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Safety Rules

As with all machinery, there are certain hazards involved with the operation and use of your machine. 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 relating 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 ensure adequate lighting is available.
2. Do not wear loose clothing, gloves, bracelets, necklaces or ornaments.
3. Do wear face, eye, respiratory and body protection devices as indicated for the operation or environment.
4. Ensure that the power is disconnected from the machine before tools are serviced or an attachment is to be fitted or removed.
5. Never leave the machine with the power on.
6. Do not use dull, gummy or cracked cutting tools.
7. Ensure 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 may impact the level of ambient noise. It is also possible that exposure level limits will vary from country to country.

 Specification sheet

<table>
<thead>
<tr>
<th>Specification</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Minimum panel thickness</td>
<td>0.375&quot; [10mm]</td>
</tr>
<tr>
<td>Maximum panel thickness</td>
<td>1.58&quot;[40mm]</td>
</tr>
<tr>
<td>Minimum panel width</td>
<td>3.5&quot;[90mm]</td>
</tr>
<tr>
<td>Minimum panel length</td>
<td>7.875&quot; [200mm]</td>
</tr>
<tr>
<td>Edgebanding thickness</td>
<td>0.0165 to 0.125&quot;[0.4 to 3mm]</td>
</tr>
<tr>
<td>Glue tank capacity</td>
<td>4 pints [2lt]</td>
</tr>
<tr>
<td>Feed speed</td>
<td>26 ft/min [8mt / min]</td>
</tr>
<tr>
<td>Installed motor power</td>
<td>8.7hp [6.5Kw]</td>
</tr>
<tr>
<td>Compressed air</td>
<td>6.5 bar</td>
</tr>
<tr>
<td>Weight</td>
<td>1500lb [680 kg]</td>
</tr>
<tr>
<td>Overall size</td>
<td>1870lb[850kg]</td>
</tr>
<tr>
<td>Overall dimensions</td>
<td>90&quot; x 31.5&quot; x 63&quot;[2300mm x 800mm x 1600mm]</td>
</tr>
<tr>
<td>Packing dimensions [Approx]</td>
<td>95&quot; x 35.5&quot; x 39&quot;[2400mm x 900mm x 1000mm]</td>
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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. Ensure 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 possibly tested again by Laguna Tools. Laguna Tools endeavors 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.
1. **Extendable panel support**  
This is a rail that can be extended and locked in position to support boards of various widths.

2. **Panel feed system.**  
The panel feed system is composed of a rubber caterpillar drive belt with rubber freewheeling rollers above that 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.

3. **Control panel**  
The control panel starts and stops the various functions of the machine.
4 & 7. **Tape feed system**
The board passes a glue-dispensing roller, which coats the edge of the board with hot glue.
The tape is fed from the tape support table where it is free to rotate. The tape is guided through a “U” bracket assembly to the tape stop in the area of the cutoff guillotine. The tape is stationary at the stop until the panel is fed into the machine. The movement of the panel pushes the tape onto the pressure roller, clamping the tape to the panel. Once the panel passes the micro-switch, the guillotine cuts the tape, and the pressure roller is released. The tape is applied to the panel by pressure rollers.

5 & 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.

8. **Panel thickness adjuster**
The machine is adjustable for different thicknesses of panel, and the control handle adjusts both ends of the panel pressure roller system through a control shaft and two right-angle gearboxes.
9. **End trim unit**
The end trim unit cuts the excess tape from the panel automatically as the panel passes the station. It has carbide cutter heads that cut the tape flush with the edge of the panel.

10. **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.

11. **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.

**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.
**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. No cable is provided for connection to your electrical supply, as this will depend on your electrical system.

**Dust extraction port**
The machine has a dust extraction port. It takes a 4-inch diameter hose and needs to be connected to a dust collector with a capacity 2000 CFM - 15" static pressure. Note: some machines are supplied with a 5-inch dust port. **Note:** The stronger the dust collector, the better. Sawdust and dirt must be removed from the machine to ensure that the machine functions correctly.

