

# Manual

## **ToughCut Cobalt 25 Edge Banding Machine**



Please read the manual carefully.

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Congratulations! You just obtain an Edge Banding Machine for solving the finish machining and efficiency problems by the most advanced technology development.

Edge Banding Machine enables you to bond the gumming band (Veneer , paper-based, ABS, PVC) perfectly in the line contour section, so as to achieve the highest efficiency.

This manual contains important information. Please read carefully, to make your equipment achieve the best performance in the safest case.

## Table of Contents

<b>1.Safety instructions.....</b>	<b>5</b>
1.1 Safety Notice.....	5
1.2 Before use of equipment.....	5
1.3 During machine installation.....	6
1.4 Before using every time.....	6
1.6 Protective measures.....	8
1.7 At the end of operation.....	8
1.8 Storage.....	8
<b>2. Reception of Edge Banding Machine.....</b>	<b>9</b>
2.1 Tool kit.....	9
<b>3. Understand the Machine.....</b>	<b>10</b>
3.1 Understand drive plane.....	11
4. Technical Specification.....	14
<b>5. Installation.....</b>	<b>15</b>
5.1 Required space of Edge Banding Machine.....	15
5.2 Electrical installation of equipment.....	16
5.2.1 Electrical connection.....	16
5.3 Installing exhaust system on machine.....	18
5.4 Installation of machine parts.....	18
5.5 Installation of pneumatic motor.....	19
5.5.1 Connection of compressed air hose.....	19
5.5.2 Lubrication.....	19
<b>6. Preparation.....</b>	<b>21</b>

6.1 Sideband regulation.....	21
6.2 Placement of adhesives.....	22
6.3 Temperature adjustment of adhesives .....	23
6.4 Dosage adjustment of adhesives.....	24
6.5 Adjustment of front panel set .....	25
6.6 Adjustment of sideband pressure roller.....	25
6.7 Regulation of clamp set.....	26
6.7.1 Regulation of vertical clamp.....	27
6.7.2 Regulation of horizontal clamp.....	27
6.8 Adhesion of sideband.....	28
6.8.1 Adhesion of Edge Banding Machine and sideband.....	29
6.9 Drive manual.....	30
6.10 Forward speed adjustment of track.....	30
6.11 Replacement of adhesives (optional) .....	31
6.12 Adhesives on withdrawal machine.....	31
6.13 Placing the adhesives in the machine.....	33
<b>7. Maintenance and Cleaning.....</b>	<b>33</b>
7.1 Cleaning of adhesives .....	34
7.1.1 Cleaning the adhesives in the mode of scrubbing by hot water.....	34
7.2 Lubrication and clamping chains.....	35
7.3 Be careful using your equipment.....	37
7.4 Pneumatic system maintenance.....	38
7.4.1 Filter and air purifier.....	38
7.5 Lubricating grease and lubricating oil.....	39
<b>8. Possible problems - cause - solution.....</b>	<b>40</b>

<b>9. List for machine parts.....</b>	<b>42</b>
9.1 Subset adhesive tape cutting machine.....	42
9.1 Subset adhesive tape cutting machine.....	44
9.2 Low level clamp.....	46
9.3 High level clamp.....	48
9.4 Drive setting.....	50
9.5 Adhesives.....	52
9.6 Pressure roller setting.....	54
9.7 Cowling setting.....	56
9.7 Cowling setting.....	58
9.8 Gear wheel setting.....	60
9.9 Push rod setting.....	62
9.10 Main frame setting.....	64
9.10 Main frame setting .....	66
10. Electrical scheme of Edge Banding Machine.....	68

## **1. Safety Instructions**

To guarantee the safety of the operator and the durability of your equipment better, you need noticing some problems during the period of installation and operation.

### **1.1 Safety notice**

Safety tips: Failure to obey will result in the serious life risks of the operators.

Safety tips: Failure to obey may result in the serious life risks of the operators.

Safety tips: Failure to obey may hurt the operators.

### **1.2 Before use of machine**

Please read the manual carefully before operating the equipment.

Please keep the manual in the available place.

Keep both hands away from the adhesives.

Please do not use this machine if failing to ground in accordance with the electrical scheme.

Please do not expose or use this machine in the improper place.

For your safer operation, please ensure that all described safety items abide by the manual.

### **1.3 During machine installation**

For the purpose of moving the machine, please use the pallet forklift. Or, if you use the lift truck, please ensure that the machine is transported by the qualified professionals. Please always keep the balance of the machine while locating the fork of the pallet forklift or lift truck (Fig. 1).

This machine must be installed in a proper concrete working area with smooth surface, big density, solidity, brightness and ventilation which is far away from doors and windows but has the air circulation and can avoid the dust, so as to pollute the adhesives.

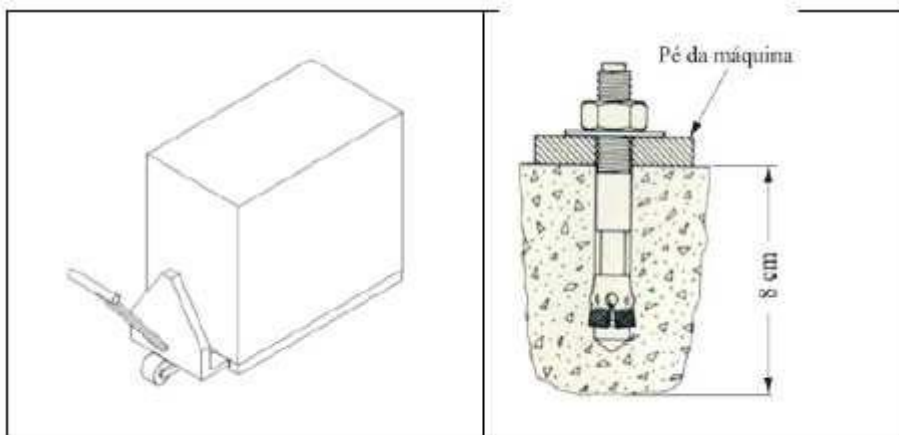


Fig. 1

Fig. 2

The grid connection of the machine must be executed by the skillful professionals.

The power grid must be assembled by the qualified professionals in accordance with the prerequisites of the installation.

#### **1.4 Before using every time**

Please check whether having the loose or damaged components.

Please clear any residues and residual articles on the machine.

Please do not use this machine without the protection and in the case of lack of original components.

#### **1.5 Important information of reducing the accident risk**

The operator should firstly read the manual carefully prior to installation, operation and maintenance.

It will reduce the losses that the machine and the operator may suffer.

Ensure that the operator receives the due training and has the ability to operate the machine.

Please do not lean against the machine when the machine is working.

Please do not start the heat seal program before the adhesives fail to reach the ideal temperature and fail to be liquefied completely.

The clamp should be properly set in accordance with the manual.

Please do not start the adhesion program before rotating the clamp to the maximum.

Please put the machine in the clean and tidy environment.

Please press the emergency button immediately in the case of the unexpected things.

Please do not put both hands in the above when the gummed paper has the residual heat.

Ensure that any articles are not placed on the machine before using the machine for working.

Fasten the parts to be bonded, and confirm that they are fully fastened on the working plate.

Please do not use the altered or damaged parts.

Please turn off the machine, interrupt the power supply, and take the appropriate maintenance measures if perceiving any exception.

If failing to take some protective measures, this machine should not be used.

This machine should not be close to the flammable liquid, dust, steam or natural gas.

Please do not bond two parts at the same time.

The operator should use this instrument after receiving (the person who has the ability to use) the training.

The existing protective measures should not be removed. Violation of the above suggestions may result in the safety problems.

#### **1.6 Protective measures**

Do not wear the loose clothes and tie, and wear the jewelry in the work environment.

As the protective measures, the operator in long hair should tie the hair up by the headscarf, for fear of being rolled up by the movable part of the machine.

Please make sure taking the appropriate protective measures to insulate the high temperature in the case of contacting with hot parts.

**Remember:** Distraction is a small matter, but the accident is a great event.



### **1.7 At the end of operation**

Turn off the machine.

Turn off the main switch.

Clean the machine and prepare for the next operation.

### **1.8 Storage**

The machine should not be stored in the humid and dirty place, or should not suffer from the indefinite weather. The machine should be covered with the insulating plastics in the case of storage or nonuse.

## **2. Receive Edge Banding Machine**

Edge Banding Machine is also equipped with a wooden packaging plastic wrap while delivery. In the case of removing the package as needed, please conduct the following operations:

Knock on the wooden packaging by the hammer (the manufacturer is not responsible for providing), and be careful of the cramp hurting the operator.

Please confirm that all following components are fully equipped.



Fig. 2



## Edge Banding Machine

01 Wooden pallet at the entrance (Component 01)

02 Supporting arm of sideband (Component 02)

03 Sideband bracket (Component 03)

04 Fixed worktable (Component 04)

05 Tool box (Component 5)

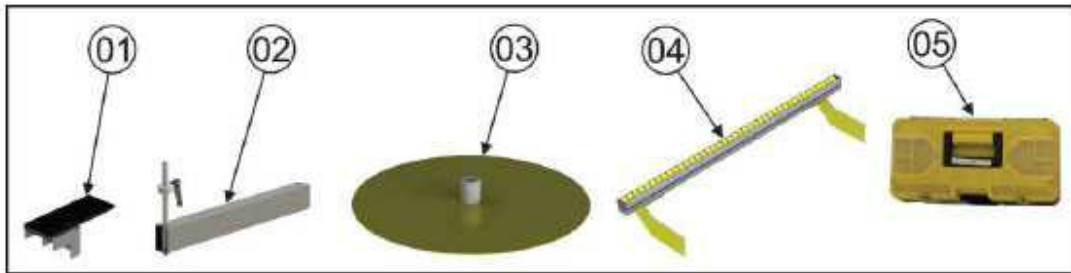


Fig. 3

### 2.1 Tool kit

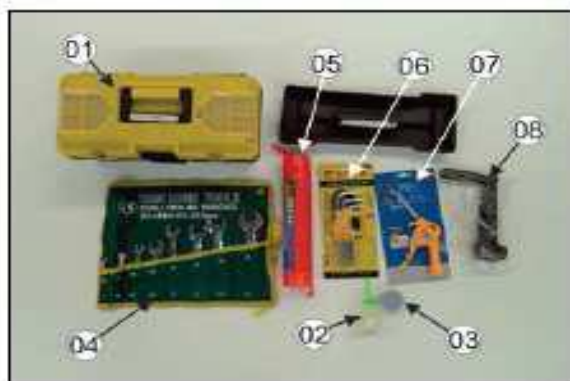


Fig. 04

01 Tool kit (Component 01)

02 Vaseline (Component 02)

03 Lubricating oil (Component 03)

04 Wrenches (Component 04)

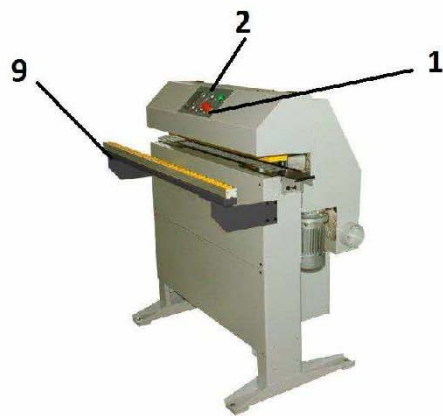
05 Spiral flexible pipe air nozzle (Component 05)

