

SNB-K3A AUTOMATIC EDGE BANDER



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Packing List

- 1、 Automatic edge banding machine: 1
- 2、 Instructions: 1
- 3、 Tools:
 - Allen wrench: 1
 - Cross screwdriver: 1
 - Flathead screwdriver: 1

Foreword

Thank you for choosing our company's woodworking machinery products.

Automatic edge banding machine Instructions mainly for construction, performance, safe operation, maintenance, and transportation, storage and so matters do a comprehensive, detailed, and efficient personnel to manage the economy, good use of the above equipment, provides the basic knowledge.

This specification rules and guidelines will help you to safe and effective use of the machine. Before the operation and maintenance manual must be read and comply with the precautions to prevent accidents due to illegal operation and maintenance may cause serious injury or death and.

Due to continuous product improvements and do change with the contents of this manual are subject , without prior notice, please user understanding.

Warning

Before starting operation and maintenance, operation and maintenance personnel must observe the following:

- Before the operation or maintenance, be sure to read and understand this manual.
- To read this manual safety notice and adhere to the mechanical security identification and must be completely understood.

To save this manual for the specified storage location, and should read the manual on a regular basis.

If this manual has been lost or defaced can not read, please immediately contact the company or distributor.

Safety identification and use language

To help you safely use automatic edge banding machine, pasted on the specification and the signs of the mechanical safety precautions in order to provide a description and methods to avoid such dangerous situations involving potentially dangerous.

The following identifies the term indicates that there could cause personal injury or damage to the potential danger. In the present specification and mechanical signs, following identification of potential terms used to indicate the degree of hazard.



DANGER

Said that if not evade the consequences of the risk will result in death or serious injury.



CAUTION

Said that if not avoid, potentially dangerous consequences that may result in lower or moderate injury or serious injury.

Solemnly declare

Due to property damage and personal injury caused by incorrect operation, the company is not responsible.

Chapter 1: Safety feature flag graphic

1.1 General Security

- (1) Before the operation, the operator must read the instructions carefully and completely understood. Security managers should confirm skilled operator can operate the machine.
- (2) Operating equipment, maintenance, maintenance personnel must be trained, familiar with the potential dangers of the machine and obtain the relevant qualifications.
- (3) Assembly, maintenance and repair personnel must fully understand the operating instructions, and in strict accordance with the requirements of the job.
- (4) After the machine stops, adjust or remove the protective device, be sure to pay attention to some rotation, drive components, due to inertia will continue to run for some time. Maintenance or adjustment should be in the danger of moving parts completely stopped.
- (5) Once the machine is abnormal or fault, the operator should immediately stop the machine, cut off the power supply, gas supply, notify promptly repaired by qualified service personnel.
- (6) Handling, disassembly and assembly of the machine must be sufficient bearing capacity lifting equipment.
- (7) The machine must be specified purposes and requirements, otherwise it may cause serious danger.
- (8) Comply with the safety instructions and warnings for all machines, and to maintain the integrity and clean safety instructions and warnings identified.

-
- (9) Before operating the operator shall conduct a comprehensive safety inspection, confirm the safety guards and safety devices of the machine before starting the machine to normal after all.
 - (10) After machine maintenance, to ensure the safety devices and protective cover, complete and accurate installation in the original location.
 - (11) Only off the power, gas supply, all the moving parts of the machine is completely stopped and disconnect the power before they can repair, maintenance, replacement and cleaning machine debugging.
 - (12) Replacement parts must use original parts, otherwise it will cause danger or damage to the machine.
 - (13) In the case of the machine must be running unattended operator when the operator leaves the machine, you must turn off the power.
 - (14) Always check all power lines and ground lines, ensure that the machine's electrical system has good insulation and grounded. Not use defective wires.
 - (15) Prohibiting the use in wet or explosive environment, or they may cause serious danger.
 - (16) Keeping the work environment clean, provide adequate lighting.
 - (17) Prohibit children and visitors close to the machine, the operator at least 18 years of age have the ability to predict the presence of dangerous machines.
 - (18) Do not drink after fatigue and have a hypnotic effect and taking similar drugs operate the machine.
 - (19) The operator must not wear loose clothing, not wearing a tie, gloves or jewelry (such as rings, bracelets, watches, etc.).
 - (20) Long hair must be wrapped with a wig and reliable, to prevent hair caught in the machine inside.
 - (21) When operating the machine is recommended to wear the necessary personal protective equipment, such as wearing ear protection to reduce the risk of hearing loss.

1.2 Equipment usage rules

- (1) At the discharge end of the machine should ensure that sufficient space-space ratio should be at least the length of the longest length of the workpiece large 500mm.
- (2) User-equipped blade, cutter and cutter machine sizes must comply with the requirements of the original configuration, the user must be selected in line

EN847-1: blade and cutter, cutter blade and the rated speed of 1997 standard requirements should not lower than its maximum speed shaft.

- (3) Adjust the machine must be carried out in accordance with the provisions of this specification by professionals, avoid touching knives and dangerous moving parts.
- (4) The machine must be connected before use and removal dust system must ensure removal equipment has been working before starting the machine. Vacuum equipment should be of sufficient air volume and velocity, which air volume of 800m³ / h, a flow rate of 25m / s.
- (5) Must cut off the power supply, gas supply when changing tools.
- (6) Air Ministry during the repair work, disconnect the gas line to prevent accidental operation of pneumatic components danger.
- (7) Should regularly check the safety-related components of each safety interlock switches, emergency stop switch, gas pressure sensor, temperature controller, etc., to ensure reliable operation of these components. If abnormal, should be repaired by qualified service personnel, replacement parts should be used original parts
- (8) Keep knives sharp, should be replaced blunt, deformed, defective blade, cutter and cutter, otherwise there will be dangerous.
- (9) Do not exceed the parameters of the processing specifications and technical requirements of the deformation of the workpiece.
- (10) Saw, milling, polishing wheel rotation direction to the right, should be consistent with the direction of the machine ID, otherwise it will be dangerous.
- (11) After the feeding device and the parts reach the maximum stable speed motor speed can be fed.

