

BULUCUT-1 N ABRASIVE CUTTER



BMS Bulut Makina Sanayi ve Ticaret Ltd. Şti.

Kocaeli KOBİ Organize Sanayi Bölgesi

Köseler Mahallesi, 6.Cadde No: 20/2 Dilovası / KOCAELİ / TURKEY

Phone: +90 262 502 97 73-76 / +90 262 503 06 51

Web: www.bulutmak.com e-mail: bms@bulutmak.com

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BULUCUT-1 N ABRASIVE CUTTER

1 Description

Sturdy table model for sectioning metals, ceramic and mineral samples
Corrosion resistance sheet metal cover with see-through hood
Special aluminum casted heavy robust base
Easy use twin cam actuated vises for holding samples
All inside parts made from stainless steel
Splash proof during cutting
Cooling by two high flow water jets to provide optimum cutting
Cutting action provided by moving motor on specimen
11W light illuminator protected from water in specially isolated cover fixed inside the cover to obtain safe and clear illumination on cutting area
Separately mounted recirculation coolant tank with large drain
57 ltr capacity coolant tank, suitable filtering part provided to filter the slugs formed during cutting.

1.1 Technical Specifications

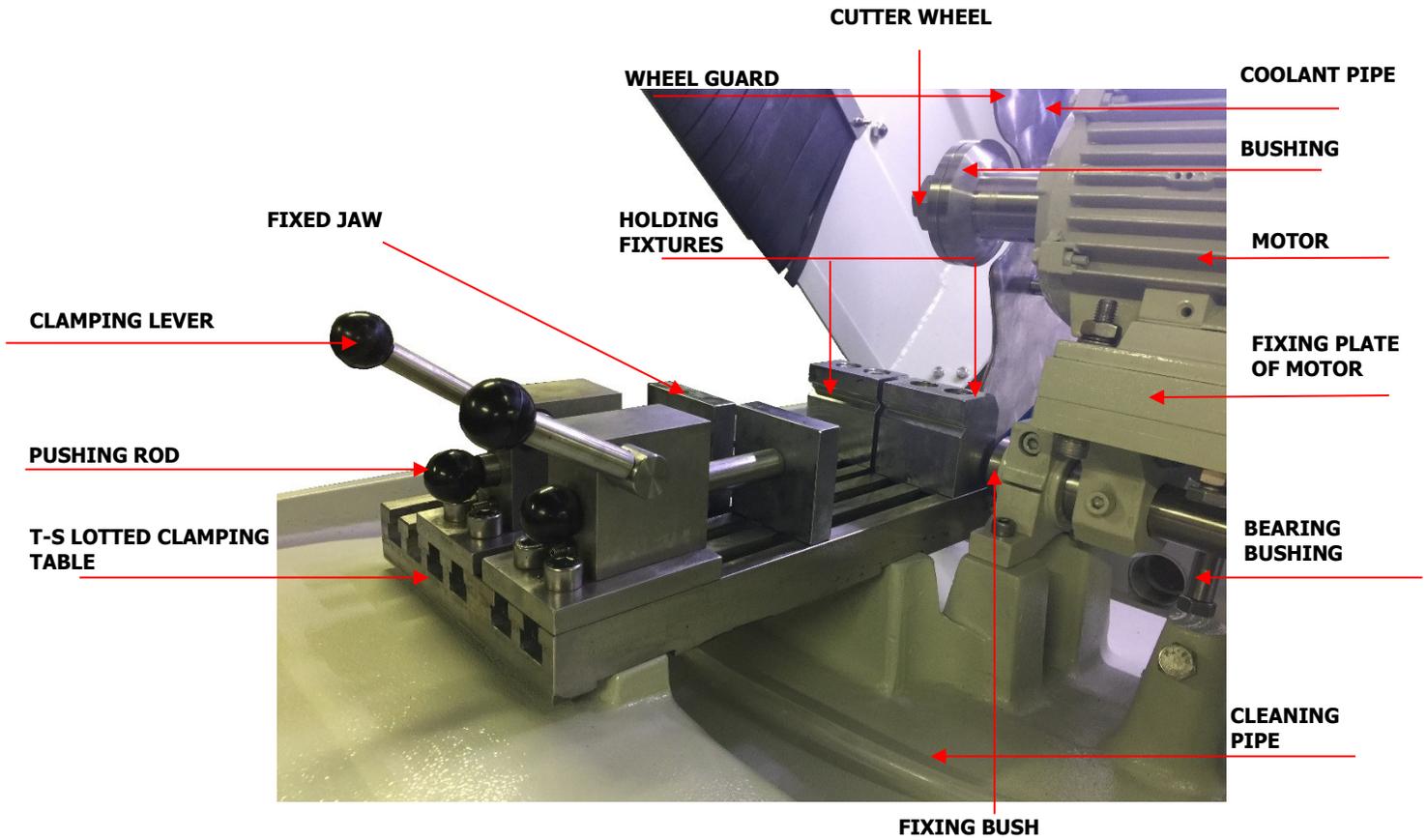
Machine dimensions	650 x 670 x 770mm
Case dimensions (coolant system included)	1200 x 900 x 800 mm
Weight (net/gross)	110/194 kg
Motor	3 KW, AC 380 Volt, 3 phase 2840 rpm
Cutting system	Manual
Table dimensions	T-slotted clamping table(370 x 173 mm) (1 pcs)
Clamping devices	Fast cam locking vises (2 pcs)
Cutting capacity	90 mm dia
Cutting wheel dim's	250x32x1,5 (1,5) mm
Coolant pump	380 V, 0,12 Kw
Coolant reservoir dimensions	600 x 400 x 300 mm, 57 ltr capacity

