Bandit 7200
Edgebander Manual
# Table of contents

<table>
<thead>
<tr>
<th>Section</th>
<th>Page number</th>
</tr>
</thead>
<tbody>
<tr>
<td>Safety Rules</td>
<td>4</td>
</tr>
<tr>
<td>Warranty</td>
<td>5</td>
</tr>
<tr>
<td>Noise emission</td>
<td>6</td>
</tr>
<tr>
<td>Specification sheet</td>
<td>6</td>
</tr>
<tr>
<td>Receiving your machine</td>
<td>6</td>
</tr>
<tr>
<td>Introduction to edgebanders</td>
<td>7</td>
</tr>
<tr>
<td>Parts of the machine</td>
<td>7</td>
</tr>
<tr>
<td>What you will receive with the machine</td>
<td>11</td>
</tr>
<tr>
<td>Where to locate your machine</td>
<td>11</td>
</tr>
<tr>
<td>Unpacking your machine</td>
<td>12</td>
</tr>
<tr>
<td>Assembly and setup</td>
<td>13</td>
</tr>
<tr>
<td>Operating and adjusting the machine</td>
<td>17</td>
</tr>
<tr>
<td>Maintenance and troubleshooting</td>
<td>33</td>
</tr>
<tr>
<td>Electrical drawing</td>
<td>41</td>
</tr>
<tr>
<td>Pneumatic drawing</td>
<td>41</td>
</tr>
<tr>
<td>Exploded view drawings and parts lists</td>
<td>41</td>
</tr>
<tr>
<td>Ordering spare parts</td>
<td>41</td>
</tr>
</tbody>
</table>
Safety Rules
As with all machinery there are certain hazards involved with the operation and use. Using it with caution will considerably lessen the possibility of personal injury. However, if normal safety precautions are overlooked or ignored, personal injury to the operator may result. If you have any questions relative to the installation and operation, do not use the equipment until you have contacted your supplying distributor.

Read the following carefully before operating the machine:

1. Keep the working area clean and be sure adequate lighting is available.
2. Do not wear loose clothing, gloves, bracelets, necklaces or ornaments. Wear face, eye, respiratory and body protection devices as indicated for the operation or environment.
3. Be sure that the power is disconnected from the machine before tools are serviced or an attachment is to be fitted or removed.
4. Never leave the machine with the power on.
5. Do not use dull, gummy or cracked cutting tools.
6. Be sure that the keys and adjusting wrenches have been removed and all the nuts and bolts are secured.
Limited Warranty

New machines and accessories sold by Laguna Tools carry a one-year warranty effective from the date of shipping. Machines sold through dealers must be registered with Laguna Tools within 30 days of purchase to be covered by this warranty. Laguna Tools guarantees all new machines and accessories sold to be free of manufacturers’ defective workmanship, parts and materials. We will repair or replace, without charge, any parts determined by Laguna Tools, Inc. to be a manufacturer’s defect. We require that the defective item/part be returned to Laguna Tools with the complaint. Any machines returned to Laguna Tools must be returned with packaging in the same manner in which it was received. If a part or blade is being returned it must have adequate packaging to ensure no damage is received during shipping. In the event the item/part is determined to be damaged due to lack of maintenance, cleaning or misuse/abuse, the customer will be responsible for the cost to replace the item/part, plus all related shipping charges. This limited warranty does not apply to natural disasters, acts of terrorism, normal wear and tear, product failure due to lack of maintenance or cleaning, damage caused by accident, neglect, lack of or inadequate dust collection, misuse/abuse or damage caused where repair or alterations have been made or attempted by others.

Laguna Tools, Inc. is not responsible for additional tools or modifications sold or performed (other than from/by Laguna Tools, Inc.) on any Laguna Tools, Inc. machine. Warranty maybe voided upon the addition of such described tools and/or modifications, determined on a case-by-case basis.

Software purchased through Laguna Tools Inc. is not covered under this warranty and all technical support must be managed through the software provider. Software is non-refundable.

Normal user alignment, adjustment, tuning and machine settings are not covered by this warranty. It is the responsibility of the user to understand basic machinery operation, settings and procedures and to properly maintain the equipment in accordance with the standards provided by the manufacturer.

Parts, under warranty, are shipped at Laguna Tools, Inc.’s cost either by common carrier, FEDEX ground service or a similar method. Technical support to install replacement parts is primarily provided by phone, fax, e-mail or Laguna Tools Customer Support Website. The labor required to install replacement parts is the responsibility of the user.

Laguna Tools is not responsible for damage or loss caused by a freight company or other circumstances not in our control. All claims for loss or damaged goods must be notified to Laguna Tools within twenty-four hours of delivery. Please contact our Customer Service Department for more information.

Only new machines sold to the original owner are covered by this warranty. For warranty repair information, call 1-800-332-4094.
**Noise emission.**
Notes concerning noise emission:
Given that there exists a relationship between noise level and exposure times, it is not precise enough to determine the need for supplementary precautions. The factors affecting the true level of exposure to operators are clearly the amount of time exposed, the characteristics of the working environment, other sources of dust and noise, etc, for example, adjacent machines, in other words, the level of ambient noise. It is possible that exposure level limits will vary from country to country.