06 Allen wrench set (Component 06)

07 Air nozzle cleaner (Component 07)

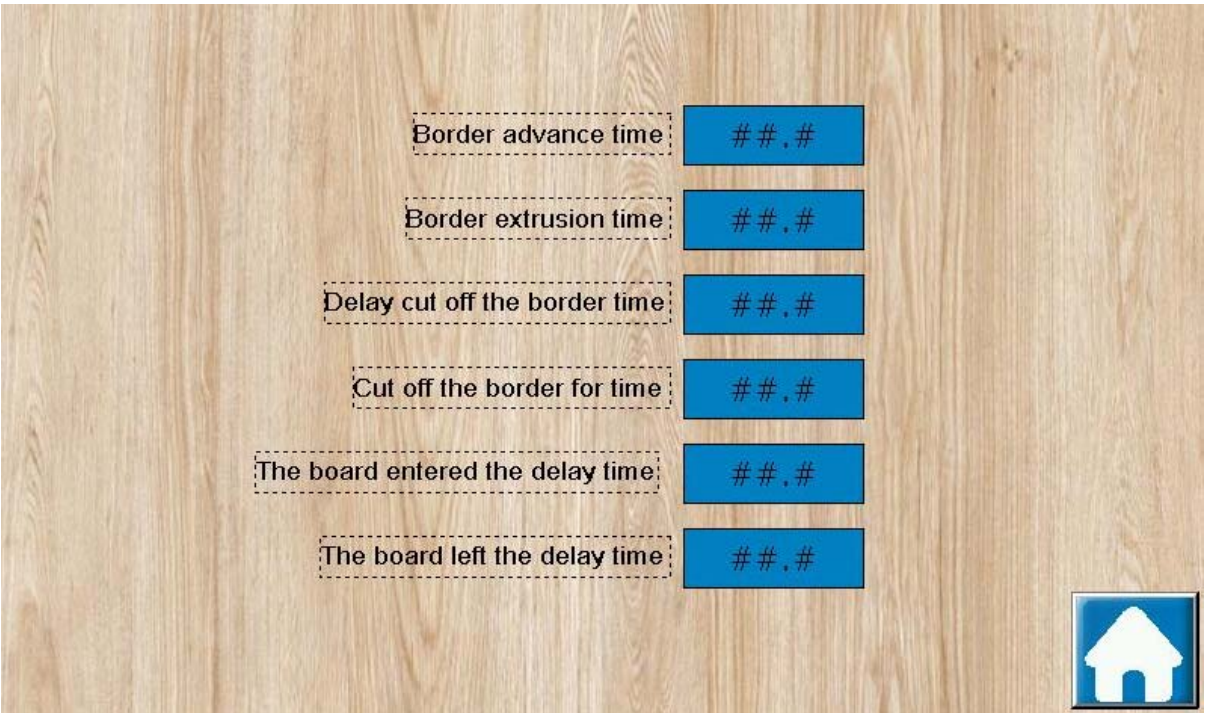
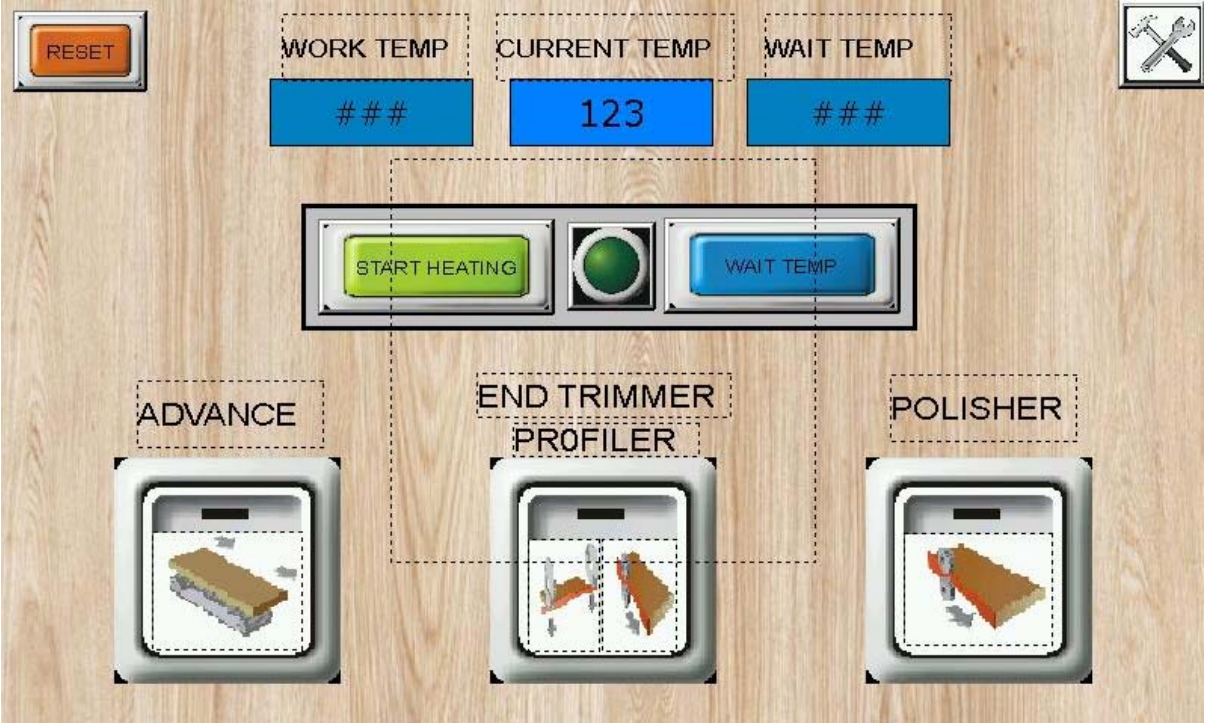
08 Handle of adjusting the panel thickness (Component 08)

### 3. Learn about the machine



- 01-Emergency button
- 02-Control panel
- 03-Height mark for pressure roll
- 04-Rotary height adjusting rod
- 05-Side tape supporting arm
- 06-Master switch
- 07-Junction box
- 08-Lubrication
- 09-Fixed work table
- 10-Trimming regulation and control
- 11-Pressure-type pushing roll
- 12-Tape cutting unit
- 13-Adhesive motion setting
- 14-Machine hood

3.1 Touch Screen



#### **4. Technical Specifications**

Min. Panel Length:	100mm
Min. Panel Width:	130mm
Panel Thickness:	9-40mm
Edge Width:	12-43mm
Edge Thickness:	0.4-3mm
Feeding Speed:	6.5m/min
Air Pressure	6 Bar
Power Voltage	240V/50HZ
Total Motor Power	2830W/3.2HP
Feeding Motor Power	1100W
End Trimming Motor Power:	370W
Fine Trimming Motors Power	500Wx2
Buffing Motors Power	180Wx2
Net Weight:	590Kg
Packing Size	2300x750x1450mm

#### **5. Installation**

##### **NOTE**

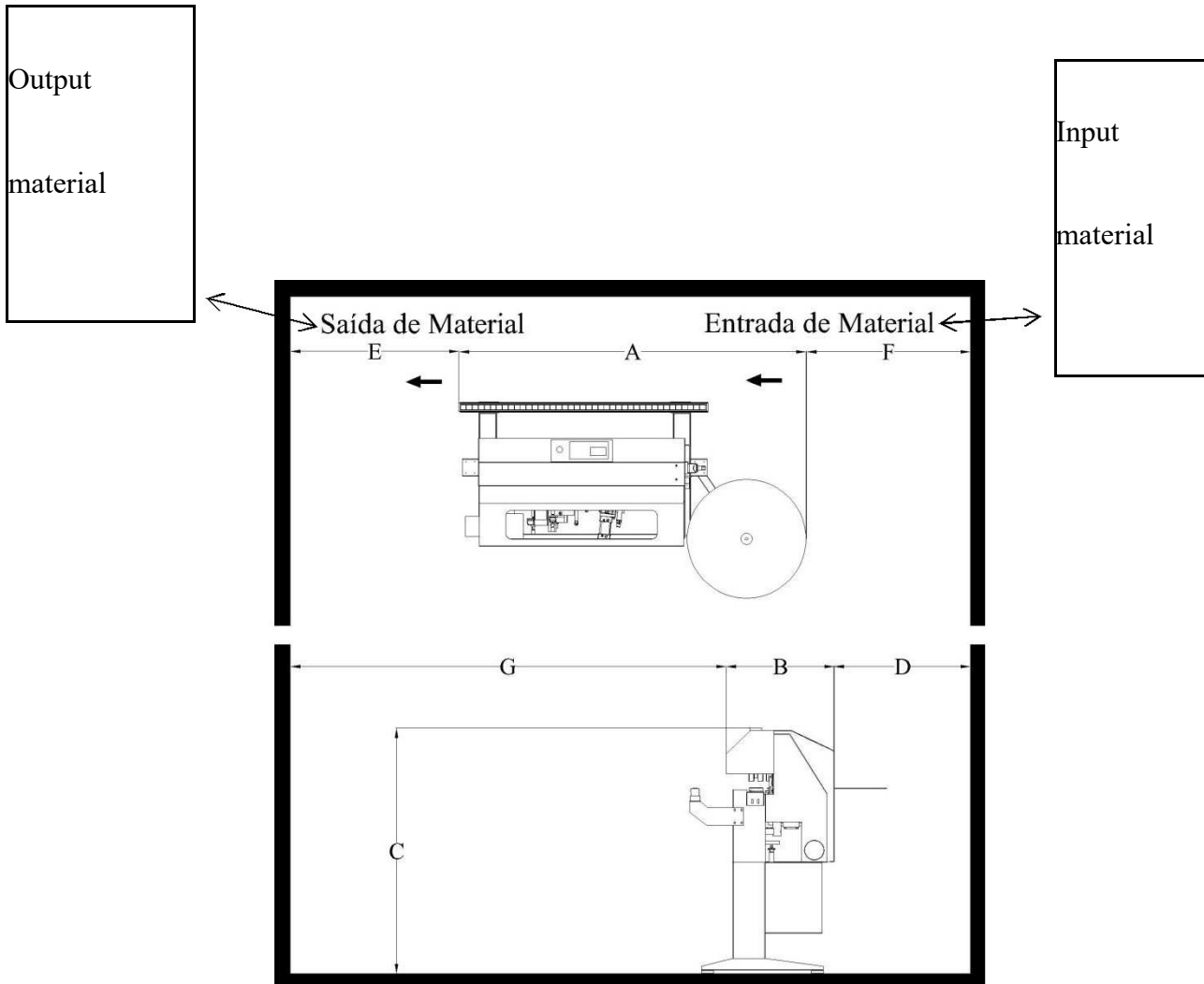
√Please read operation instructions carefully before connecting the power source of the machine and the power source of the air compressor;

√Prior to installing the machine, please examine whether electrical screws are fastened, because they could loosen during transportation;

##### **5.1 Space needed by Edge Banding Machine**

Before installing, you must estimate appropriate space in your company, please refer to the following figure 11. When the machine hood is completely opened, the machine needs 1.9m in height.

Modelo	A	B	C	D	E	F	G
ME-207	3000	542	1280	1300	3400	3400	3400



Key point:

√Examine all components of the machine prior to the installation of the machine

## **5.2 Electrical Installation**

### **Danger**

√Electrical service must be operated by sophisticated electricians;

√Please use the electrical installation diagram to help you in respect of installation, you can find the diagram at the end of the instructions;

- √Your machine should be stored at a dry place with air, should not be exposed to natural conditions;
- √In order to avoid electric shock and damaging the machine, please cut off the power prior to repair;
- √the machine is switched on, must not touch the lower end of the machine;
- √If the power wire is broken, immediate replacement is required;
- √If grounding is not correctly performed according to the drawing, do not use the machine.

**Note**

- √The operation must be performed by sophisticated technicians;
- √Please confirm whether the rotating direction of the motor is correct, otherwise, please contact technicians.