**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 off the machine. A consistent dry clean supply pressure of 6.5 bar minimum is required for the machine.

**Access panels**
The conveyor drive system is located behind the access panels.

**Data plate**
There is a data plate which lists all the relevant machine data on the end panel of the machine.
What you will receive with the machine

- Manual
- Tools and vertical control handle
- Tape support table
- Adjustable support feet
- Parts stored for transportation
- Mobility wheels [optional]
**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 your machine 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 [if fitted].
5. It is recommended that the machine be removed from the pallet by lifting it with a hoist or forklift. Remove from 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 (4400 lbs).
**Note:** The machine is heavy; ensure that you have a sufficient number of 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

Lifting and lowering the doors
The main door is very heavy. To assist with opening and closing, it is fitted with gas struts. When the tape feed door is lifted to the fully open position, fit the support latch into the hole as shown. This stops the door from closing. To close the door, the latch has to be deactivated. Both doors are fitted with safety switches. They remove power to the machine, and it will not operate with the doors open.

Note: When conducting maintenance or adjustments, never rely on the safety switches; disconnect the machine from the electrical and air supply.

Optional mobility wheels
To fit the mobility wheels, lift the machine and place wooden blocks under the machine. Fit the wheels and then lift the machine, remove the wooden blocks and lower to the floor.
**Leveling feet**
To fit the leveling feet, lift the machine and place wooden blocks under the machine. Fit the feet and then lift the machine, remove the wooden blocks and lower to the floor.

**Note:** Never work under the machine while it is supported by any lifting device unless safety blocks are in place.

**Leveling the machine**
The machine is provided with four leveling feet. Move your machine to its final position. To fit the leveling feet, lift the machine and place wooden blocks under the machine. Using a spirit level on the conveyor, adjust the leveling feet so that the conveyor is level in both directions. Ensure that the machine does not rock. Remove the wooden blocks and lower the machine to the floor.

**Note:** Never work under the machine while it is only supported by any lifting device. Always use safety blocks under the machine.

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

**Tape support wheels**

**Tape support table**

**Support arm**

**Leveling bolts**

**Support arm**

**Tape guide wheels**
Assemble the support arm to the machine as shown above.
Assemble the table to the support arm as shown above.
The support table must be free to rotate. If the table is rubbing on the outer guide wheels, adjust the wheels vertically so that there is a minimum of 1/8" clearance between the bottom of the wheels and the top of the table.

**Leveling the tape support table**
The tape support table must be level with the bed of the machine. You will need an engineer’s straight edge.
Lay the engineer’s straight edge across both the tape support table and the bed of the machine.
Adjust the leveling bolts until both the bed and tape support table are level with each other.

**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.
You will require an air supply that can deliver a constant minimum pressure of 6.5 bar. The input air regulator will need to be adjusted to 6 bar once you have connected your air supply to the machine.
**Note:** No air pipe is supplied, as the length required will depend on your installation.
To adjust the air pressure, pull the cap out and rotate until 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 a minimum 7 bar be supplied to the machine and that the regulator then be set to 6 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 is 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 has an automatic oiler. To fill the oil container press the plastic catch and twist clockwise. Use a good quality pneumatic oil.

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 (single-phase 220 V).

It is recommended that you use a 30-amp mains breaker.
Note: The machine is not supplied with an electrical plug or cable as the type of plug and cable will depend on the installation.

Dust collection
The machine has a dust extraction port. It takes a 4-inch diameter hose and needs to be connected to a dust collector with a capacity 2000 CFM - 15" Static pressure. The stronger the dust collector, the better. Note: Some machines are supplied with 5-inch dust port.

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 WD40 or a similar solvent. It is important that you remove ALL the grease and re-lubricate with a Teflon-based lubricant. Teflon is less likely to attract sawdust and cause clogging.