**Specification sheet.**

<table>
<thead>
<tr>
<th>Minimum panel thickness</th>
<th>½ in</th>
</tr>
</thead>
<tbody>
<tr>
<td>Maximum panel thickness</td>
<td>2 in</td>
</tr>
<tr>
<td>Minimum panel width</td>
<td>2 ¾ in</td>
</tr>
<tr>
<td>Minimum edgebanding thickness</td>
<td>0.4mm</td>
</tr>
<tr>
<td>Maximum edgebanding thickness</td>
<td>5mm</td>
</tr>
<tr>
<td>Feed speed</td>
<td>35 F.P.M.</td>
</tr>
<tr>
<td>Total power</td>
<td>3.63 kw</td>
</tr>
<tr>
<td>Power requirements</td>
<td>220V 3-phase</td>
</tr>
<tr>
<td>Compressed air</td>
<td>90 P.S.I. 2 C.F.M.</td>
</tr>
<tr>
<td>Weight</td>
<td>500kg</td>
</tr>
<tr>
<td>Overall size</td>
<td>2100mm X 800mm X 1320mm 82.5in X 31.5in X 52in</td>
</tr>
</tbody>
</table>

**Receiving your machine.**

**Note:** It is probable that your machine will be delivered by a third party. Before you unpack your new machine, you will need to first inspect the packing, invoice and shipping documents supplied by the driver. Insure that there is no visible damage to the packing or the machine. You need to do this prior to the driver leaving. All damage must be noted on the delivery documents and signed by you and the delivery driver. You must then contact the seller [Laguna Tools] within 24 hours.

**Note:-** It is probable that you will find sawdust within your machine. This is because the machine has been tested prior to shipment from the factory and or Laguna Tools. Laguna Tools endeavours to test machines prior to shipping to customers as movement can take place during transportation. It must be noted that additional machine movement can take place between Laguna Tools and the end-user, and
some adjustments may have to be undertaken by the customer. These adjustments are covered in the various sections of this manual.

**Introduction to edgebanders.**
This edgebander is designed to give you years of safe service. Read this owner’s manual in its entirety before assembly or use.

**Parts of the edgebander.**
The major parts of the edgebander are discussed in this section of the manual. If you are not familiar with the edgebanders, take the time to read this section and become familiar with the machine.
Identification.
There is a plate at the back of the machine listing all the manufacturing data including the serial number, model, etc.

1. Cabinet.
The cabinet has a large footprint and is of welded construction manufactured from heavy gauge steel plate. The cabinet houses all the parts of the machine and the heavy construction ensures that the machine is stable. This weight also helps to absorb any vibration that is produced during operation.

2. Electrical system.
The electrical control system is housed in a dust-proof box, located at the back of the machine behind the main panel. All the fuses and breakers are located in the box and the electrical controls are located on the front of the machine. A cable is provided for connection to your electrical supply, but no plug is provided as this will depend on your electrical system.

3. Tape feed system.
The tape is fed from the tape support table were it is free to rotate. The tape is guided through a “U” bracket assembly to the cut-off guillotine. The tape is
stationary at the guillotine until the panel is fed into the machine. The movement of the panel activates a micro-switch which operates the pressure roller clamping the tape to the rubber drive roller which moves the tape toward the panel. The board passes a glue dispensing roller which coats the edge of the board with hot glue. Once the panel passes a micro switch the guillotine cuts the tape and the pressure roller is released. The tape is applied to the panel by pressure rollers.

4. **Control panel.**
The control panel starts and stops the various functions of the machine. It also houses the machine alarms.

5. **Hinged cover.**
The cover is lifted when access to the workings of the machine is required. It is supported by two gas-filled supports. When the cover is lifted, the power is removed from the machine by a safety micro-switch.

6. **Gluing system.**
The machine uses unglued tape, and heated glue is applied to the panel by the glue roller that is part of the glue pot assembly. The tape is then guided and pressed onto the edge of the panel by pressure rollers.

7. **End trim unit.**
The end trim unit cuts the excess tape from the panel automatically as the panel passes the station. It has two rotating cutters that cut the tape flush with the edge of the panel.

8. **Tape-trimming system.**
The machine has an automatic tape-trimming system that cuts the tape level with the top and bottom faces of the panel. As the panel passes the unit, the cutters are aligned vertically by copy pads. The cutters then remove the excess tape. The cutters vertical position to the copy pads is adjustable to suit the cutter being used and ensure a flush edge.

9. **Emergency stop button.**
10. Dust extraction port.
The dust collection port is diameter 4 in and is located at the end of the machine. You will need a dust collection system with a minimum airflow of 65 feet per second and 1000 cubic feet per minute. **Note:** The stronger the dust collector the better. Sawdust and dirt must be removed from the machine to ensure that the machine functions correctly.

11. Panel thickness adjustment handle.

12. Panel feed system.
The panel feed system is comprised of a rubber caterpillar drive belt with rubber freewheeling rollers above which keep the panel pressed onto the drive belt. The caterpillar drive belt pulls the panel past the various functions of the machine. The rubber rollers are vertically adjustable to accommodate different thicknesses of panels and have a numeric readout. The speed of the drive belt is fixed.

13. Extendable panel support.

14. Pneumatic system.
The pneumatic control system consists of a number of valves and control switches that are located inside the machine and are accessible if you lift the cover of the machine. A consistent dry clean supply pressure of 6.5 bar minimum is required for the machine

15. Access panels.
The conveyor drive system is located behind the access panels.
What you will receive with the machine.

Tape support table
Spare rive belt
Tape support table rollers
Tape support table arm
Tool box & tools

Where to locate your machine.
Before you remove your machine from the pallet, select the area where you will use your machine. There are no hard and fast rules for its location, but below are a few guidelines:
1. There should be an area at the front of the machine suitable for the length and width of panel that you will be edging.
2. There should be sufficient area at the back of the machine to allow access for adjustments and maintenance to be conducted.
3. Adequate lighting. The better the lighting the more accurately and safely you will be able to work.
4. Solid floor. You should select a solid flat floor, preferably concrete or something similar.
5. Locate close to power source and dust collection.
6. Allow an area for the storage of blanks and finished panels.
Unpacking your machine.