Warning:

- Failure to comply with these rules may lead to serious injury.
- Machinery and transport dangerous to squeeze between the plate and the pressure drag wheel, prohibit access to these parts of the machine is running, it may cause serious injury.
- Power supply isolation means does not have a pressure gas source isolation, maintenance parts when closed pneumatic manifold isolation valve, and release the residual pressure in the pipeline.
- Melt glue pot surface temperature after turning off the power at the surface of

the machine will last longer period of time, prohibit hand directly touch the surface of the melt glue pot and melt glue pot, to avoid burns.

1.3 Limitations of the surrounding environment:

Place the machine on the operating environment requirements

Power	Referring to the body stickers	Relative humidity	90% No condensation
Power frequency		Altitude	≤1000m
Ambient temperature	0° C—40° C	Silo temperature	0° C—40° C

1.4 Noise statement:

Noise measurements were performed according to standard ISO7960.

The machine noise level when the load is not greater than 82dB (A).

1.5 Logo Graphic:



ROLLING
KEEP HANDS AWAY



HIGH TEMPERATURE
DO NOT TOUCH



ROLLING
KEEP HANDS AWAY



DANGEROUS
KEEP HANDS AWAY



CUT
KEEP HANDS AWAY



DANGEROUS
DO NOT TOUCH



ADD INFUSE
GREASE REGULARLY



ELECTRIC SHOCK
OPERATE CAREFULLY

Chapter 2: Care and maintenance

Disclaimer: This device is a high-precision machinery and equipment, the need for strict maintenance, strictly in accordance with the requirements of the equipment necessary maintenance. Due to lack of maintenance failures caused by maintenance, not free within the service range!

In order to ensure the normal operation of the machine for a long time, it must perform regular maintenance and upkeep, partly due to the need of production, on the other hand is the need to device usability and safety.

- Before all maintenance, service and repair work, you must turn off the main power switch and disconnect the power, strictly prevent accidental machine startup.
- When the machine work, you must use the vacuum suction device.
- Regular cleaning can prolong its life, and is an important prerequisite to ensure that the workpiece to achieve good results. Therefore, after the class of equipment must be cleaned and maintenance, for at least a week for a major clean-up equipment and maintenance.
- Regularly check the wear blade, cutter, blade, polishing wheels, so the device is always kept in good working condition.
- Only by mastering the expertise to understand the possibility of dangerous equipment to allow maintenance personnel.
- You can only use the original machine parts for maintenance, or else, it might give operational risk.

See detailed maintenance schedule

Maintenance schedule

No.	Timetable	Area	Operation	Lubricants / solvent
1	After the end of the work day	The whole machine	a. The whole machine cleaning sweeps, wipe clean b. Clean up litter on the chain sprocket crawler c. Transmission parts litter cleanup, waste silk d. Clean up the excess melt glue pot around e. Each processing surface anti-rust oil f. Each oiling point refueling	Rust oil/ 3 # Molybdenum disulfide lithium grease
2	Every 80 working hours	Glue pot	High temperature grease injection pressure of linear bearing with grease gun	3 # Molybdenum disulfide lithium grease
		Active edge roller	Injection of oil with high temperature grease gun	3 # Molybdenum disulfide lithium grease
3	Every 200 working hours	Rubber box driving chain plate chain	Check chain tension	Timely adjustment
4	Every 2 months (400 hours)	Feed track	Using hand pressure pump to lubricate the moving track	Lubricating oil
		Feed track	Check chain tension, if	

			necessary to adjust	
5	Timely inspection, when the container level becomes low	Air source processor	The oil cup filled with lubricating oil 3/4	Mobil VG32 ISO oil