Operating and adjusting the machine

Control panel
1. Start button.
2. Frequency convertor reset button.
3. End trim on/off switch.
4. Top and bottom trimming start button.
5. Top and bottom trimming stop button.
6. Conveyor start button.
   This switch will start the conveyor operating provided all the safety switches have been set.
7. Conveyor stop button.
8. Emergency stop button.
   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.

9. Glue temperature reset switch.
When the machine is in idle mode, the glue temperature drops and the light comes on. Pressing this button restarts the heating process. When the glue reaches the correct temperature, the light goes out.

10. Glue heater on/off switch.
This switches on the glue pot heating element.

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

Electrical

Main isolation switch
This switch isolates the machine’s electrical system from the incoming electrical supply. It is located on the door of the electrical cabinet. 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.

Note: The door cannot be opened or closed with the main isolation switch in the on position.

INITIAL STARTUP
The initial startup steps are as follows.
1. Check that the air pressure is set to 6 bar.
2. Turn on the main isolator switch.
3. Press the start button (1) to turn on the power.
4. Turn on the glue temperature on/off switch (10).
5. When the glue temperature reaches the working temperature, press the conveyer start button (6).

Note: When the edgebander has not been used for a while the machine will drop the temperature and the indicator light will come on. To reheat the glue press the button.
6. Turn the end trim switch on if required (3).
7. Press the start button of the top and bottom cutters if required (4).
8. The machine will start to operate.

Shutdown

1. Check there are no panels in the machine.
2. Press the conveyer stop button (7).
3. Press the frequency converter stop button.
4. The machine will stop, and the temperature in the glue pot will drop until it reaches half the set temperature.

**Re-Start procedure**
1. If the indicator light for glue temperature reset switch is illuminated, press (6).
2. When the glue temperature reaches the set value, press the start button of frequency converter and press the start button of conveyer.
3. The machine will start to operate.

**Tape selection**
The type and 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 top side 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.

**Conveyor and extension rollers**
The conveyor system is composed of a driven slat conveyor with upper pressure rollers. The pressure rollers are vertically adjustable to accommodate thicknesses of panel between 3/8" to 1.58"
The conveyor drive chain is spring tensioned. The black tape pressure rollers are driven by a pulley that is attached to the tension arm.

**Extension rollers**
The extension rollers pull out from the machine to support various widths of panel. The extension rollers are factory set for level with the conveyor and no adjustment should be required. There is a locking knob on the underside of the support bushing.

**Conveyor height adjustor**
The height is adjusted by a handle that moves the top pressure rollers vertically. There is a counter that indicates what height the conveyor is set to. The conveyor height counter reads in metric. Below is a handy reference to convert to inches:
- 1/4 in = 6.35mm, 3/8 in = 9.53mm
- 1/2 in = 12.7mm, 5/8 in = 13.34mm
- 3/4 in = 19.0mm, 7/8 in = 22.2mm
- 1 in = 25.4mm

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 pressure rollers. 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 may 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.

**Glue application system**

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 preset temperature and is liquid. It takes approximately 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 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 debris that is in the glue will affect the final glue bond and could damage the glue pot mechanism. 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.

The glue roller can be adjusted forward and back to suit the amount of glue that is applied to the side of the panel. Move the glue roller by rotating the knob. To check that the application is correct, run a scrap panel through the machine.
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. 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 at 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.

**Adjusting the glue temperature**

The glue temperature controller comes factory set at 180 degrees C. This will suit most glue and should not need adjustment. If adjustment is required, consult the manual supplied with the temperature controller.