To unpack your machine, you will need tin snips, knife, star screwdriver and a wrench.

1. Using the tin snips, cut the banding that is securing the packing box [If fitted].
   WARNING: EXTREME CAUTION MUST BE USED BECAUSE THE BANDING WILL SPRING APART AND COULD CAUSE INJURY.
2. Dismantle the box
3. Using the knife cut the plastic wrap. The tape support table and accessories that were ordered are in the box.
4. Remove the base mounting bolts that secure the machine to the base of the box.
5. It is recommended that the machine be removed from the pallet by lifting it with a hoist or forklift. Remove the pallet and lower to the floor. The machine can be lifted using a forklift truck, the forks lifting the machine between the feet of the machine or by using a "SLING" with a lifting capability of 2000 Kg [4400lb]
   Note: Four lifting eyes are provided. They are located at the corners of the machine.
   Note: The machine is heavy; ensure that you have sufficient people.
   Note: If you have any doubt about the described procedure, seek professional assistance. Do not attempt any procedure that you feel is unsafe or that you do not have the physical capability of achieving.
Assembly and setup.

Leveling the machine.
The machine is provided with 4 leveling bolts. Move your machine to its final position and, using a spirit level on the table, adjust the leveling bolts so that the table is level in both directions. Ensure that the machine does not rock. The machine is also provided with 4 holes to bolt the machine to the floor [bolts not provided]. If you decide to bolt the machine to the floor, you must level the machine with the leveling bolts but do not overtighten the clamping bolts as they could damage the base of the machine.

The machine comes mostly assembled. You will have to assemble only the tape support table.

Assembling the tape support table.

1. Assemble the support arm to the body of the machine.
2. Assemble the shaft into the arm.
3. Place the tape support table onto the shaft and check that it rotates freely.
4. Assemble the 4 rollers on the table.
5. Place a straight edge on the table and the top of the machine table.
6. Adjust the tape support table until it is level with the bottom of the tape support guide.
7. Fully tighten the clamp screws.
8. Check that the tape support table rotates freely.

**Connecting air to the machine.**

The machine is supplied with a number of air regulators. The input air regulator regulates the air pressure that is supplied to the machine.
The other regulators regulate various functions of the machine.

**Connecting the air supply.**

The machine is supplied with an air connector, which you can connect your air supply to. You will require an air supply that can deliver a constant minimum pressure of 6.5 bar. The machine is supplied with an input air regulator that you will need to adjust to 6.5 bar once you have connected your air supply to the machine.

**Note:** No air pipe is supplied, as the length will be dependent on your installation.
To adjust the air pressure, pull the cap out and rotate until the pressure on the gauge reads the correct pressure. Once the pressure is adjusted, push the cap in. **Note:** An air supply of 6.5 bar minimum is required for the machine. It is strongly recommended that 7 bar be supplied to the machine and that the regulator then be set to 6.5 bar. This will ensure that the machine always has the minimum required air pressure. The input regulator has a moisture trap that must be emptied each day.

**Note:** It is important that the air that is supplied to the machine be clean and dry. The machine will not perform consistently if the air is dirty, as any dirt will block the valves. Wet or damp air will damage your machine and cause inconsistent performance. **Note:** The pneumatic system does not need any type of lubricant. Some types of lubricant can damage the machine and compromise the machine’s functions. **Note:** During maintenance always disconnect the air supply.

**Connecting the electrical supply.**

**Note:** A qualified electrician must carry out the installation. Ensure that the main supply corresponds with that of the machine [Three-phase 220 V]. It is recommended that you use a 30-amp mains breaker. If you need a longer cable than that supplied on the machine, you can connect a new cable into the internal power termination point, which is located behind the front cover.
Note: The machine is not supplied with an electrical plug, as the type of plug will be dependent on the installation.

**Dust collection.**

The machine has a dust extraction port. It takes a 4” diameter hose and needs to be connected to a dust collector with a capacity of 1,000 cubic feet per minute min and a velocity of 65 feet per min [The stronger the dust collector, the better].

Note: Two things are very important to ensure that the machine performs consistently. One is the cleanliness of the machine [the other is a clean dry air supply]. If the dust and chips that are produced by the cutters on the machine are not removed, they will jam or block the various switches and micro-switches. It is therefore important that the dust collection works efficiently and is of sufficient power to remove all the dust and chips from the machine.

**Cleaning the machine.**

Remove the rust protection grease with WD 40 or a similar solvent. It is important that you remove all the grease and relubricate with a Teflon based lubricant. Teflon has fewer tendencies to attract sawdust and cause clogging.
Operating and adjusting the machine.

Electrical control panel.

1. Conveyor, glue heat start switch
   This switch will start the conveyor operating, providing that the safety switches have been made. **This also switches on the glue pot heating element.**

2. Emergency stop switch
   This switch, when fully pressed in, will stop the conveyor and other electrically controlled functions. The machine will not start if the switch is in the off position. To reset the switch, rotate and the switch will pop out.
Should your machine not start, check that the stop switch is in the fully out position.

3. **Top and bottom cutters switch.**
   This switch starts the top and bottom cutters.

4. **Glue temperature controller.**
   This controls the temperature that the glue pot is set to.

5. **End trim switch.**
   This switch starts the end trim unit.

6. **Glue heat off switch.**
   This switch turns the heating off in the glue pot.

7. **Power off.**

8. **End trim alarm.**

9. **Low air pressure alarm.**

10. **Low glue temp. alarm.**

11. **Power on light.**
   This light indicates that the machine is switched on.

