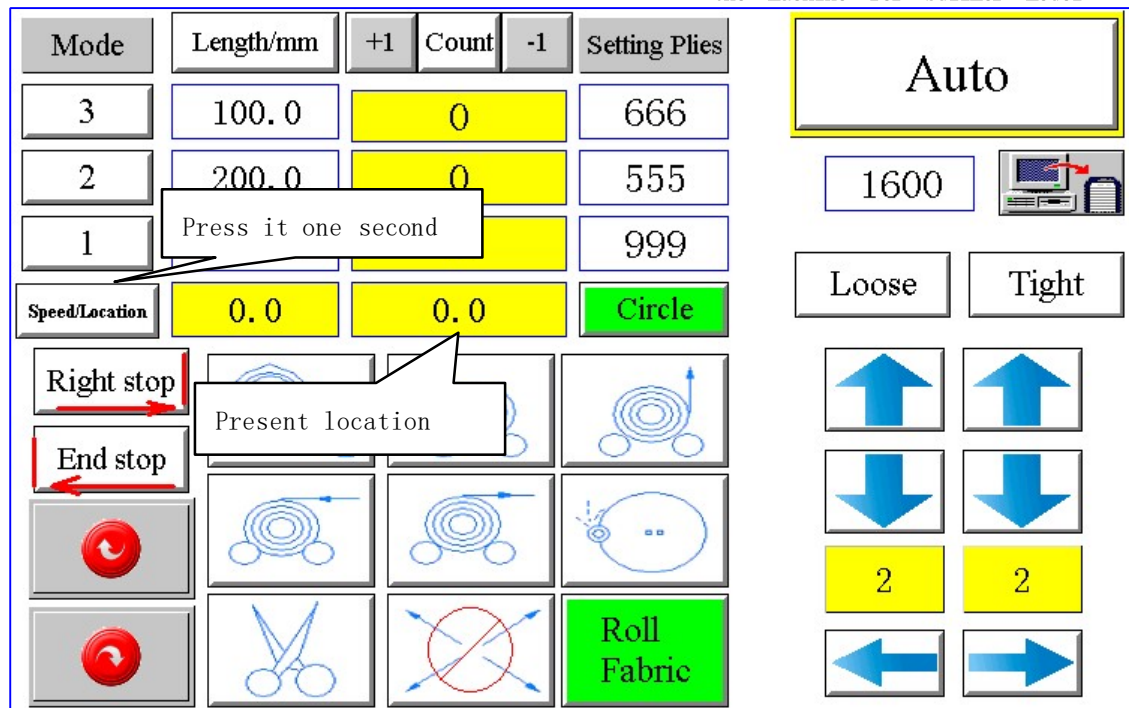
Normal Operation :



Press it and display digital keyboard as the right figure, input the desired figure and press ENTER , [Spreading length] Unit: mm 1M=1000mm 1inch=25.4mm

Single spreading mode: When [COUNT] achieves [WANTED] value, the machine will stop.

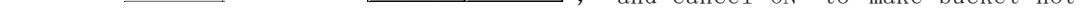
Continuous spreading mode: When all [COUNT] achieve [WANTED] value, the machine will stop.



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

press mode **Speed/Location** for one second after moving the machine to the desired position, as shown in the figure, and now, the position value will be set in mode **1** spreading length. Mode **2** and **3** can be set in spreading length according to this method.

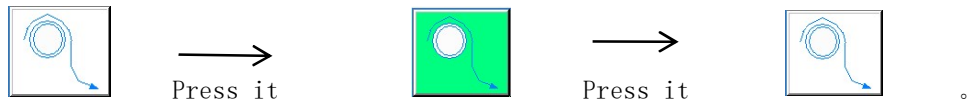
[illegible]



Downloaded from <http://ajphaphysocpharm.com/> on November 10, 2015







RUN 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/mm	+1	Count	-1	Setting Plys
3	100.0		0		666
2	200.0		0		555
1	300.0		0		999
Speed/Location	0.0		0.0		Circle

Auto

0

Loose Tight

Right stop

End stop

Roll Fabric




Cutting Button

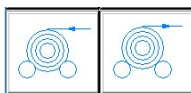


When the machine stops, press  to carry out cutting action for one time.