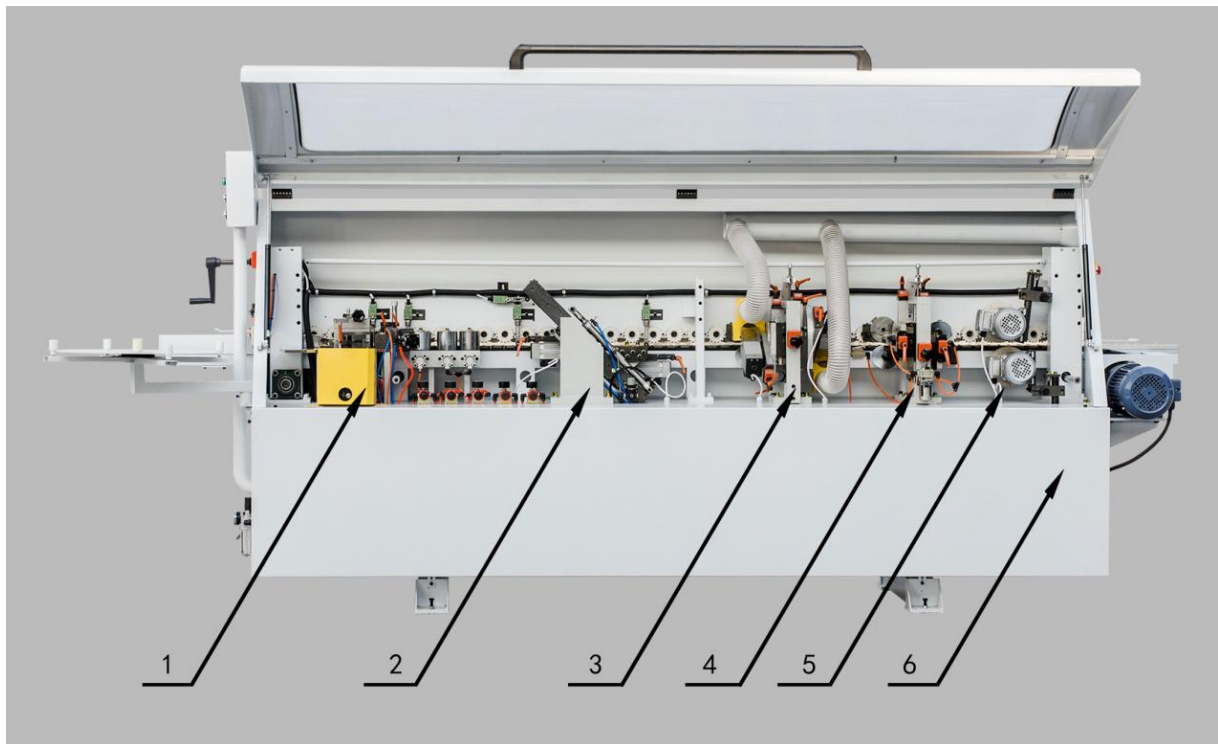
Chapter 3: Mechanical use and characteristics

USE The machine is set machine, electricity, gas as one of the high-tech, high-efficiency edge models. It is mainly used for roll edge type and hot melt adhesive and wood panels, particleboard, blockboard, medium density fiberboard and other sheet metal straight edge bonding and dressing, the processing after the sheet edge is evenly and firmly, trimming smooth and more durable and beautiful.

Characteristics The machine can from the plate into the auto completion: adhesive edge, end trim, fine trim, scraping and buff five functions, to avoid the manual processing in the process of machining error, ensure the consistency of the size of the processing. The machine has high automation degree, edge of good quality, high production efficiency, and has the advantages of beautiful appearance, compact structure, stable and reliable work is use of panel furniture manufacturer is one of the important equipment.

Chapter 4: Machine tool

structure



Picture 1 Automatic edge banding machine

- 1、Edge banding 2、end trimming 3、fine trimming 4、scraping 5、buffing 6、body

Chapter 5: Technical parameter

The main technical parameters of automatic edge banding machine

sheet thickness	10-50mm	
edge thickness	0.4-3mm	
minimum working plate width	$\geq 50\text{mm}$	
minimum working length	$\geq 140\text{mm}$	
higher than the maximum size of sheet sapwood (per side)	2mm	
feed speed	13m/min(constant speed)	
compressed air pressure	0.7Mpa	
power supply	see fuselage terminal box	
Feed motor	1.5kW	
Plastic box motor	0.37kW	
End trim motor	0.55kW*2. 200Hz. 18000r/min	

Fine trim motor	0.75kW*2. 200Hz. 18000r/min	
Buff motor	0.18kW*2. 50Hz. 1400r/min	
heat	1.5kW	
Preheat	0.12kW	
Power	7.0kW	
Electric current	15A	
Fine trim milling	D=Φ68. d=Φ16(+0.017+0.006)	
End trim milling	D=Φ100. d=Φ22	
Hot melt (reference resources)	160-200°C	
Machine size	3940×900×1800 (mm)	
Machine weight	About 1500kg	

Chapter 6: Transport

6.1 The machine can be carried through the body at the bottom of the forklift;

Warning:

- In the beginning before moving, please confirm the lifting and handling equipment should have sufficient bearing capacity.
- In the handling and lifting process, should slow up the light, keep the balance. Otherwise, it may affect the machining accuracy, and even damage the machine.
- The lifting and handling process, prohibited under the machine and its adjacent station, to prevent accidental injury.
- If the machine must be stored, please keep the machine in the greenhouse and dry environment, and the cover is sealed by a plastic bag.

Chapter 7: Machine installation

7.1 Machine installation:

- (1) the installation of the machine should be far away from the vibration source.
- (2) the operation room should be cement ground, and check whether the ground is smooth. Avoid shaking when the machine is adjusted.
- (3) should put the machine in close proximity to the power supply, air outlet, the waste pumping outlet position, the workplace should ensure adequate lighting, the luminous flux of not less than 500Lx. Suggested that the vacuum cleaner flow rate is greater than 800m/h, the flow rate is 25m/s. The machine vacuum interface with 100mm, the pressure is greater than 1100Pa, the flow rate is greater than 12m/s.
- (4) the rubber boiler waste gas and waste plastic must be concentrated discharge, and should meet the requirements of local environmental protection.
- (5) around the machine should be set aside enough space for proper installation and maintenance of equipment. The size of the space is determined by the size of the sheet to be processed.

- (6) the machine must be surrounded by the largest sheet and other obstacles to set aside 500mm free space.

Warning: narrow working space can lead to serious personal injury.

- (7) in order to ensure the smooth machine, after placing the good machine, should adjust the adjustment screw, so that the central position of the fixed table vertical and horizontal horizontal meter readings are not more than 0.10/1000. After the machine is fixed, the belt plate is installed on the working table.