**Main isolation switch.**
This switch isolates the machine’s electrical system from the incoming electrical supply. If you are conducting maintenance work or require access to any of the electrical components of the machine, you must isolate the machine from the electrical supply. The main isolation switch must be in the off position. The air supply must also be disconnected.

![Main isolation switch](image)
**Tape selection.**
The height of the tape that you select for your panels will depend on availability from your supplier. Suppliers carry tapes for most common thicknesses of panel. It must be noted that the maximum that the top and bottom trimmer can remove is 2mm [each side]. Always allow for overhang on both the topside and the bottom side of the panel as no machine will apply the tape perfectly and a small amount will always have to be cut off the finished panel.

**Tape feeding mechanism.**
The tape feed systems function is to feed the tape at the correct time onto the board and to cut the tape so that a small section extends from the back of the board.

**Setting up the tape feed system.**
1. Feed the tape through the two tape guides. Adjust the top sliding blocks so that the tape is free to move and that there is a clearance of approximately 1/64in between the tape and the block.
2. Adjust the tape pressure plate so that the tape is pushed against the support plate firmly but not so tight that the tape is not free to move with ease.
3. Adjust the tape guide that is on the panel side of the guillotine so that the tape is free to move and that there is a clearance of approximately 1/64 in between the tape and the block.

4. Once all the tape adjustments have been made, pull the tape back so that it extends through the guillotine by approximately ¼ in.

5. The distance that the tape overhangs the edge of the panel can be adjusted by repositing the micro-switch. It is suggested that 1/2” is approx. correct overhang front and back. The machine comes factory-set and no adjustment should be required.
**Tape drive roller.**
The tape feed mechanism is activated and stopped by the tape activation micro switch. As the panel hits the micro-switch the air cylinder is activated and this clamps the tape between the drive roller and the pressure roller. The drive roller pushes the tape so that it lines up with the panel. Once the panel trailing edge passes the micro-switch, the guillotine is operated and the air cylinder is retracted, removing the drive from the tape.

**Drive roller pressure adjustment.**
To adjust the air pressure regulators, pull the plastic cap out, twist until the required pressure is set on the gauge and push the cap in. The pressure that is applied to the tape varies depending on the tape thickness and stiffness. This cannot be defined and will come with experience. It is recommended that you set the pressure between 2 to 2.5 bar: 2 bar for thin flexible tape and 2.5 bar for thick stiff tape.

**Guillotine pressure adjustment.**
An air regulator valve controls the guillotine air pressure. By adjusting the valve, the guillotine will move faster or slower. If the guillotine will not cut the tape, you may have to increase the air pressure to the cylinder, but before you adjust the valve, check that the knives are clean, free from glue residue and sharp. The above are the most common causes for the tape not being cut. Also check that the blade guide tracks are clean and lubricated. Only adjust the valve in small steps, and then test the cutting action. Screwing in decreases the air pressure, unscrewing increases the air pressure.
Note: With too much pressure the guillotine may remain open; and with insufficient pressure it may stay closed. The recommended starting pressure is 4 bar.

**Guillotine forward and back adjustment.**
The guillotine assembly is mounted on slots. When the clamping screws are loosened, the assembly can be moved forward and back. You will have to re-centralize the guillotine if you have removed the assembly from the machine for any reason. This movement allows the tape to be centered in the machine tape feed track. In most cases the guillotine is not adjusted as the guide rods ensure that the tape is guided centrally into the track. Do not rely on the guide rods to do all the work; if the guillotine is off center there will be extra drag on the tape that could cause feeding problems.

**Glue application.**

The machine applies heated glue to the edge of the panel with a rotating roller. The glue roller will only rotate when the glue has been heated to the pre-
set temperature and is liquid. It takes approx. 20 minutes to heat the glue. It is recommended that the heater is switched on at least 30 minutes prior to requiring the machine for production. The additional 10 minutes allows the glue temperature to stabilize. As the glue is used, additional glue can be added by removing the lid [as shown] and pouring in additional glue granules. The lid must be kept on the glue pot at all times to stop the ingress of dirt, sawdust, etc. Any dirt, etc. that is in the glue will affect the final glue bond and could damage the glue pot mechanism.

The glue roller can be adjusted forward and back to suit the amount of pressure that is exerted on the side of the panel. This is achieved by adjusting the glue pot sideways. The support shaft is at an angle to the conveyor, and moving the assembly laterally will adjust the roller forward and back.

The amount of glue that is applied to the panel is controlled by an adjustment knob located at the back of the yellow guard.

To check that the tape feed mechanism is functioning correctly, test the system with a scrap panel.

**Adjusting the glue temperature.**

The glue temperature controller comes factory set at ???Degrees C

This will suit most glues, but should you need to adjust the temperature, adjust as follows.

1. Press the green set button.
2. Press the up or down arrow until the required temperature is displayed.
3. Press and hold the green set button until the display stops flashing.

**Note:** Allow the glue pot to stabilize at the new temperature before running production.
**Adjusting the glue roller forward and back.**
The glue roller must be between 1mm - 2mm forward of the guide fence.
The machine comes factory-set, but should adjustment be required, adjust as follows:
1. Place a straight edge on the fence and push it along until it contacts the glue roller.
2. Check the amount of deflection of the roller when the straight edge contacts the glue roller.
3. If adjustment is required, loosen both lock nuts, one either side of the glue pot. Adjust the glue roller adjustment shaft and lock the lock nuts in place.
4. Recheck the deflection only with the lock nuts tight.

**Adjusting the glue volume.**
For most common jobs the glue volume will be constant. If the panel is very porous, thick, non porous, etc. you will have to adjust the amount of glue that is on the roller. To achieve this, the glue pot assembly has a built-in wiper that is an adjustable distance from the roller. To adjust this distance simply turn the adjustment knob that protrudes through the yellow guard.