1.2 Standard Accessories

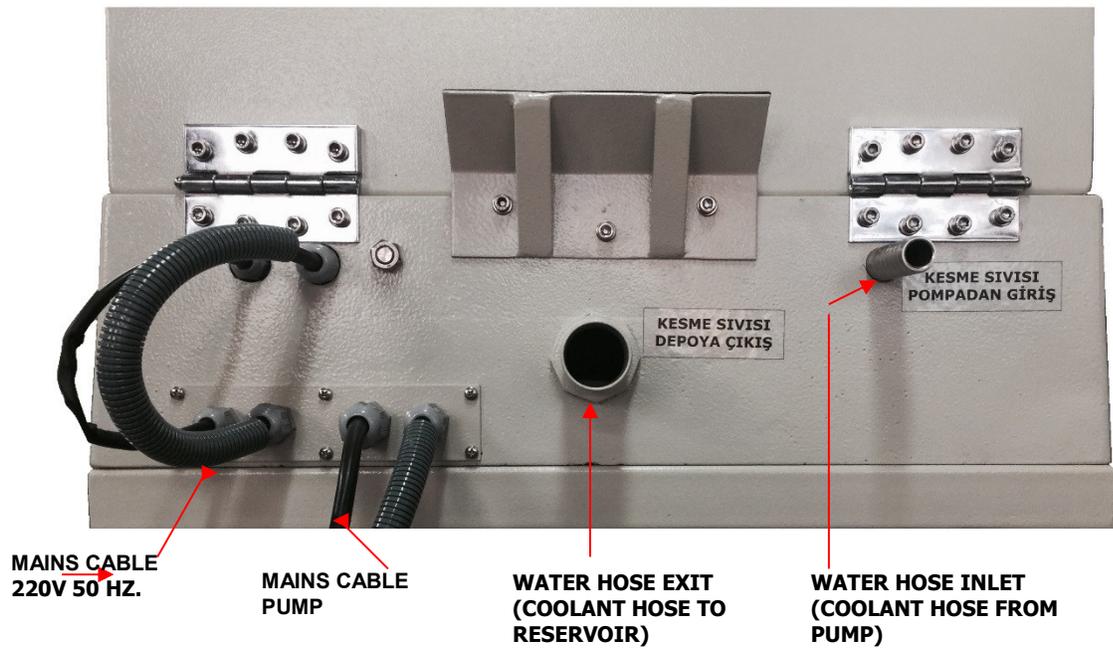
Abrasive cutter
Recirculation Coolant System
Two coolant circulation hoses and clips
Arrow wrench and arbor pin
5 pcs abrasive cutting wheels
Abrasive cutting fluid (5 liter)
Fast cam locking vise clamping devices (2 pcs)



**ELECTRICAL
SAFETY
SWITCH**



(Rear of Machine)



FILL THE RESERVOIR TANK WITH WATER (55 LITER) AND %5 (2 LITER) OF CUTTING FLUID. LOCATE TOP COVER ON TANK.