**Tape feeding mechanism**

The tape feed system's function is to feed the tape at the correct time onto the board, then to cut the tape so that a small section extends from the back of the board. Feed the tape through the pressure roller and adjust the pressure adjustor until the tape is held firmly but can still be moved with reasonable force. Feed the tape past the guide roller and into the tape guide.
Adjust the tape height adjuster so that the tape is free to move and so that there is a clearance of approximately 1/64 in between the tape and the top of the adjuster. The tape extends onto the tape stop and, as the panel passes the roller, it attaches to the tape. The panel then pulls it through the guides. The tape is cut by the rough-cut guillotine that is resting on the top of the panel. The guillotine has a rubber roller that runs along the panel and, as the end of the panel passes the rubber roller, the guillotine falls down and operates, cutting the tape.
**Pressure rollers**
The pressure rollers are adjustable to compensate for the thickness of the tape. Adjustment is made by rotating the tape thickness adjustor to the thickness of the tape as indicated by the tape thickness scale. The rollers are spring loaded. The spring is factory set. The spring tension is adjustable by rotating the pressure roller spring adjustor.

**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.
Rough-cut guillotine

The rough-cut guillotine cutting pressure is selected with the tape selector switch. For thin tapes, select the 1mm setting. For thick tapes, select the 3mm setting. Once the input air regulator has been set to 6 bar, adjust the rough-cut guillotine cutting pressures as shown on the panel.

To adjust the air pressure, pull the cap out and rotate until the gauge reads the correct pressure. Once the pressure is adjusted, push the cap in. The fall height of the guillotine is factory set.

The guillotine is raised to the starting position by the air cylinder. If you are using precut strips, you will not...
require the rough-cut guillotine. To raise the guillotine, utilize the lifting stop. If the guillotine will not cut the tape, you may have to increase the air pressure to the cylinder but, before you adjust the regulator, 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. The guillotine function is activated by a micro switch. This micro switch also activates the front and back trimming units [covered later in the manual].

**Front and back tape endtrimming trimming unit**

Both front and back end trim cutters are held at the top of the travel by air cylinders. As the board moves along the conveyor, it activates the micro switch which releases the trim units. As the board hits the copy pad of the front trim unit, it pulls it along and down cutting off the excess tape. The amount that the cutter removes is adjustable by turning the cutter adjustment screw. The back trim unit drops onto the top of the panel and as the panel end passes the back end trim unit the cutter moves down and along cutting off the tape at the back of the panel. The amount that the cutter removes is also adjustable by turning the cutter adjustment screw. Once the back end trim unit hits the end micro-switch, both front and back end trim units retract to the starting position. Once the input air regulator has been set to 6 bar, adjust the end trim cutter pressures. To adjust the air pressure, pull the cap out and rotate until the gauge reads the correct pressure. Once the pressure is adjusted, push the cap in.
As the panel passes the top tape trimming unit, copy pads make contact with the top of the panel and raise the trimming unit. The cutters remove the excess tape.
[max 2mm per side]. The panel continues onto the bottom trim unit. The copy pads make contact with the bottom of the panel, which forces the unit down and, as the panel passes the cutters, removes the excess tape [max 2mm per side]. The top and bottom trim units have the same adjustments.

The cutters have a slight taper, and by moving them in/out, they will cut the tape flush with the panel. The cutters shown also have a radius for producing radius edges on the panel. To adjust for the different thicknesses of tape, loosen the lock handle at the side of the unit. Turn the tape thickness adjustment screw to the thickness of tape that you are applying using the tape counter as a reference. Adjusting the top and bottom trim unit after fitting new blades is conducted by adjusting the cutter adjusting screw. There is a scale on the side of the unit as a reference. Loosen the clamp handle on the side of the unit, adjust the screw and lock the clamp handle. Run a scrap panel through the machine and check that the tape is cut correctly. Should fine adjustment be required, re-adjust and re-test with a scrap panel. Repeat for the bottom trim unit.

**Guide fence**
The fence must be in alignment with the pressure rollers. The rollers are the datum and not the fence. The fence is factory set and pinned in position so no adjustment should be required.

**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 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 undercut 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 have 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.

4. Machine adjustments
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 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 within specifications and no adjustments should be required. During the life of the machine, fine-tuning will have to be performed from time to time and the procedure that should be followed for each adjustment and setting are detailed in the manual.