*Note:* For dense panels you will need less glue, and for porous panels you will need more glue. If insufficient glue is applied to the panel edge, the tape may not adhere correctly, and if too much glue is applied, it will squeeze out top and bottom, which will gum up the cutters. It is far better to take the time to adjust for the job in hand and apply the correct amount of glue rather than spend extra time cleaning cutters or replacing unglued tape.

*Note:* After adjustments it is recommended that you run a test panel prior to production to check that the adjustments are correct.
**Pressure rollers.**
An air regulator controls the pressure that the rollers exert on the side of the panel. To adjust the pressure, pull the cap out, rotate until the correct pressure is shown on the gauge and push the cap in.

The pressure that is applied to the side of the panel varies depending on the tape thickness, width and stiffness. This cannot be defined and will come with experience. It is recommended that you set the pressure between 2 to 2.5 bar: 2 bar for thin flexible tape, and 2.5 bar for thick stiff tape

**Note:** Too much pressure will cause the tape to wander up and down on the panel edge. Too little pressure will cause a poor glue joint.
Top and bottom trimming.

The machine trims the excess tape from the top and the bottom of the panel with two cutter heads that are controlled by copy pads. The distance the cutters are to the panel is adjusted with two adjusting bolts located at the back of the machine behind a guard cover. The cutter teeth are radiused, and moving the cutter heads in or out adjusts the distance between the cutter teeth and the side of the panel. This is factory-set and should not need adjustment. When you run your first panel through the machine, check if the cutters are trimming the tape to the correct radius and, if required, adjust with the adjusting bolts at the back of the machine.

Note: You will have to remove the guard cover to gain access to the in out adjusting bolts and extreme caution must be exercised when adjusting as your hands will be exposed to the belts.

Note: Only adjust the cutter adjusting bolts with the machine running.
**Top and bottom trimmer adjustment.**

The copy pads can be adjusted vertically to move the cutters closer/farther away from the panel.

To adjust the height:

1. Open the conveyor to max.
2. Loosen the front clamp screw and turn the adjustment screw either up or down after loosening the lock nut.
3. Tighten the lock nut and clamp screw.
4. Repeat for the other copy pad.

**Note:** Test on scrap panel prior to running production.

**Conveyor height adjustment.**

The conveyor height counter reads in metric. Below is a handy reference to convert to inches:

- \( \frac{1}{4} \text{ in} = 6.35 \text{ mm} \)
- \( \frac{3}{8} \text{ in} = 9.53 \text{ mm} \)
- \( \frac{1}{2} \text{ in} = 12.7 \text{ mm} \)
- \( \frac{5}{8} \text{ in} = 13.34 \text{ mm} \)
- \( \frac{3}{4} \text{ in} = 19.0 \text{ mm} \)
- \( 7/8 \text{ in} = 22.2 \text{ mm} \)
- 1 in = 25.4 mm

When adjusting the conveyor, always move the conveyor down past the dimension required and then move it up to the required height.

The panel being edged should be a snug fit between the conveyor and the bed of the machine. If the panel is too loose, the panel will move away from the pressure rollers and the edging will not be applied with sufficient force. If the panel is too tight, the conveyor belt could be damaged or the conveyor stall.

You will soon gain the experience to know the correct height for each type of panel. A handy way to check if the conveyor is set to the correct height is to push a panel in a short distance under the conveyor and pull it from side to side. The panel should hold firmly and not be easy to move.
Note: If the conveyor is too tight, the conveyor belt could be damaged or the conveyor stall.

Guide fences.
The fence must be in alignment with the steel pressure rollers. The rollers are the datum and not the fence. To check that the fence is lined up correctly cut a short length of tape and place it in front of the rollers. Using a straight edge pushed up hard against the fences, check that the steel rollers are snug and that there is resistance to rotation. Should adjustment be required, loosen the fence clamp bolts to align the fences and retighten the bolts.

If you are using very thick tape, you may find that you have to adjust the fences to suit the new tape thickness.

Panel support rail.
The panel support rail can be pulled from the side of the machine to support wide panels. The yellow rollers should be level with the top of the conveyor. If adjustment is required, place a straight edge across the width of the conveyor and onto the top of the yellow rollers. Loosen the central allen screw on both the support arms and adjust the lower jacking screw until the yellow rollers are level with the conveyor. Reclamp the central allen screw.

Panel spacing stop.
If the panels are fed through the machine too close together, the end-trim unit has an insufficient gap to work. A minimum gap
between the panels is 2 feet [600mm]. A piston stop is provided that is controlled by a micro-switch and ensures that the correct spacing is maintained. Do not try to force panels past the stop or hit it with panels; it will become damaged.

**End trim.**
The end-trim unit cuts the edging tape flush with the panel. As the panel progresses along the machine, it contacts a micro-switch that activates the air cylinders. The cutter units retract until they reach electronic eyes that stop the outward movement of the pistons. As the panel hits a micro-switch, the lower cutter head moves up until it contacts the panel and cuts the excess tape. As the trailing edge of the panel releases the micro-switch, the upper cutter unit moves down, cutting the excess from the rear of the panel.
The machine comes factory-set. Should adjustment be required, adjust as follows:

**Cutter not traveling with sufficient speed or too fast.**
The cutters are moved by air pistons. They each have two sets of regulators.

1. **Control panel air gauges and regulators [A&B].**
   These control the pressure that the air cylinder receives and are the main adjustment. **Note:** Set the end-trim gauges to 4 bar. The pressure may be increased to speed the cutting action of the
cutters, but it must be noted that the faster the cutting action, the poorer the finish that the cutters will produce. Also, if the speed of cutting is too fast, there is a danger of damaging the glue joint. Gauge C is the master supply gauge regulator and should be set at 6 bar.