**5.2.1 Electric connection**

- Verify the standard of local public service company to install such equipment and factory takes no responsibility for any client who makes adjustment for agreed requirements of local energy approval authorities.
- The electric grid should be installed in compliance with the figure 11.

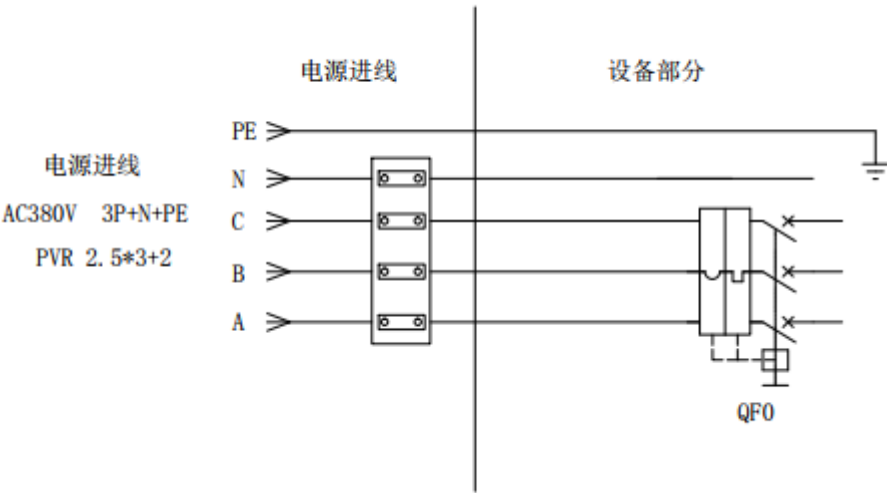


Figure 11--Installation Instruction

- √It is a mandatory single-pole circuit breaker (figure 5), or double-pole circuit breaker (figure 6), Curve C in IEC standard, as shown below

Model		Wire
Edge Banding	Machine	2.5mm²
380V		

√The connection of the machine and the circuit breaker of the machine should conform to the following rules:


√Note: According to NBR5410, if the distance between the electric grid and the electric framework is larger than 10m, you should check the operation profile map, and contact technicians.

√The device must be grounded in compliance with the current national standard.

√The client is responsible for the grounded efficiency.

√The resistance of the grounded device must be smaller than 5 ohm. The violation of the provision may result in the damage to the machine or the injury to the safety and health of the operator.

√The variation of the voltage at the entrance of the device is 5%, and the adjustment is made according to the following standard:



Voltage	Variation	Total
380V	+5%	399V
380V	-5%	361V

### **5.3 Exhaust system on machine**

√ Mandatory installation of efficient exhaust system, please check the item

—exhaust system

**Note: The violation of this item may result in serious damage to the machine and loss of insurance.**

**Note: The exhaust system of is recommended not to be larger than 5m in installation.**

√We suggest it be installed between the entrance wrench of the exhaust system and the electric grid. The right wrench is used for protecting the engine, and it consists of the following components: magneto circuit breaker + contactor + overload protection + switch. This job should be completed by qualified professional electricians.

### **5.4 Accessories of machine**

The accessories (01, 02, 03, 04 in figure 12) in the package should be demounted.

Operation should be performed upon the model.



√According to (figure 13), screw 04 penetrates through bottom part 01 (figure 12)

√According to (figure 14), fix 02 via screw and nut of 01

√According to (figure 14), wedged mortise (figure 12)

√According to (figure 14), part 04 keeps aligning through screw 08

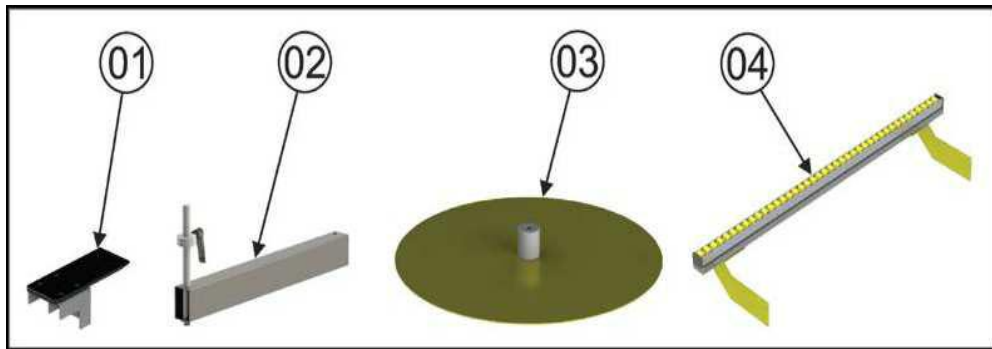


Figure 1

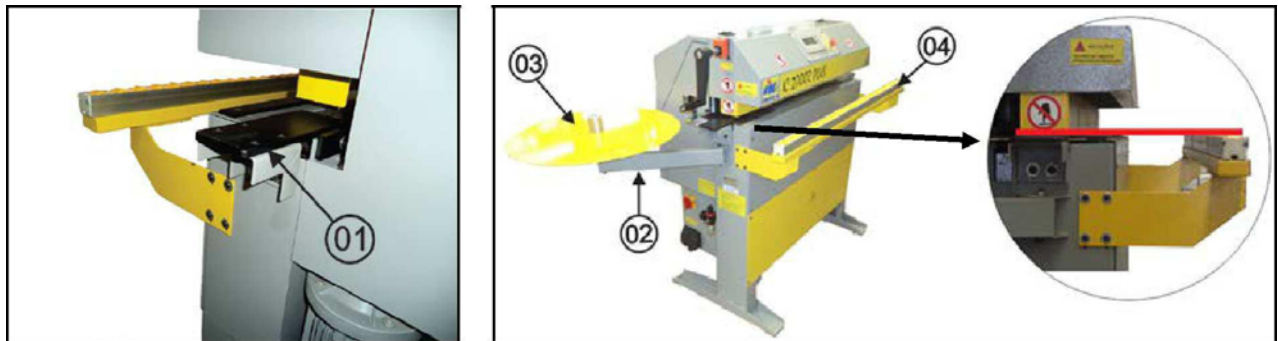


Figure 13

Figure 14

21

## **5.5 Pneumatic installing machine**

### **5.5.1 Connection of air compression hose**



Figure 15

√ Connect the machine to the compressed air source (01 in figure 15) √ Adjust the circuit pressure to 0.6Mpa.

### **5.5.2 Lubrication**

The product developed by us has long duration and high performance. In order to fulfill all demands of our clients, we test all machines prior to packing to ensure quality. Please note, before you use the machine, the machine leaving our factory is provided with little oil for test. To obtain a device with good performance, the oil amount suggested for (03 in figure 15) must be accepted. Do as follows to achieve such purpose:

- √ To connect (01 in figure 15), cut off the air network and the supply of compressed air;
- √ Rotate clockwise to put down the window;
- √ Fill the container with more than half of gasoline, see the condition 7.5 table of lubricating oil and lubricating grease
- √ Replace the container at the original place. Please confirm O ring.
- √ The amount of oil drop is adjusted by the factory, and in general, multi-step adjustment is made. However, we recommend the operator to examine whether one oil drop can be consumed per 20 to 30 drivers. If adjustment is needed, please operate the following instruction:
  - √ Rotate the pull rod (04 in figure 15) clockwise till it is completely closed. Then, loosen  $\frac{1}{4}$  till the lubricating oil gets the position mentioned above.

## **6. Operation**

Attention

- √ Touching the glue container when the machine is operating is forbidden. Be careful

✓ Don't begin your work on the machine before the temporary of the machine meets the prescribed conglutination standard.

✓ After the prescribed temperature is met, start all the equipment components and keep the machine operating for at least 5 minutes.

Danger

✓ Put the machine into service when all the protecting equipments are installed and run properly.

## **6.1 Webbing adjustment**

The webbing should be set to be no more than 0.4 millimeter thick when the machine is dispatched from the factory.

✓ When the panel in the figure 16 is pasted, the operator should choose the width of the adhesive tape panel, which is important for enclosing the panel.

✓ The chosen adhesive tape on the two sides of the panel should be about 0.15 millimeter wider than the each side of the panel.

✓ Install the tape roll on the support plate with adhesive tape as is shown in the figure 17.

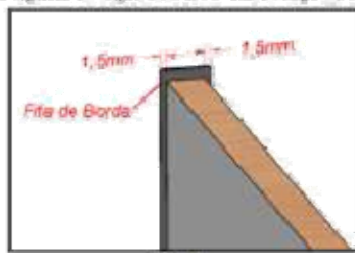


Fig.16



Fig.17



Fig. 18

✓ Place the tape handle (position-02 in the figure 18) gently.

✓ Add the tape and thread in the back of tape pressure board (position-01 in the figure 18).

✓ Only press the tape button (position-02 in the figure 02). Close the handle of that position.

✓ Check if the adhesive tape is added properly, making the space as small as you can.

✓ Press the adhesive tape (03 in the figure 18) gently. Do not press it heavily or leave too much space, otherwise the tape cutting machine would pull or waste materials.



Fig. 19

## **6.2 Adding adhesive tape on the glue container**

- √ Remove the lid(position-01 in the figure 19) of the glue container.
- √ Check the horizontal position of the tape on the glue container (figure 19). (A small amount of tape comes with the machine. It is for the factory testing.) If necessary, replace it carefully, keeping the horizontal position of the tape no more than 1.5 centimeters higher than the glue container.
- √ Use the panel binder only when the tape is running at a slow or moderate speed.

### **Attention**

- √ Don not touch the machine with your hand or any other part of your body when the machine is pasting, otherwise you'll be scalded severely.
- √ Do not blend different glues otherwise the work efficiency of the machine would be reduced. Please clean the container when changing the glue.

## **6.3 The adjustment of the binder's temperature.**

### **Attention**

- √ The glue container will get hot when the machine operates. You'll be scalded severely if you touch it.
- √ Don't start the machine before the temporary meets the prescribed standard, or the machine will be damaged.
- √ Don't use the machine when ambient temperature is below 18 °C. The panel materials and the tape panel must be heated beforehand.

Note: The temperature or applicable temperature of the heat sealing machine glue container is 130-220°C, but it should be operated according to the operation guide after the dispatch from the supplier. As for other temperatures, you should confirm the technical data from the glue supplier.

- √ Do as the follows to manage the temperature of the glue.
- √ Press “SET” button;
- √ And input the temperature figures needed by pressing numeric keys, and then programming the temperature needed, confirming by pressing “ENT” button.
- √ When the real temperature of the glue shown on the display is higher than that on the left/right, the operator should adjust the temperature;
- √ “CLR” button is for clearing the adjusted figures on the display.
- √ The amount of the binder in the container should be always sufficient. Adding more binder than the container’s level can help preventing the glue from getting hot.
- √ After the machine switches into “stand by” mode, please adjust the general temperature to a getting hot. It stays idle for more than 15 lower level to avoid the glue

## **6.4 The adjustment of the binder's amount**

### **Attention**

- √ Adjusting the binder's thickness under the non-working temperature is forbidden.
- √ Ambient temperature can influence the adhesive tape. When it is cold, operating the machine for 30minutes before working is advised.

The Edge Banding Machine has its own usable glue layers when it is dispatched. Do as the follows if you need change it.

- √ When the temperature on the display has met that designed by the program, start the machine, pressing the numeric key 2 (figure 21) on the display.
- √ When the machine is started and the temperature is applicable, please operating the machine for at least 5 minutes, making sure that there is sufficient glue in the Transmission Pipe.
- √ Rotate the time-controlling handle (position-01 in figure 22) and set the maximum thickness of each glue layer. And then, set the minimum thickness of each glue layer without time controlling and rotate to the marked point (position-02 in figure 21) for verification. By doing this, you can get the ideal glue thickness to finish your task.