If the cutter head doesn't stop at fixed position due to emergency stop, press  let the head return to fixed position. When press the cutting button for manual cutting, the layer number value is unchanged.

Call buck Inch move



“Manual” key

When press  the cloth will roll back with low speed.



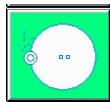
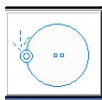
When press  the cloth will roll out with low speed.



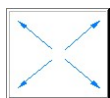
Cloth bucket roller



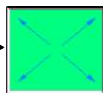
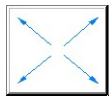
The key of knife stone



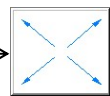
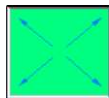
Press The blade rotates and then gently millstone to sharpen according to the set time.



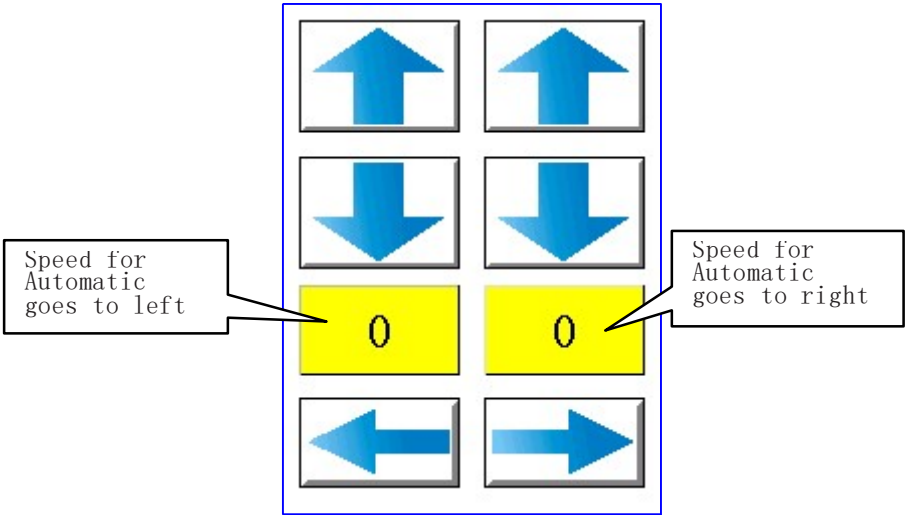
Release Brake key



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







Press Brake locks and need to big strength to push machine.





LIFT RIGHT

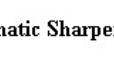
Normal Operation:





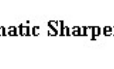




0-1






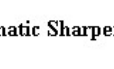
Speed








Width(CM)





blade speed	<input style="width: 100%;" type="text" value="0"/>	
Manual Bucket Speed	<input style="width: 100%;" type="text" value="0"/>	Hz
Walking manual speed	<input style="width: 100%;" type="text" value="0"/>	Period
Automatic Sharpening Counts	<input style="width: 100%;" type="text" value="0"/>	Count
Automatic Sharpening Time	<input style="width: 100%;" type="text" value="0.0"/>	s
Automatic Sharpening Switch	<div style="border: 1px solid black; padding: 2px; text-align: center;">OFF</div>	
Height Monitor Switch	<div style="border: 1px solid black; padding: 2px; text-align: center;">OFF</div>	
Chain start switch	<div style="border: 1px solid black; padding: 2px; text-align: center;">OFF</div>	
Edge Even Out Device	<div style="border: 1px solid black; padding: 2px; text-align: center;">OFF</div>	Open edge manually

Layer number grid

Mode	Length/mm	+1	Count	-1	Setting Plys
3	100.0		0		555
2	200.0		0		555
1	300.0		0		999
Speed/Location	0.0		0.0		Circle

Figure grid

0

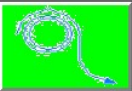


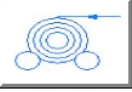
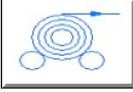









Loose Tight

Right stop


End stop

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/mm	+1	Count	-1	Setting Plies
3	100.0		0		666
2	200.0		0		555
1	300.0		0		999
Speed/Location	0.0		0.0		Circle
Right stop					
End stop					
					
					

Auto



1600 

Loose Tight

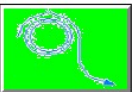


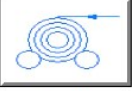
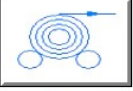
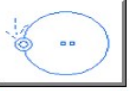








 


2 2



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/mm	+1	Count	-1	Setting Plies
3	100.0		0		666
2	200.0		0		555
1	300.0		0		999
Speed/Location	0.0		0.0		Circle
Right stop					
End stop					
					
					

Auto



0 

Loose Tight


 


0 0


 


Start coherent spreading functions, the machine will pass through all modes of having set preset value according to mode 1, 2, 3, then stop.