2. Air flow regulators [D].
These are located on the air pistons and regulate the rate of flow that the piston receives. Once the air flow regulators are set, they should not be adjusted unless unavoidable.

Cutter not square with the edge of the panel.
If the cutter is not cutting the tape square with the panel, loosen the ratchet handle, adjust the cutter head, and reclamp. **Note:** Adjust in small steps and check by processing a scrap panel.

Cutter not cutting the tape flush with the panel.
If the tape is not flush with the panel or the cutters are cutting into the panel, adjust the cutter head in/out with the adjusting screw. **Note:** Adjust in small steps and check by processing a scrap panel.
Before you start to process panels, read the following:
It is simple to get good results from your machine, but it is necessary for you to ensure that the following points are always adhered to:

1. Panel quality.
The panel must be of good quality with sufficient density. The panel edge MUST be at 90 degrees. If the panel edge is not at exactly 90 degrees, the pressure rollers will not be able to press the tape onto the edge of the panel and a poor joint will result.
The panel edge must not have a ledge from the scoring blade. If the scoring blade on your panel saw is set so that it cuts a ledge, the tape will not stick to the under cut ledge and the tape will be loose in this area.
The panel edge must be clean and free from dust, dirt, oil, humidity, or other contaminants. If the edge has been contaminated the glue on the edge banding will not stick and a poor joint will result.
The edge of the panel must be straight to within 0.1mm [0.004 in].
The edges must be chip free. The edge banding cannot fix a chipped panel and you will be wasting time and money.

2. Edgebanding tape.
Always use a good quality tape from a reputable supplier. The better the tape, the better the finished panel and the less time spent on the job.
Always store the rolls of tape flat in a cool dry environment. If the tape is not stored flat, the roll may become distorted and may have to be scrapped.
Check the manufacturer’s date on the roll. Always use the first-in first-out principle when using your tape stock.

3. Glue.
Always conduct a test to check that the temperature that you have set the machine to is correct. A simple test is to apply the tape to a test panel and after about one minute using pliers, pull the tape off. The tape should be adhered to the panel evenly along its length and evenly across its width. The tape should have particles of the panel stuck to it over the complete length and width.

Always turn the main isolation switch to the off position disconnect the electrical supply and disconnect the air supply before conducting any adjustments or maintenance.
Your machine is provided with many adjustments and setting changes that can be made to optimize performance. All the adjustments and settings have been set at the factory during assembly and testing. Unless the settings and adjustments have moved during shipping, the machine should perform with in specifications and no adjustments should be required. During the life of the machine fine-tuning will have to be made from time to time, and the procedure that should be followed for each adjustment and setting are detailed earlier in the manual.

**Check that the machine has been set to suit the current job.**

Is the conveyor set at the correct height?
Are the tape tracks set to the correct height and the tape free to move smoothly?
Is the glue pot set at the correct temperature?
Are the dust hoses clear of any obstructions and the dust collection working efficiently?
Is the machine clean and free from dirt or saw dust?
Are the rollers and fences clean and free of glue?
Is the air pressure set at the correct pressure?
All other machine settings have been adjusted at the factory when testing the machine and should give you a good high-quality product. If adjustments need to be made because one or more of the settings have been moved during transportation, then only change one setting at a time. If the change will not correct the fault, then return that setting to its original position and go to the next adjustment.
Always allow the glue pot to stabilize after making adjustments to the temperature.
Maintenance.

Always turn the main isolation switch to the off position, disconnect the electrical supply and disconnect the air supply before conducting any adjustments or maintenance.

Lubrication.
It is recommended that you use a Teflon-based lubrication on your machine as it tends to dry and will reduce the amount of sawdust buildup on the machine. Teflon lubricants are available from most leading hardware stores.

Maintenance guide.