Check that the machine has been set to suit the current job
Is the conveyor set to the correct height?
Are the tape tracks set to the correct height and is the tape free to move smoothly?
Is the glue pot set to the correct temperature?
Are the dust hoses clear of obstructions and is the dust collection working efficiently?
Is the machine clean and free from dirt or sawdust?
Are the rollers and fences clean and free of glue?
Is the air pressure set to the correct pressure?
All other machine settings have been adjusted at the factory.
If adjustments need to be made because one or more of the settings have been moved during transportation, only change one setting at a time. If the change does not correct the fault, 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.

**Changing the front and back end trim blades**

**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**

To access the front and back end trim cutter blades the yellow guards have to be removed. Never run the machine with the guards removed.

**Changing the top and bottom cutters**

1. To access the top cutters, remove the dust chute.
2. Remove one of the blade clamp screws and the cutter blade.
3. Replace the blade and clamp in position with the clamp screw.
4. Continue until all the cutters are changed and replace the dust chute.

**Note:** When replacing the blades, ensure there is no dirt or sawdust in the blade pocket. If dirt is present, the teeth will not be all set to the same height.
**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 guide parts are adjusted to guide the tape centrally into the machine tape-feed guide.

**Maintenance guide**

*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*

<table>
<thead>
<tr>
<th>Item</th>
<th>Schedule</th>
<th>Action</th>
</tr>
</thead>
<tbody>
<tr>
<td>Conveyor track</td>
<td>Weekly or when dirty.</td>
<td>Wipe clean. Remove any glue.</td>
</tr>
<tr>
<td>Pressure rollers</td>
<td>Weekly or when dirty.</td>
<td>Wipe clean. Remove any glue.</td>
</tr>
<tr>
<td>Fence</td>
<td>Weekly or when dirty.</td>
<td>Wipe clean. 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. Remove any glue.</td>
</tr>
<tr>
<td>Rough-cut blades</td>
<td>Weekly or when dirty.</td>
<td>Clean with solvent and check for sharpness or any damage [nicks, etc.] and replace or resharpen if required. Lubricate with WD40 or Teflon-based lubricant.</td>
</tr>
<tr>
<td>End trim cutter</td>
<td>Weekly or when dirty.</td>
<td>Clean with solvent and check for sharpness or any damage [nicks, etc.] and replace or resharpen if required. Make sure there is no</td>
</tr>
<tr>
<td>Top and bottom cutters</td>
<td>Weekly or when dirty.</td>
<td>Clean with solvent and check for sharpness or any damage [nicks, etc.]. If required, replace cutter inserts.</td>
</tr>
<tr>
<td>------------------------</td>
<td>-----------------------</td>
<td>--------------------------------------------------------------------------------------------------</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>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>
<tr>
<td>Pneumatic oiler</td>
<td>Weekly.</td>
<td>Check there is sufficient oil and top up if required.</td>
</tr>
</tbody>
</table>

**Rough-cut guillotine blades**
When sharpening the blades, sharpen on the cutting edge only and never on the thickness.

**To reset the internal breakers**
Lower the door.
Check the breakers and reset if required. Reassemble the electrical box door.
**Note:** The main isolation switch must be in the off position to allow the door to be opened or closed. This should never be relied on, so ensure that the power and air have been disconnected prior to opening.

**Glue pot**
The glue pot drive system is located behind the conveyor cover. The chain should be cleaned and lubricated with good-quality grease monthly. Check that the chain tensioner is working and is free to move.

The glue will have to be cleaned out of the glue pot periodically. The easiest way to remove the glue is to place a piece of scrap wood into the glue pot while it is hot and liquid. Allow the glue to set overnight. Start the glue heating cycle, and as the glue melts, the glue in the center will still be hard. Lift the glue out of the pot on the end of the scrap stick. Turn the heater off and scrape the remaining glue out of the pot. Once the pot is clean, refill with new glue granules and reheat the glue pot.
**Note:** Always wear protective clothing, face mask, gloves, etc. The melted glue is very hot and will burn.