7.2 Electrical installation:

7.2.1 Circuit installation

- (1) User's distribution system should be equipped with over voltage protection device.
- (2) Because the voltage frequency of each country is different, the voltage and frequency of this equipment, please refer to the junction box office. Voltage fluctuation range 10%, frequency fluctuation range 0.5Hz.
- (3) The machine with 5 copper core wires, copper wires for power lines into the.
- (4) The cross-sectional area of the grounding line should be not less than the phase stack area.
- (5) Ground resistance should not be greater than 4Ω .
- (6) Power cord should be connected to the junction box in the lower part of the body.

7.2.2 Check before power on: the following inspection should be carried out before the machine is powered on

- (1) Check the movement of the moving parts should be no obstacle.
- (2) Tool clamping should be firm.
- (3) The lubricating parts should be good.
- (4) Pneumatic three pressure gauge indication in 0.6Mpa.

7.2.3 Electricity: (Figure 2)

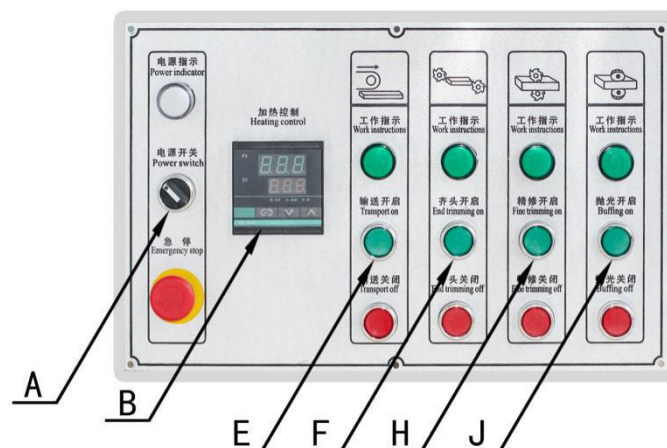


Figure 2

- (1) All emergency stop button reset.
- (2) When the protective cover is not opened, the total power switch is closed, and the starting switch of the control power switch A is opened, and the operation can

be carried out.

7.2.4 Power after the first boot

(1) After the power supply, turn on the power switch A. If the power indicator light is normal, the connection is correct. Such as electricity without the power indicator, should change the power supply to re open the power switch A, check the power indicator.

(2) Confirm the correct connection, set the thermostat B to the required value.

(3) After the actual temperature to reach the set temperature of ten minutes after all the motor in order to start.

7.2.5 Shutdown:

(1) Switch off all motor switches.

(2) Switch off the control power switch A, cut off the control power supply.

(3) Turn off the main switch, the whole machine power off. Cut off the power.

7.2.6 Gas installation:

(1) before the installation, check the gas supply capacity of not less than 0.5m³/min 0.5-0.6Mpa fand air pressure.

(2) were inserted into the trachea machine nozzle used on aerodynamic inlet triple in ventilation.

Chapter 8: Machine tool use and adjustment

This machine tool has passed the precise adjustment and the strict test before leaving the factory, has not been related to the training or has not specially specially specially to instruct not to be arbitrarily randomly to tune. In the process of use, the user may need to adjust the machine according to the change of the material specification. Such adjustments must be carried out by a specially trained professional.

8.1 Plate thickness adjustment (Figure 3)

When the change of the thickness of the plate must be of material pressing height corresponding adjustment: according to the thickness of the plate with special crank rotation adjustment rod (1) to realize the numerical and the plate thickness is consistent with that of the position of monitor. Clockwise rotation, the vertical plate up, counter clockwise rotation, the vertical plate down.

8.2 After adjustment of supporting material device (Figure 4):

After the material holding device is mainly used for large workpiece edge support, it can be adjusted according to the width of the workpiece. The adjustment method is as follows: pull the handle on both ends of the support frame, and move it to the appropriate position.

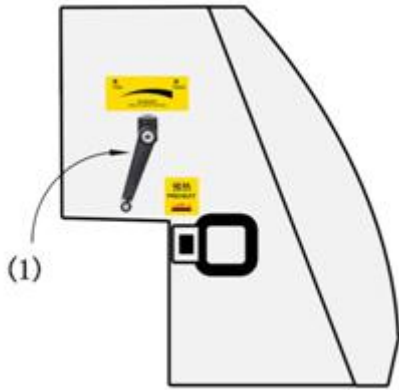


Figure 2

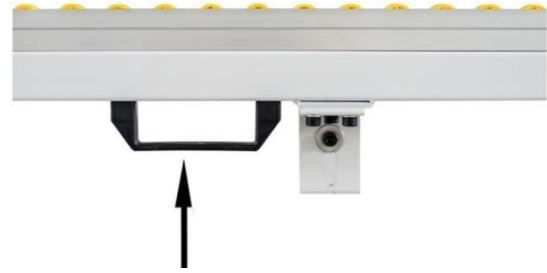


Figure 4

8.3 Control system (Figure 5):

Turn on the power control switch "A" start button, control power on.

Set the required temperature on the temperature control table B. When reaching the set temperature, after ten minutes press the conveyor belt switch "E" start button, conveyor belt running, press the corresponding switch motor operation.

In order to minimize the frequency converter, power outages, the system is not as far as possible after the removal of artificial, to ensure the normal use of the frequency converter.

When the wood into the machine touches the travel switch, push conveyor cylinder edge forward. Board to enter the end of the trip to leave the trip, stop feeding.