<table>
<thead>
<tr>
<th>Item</th>
<th>Schedule</th>
<th>Action</th>
</tr>
</thead>
<tbody>
<tr>
<td>Convoyor belt.</td>
<td>Weekly or when dirty.</td>
<td>Wipe clean. Remove any glue.</td>
</tr>
<tr>
<td>Fences.</td>
<td>Weekly or when dirty. Make sure that they are always clean.</td>
<td>Wipe clean and remove any glue. Do not use any lubricant as this can weaken the tape adhesion.</td>
</tr>
<tr>
<td>Steel rollers.</td>
<td>Weekly or when dirty.</td>
<td>Wipe clean and remove any glue. Do not use any lubricant as this can weaken the tape adhesion.</td>
</tr>
<tr>
<td>Rubber rollers.[Above the conveyor].</td>
<td>Weekly or when dirty.</td>
<td>Wipe clean and remove any glue.</td>
</tr>
<tr>
<td>Rough cut guillotine knives.</td>
<td>Weekly or when dirty.</td>
<td>Clean with solvent and check for sharpness, any damage [nicks, etc.] and replace or resharpen if required. Lubricate with WD40 or Teflon lubricant.</td>
</tr>
<tr>
<td>End trim cutter.</td>
<td>Weekly or when dirty.</td>
<td>Clean with solvent and check for sharpness, any damage [nicks, etc.] and replace or resharpen if required. Make sure that there is no buildup of glue on the cutter. A little spray with Teflon or WD40 helps to prevent buildup.</td>
</tr>
<tr>
<td>Equipment</td>
<td>Frequency</td>
<td>Maintenance</td>
</tr>
<tr>
<td>---------------------------------------</td>
<td>--------------------</td>
<td>---------------------------------------------------------------------------------------------------------------------------------------------</td>
</tr>
<tr>
<td>Top and bottom cutters.</td>
<td>Weekly or when dirty</td>
<td>Clean with solvent and check for sharpness, any damage [nicks, etc.]. If required, replace cutter inserts.</td>
</tr>
<tr>
<td>Top and bottom cutter drive belt.</td>
<td>Weekly</td>
<td>Check for damage or wear. If required, replace belt.</td>
</tr>
<tr>
<td>Copy pads.</td>
<td>Weekly or when dirty</td>
<td>Clean the panel contact surfaces.</td>
</tr>
<tr>
<td>Dust collection.</td>
<td>Weekly</td>
<td>Check that all dust chutes and hoses are clear and free from buildup. Clear any blockages. This is the most common cause of any issues with your edgebander. Proper dust collection with a high static pressure is needed. Keep your machine clean and blow down with compressed air regularly.</td>
</tr>
<tr>
<td>Airline water separator.</td>
<td>Daily</td>
<td>The pneumatic system is extremely reliable. The machine is supplied with a small water separator on the input regulator; drain daily. We highly recommend that a compressed air dryer be used, as this will greatly enhance the longevity of the pneumatic system and your machine.</td>
</tr>
<tr>
<td>Pneumatic system.</td>
<td>Monthly</td>
<td>Spray a small amount of WD40 into the pneumatic line from the exterior air regulator.</td>
</tr>
<tr>
<td>Clean machine.</td>
<td>Weekly or more often if required</td>
<td>Blow down with an airline and wipe clean. Check that there are no small pieces of scrap that could jam any of the switches or mechanisms.</td>
</tr>
</tbody>
</table>
**Rough cut guillotine blades.**
When sharpening the blades, sharpen on the cutting edge only and never on the thickness.
When you are reassembling, ensure that the tape guides parts are adjusted to guide the tape centrally into the machine tape-feed guide.

**Replacing the top and bottom cutter drive belt.**
Remove the guard. Lift the motor to take the weight off the drive belt. Remove the belt and replace with belt as shown. No tensioning is required as the weight of the motor keeps the belt tensioned.

**Replacing the cutter blades in the top bottom trimming unit.**
1. With the power disconnected from the machine, remove the top dust chute.
2. Remove one of the blade clamp screws and the cutter blade.
3. Replace the blade clamp in position with the clamp screw.
4. Continue until all the cutter teeth both top and bottom are changed and replace the dust chute.

**Note:** When replacing the blades, ensure that there is no dirt sawdust in the blade pocket. If dirt is present, the teeth will not be all set to the same height.
**To reset the internal breakers.**

Remove the fixing screws from the front cover.
Remove the screws from the electrical box.
Check the breakers and reset if required
Re-assemble the electrical box cover and the front cover.

**Note:** There is a micro-switch on the side of the box that will remove the electricity from the electrical box. This should never be relied on, so ensure that the power and air have been disconnected prior to opening the electrical box.

**Note:** The micro switch will have to be held back while the electrical box cover is closed.

**Conveyor drive system.**
There is very little maintenance that needs to be conducted on the conveyor drive system, apart from cleaning and lubricating the chain periodically.
Trouble-shooting:
Check the list below to try and remedy the fault before contacting your supplier technical department for advice.

Note: The most common cause of faults with edgebanding machines is:
1. Water or dirt in the air system. Check that the water trap on the machine is emptied daily and that the machine is supplied with clean dry air.
2. Dirt or small pieces of edgebanding jamming switches or air cylinders.
If you keep your machine clean, supplied with clean dry air and conduct regular preventive maintenance, your machine should give you many years of trouble-free service.

Always turn the main isolation switch to the off position, disconnect the electrical supply and disconnect the air supply before conducting any adjustments or maintenance.

Troubleshooting guide.