(Recirculation Coolant System)

2 Unpacking



Remove packing materials and lift out machine complete with baseboard. Remove 4 securing bolts that secures machine to baseboard.

3 Installation

Open cover.

Remove the shipping strap from the cutting head and push the cutting lever to the rear to raise the cutting Wheel as high as possible.

Install the cutter on suitable table and secure alignment by means of adjusting positions of 4 secure leveling bolts.

Plug to mains 380-400V (3 phase) power and **check the turning position of cutter and ensure correct turning if necessary.**

4 Plumbing

Locate recirculation pump on its table and bring it to the near of cutter.

Make recirculation pump electrical connections Connect 18 mm coolant supply hose to the rear of cutter and tighten the hose clamp. Locate the other end to recirculation pump and tighten the hose clamp.

Connect the 40 mm dia coolant return hose to rear of cutter and clip the hose clamp. Locate other end of hose on filter of reservoir tank.

Fill the reservoir tank with water (55 liter) and %5 (2 liter) of cutting fluid. Locate top cover on tank.

Open the cover of cutter and press PUMP button on PLC and allow pump to run a few minutes. This procedure ensures adequate mixing of coolant solution. (PUMP button is not used when the cover is closed.)

5 Cutter Wheel Locating

Please pay attention while installing abrasive cutting wheel. Do not use wheel dia greater than 250 mm and thickness 1, 8 mm.

Raise cover and remove the Wheel guard. Insert the arbor pin into hole of bushing and using 36 mm wrench loosen the wing nut (Bushing of motor spindle has left hand thread) and locate the cutter. Wheel in position perfectly.

Make the same procedure to ensure tighten of wing nut as well. Never leave arbor pin inserted into hole of bushing.

Make sure two faces of wheel and bushing clean.

6 Cutting Fluid Manual

6.1 First Time Filling Of Reservoir Tank

- 1) - Obtain separate tank for mixing. (For example 25 ltr. plastic tank)
- 2) - Fill tank with water. (For example 20 ltr) Later, add, %5 CIMSTAR 506 cutting fluid (or its compatible) (1 ltr for 20 ltr water)
- 3) - While adding, cutting fluid to water slowly, mix well
- 4) - Put this mixed fluid to reservoir tank.

6.2 Adding cutting fluid after some period of usage

- 1) - In case of requirement of adding cutting fluid after first time filing, followings to be considered.
- 2) - Fill plastic tank with water. (For example 20 ltr.) Later, add %3 CIMSTAR 506 Cutting fluid (For 20 ltr water 0.6 ltr cutting fluid)
- 3) - While adding, cutting fluid to water slowly, mix well
- 4) - Put this mixed fluid to reservoir tank.

After each month of usage we recommend you to clean reservoir tank and add new cutting fluid as first time filling

7 Sample Fixing

Two wises positioned at our works for general purpose of cutting.

When required for larger samples, it can be necessary to reposition the wises nearer to the front of the machine.

For this purpose, loosen 4 bolts of fixing plate of holding fixture. Locate the sample on fixed jaw and push forward clamping jaw against sample. Use a suitable pressure and push clamping lever tightly. Do not over clamp.

8 Cutting Operation

Be sure sample is clamped and jaws tighten well.

Close the cover. (The cutter will not operate unless the cover is completely closed)

Start cutting and pump motors by pressing **START button. (Do not start motors when cutting lever is in mid position and be sure cutting wheel is not touching the sample)**

Check the flow of coolant and adjust the flow of water jets if required

Slowly feed the cutter wheel on sample by pulling cutting lever.

To reach constant cutting range maintain pressure as required. (Excessive force may cause motor overload and damage cutter wheel.)

When cutting procedure is completely finished, bring the cutting lever to its starting position.

Cutter wheel rotates for several seconds after pushing STOP button or opening cover. In case of opening cover, please be sure cutter wheel completely stopped.



LED 24V DC, 8,4W /1 MT