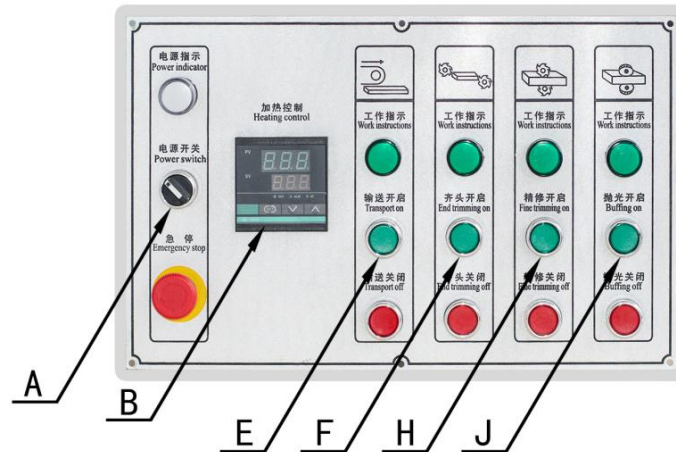


Figure 5

8.4 Edge system:

This system adopts the edge banding machine mounted under the hot glue box, double helix type glue feeding structure, ensure uniform glue glue feeding convenient. Edge belt into the machine, roll edge away straight edge banding conveyor belt with sealing device for workpiece linkage, with knurled wheel conveyor belt and the cylinder pressure zone, knurled wheel is used for thin and soft edge banding. Banding belt pressing the spring compression mode and pressure can be adjusted, into the edge belt, auto plate spring pressure, the belt pressing roller and the roll round flower of complete tape

feeding action. Edge with upstream and downstream zone with limiting blocks are high in the form of constraints and regulation to the attention of the press not loose not tight, in order to ensure the smooth and not to the upstream and downstream with. Cut off by quick exhaust valve with sealing, to ensure the rapid and effective cutting. PVC edgeband with belt cutting method. Edge banding and the pressure between the plate by means of gas moving horizontal pressing wheel device, the pressure of front and rear wheel position and size can be adjusted, the edge belt and plate between the bonding more solid and reliable. In the use of machine process, due to the change of specification and the plate edge thickness increase or decrease in the edge zone, need to adjust the following parts:

8.4.1 Installation, adjustment and sealing material automatic feeding cutting device adjustment:

Sealing material mainly PVC, thin wood (veneer), coil.

8.4.1.1 The installation and debugging of roll banding material (Figure 6): the thickness of 0.4-3mm roll type sealing material.

a. The roll edge belt on the belt wheel.

b. Edge banding followed by edge with a height positioning rod (1), edge band limiting plate (3), send belt wheel (5), edge band height positioning column (7) has been to the cutter (14) edge position.

c. According to the edge with the height and the adjustment of edge with the height of the positioning rod (1) position, pay attention to rods with minimum position and edge with retention of the reasonable clearance, the edge belt is not stuck also will not shake, after a good tune, tighten the regulating handle (2).

d. According to the edge with the height and the adjustment of edge with the height of the height positioning column (7), pay attention to and edge belt to maintain a reasonable gap, the edge belt is not stuck also will not shake, after a good tune, tighten the regulating handle (8).

e. According to the height of the edge with the height and the rotation of the adjusting nut (9) to adjust the edge zone height positioning blocks (10), pay attention to and edge band to keep the reasonable clearance, the edge belt is not stuck also will not shake, after a good tune, tighten the regulating handle (11).

f. according to the edge thickness, adjust the pressure cylinder (12) pressure, the tightness of the right. Note: generally do not need to adjust here, unless the edge is thick, the pressure is too large.

g. When the edge is thick, the cutting knife can not cut off, increase the cutting cylinder (13) pressure, until the belt cutting smoothly.