## **6.5 The adjustment of the front panel union**

The rolling wheel supply is the main undertaker to instruct the panel's automatic operation when gluing the panel. You can control the thickness of each panel on the rolling wheel supply by doing the follows:

- √ Hold the panel in your hand and measure the thickness with a Vernier caliper, confirming as is shown in figure 24;
- √ Use the handle to adjust the panel's thickness until it meets the requirements of the gauge(position-01 in figure 25).
- √ The average thickness of the panels should be the same to that of the compressor.If the rolling wheel supply presses the panel gently or heavily,the compressor will adjust the adhesive tape on the working panel.



Fig.24



Fig.25

## **6.6 The button to adjust the rolling wheel of adhesive tape on the working panel**

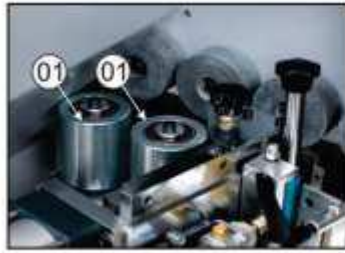


Fig. 26

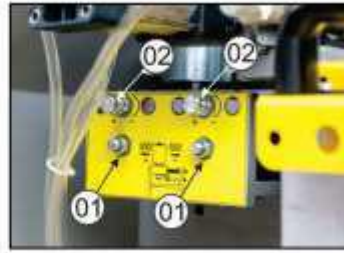


Fig. 27

The rolling wheel is to instruct the operation of the panel, making sure that there proper support when pressing the panel with the adhesive tape on the working panel. There is no need to adjust those rolling wheels for they have been adjusted in the factory. If you must do as the follows:

- √ To adjust the button (position-01 in figure 26) of the rolling wheel on the working panel, you should turn the screws (position-01 in figure 27) round and round, and control the time button and deal with another button (position-01 in figure 26) without time controlling in the same time.
- √ After managing these rolling wheel buttons, you should adjust them to increase the pressure to the screws (position-02 in figure 27) at certain times or reduce the pressure to the screws from the rolling wheel.
- √ Frequently clean these rolling wheel buttons and keep away from the binder.

## **6.7 The adjustment of the joint manual operator.**

The Edge Banding Machine is dispatched with the set joint manual operator. If you need change it, do as the follows so that you can raise it when it has decreased.

- √ Confirming in figure 28, adjust the places of the manual operator.
- √ Pay attention to the maximum thickness of the working panel, and each side should be 2.00 millimeters thick.

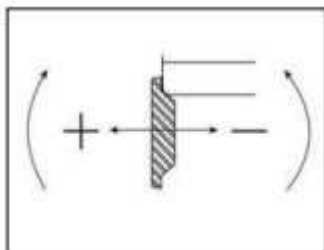


Fig. 28

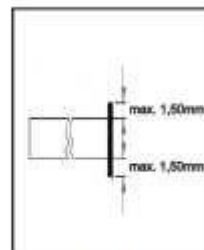


Fig. 29

### **6.7.1 The adjustment of the vertical manual operator.**

Do as the follows to manage the vertical manual operator:



- √ Loosen the screw (position-01 in figure 30).
- √ Adjust the height to the middle of the handle (position-2 in figure 30).
- √ Attention: using the panel with or without rotating the time controlling handle, such instructions should be started on where the trademark (position-01 in figure 30) is.
- √ Tighten the screws after those steps.
- √

### **6.2.2 The adjustment of the horizontal manual operator.**

- √ Loosen the screw (position-01 in figure 31).
- √ Adjust (in the front or in the back) the rotating handle of the manual operator(position-02 in figure 31).you can use the panel with or without rotating the time controlling handle. The average thickness of the working panel should be within the range of the display.
- √ Tighten the screws (position-01 in figure 31).



Fig. 30



Fig. 31

## **6.8 Install Workbench sideband**

### **Notice**

- √ When select to stick panels with workbench sideband, you shall stick different material with particular tape. If necessary, each kinds of material shall be used with different proprietary glue;
- √ Any panel is forbidden to stick until the temperature reaches the temperate explained by the provider; otherwise the machine will be damaged. After the glue reaches the regulated temperature, start the machine and run for at least 5 minutes;
- √ When the temperature has not reached operating temperature, you shall adjust the thickness of the glue as more as possible;
- √ In those days where temperature is below18 degree, it is recommended to start the machine and run for 30minutes before working;
- √ After starting the machine, containers filled with glue began to heat up. If tough, it may causes scald to the operator;

- √ It is forbidden to put hands or other parts of body into glue pot ,otherwise it will bring the risk of severe scald; Hands shall keep distance with the roll wheel supply of panels;
- √ Adhesive-glues of different types are forbidden to mix, which will influence the working efficiency of bonder. Regularly clean the container filled with glue when replacing the glue;
- √ Use the machine on the condition that all the protective devices have been installed and can operate normally;
- √ Check all the generators to ensure that they can normally operated. If they are abnormal, please contact the technical support of;
- √ Material to be stuck shall be avoided to interrupt for more than 12 hours in the process of the adhesive, which will become moist and affect adhesiveness. For bars, the most ideal state is to avoid damp, and be stored in the greenhouse before the adhesive. For sub-point bars, the humidity is recommended to between 8%-12%. Adhesiveness will also be affected by surrounding environment, so adhesive-glue shall be bonded together with other materials.
- √ It is suggested that all the items be installed in a dry environment and be away from dust and diesel.
- √ This machine will operate normally on the condition that the temperature reaches the operating temperature after leaving factory.
- √ Check whether all the glues are normal before starting work.
- √ Check the technical data provided by the manufacturer of the glue regularly.

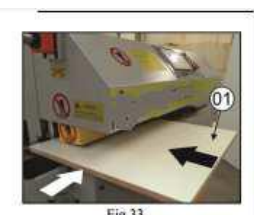


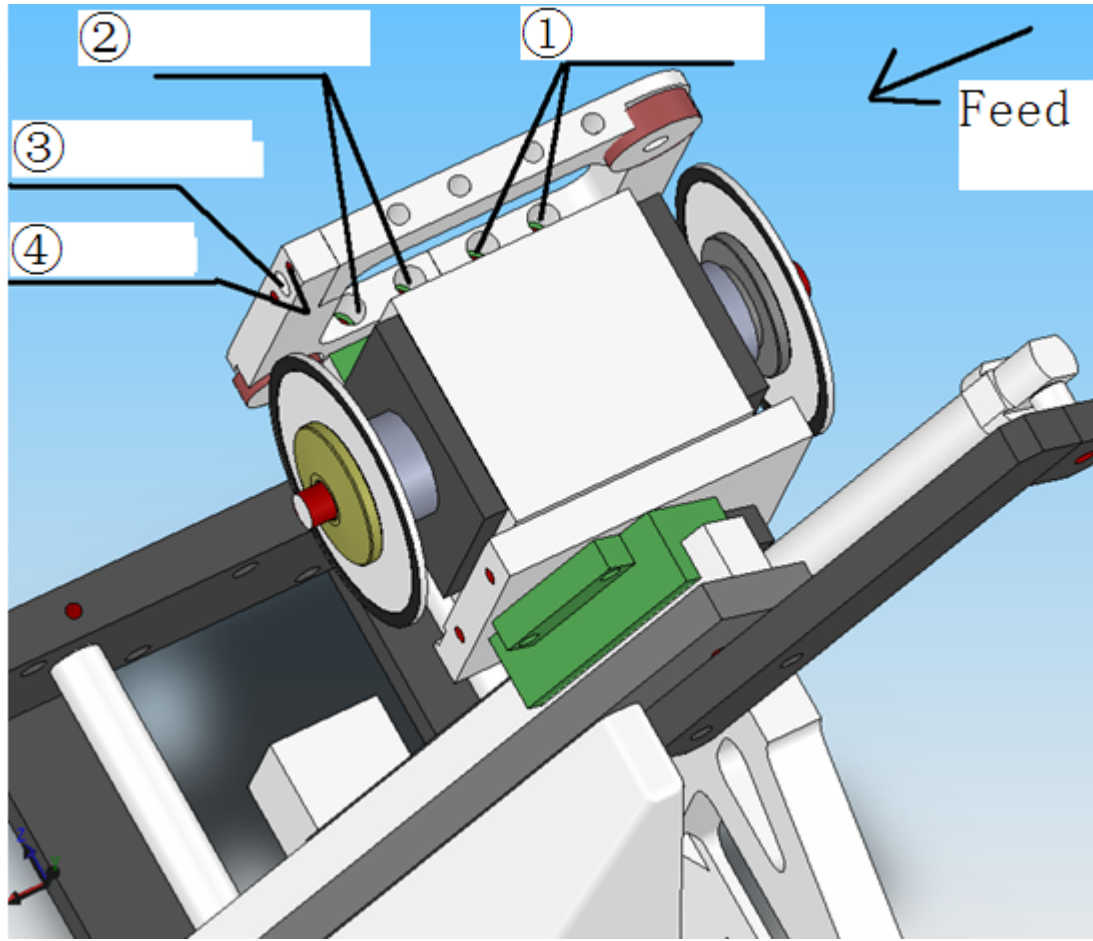
Fig.33

- √ After the temperature reaches a predetermined temperature. Start the machine and press technical data of button 2. (Figure 32) start manual operator.
- √ After the machine is overall startup, the machine shall be operated for at least 5 minutes to melt glue;
- √ Put the panel to be bonded on the tape and fixed and supported with desks;
- √ Push the panel with hands in the direction of roll wheel supply to make the panel adjoined tightly and guide the parts to pass by (figure 33). This will ensure that the parts complete bonding within the framework;

√ When finished, the machine will push the panel to the operator appropriately. Then ensure that the panel will come out on the other side of the machine (01 position of figure 33). In this from, the adhesion work is done.

√ Turn off the machine, press button1 (figure 32)

### **6.9 End cutting group**



1. front end trimming plate fixing screw
2. tail end trimming plate fixing screw
3. plate locking screw
4. plate adjustment screw

#### **6.9.1 Operation**

The end cutting group it's activated pushing the button in touch screen.

Once activated, the motor start up.

When the board move forward, touch the front tracer and the group start the descent and cut the front part of edge.

The contact between the tracer and the board is maintained by the pressure piston that can be adjusted with gauge L. The Factory preset it's 5 bars.

Once the front cut it's done, the group back and wait until the switch signal from micro switch M. When the board release the switch, the groups advance to do the rear cut.

### **6.9.2 Adjust**

End trimming adjustment method:

When the edge band appears longer on the edge of the panel, you need to loosen the “front end trimming plate fixing screw”, then turn the “plate adjustment screw” counterclockwise to rotate the appropriate position, and then “plate locking screw” is tightened, and after the final adjustment is completed, then “front end trimming plate fixing screw” is locked.