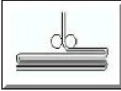
Normal Operation:














blade speed

5000

Manual Bucket Speed

5

Hz

Walking manual speed

1

Period

Automatic Sharpening Counts

0

Count

Automatic Sharpening Time

0.0

s

Automatic Sharpening Switch

OFF

Height Monitor Switch

OFF

Chain start switch

OFF

Edge Even Out Device


OFF


Open edge manually


0-1

Speed

Width(CM)










0.02

5


160







Stop Key

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

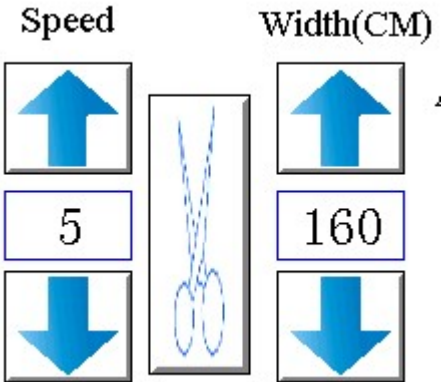
0-1

0.00

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.

16

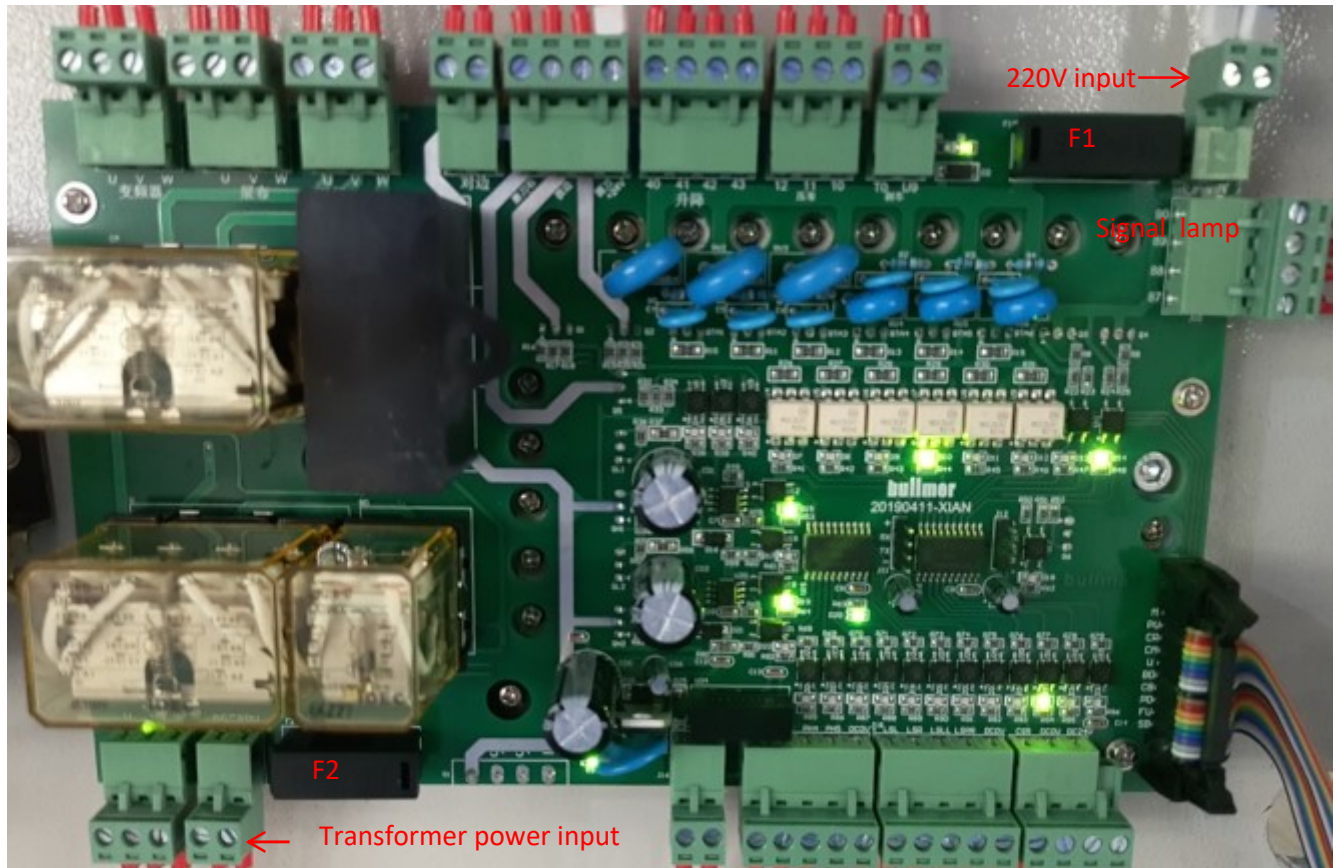


Cutting button 2: Press this button for manual cutting, the layer number will add 1. According to cloth nature and width to set cutting speed and length to make them well cooperate with.



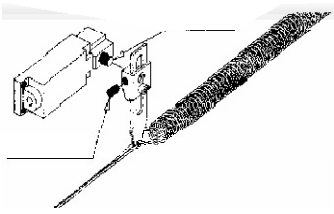
Double spreading mode of hanging cutter group not automatically cut, and spreading mode of cylinder cloth using double-roller device.

Fault:



F1: Common fuses of lifting motor, cloth pressing motor and electromagnetic brake circuit.
 F2: Common fuses for opposite motor, edge shifting motor, circular knife motor and knife grinding electromagnet.

Simple troubles hooting:

Status	Reason	Countermeasure
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. 4.Use a multimeter to measure whether the input power of the transformer is 20V AC.
Unable to turn on the power	1.Thermal electric translation tripping in electromagnetic contactor.	1.Open the electromagnetic contactor shell and press the back return lever once. 2.Use the electricity meter to measure along the line.
	2.Open circuit of power supply outside the machine.	
<div style="border: 1px solid black; padding: 2px; display: inline-block;">AUTO</div> automatically unable to walk automatically	OP relay is abnormal. OP must be in On state. Press wire rope ↓ Let 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.