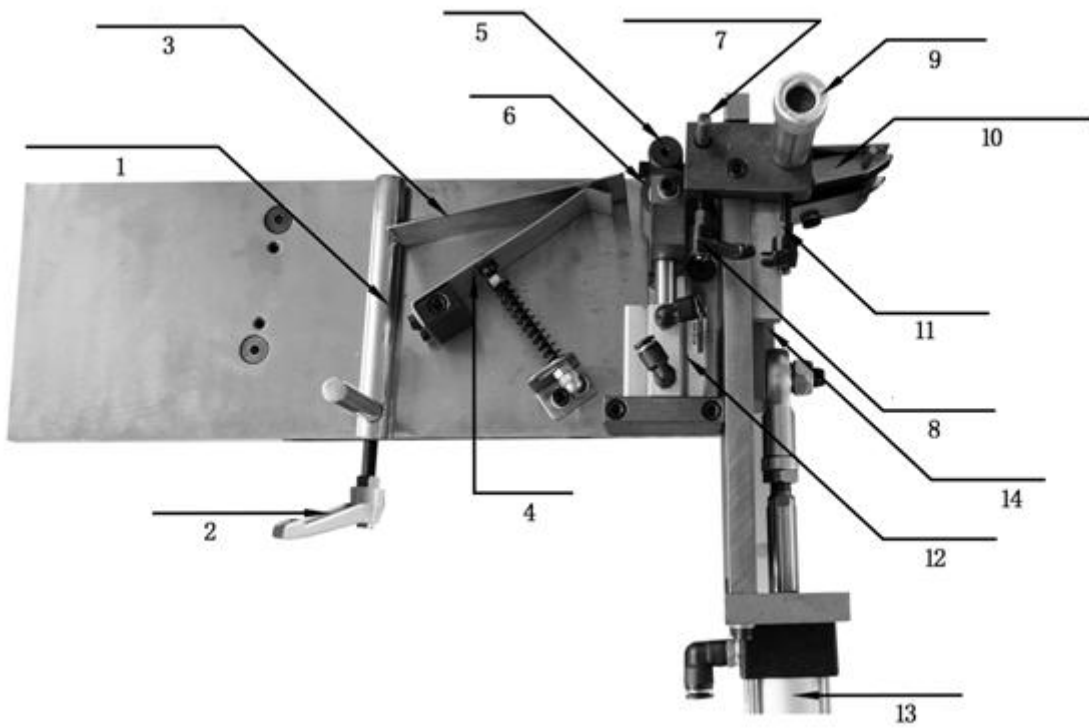


Figure 6



Figure 6-1



Figure 6-2

8.4.2 Edgeband other allowance adjustment

8.4.2.1 About: the workpiece edge material stretch adjustment; edgeband plate is higher than that of unilateral height adjustment;

Note: the above two data ready standard adjustment at the factory, in the normal working state of the equipment without reset. This data is abnormal, please consult the after-sales service.

8.4.2.2 Melt glue temperature regulation (Figure 7):

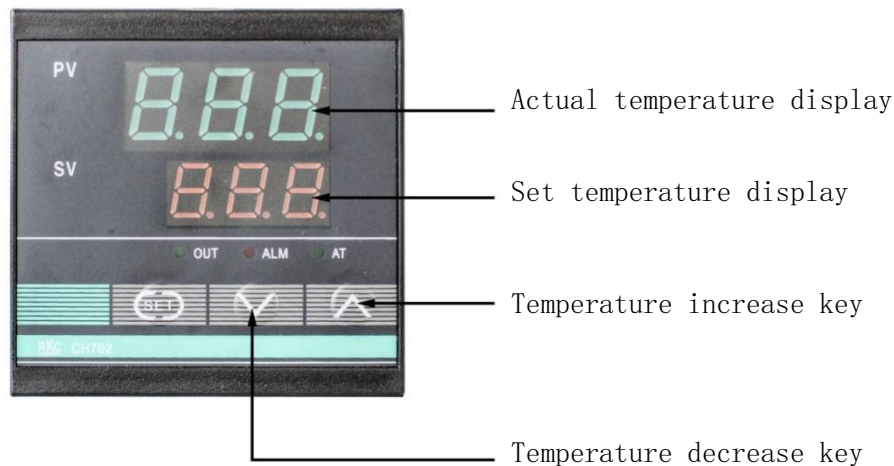


Figure 7

Temperature settings: hold down the temperature increase or reduce the temperature of the key to hold for 3 seconds, in the "set temperature display" in the number will gradually increase or decrease, in order to set the desired temperature value.

8.4.2.3 The use of hot melt and temperature control

a. This machine is recommended to use the hot melt adhesive, German Henkel.Dornproduction model for KS217 or KS215 edge with hot melt adhesive, in line with European safety standard non hazardous ingredients.

b. This machine is recommended to use the hot melt adhesive, it is recommended (and temperature) temperature 190-200°C, sticky at best for machinery, slow running.

Note: when the heating temperature exceeds 250 °C, hot glue decomposition failure.

c. Note: adhesive hot bath is heated to operating temperature, should be extended 10 minutes to be coated rollers to operating temperature before startup, otherwise it might damage cots.

d. Users must according to the requirement of edge material selection of suitable environmental and safety requirements of the hot bath gel, and according to the use of hot melt adhesive select instructions, in order to avoid a hazard.

e. Users before the hot melt adhesive should carefully read the MSDS of hot melt adhesive, known as its physical and chemical properties, processing methods of emergency treatment and waste,.

8.4.3 Adjust the amount of Rubber Cots (Figure 8):

According to the label, the control direction is marked, and the handle is screwed and transferred to the required amount of glue. Note: the addition amount of glue to add glue pot depth three divides into two following to prevent fill out excess glue, don't side with adhesive, prevent glue hasn't melted into the machine, the damage to the machine. Recommended to stop the machine running, a plus glue, glue to be completely dissolved over ten minutes before the boot can be.



Figure 8 Glue quantity regulating handle

8.4.4 Cylinder working pressure adjustment:

Due to changes in the edge thickness must be to pressure with a cylinder, edge compression roller cylinder, cut take the work pressure of the cylinder to make corresponding adjustment, value adjustment range is as follows:

Equipment	Working pressure (Mpa)	Equipment	Working pressure (Mpa)
Front pressure	0.2-0.3	End cutting down	0.2-0.3
Back pressure(2)	0.2-0.3	End cutting up	0.3-0.4
Cutter	0.2-0.6	Feed cylinder	0.1-0.2

Special remind: as a result of some edge belt material is more sensitive to temperature, so when the ambient temperature is below 15 DEG C, may have an impact on the edge, blunting effect. The method can be used to improve the environment temperature of the tray of the tray.

8.5 End timing system

This system is used to trim the edge blunt edge plate front and rear excess sealing material. Blunting system using high speed frequency conversion motor 0.55KW*2.200Hz.18000RPM and profiling track structure, ensures that the motor cutting cut section of smooth and tidy. Before and after the butting motor adopts imported cylinder, imported linear guide, ensure the motor cutting in the long-term stable and accurate. The motor base is made of precision, which ensures the strength of the machine tool's long-term work. Block system block and the tail two parts together. Each system has been the standard to debug in the factory, under normal working condition has no need to debug.