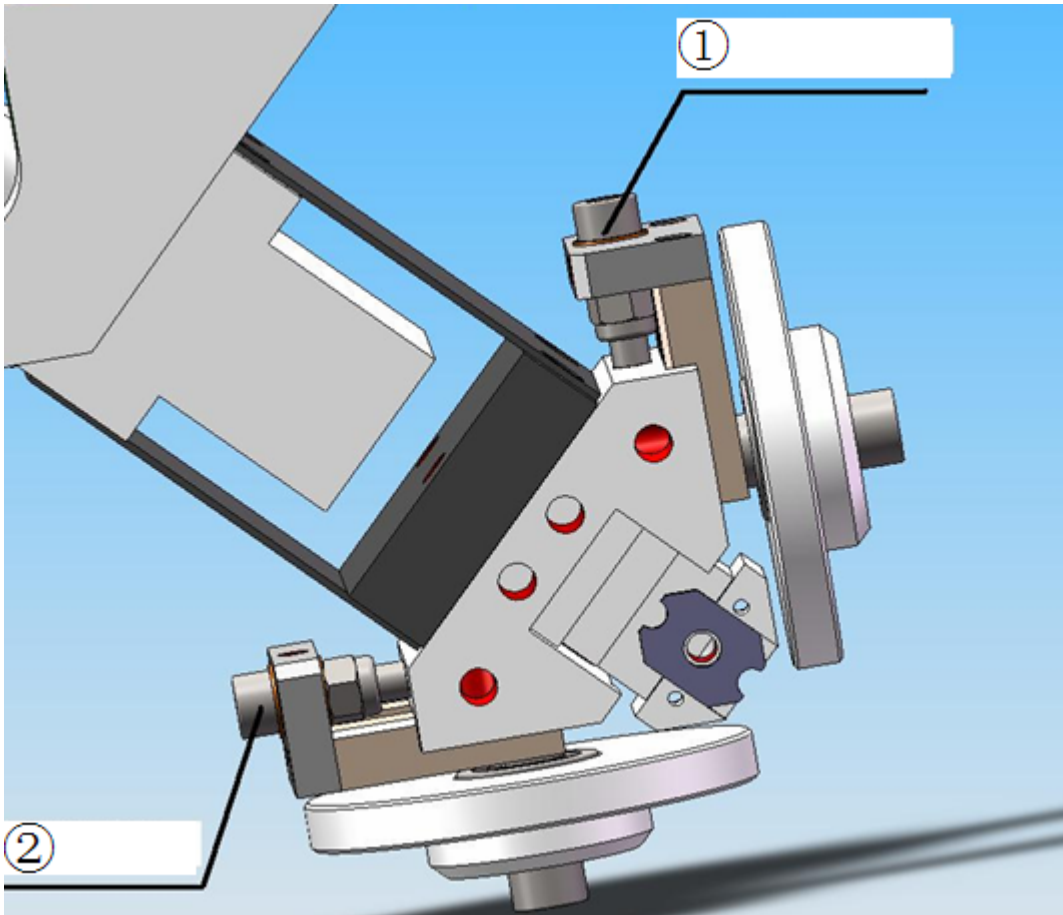
When the edge banding is shorter than the plate, you need to loosen the “front end trimming plate fixing screw”, then loosen the “plate locking screw” counterclockwise, and then adjust “plate adjustment screw” by clockwise. Rotate to the appropriate position and lock the “front end rimming plate fixing screw” after the final adjustment is completed.

Tail end trimming adjustment method:

When the edge band appears longer on the end of the strip, you need to loosen the "tail end trimming plate fixing screw", then turn the "plate adjustment screw" counterclockwise to rotate the appropriate position, and then turn the " plate locking screw" clockwise fasten and lock the “tail end trimming plate fixing screw” after the final adjustment is completed.

When the edge banding is shorter than the plate, you need to loosen the “tail end trimming plate fixing screw”, then loosen the “plate locking screw” counterclockwise, and then rotate the “plate adjustment screw” clockwise. In the proper position, after the final adjustment is completed, the “tail end trimming plate fixing screw” will be locked.

### **6.10 End cutting group**

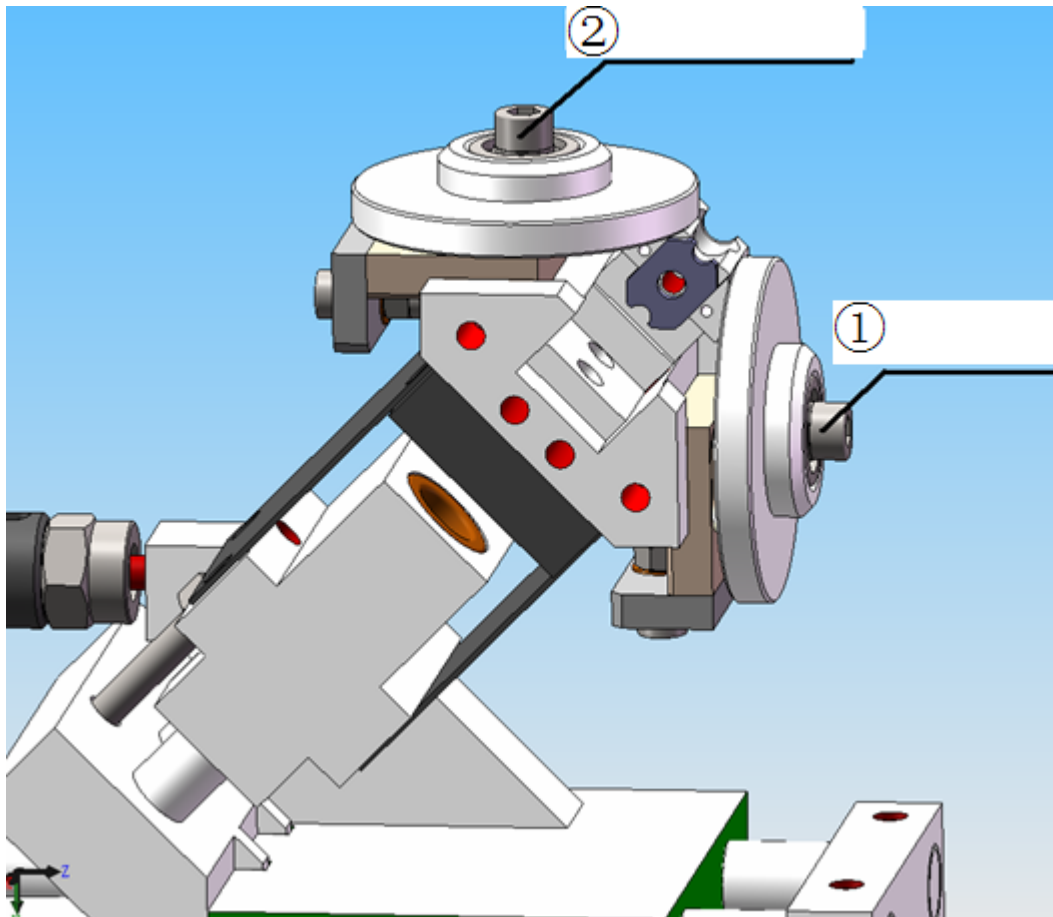


1. UP SCRAPING UP ADJUSTING WHEEL
2. SIDE ROLLER ADJUSTING SCREW

Upper scraping adjustment method:

When the edge panel passes the upper scraping device, if the scraper is scraped onto the surface of the panel, it is necessary to rotate the "upper scraper upper adjusting wheel" clockwise. Otherwise, it rotates counterclockwise.

When the edge panel plate passes the upper scraping device, if the arcing is too large, it is necessary to rotate the "side roller adjusting screw" clockwise. Conversely, rotate counterclockwise.



1. Lower scraping lower pressing wheel adjusting screw
2. Lower scraping side pressure roller adjusting screw

Lower scraping adjustment method:

When the edge panel passes through the lower scraping device, if the scraper is scraped onto the surface of the panel, it is necessary to rotate the "lower scraping lower pressing wheel adjusting screw" clockwise. Otherwise, it rotates counterclockwise.

When the edge panel passes the upper scraping device, if the arcing of the scraping edge is too large, it is necessary to rotate the "lower scraping side pressure roller adjusting screw" clockwise.

Otherwise, it rotates counterclockwise.

### **6.11 Buffing group**

The buffing group it's used for the finishing of the piece, cleaning and polishing any glue stick over the piece Surface.

The buffing group it's activated from the touch screen when the feeding chain it's activated.

The group has 2 asynchronous motors of 0.18Kw with polishing pads that should be change when wear was. These pads should be adjusted to be in contact with the piece only 1 millimeter approx.

The adjustment of motor can be made loosen the screw that holds the motor.

### **6.12 How to take away the machine adhesive?**

Please follow the below steps to take away the machine adhesive.



Fig. 37

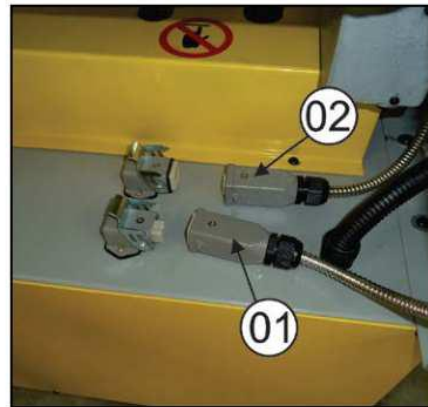


Fig. 38

Turn off the main switch of the machine. (For details see Position 01, Picture 37.) Disconnect the resistance power plug and thermocouple connector. (For details see Position 01 and 02, Picture 38.) Pull the machine adhesive towards the back (For details see Position 01, Picture 41.) and make the tractor to be in the position of Picture 42. (For details see Picture 42.)

Loosen the handle. (For details see Position 01, Picture 39.)

Take away the guiding device of the adhesive. (For details see Position 01, Picture 40.) Take away the machine adhesive by wearing heat-resistant gloves, and pull up the handle to the vertical direction as shown in Picture 43. (For details see Picture 43.)





Fig. 39



Fig. 40



Fig. 41

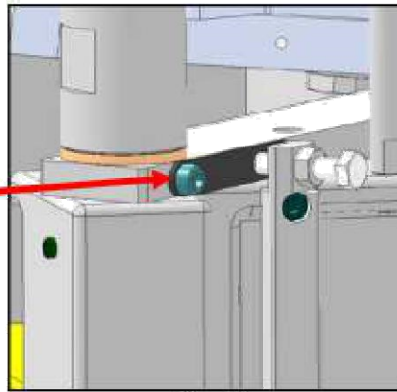


Fig. 42



Fig. 43

### **6.13 How to put the adhesive onto the machine?**

Please follow the below steps to put the adhesive onto the machine.

Put the adhesive to the position of the support shaft. (For details see Picture 43.)

Please do not damage the resistance power supply wire and thermocouple wire.



Change the tractor position and make the adhesive to be in the normal operating position. (For details see Picture 42.)

Plug the resistance power plug and thermocouple plug into the sockets. (For details see Position 01 and 02, Picture 38.)

Turn on the main switch. (For details see Position 01, Picture 37.)

Press Button 01 of the control panel, so as to heat the adhesive. **For details see Item**

## **7. Maintenance and cleaning**

### **Danger**

Before doing any repair and maintenance, please make sure the machine is in a power completely off state. Furthermore, all the steps should be operated by professional personnel and or trained personnel.

The machine should be maintained and cleaned regularly, so as to make sure it achieves the ideal result in the process of using and to avoid the losses may be incurred for the operation personnel and the machine.

No turning on the machine before finishing all protection programs. It shall ensure that the ventilation system is on normal operation.

The distribution board of the machine shall be in the disconnected state when it is under the situation of maintenance or repair. People shall remember to disconnect the power under this situation.

When cleaning the ventilation system, it shall clean the collector interior and the air outlet system. It shall keep a clean operating environment, so as to avoid the machine oil and lubricant of the machine being in touch with ash, dust and wood chip.

### **7.1 The cleaning of the adhesive**

#### **Attention**

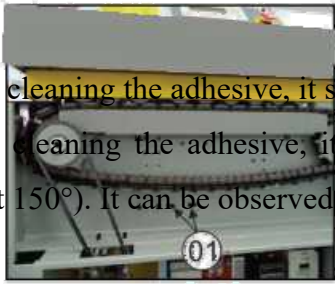
It should be careful when dealing with the overheating adhesive. It may cause severe ambition.

**Danger**



When cleaning the adhesive, it shall use the safety protective gloves (high temperature resistance).

When cleaning the adhesive, it is recommended to heat the file to the temperature of the trowel (about 150°). It can be observed that the adhesive will peel off completely after heating.