<table>
<thead>
<tr>
<th>Problem</th>
<th>Cause</th>
<th>Corrective action</th>
</tr>
</thead>
<tbody>
<tr>
<td>Tape jams and is either late to meet the board or misses the board.</td>
<td>Tape support table not level with the machine tape feed track.</td>
<td>Readjust tape support table.</td>
</tr>
<tr>
<td></td>
<td>Tape-feed pinch roller too loose; tape slipping</td>
<td>Adjust tension on tape-feed pinch pressure roller.</td>
</tr>
<tr>
<td></td>
<td>Tape guide track too tight [tape-feed table and or machine tape-feed tracks].</td>
<td>Adjust tape-feed tracks so that the tape is free to move smoothly in the track/s.</td>
</tr>
<tr>
<td></td>
<td>Tape-guide tracks are damaged.</td>
<td>Replace tape-guide tracks.</td>
</tr>
<tr>
<td></td>
<td>Glue buildup in the tape-feed tracks.</td>
<td>Clean tape-feed tracks.</td>
</tr>
<tr>
<td>Tape not cut by the rough-cut guillotine.</td>
<td>Knives dull or damaged.</td>
<td>Sharpen or replace the knives.</td>
</tr>
<tr>
<td>Issue</td>
<td>Cause</td>
<td>Solution</td>
</tr>
<tr>
<td>--------------------------------------</td>
<td>-----------------------------------------------------------------------</td>
<td>--------------------------------------------------------------------------</td>
</tr>
<tr>
<td>Guillotine air pressure too low.</td>
<td>Check the air regulator is set to 6.0 bar. If OK, adjust guillotine air pressure. See adjustment section.</td>
<td></td>
</tr>
<tr>
<td>Tape rides up or drops down on the board edge.</td>
<td>The tape-feed pinch roller too tight.</td>
<td>Adjust pinch roller pressure.</td>
</tr>
<tr>
<td></td>
<td>Excessive vertical clearance in the tape-feed tracks.</td>
<td>Adjust tape-feed tracks height.</td>
</tr>
<tr>
<td></td>
<td>Insufficient conveyor to panel pressure.</td>
<td>Check that the panel is held firmly when clamped by the conveyor. If the panel is not held firmly and presses the edge of the panel onto the fences and rollers, the tape can wander up and down on the panel. If required, readjust conveyor height.</td>
</tr>
<tr>
<td>Tape too short at rear of panel</td>
<td>Tape sticking in the tape-feed tracks.</td>
<td>Clean tape-feed tracks and or adjust track height.</td>
</tr>
<tr>
<td>Tape too high above the panel after top bottom trimming.</td>
<td>Cutters need adjusting.</td>
<td>Adjust copy pads.</td>
</tr>
<tr>
<td>Panel cut by top or bottom cutters.</td>
<td>Cutters need adjusting.</td>
<td>Adjust copy pads.</td>
</tr>
<tr>
<td>Poor finish on tape after trimming with top bottom cutters.</td>
<td>Cutters dull or gummed with glue.</td>
<td>Clean off glue with solvent or replace cutters.</td>
</tr>
<tr>
<td>Top or bottom cutters cut into the</td>
<td>Copy pads are not set at correct height.</td>
<td>Adjust copy pads level. See adjusting section.</td>
</tr>
<tr>
<td>Issue Description</td>
<td>Problem Description</td>
<td>Solution</td>
</tr>
<tr>
<td>----------------------------------------------------------------------------------</td>
<td>--------------------------------------------------------------------------------------</td>
<td>-------------------------------------------------------------------------</td>
</tr>
<tr>
<td>Tape bent over on top of the panel or not cut off cleanly.</td>
<td>Tape too wide for the panel.</td>
<td>Change the tape to the correct width of tape. The tape must be a maximum of 2mm above and below the panel.</td>
</tr>
<tr>
<td>The copy pads mark panel.</td>
<td>Copy pads dirty or have glue on them</td>
<td>Clean copy pads.</td>
</tr>
<tr>
<td>Board twists, binds or stops at any point during run.</td>
<td>Feed conveyor too loose.</td>
<td>Readjust conveyor height.</td>
</tr>
<tr>
<td></td>
<td>Feed conveyor too tight.</td>
<td>Adjust conveyor height.</td>
</tr>
<tr>
<td>Tape not stuck to edge of panel</td>
<td>Edge of panel not square.</td>
<td>Recut panel square.</td>
</tr>
<tr>
<td></td>
<td>Edge of panel not straight.</td>
<td>Recut panel straight.</td>
</tr>
<tr>
<td></td>
<td>Fences not in alignment.</td>
<td>Realigns fences. See adjustment section.</td>
</tr>
<tr>
<td></td>
<td>Rollers not in alignment.</td>
<td>Realigns rollers.</td>
</tr>
<tr>
<td></td>
<td>Glue temperature not correct.</td>
<td>Reset glue pot temperature.</td>
</tr>
<tr>
<td></td>
<td>Glue old or faulty.</td>
<td>Replace glue in glue pot once all old glue is removed.</td>
</tr>
<tr>
<td></td>
<td>Insufficient glue</td>
<td>Adjust glue roller.</td>
</tr>
<tr>
<td>Machine will not start or stops during operation.</td>
<td>Tripped circuit breaker [External to the machine or internal].</td>
<td>Typical causes are: dull or gummy cutters, jammed cutter head, conveyor jammed, etc. Clear the fault and reset breaker.</td>
</tr>
<tr>
<td>Machine will not start.</td>
<td>Safety switch/s not made.</td>
<td>Reset safety switch/s. [cover and electrical box]</td>
</tr>
<tr>
<td>Machine not plugged into the electrical supply.</td>
<td></td>
<td>Connect machine to electrical supply.</td>
</tr>
<tr>
<td>Condition</td>
<td>Action</td>
<td></td>
</tr>
<tr>
<td>------------------------------------------------</td>
<td>--------------------------------------</td>
<td></td>
</tr>
<tr>
<td>Isolation switch not turned on.</td>
<td>Turn isolation switch to on-position.</td>
<td></td>
</tr>
<tr>
<td>Mains breaker tripped.</td>
<td>Reset breaker.</td>
<td></td>
</tr>
<tr>
<td>Machine internal breaker tripped.</td>
<td>Reset internal breaker.</td>
<td></td>
</tr>
<tr>
<td>Electrical box micro switch not set.</td>
<td>Readjust electrical box micro-switch.</td>
<td></td>
</tr>
<tr>
<td><strong>Pneumatic system is sticky or erratic.</strong></td>
<td><strong>Dirt or water in the pneumatic system.</strong></td>
<td></td>
</tr>
<tr>
<td>[Air cylinder sluggish, micro switch sticky, etc.,]</td>
<td><strong>Supply machine with clean dry air. Remove airline and squirt a small amount of WD40 into the air connector. Cycle the machine 10 times and if required repeat.</strong></td>
<td></td>
</tr>
</tbody>
</table>
Electrical drawing schematic

Electrical drawing block diagram

Pneumatic drawing schematic.

Pneumatic drawing Block diagram.

Exploded view drawings

Spare parts
Ordering spare-parts
When ordering spare parts specify:
Machine Model
Part number required, taken from the exploded view drawings and parts lists on the following page.
Quantity required
EXAMPLE. To order a Guillotine knife.
Model. Bandit edgebander.
Part description. Guillotine knife.
Part number. 110598 – K2530.
Quantity. 1 piece