8.6 Fine trimming system

This system is for the side edge of the upper part of the lower sealing material to repair the extra sheet edge after processing. Repair system using high speed variable motor (0.75KW*2.200Hz.18000RPM) and profile modeling tracking structure, ensure the motor trimming plate on the lower part of the smooth neat. Repair edge profiling at the factory has made a precise adjustment, but in the actual production process due to changes in the band edge and the edge plate specifications, material, may adjust the following parts:

8.6.1 Under the regulation of finishing automatic trimming device:

All the equipment in the factory are the standard debugging, when the user to replace with different thickness of the edge should be readjusted. According to the different types of edge trimming machine, a cable repair (Figure 9) peace repair (Figure 10) two.

8.6.1.1 Tilt trim adjustment

- (1) Regulation edgeband thickness regulator (3), the counter shows the edge of the replacement of strip thickness;
- (2) if the replacement of the edge strip thickness greater than the thickness of the band edge of the current device used, you need to first trimming quantity adjustment handle (1 and 4) increase, the trimming the right amount. Then, the upper and the lower circular arc regulating handles (2 and 5) are adjusted to make the trimming of the circular arc suitable. After adjustment, lock the handle. Note, in the regulation, because the regulating handle is more sensitive, so please do not substantially adjust the handle.
- (3) if the replacement of edge thickness is less than the thickness of the band edge of the current device used, first on the trimming quantity regulating handle (1 and 4) small, the trimming quantity appropriate. Then the upper and lower circular arc regulating handles (2 and 5) are small, so that the amount of the trimming of the circular arc is appropriate. After adjustment, lock the handle. Note, in the regulation, because the regulating handle is more sensitive, so please do not substantially adjust the handle.

8.6.1.2 Horizontal trimming adjustment

- (1) if you want to change the edge thickness greater than the thickness of the band edge of the current device used, you need to first trimming quantity adjustment handle (1 and 4) increase, the trimming the right amount. Then, the upper and the lower circular arc regulating handles (2 and 5) are adjusted to make the trimming of the circular arc suitable. After adjustment, lock the handle. Note, in the regulation, because the regulating handle is more sensitive, so please do not substantially adjust the handle.
- (2) if the replacement of edge thickness is less than the thickness of the band edge of the current device used, you need to first trimming quantity regulating handle (1 and 4) small, the trimming quantity appropriate. Then the upper and lower circular arc regulating handles (2 and 5) are small, so that the amount of the trimming of the circular arc is appropriate. After adjustment, lock the handle. Note, in the regulation, because the regulating handle is more sensitive, so please do not substantially adjust the handle.

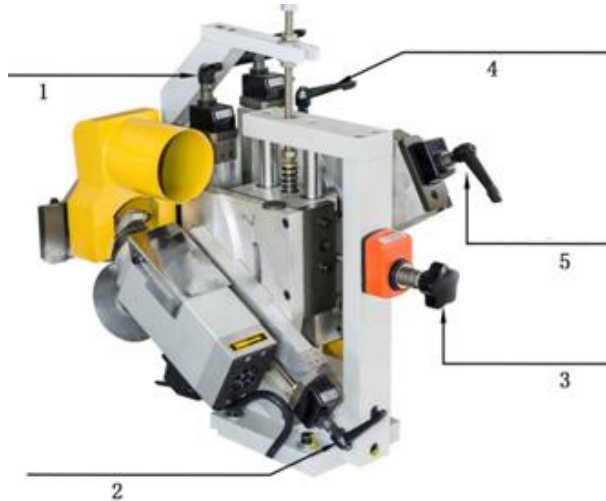


Figure 9

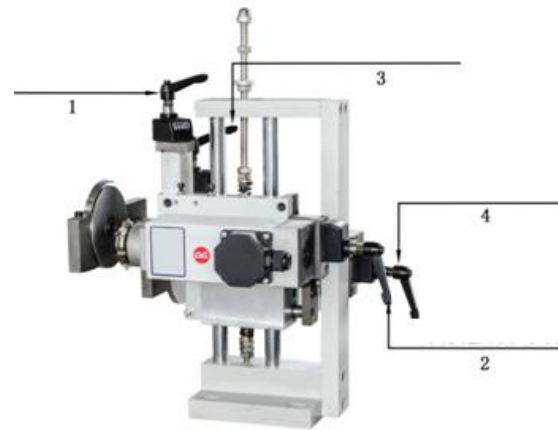


Figure 10

8.6.2 The cutting direction of the trimming knife should be opposite to the running direction of the plate (FIG. 11)

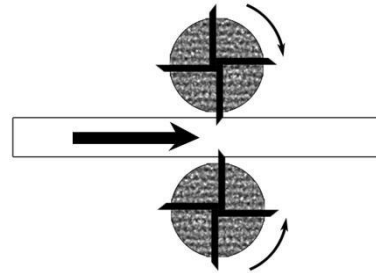


Figure 11

8.7 Scraping system

The edge banding machine, scraping edge system is to eliminate due to trimming non linear motion of the cutting caused by the traces, the sapwood on the lower part of the more smooth and clean. In the actual production process, the following parts are likely to be adjusted:

8.7.1 The regulation of the scraping system (Fig. 12):

- (1) if you want to change the edge thickness greater than the thickness of the band edge of the current device used, you need to first scraping amount regulating handle (1 and 4) increase, so that the upper and lower scraping the right amount. Then, the upper and lower circular arc regulating handles (2 and 5) are adjusted to make the circular arc with a suitable edge. After adjustment, lock the handle. Note, in the regulation, because the regulating handle is more sensitive, so please do not substantially adjust the handle.
- (2) if the replacement of edge thickness is less than the thickness of the band edge of the current device used, you need to first scraping amount regulating handle (1 and 4) small, make scraping the right amount. Then the upper and lower circular

arc regulating handle (2 and 5) is small, so that the amount of the circular arc is suitable. After adjustment, lock the handle. Note, in the regulation, because the regulating handle is more sensitive, so please do not substantially adjust the handle.