Tools needed: Fig. 50



Fig. 51

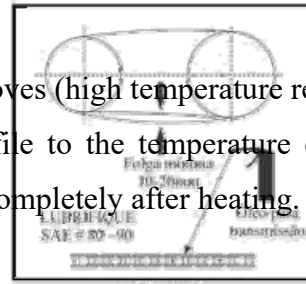


Fig. 52

Teflon trowel or wooden trowel (excluding in the machine)

Safety protective gloves with high temperature resistance (excluding in the machine)

### **7.11 Heat the file to clean the adhesive.**

For heating the adhesive, turn on the machine (main switch) and heat the adhesive to the operating temperature.

Use a stick to dip the adhesive. (For details see Picture 44.) Turn off the machine and let the glue cool down completely.

Turn on the machine again and heat the adhesive with melting exterior and solid interior.

Turn off the machine and pull the stick outwards, so as to make the adhesive paste to the stick. (For details see Picture 45.)

Use teflon trowel or wooden trowel to get rid of the adhesive with the thick layer, leaving the thin layer. (For details see Picture 46.)



Fig.44



Fig.45



Fig.46



Fig.47

After getting rid of the adhesive with the thick layer, make the adhesive cool down to the indoor temperature, so that the remained adhesive layer can be torn off. (For details see Picture 47.)

## **7.2 Lubricant and the gripping ability of transmission chain**

The welt fitting machine has the component with lubricant function, for example, mechanical transmission chain. In this case, for ensuring the normal operation, the transmission chain needs the lubrication of the lubricant.

The lubricant used by all transmission chain of the welt fitting machine can be made through lubricating grease or specially made machine oil. For details see Item 7.5 - lubricating grease and lubricant table.

There is a transmission chain under the adhesive (Position 01, Picture 48). This transmission chain is in charge of driving the transmission of the adhesive. It can be observed that the transmission chain needs to be a little bit loosened. Please follow the below steps to adjust the transmission chain:

Use a 4mm hexagon wrench to loosen and take off the screw, and then take off the iron cover, just like Position 01, Picture 48 and Position 01, Picture 49.

Then use 6mm hexagon wrench to loosen the screw but not take off, just like Position 01, Picture 50.

Use 13mm wrench to loosen the screw nut of Position 01, Picture 51. Then use 13mm wrench to turn the screw of Position 02, Picture 51 by anti-clockwise direction, until the transmission chain can meet the gripping ability requirement of Picture 52.

Picture 52 words: Flag minimum 10-20mm Minimum clearance: 10-20mm

Lubricant SAE#80-90

Transmission machine oil

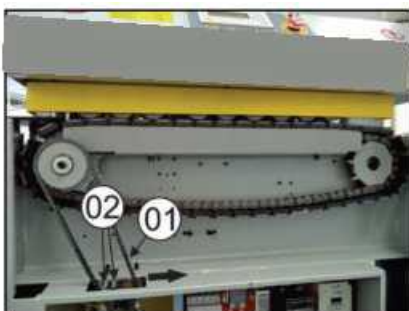


Fig. 53

For checking the conveying chain, it is recommended to take off the boards of Position 01 and 02 of the below picture.

The adhesive of the transmission chain of Position 01, Picture 53 is driven by geared motor for revolving shaft. For stretching this transmission chain, the screw of Position 02, Picture 53 should be loosened and put the gear in the direction of the arrow of Picture 53. After that, tighten the screw of Position 02, Picture 53 again.

### **7.3 Pay attention to other devices.**

Please read the below essential notes for the efficiency and output of the machine.

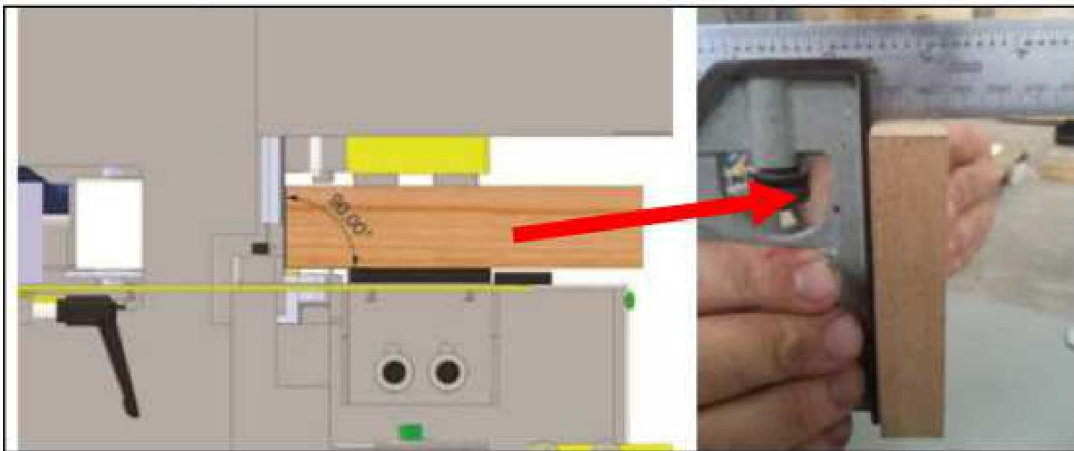


Fig.54

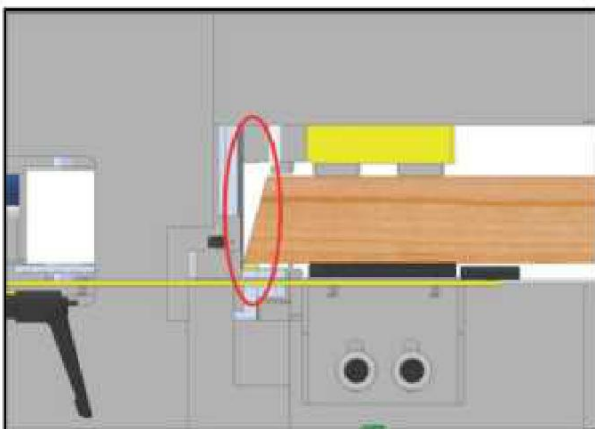


Fig.55

After using the machine, it is recommended to cover the machine with a tarpaulin, so as to prevent the environmental dust polluting the adhesive.

Make sure the part going to be stuck is a perpendicular type, that is, the bottom of the glued part and the main shaft of the adhesive can be  $90^\circ$ . (For details see Picture 54.) If the bottom is not  $90^\circ$ , the adhesive tape will not stick to the chassis completely. (For details see Picture 55.)

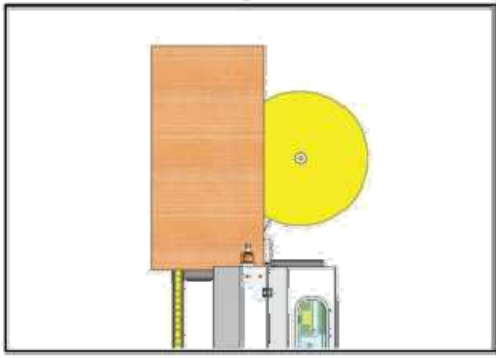


Fig. 56

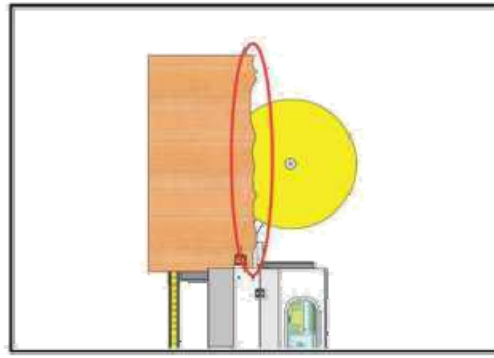


Fig. 57

Make sure the trimming line of the part is a straight line (see Picture 56). If the trimming line is not a straight line, then it will not stick correctly (see Picture 57).

## **7.4 Maintenance of pneumatic system**

### **7.4.1 Air filter apparatus and cleaning facility**

Check the compressed air condensate of the air filter apparatus. (For details see Position 02, Picture 56.) After leaving the compressor, the compressed air comes together with water, dirt and dust. Meanwhile, the lubrication oil tank can filter the compressed air and keep the dirt in the filter.



Fig.58



Fig.59



Fig.60

All the powers of the compressed air are different, so the water volume and dirt volume can be different. Therefore, we recommend users to check the water level in the lubrication oil tank everyday. (For details see Position 02, Picture 58.) If appropriate, empty the water level and it doesn't need to disconnect the power of the compressed air. (For details see Position 01, Picture 58.)

We also recommend cleaning the filter in the water tank at least one time a week.

Please follow the below steps for cleaning:

Disconnect the compressed air power. (For details see Position 01, Picture 58.) Rotate clockwise and take away the water tank. (For details see Position 02, Picture 58.)

Rotate clockwise and take away the filter (For details see Position 04, Picture 59 and Picture 58.), and use compressed air for cleaning.

After finishing the above steps, put the filter back in place.

Put the filter and water tank back in place again. Make sure the O-ring is inserted normally.

## **8. Possible problems - reasons - solutions**

### Note

Please turn off the main switch and disconnect the power before carrying any maintenance.

Problems	Possible reasons	Solutions
	No correct adjustment on	The adjustment on the adhesive tape
	adhesive tape guiding device	guiding device can't be too loose or too
		tight.
	The preset time for turning	
Welt feeder can't	on the adhesive tape can't	Adjust the adhesive tape timer, until
operate normally.	meet the operation time for	it meets the normal operation time.
	component dimensions.	
	The adhesive tape feeder	
		Adjust the operation pressure of the
	cylinder can't press the	
		adhesive tape feeder cylinder.
	adhesive tape fully.	
	The machine tool hasn't	Adjust the machine tool. For details
	been adjusted appropriately.	see 6.1.3
The machine tool is		Check whether the chassis is a right
not suitable or the	The chassis is not a right	angle and check whether it is inserted

machine tool damages	angle.	into the machine by a right angle
the welt.		form. For details.
	The chassis inserts into the	Check whether the chassis is rolling
	machine obliquely.	compacted by the feeder, that is,
		check whether the chassis can move
		freely (loose).
		The machine tool needs polishing
	Polish the machine tool.	when it is adjusted. The machine tool
		needs polishing only after getting
		adjustment.
	The contour surface is not	Check whether the contour is a right
	straight linear.	angle.
	When overall startup, it	Check whether the contour inserts
	doesn't move straightly.	into the machine obliquely.
	The cut of the component is	
		Check whether the component is a
	a non-right-angle or non	
		right angle. For details.
	linear.	
There is unevenness	It is too loose or too tight	
		Adjust the normal operation position

when sticking.	when sticking the	
		of the adhesive group. For details see
	component contour by using	
		6.6.
	the adhesive group.	
	During the process of	
	adhesion, sheets will	
	obstruct the contour	Adjust the normal operation positions
	contacting the adhesive	of the sheets.
	when it is too close or too	
	far away from the adhesive.	

	The quantity of the adhesive is too big or too small.	Adjust the quantity of the adhesive.
	The temperature of the adhesive can't meet the temperature required by the manufacturer.	Adjust the temperature to meet the temperature required by the manufacturer. And turn on the adhesive procedure when the machine temperature meets the designated value.
Edge cutting machine can't cut the adhesive	Lack of operation pressure.	Adjust the operation pressure.
	The knife is not sharp	Check whether the knife is sharp



tape.	enough.	enough.
Startup group can't slide successfully.	Startup group can't slide horizontally or vertically.	Adjust the startup group of the angle position.
	The chassis is adsorbed on the detector.	Adjust the startup group height according to the chassis height.
	The pusher over presses the component contour.	