**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 and checking that the tensioner moves freely.

**Troubleshooting:**
Check the list below to remedy the fault before contacting your supplier's technical department for advice.

**Note:** The most common causes of faults with edgebanding machines are:
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>Re-adjust 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 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></td>
<td>Guillotine air pressure too low.</td>
<td>Check the main air regulator is set to 6.0 bar. If OK, adjust guillotine air pressure.</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 track height.</td>
</tr>
<tr>
<td></td>
<td>Insufficient conveyor to</td>
<td>Check that the panel is held</td>
</tr>
<tr>
<td><strong>Problem</strong></td>
<td><strong>Possible Cause</strong></td>
<td><strong>Solution</strong></td>
</tr>
<tr>
<td>----------------</td>
<td>-------------------</td>
<td>--------------</td>
</tr>
<tr>
<td>Panel pressure.</td>
<td>Panel is not held firmly.</td>
<td>Tighten conveyor.</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.</td>
</tr>
<tr>
<td>Tape too high above the panel after top/bottom trimming</td>
<td>Cutters need adjusting.</td>
<td>Adjust cutters.</td>
</tr>
<tr>
<td>Panel cut by top or bottom cutters</td>
<td>Cutters need adjusting.</td>
<td>Adjust cutters.</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>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.</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>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>Edge of panel not straight.</td>
<td>Recut panel straight.</td>
<td></td>
</tr>
<tr>
<td>Fences not in alignment.</td>
<td>Realign fences.</td>
<td></td>
</tr>
<tr>
<td>Rollers not in alignment.</td>
<td>Realign rollers.</td>
<td></td>
</tr>
<tr>
<td>Glue temperature not correct.</td>
<td>Reset glue pot temperature.</td>
<td></td>
</tr>
<tr>
<td>Glue old or faulty.</td>
<td>Replace glue in glue pot once all old glue is removed.</td>
<td></td>
</tr>
<tr>
<td>Insufficient glue.</td>
<td>Adjust glue roller.</td>
<td></td>
</tr>
<tr>
<td>Machine will not</td>
<td>Tripped circuit breaker</td>
<td>Typical causes are dull or</td>
</tr>
<tr>
<td></td>
<td></td>
<td>faulty.</td>
</tr>
<tr>
<td>Start or stops during operation</td>
<td>[external to the machine or internal].</td>
<td>Gummy cutters, jammed cutter head, conveyor jammed, etc. Clear the fault and reset breaker.</td>
</tr>
<tr>
<td>--------------------------------</td>
<td>---------------------------------------</td>
<td>------------------------------------------------------------------</td>
</tr>
<tr>
<td>Machine will not start</td>
<td>Safety switches not set.</td>
<td>Reset safety switches.</td>
</tr>
<tr>
<td></td>
<td>Machine not plugged into the electrical supply.</td>
<td>Connect machine to electrical supply.</td>
</tr>
<tr>
<td></td>
<td>Isolation switch not turned on.</td>
<td>Turn isolation switch to on position.</td>
</tr>
<tr>
<td></td>
<td>Mains breaker tripped.</td>
<td>Reset breaker.</td>
</tr>
<tr>
<td></td>
<td>Machine internal breaker tripped.</td>
<td>Reset internal breaker.</td>
</tr>
<tr>
<td>Pneumatic system is sticky or erratic [air cylinder sluggish, micro-switch sticky, etc.]</td>
<td>Dirt or water in the pneumatic system.</td>
<td>Supply machine with clean, dry air. Remove air line and squirt a small amount of WD40 into the air connector. Cycle the machine 10 times and if required repeat.</td>
</tr>
</tbody>
</table>

**Electrical drawing schematic**

The electrical circuit may vary from below diagrams. Refer to the documents and drawings supplied with the machine.

**Pneumatic circuit**

**Note:** The Pneumatic circuit may vary from below diagrams. Refer to the documents and drawings supplied with the machine.