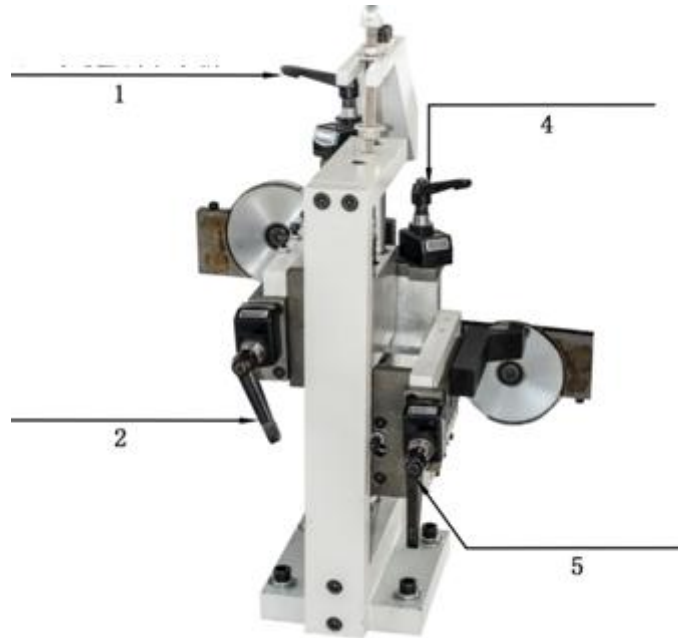


Figure 12

8.8 Buffing system

The edge machine buffing system is to clean up the plate processing and play a good role in polishing. Polishing assembly consists of a two motor with cotton polishing wheel, they are independent each other, respectively of sealing material of upper and lower working surface in polishing, in the actual production process, the following parts may adjust:

8.8.1 Adjustment of buffing device (Figure 14):



Figure 14

- (1) Up and down buffing position:
- Loosen upper and lower buffing fastening screws (5 and 6)
 - Move the motor to retreat to the appropriate location
 - Tighten upper and lower buffing fastening screws (6 and 5) with a six angle wrench.
- (2) Top and bottom buffing up and down position:
- Loosen upper and lower buffing fastening screws (1 and 4)
 - Turn up and down buffing adjustment screws (3 and 2), through the screw to drive the motor up and down to move to the right position
 - Tighten upper and lower buffing fastening screws (4 and 1) with a six angle wrench.
- 8.8.2 The buffing wheel rotation should be opposite to the forward direction of the plate (FIG. 15):

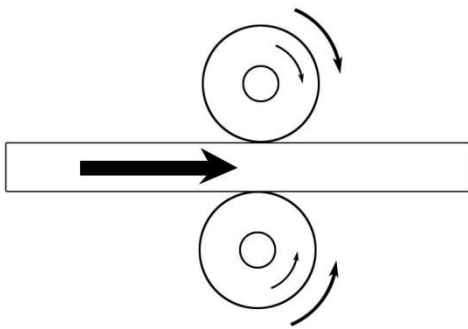


Figure 15



Figure 16

8.9 Preheat

In the low temperature environment, influence of edge effect, the preheating switch can be turned on the left side of the fuselage, for preheating plate. (Figure 16)

Chapter 9: Abnormal phenomenon and its elimination

9.1 The common abnormal phenomenon and edge edging system:

phenomenon	reason	solution
The glue doesn't reach the working temperature.	Heating pipe burn	Replace heating tube
Excessive amounts of glue on wood	Too much glue	Adjust the amount of glue
Edgeband with plate bond is not strong	Too little glue	Adjust the amount of glue
	Lack of edge roller pressure	Increase the edge roller pressure
	Wood is too wet	Replace wood
Easy to carbonization glue	Temperature control set too high	Re adjust the temperature
Wood materials lack of tail	Wood into the machine	When the wood is fed into the

welt	position is not correct	machine, it is kept in parallel with the feeding guide rail
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9.2 End trimming system common abnormal phenomenon and its elimination:

phenomenon	reason	solution
Endtrimming is not perfect	The glue residue in the tool or profiling on	Clear glue residue
	Saw blade too old or installation error	Install new saw blade or check the installation
The motor cannot be raised to the cutting position	Cylinder working pressure is not enough	Check and adjust the working pressure of the cylinder

9.3 Fine trimming system common abnormal phenomenon and its elimination:

phenomenon	reason	solution
The trim on the wood is not sustainable.	The wood plane can not accurately track profile	Increase the pressure profile tracking
The wood is not perfect in the beginning of the stage	Cam position changes	Re adjust the cam position
Edge gap	Trimming knife edge material with broken or too wide	The replacement of the knife edge repair, choose suitable edgeband width
jagged edge	Cutter radial too large	Install new trimming knife

Chapter 10: Thanks

I sincerely thank you for your purchase of our company's woodworking machinery products, hope that our products can contribute to your career development! We will be happy to serve you!