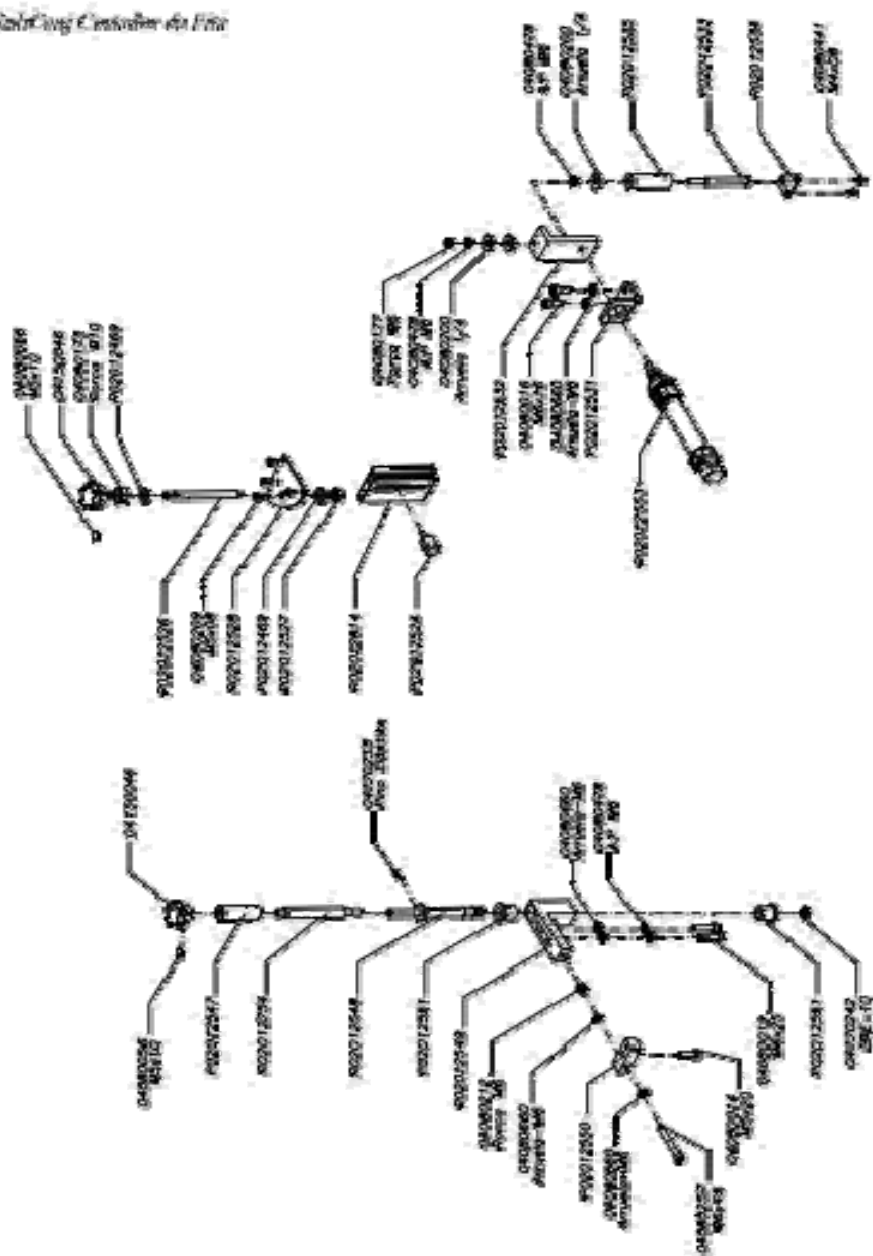
## EDGE BANDER CUBE

### PART LIST

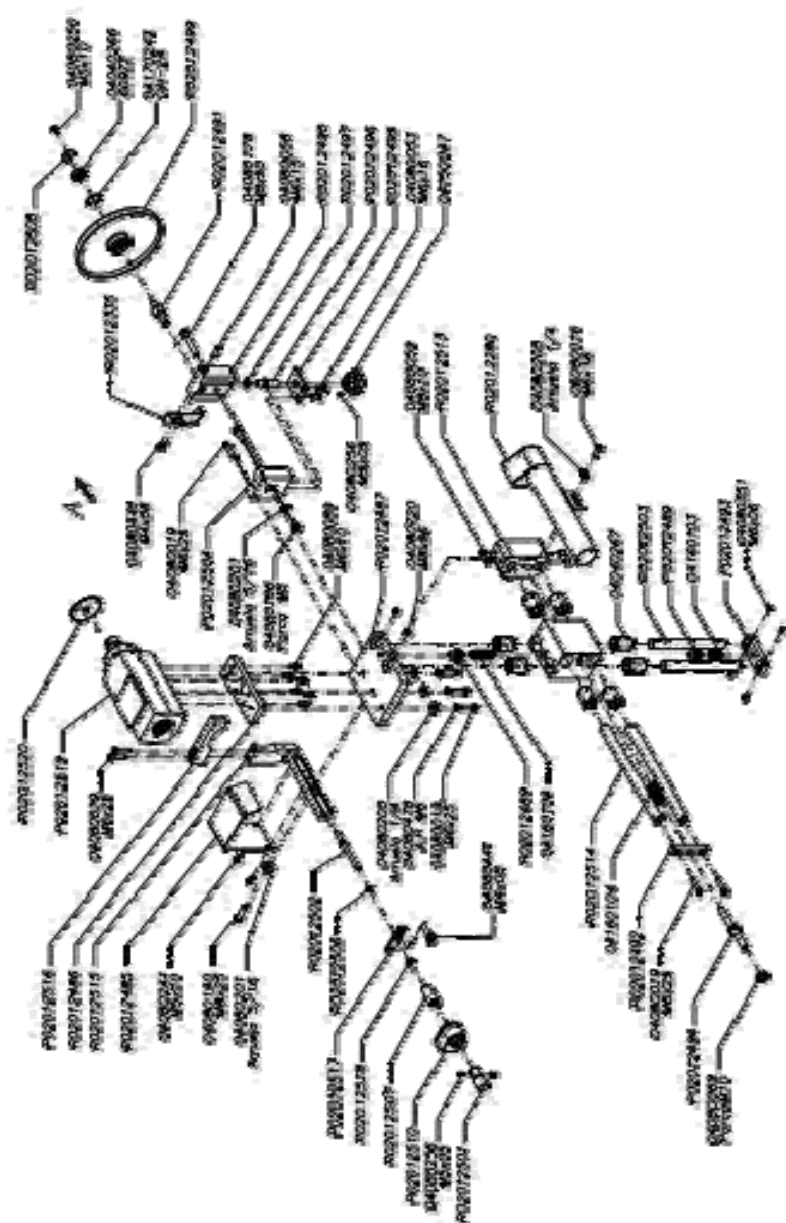
Code	Decription	Code	Decription
P02012521	tape coiling press plate guide	P020125	push broach
P02012522	tape coiling guide	P0201255 2	Oin cylider of tape coiling cutting machine
P02012523	take-up spool	P0302085	Manual alum M8x25 mm
P02012525	cutting machine stand	04080014	Internal engine cabin / cabin M5x20mm dimention 912 screw
P02012529	tape coiling scale guide	04080018	Internal engine cabin / cabin M6x20 mm dimention 912 screw
P02012530	cutting machine baseplate	04080019	Internal engine cabin / cabin M6x25 mm dimention 912 screw
P02012536	cutting machine strangulation	04080053	Internal engine cabin / flat cabin M6x16 mm dimention 7991 screw
P02012537	Fixed stand of cutting machine oil cylinder	04080057	Internal extension S/cabin M6x10 mm dimention 916 screw
P02012538	tape coiling scale facing bar guide	04080082	zinc coat 8mm grooved rod
P02012539	drum protection board	04080160	zinc coat 4mm Sext Ma nut
P02012540	cutting machine guide	04080179	zinc coat 8mm Sext Ma nut
P02012541	tape coiling scale support pin guide	04080253	Internal engine cabin / cabin M6x12mm screw
P02012542	cutting machine's blade	04080441	Internal engine cabin / flat cabin M4x8 mm dimention 7991 screw
P02012543	blade pin	04080478	zinc coat 6mmpressure disk
P02012544	fixing band support shaft	04080588	zinc coat M6x12 mm dimention 933 external engine cabin
P02012545	fixing band	04080660	zinc coat 6mmflat washer



Code	Description	Code	Description
P02012289	tape coiling guide	P02012754	Manual lever of scroll roll
P02012469	16x9,5x1,5mm washer	04080014	Internal engine cabin / cabin M5x20mm dimension 912 screw
P02012524	tape coiling output guide	04080016	Internal engine cabin / cabin M6x16mm dimension 912 screw
P02012526	tape coiling screw guide	04080019	Internal engine cabin / cabin M6x25mm dimension 912 screw
P02012527	tape coiling wheel nuts guide	04080056	Internal extension S/ cabin M6x10mm dimension 912 screw
P02012528	tape coiling support nut guide	04080173	10mmZinc coat Sext Ma type automatic lock nut
P02012531	Cutting machine tape coiling oil cylinder support plate	04080177	Dimension 934zinc coat 6mm Sext Ma typenut
P02012532	cutting machine tape coiling stand	04080200	1/4 oil galvanized flat washer
P02012533	cutting machine tape coiling screw	04080209	Internal engine cabin / cabin M4x08mm dimension 912 screw
P02012534	cutting machine tape coiling baseplate	04080212	10mm zinc coat Sext Ma type automatic lock nut
P02012535	cutter roller	04080257	Internal engine cabin / cabin M4x45mm screw
P02012547	traction roller	04080441	Internal engine cabin / flat cabin M4x8mm dimension 7991screw
P02012548	traction roller bearing	04080478	Zinc coat 6mm pressure disk
P02012549	traction fixing roller	04080660	Zinc coat 6mm flat washer
P02012550	Supervision guide of traction fixing roller	04150046	Manual 3526-M8 F/Liso C/Lat M5 bakelite
P02012551	traction fixing roller's bearing	04170233	2,50x14,00mm elastic pin
P02012553	tape coiling roller's oil cylinder	04170242	Elastic ring P/ retainer shaft dimension 10,00 mm



Code	Descriptio	Code			Description	
P02012280	bottom cutting machine precipitator	P02012518	6,50x13,00x2,00mm washer			
P02012335	bottom cutting machine precipitator	P02012519	0.35kWTrif 220v/380v 200hz 2p (L)			
			cutting machine motor			
P02012485	bottom cutting machine substation protection	P02012520	(L) cutting machine milling cutter			
P02012486	bottom variable motor plate	04040266	609 Zz Nsk bearing			
P02012487	bottom power sustain cutting machine motor support	04040267	Linear bearings Kh 1630 PP			
	plate					
P02012489	vertical spring bottom substation axis	04080016	Internal engine cabin / cabin M6x16mm dimension			
P02012489	vertical spring bottom substation axis	04080019	Internal engine cabin / cabin M6x25mm dimension			
			912 screw			
P02012490	copier stabilizer bottom substation screw tapping	04080053	Internal engine cabin / flat cabin M6x16mm			
	module		dimension 7991 screw			
P02012491	copier bearing	04080058	Internal extension S/ cabin M6x16mm dimension 916			
P02012492	horizontal fixed bearing	04080059	Internal extension S/ cabin M8x10mm dimension 916			
P02012493	vertical fixed bearing	04080069	10mmzinc coat Sext Ma type nut			
P02012494	copier stabilizer horizontal bearing	04080089	Internal engine cabin / cabin M6x10mm dimension			
P02012495	copier stabilizer vertical support plate	04080140	External extension cabin		Ext M8x25mm zinc coat	
P02012496	vertical copier stabilizer regulator	04080178	External extension cabin		Ext M8x50mm zinc coat	
P02012497	10,00x16,00x1,50 mm washer	04080186	Sext Ma	type8mm zinc coat self-locking nut		
P02012499	CUBE type vertical copier stabilizer	04080200	1/4 oil galvanized stainless steel flat washer			
P02012500	6,00x20,00x3,00mm washer	04080201	5/16 oil galvanized stainless steel flat washer			
P02012501	coiling thickness manual adjustment	04080241	Internal engine cabin / cabin M5x10mm convex			
P02012502	horizontal copier stabilizer regulator	04080250	Internal	engine cabin / flat cabin		M5x10mm
P02012503	cutting machine vertical bearing guide	04080256	Internal	extension	S/ cabin M5x05mm	dimension
			916screw			
P02012504	bottom power substation copier stabilizer regulator	04080351	Internal extension S/ cabin M6x06mm dimension			
	ring module		916screw			
P02012506	6,00x12,00x1,00mm washer	04080441	Internal	engine cabin / flat cabin		M4x8mm
P02012507	decrement gauge	04080478	6mm zinc coat stainless steel pressure washer			
P02012510	clockwise pedometer	04080720	Internal extension S/ cabin M8x06mm dimension			
			916screw			
P02012513	bottom cutting machine support component	04150047	manual	bakelite	4631-M10 F/Liso	C/Lat M5
			Baquelite			
P02012514	bottom cutting machine horizontal bearing guide	04160103	Pressure spring 14,00x34,00x1,50mm			
P02012515	bottom cutting machine support component	04160104	Pressure spring 14,00x40,00x1,50 mm			
	guide					
P02012516	bottom copier	04170243	Elastic ring P/ retainer hole dimension 24,00mm			
P02012517	bottom odometer stents					