Can't sharpen the knife	<ol style="list-style-type: none"> 1. Fuse F2 is burnt 2. Circuit board is damaged 3. Grinding electromagnet failure 	<ol style="list-style-type: none"> 1. Check the fuse 2. Measure whether the output plug of the sharpener has a DC voltage of about 24V after sharpening. If not, replace the circuit board. 3. Electromagnets are not easy to fail. 4. Use a multimeter to measure whether the input power of the transformer is 20V AC.
Edge motor does not work	<ol style="list-style-type: none"> 1. Fuse F2 is burnt 2. Circuit board is damaged 3. Edge motor failure 	<ol style="list-style-type: none"> 1. Check the fuse. 2. Open edge function measure whether there is about 24V DC voltage on the output plug of the dial. If not, replace the circuit board. 3. Replace the flanging motor. 4. Use a multimeter to measure whether the input power of the transformer is 20V AC.
Lifting does not work	<ol style="list-style-type: none"> 1. Fuse F1 is burnt 2. Circuit board is damaged 3. Lifting motor failure 	<ol style="list-style-type: none"> 1. Check the fuse. 2. Press up to measure whether there is 220V AC between circuit board 43 and 40, press down to measure whether there is 220V AC between 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 input power supply is AC 220V.

Cloth pressing mechanism does not work	<ol style="list-style-type: none"> 1. Fuse F1 is burnt 2. Circuit board is damaged 3. Lifting motor failure 	<ol style="list-style-type: none"> 1. Check the fuse. 2. When loosening, measure whether there is 220V AC between circuit boards 12 and 11. When pressing, measure whether there is 220V AC 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.
Brake does not work	<ol style="list-style-type: none"> 1. Fuse F1 is burnt 2. Circuit board is damaged 3. Electromagnetic brake failure 	<ol style="list-style-type: none"> 1. Check the fuse. 2. Open the brake and measure whether the brake output plug has about 220V AC voltage. If not, replace the circuit board. 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.

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.