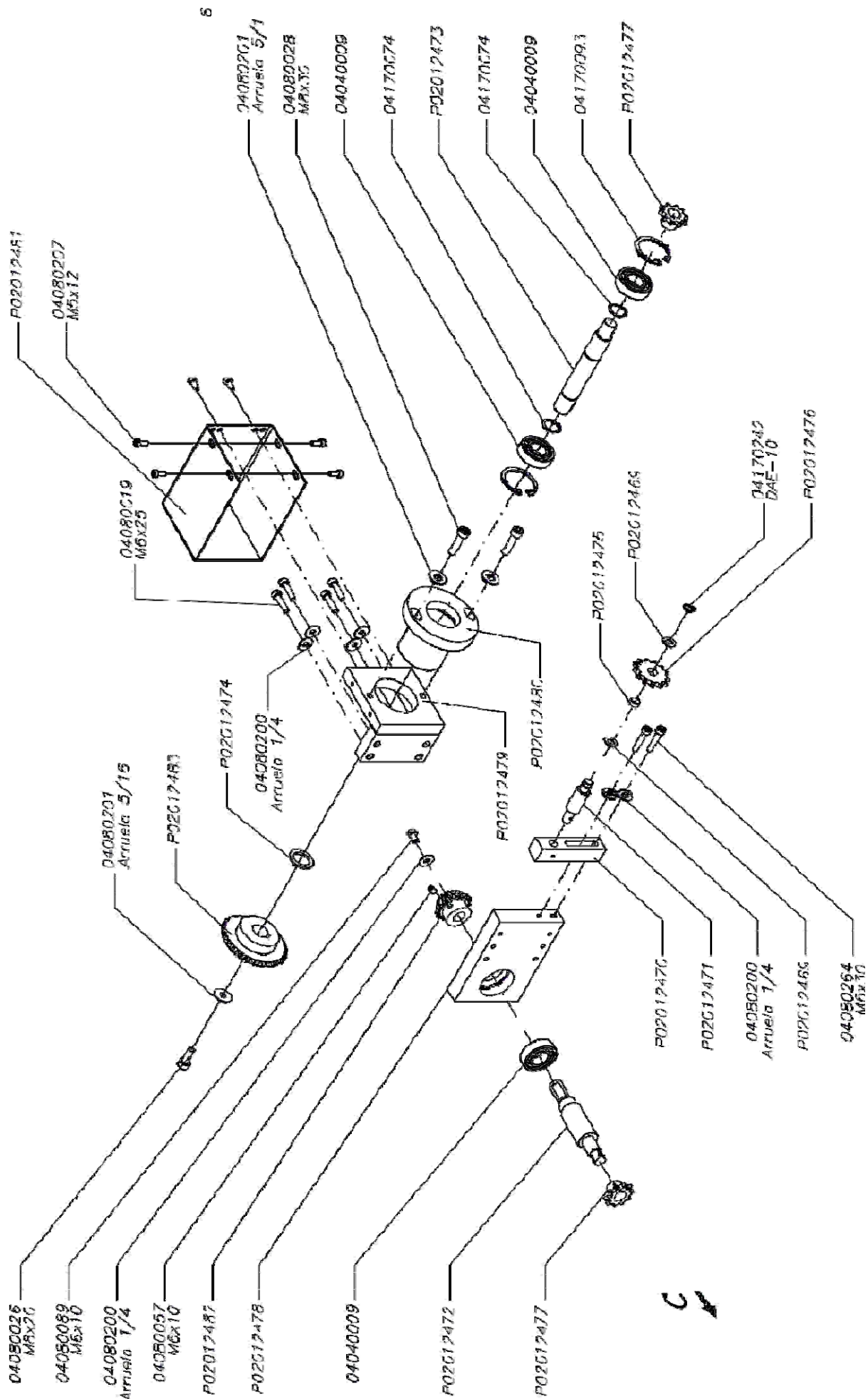
Code	Description	Code	Description
P02012280	bottom cutting machine precipitator	P02012518	6,50x13,00x2,00mm washer
P02012335	type bottom copier cleaner	P02012519	0.35kW Trif 220v/380v 200hz 2p (L)
P02012485	Proteção Inf-Sup Do Refilador		(L) cutting machine miller
P02012486	Placa Motor Sup-Inf bottom variable motor plate	02012520 4040266	609 ZZ Nsk bearing
P02012487	Placa Suporte Inf-Sup Motor Refilador bottom substation cutting machine motor support plate	4040267	Linear bearings Kh 1630 PP
P02012489	vertical spring bottom substation axis	4080016	Internal engine cabin / cabin M6x16mm dimension 912 screw
P02012489	vertical spring bottom substation axis	4080019	Internal engine cabin / cabin M6x25mm dimension 912 screw
P02012490	Bloco Macho Inf Sup Regulador Do Copiador copier regulator bottom substation screw tapping module	4080053	Internal engine cabin / flat cabin M6x16mm dimension 7991 screw
P02012491	Eixo Do Copiador copier axis	4080058	Internal extension S/ cabin M6x16mm dimension 916
P02012492	Fixação Eixo Horizontal horizontal fixed bearing	4080059	Internal extension S/ cabin M8x10mm dimension 916
P02012493	Fixação Eixo Vertical vertical fixed bearing	4080069	10mm zinc coat Sext Ma type nut
P02012494	copier regulator horizontal bearing	4080089	Internal engine cabin / cabin M6x10mm dimension 912 screw
P02012495	copier regulator vertical support plate	4080140	External extension cabin Ext M8x25mm zinc coat screw



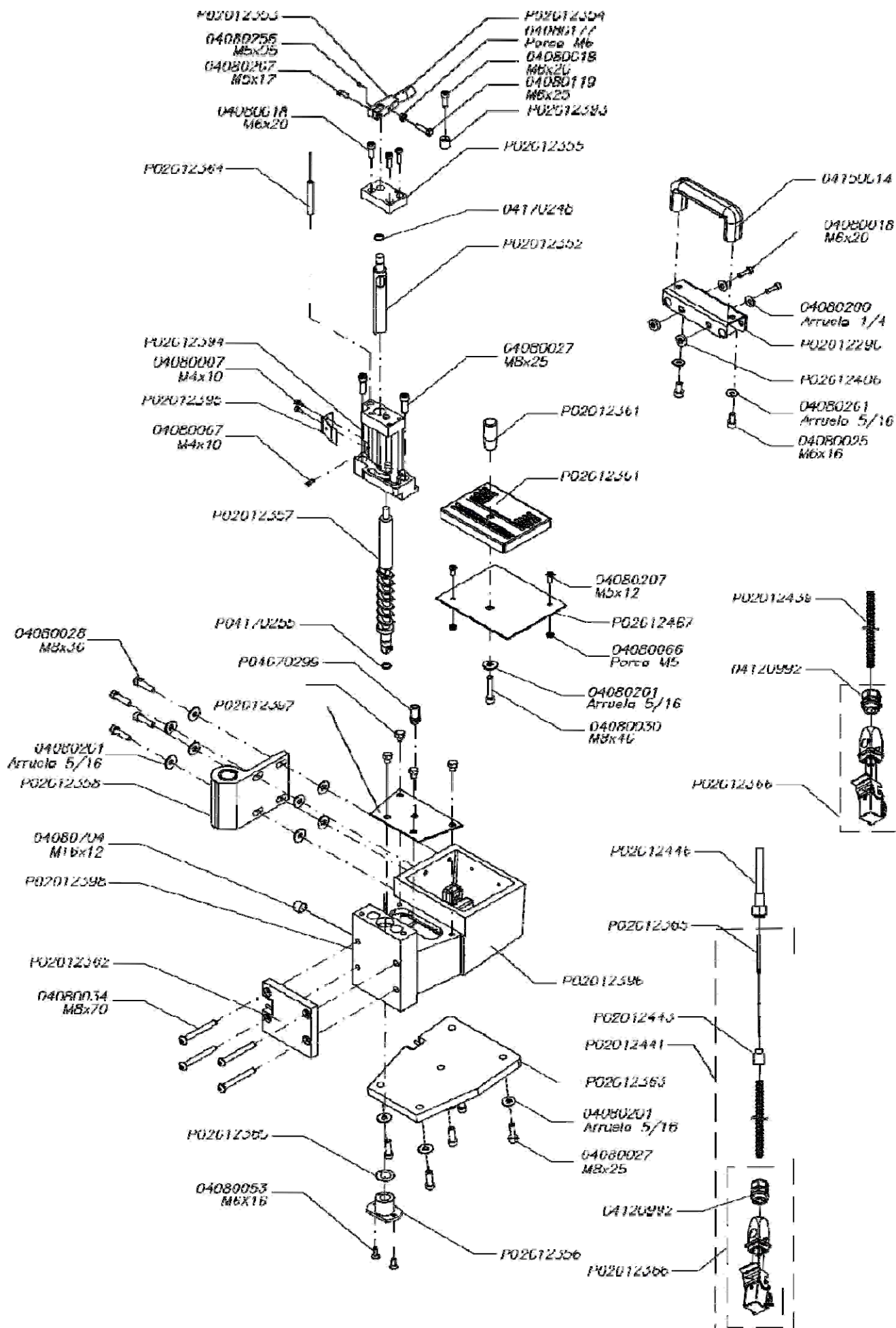
P02012496	vertical copier regulator	4080178	External extension cabin Ext M8x50mm zinc coat screw
P02012497	10,00x16,00x1,50mm CUBE type washer	4080186	Sext Ma type8mm zinc coat self-lock nut
P02012499	vertical copier	4080200	1/4 oil galvanized stainless steel flat washer
P02012500	6,00x20,00x3,00mm CUBE type washer	4080201	5/16 oil galvanized stainless steel flat washer
P02012501	tape coiling thickness manual adjustment	4080241	Internal engine cabin / cabin M5x10mm hump screw
P02012502	horizontal copier regulator	4080250	Internal engine cabin / flat cabin M5x10mm dimension 7991screw
P02012503	cutting machine vertical bearing guide	4080256	Internal extension S/ cabin M5x05mm dimension 916screw
P02012504	bottom substation copier regulator ring module	4080351	Internal extension S/ cabin M6x06mm dimension 916screw
P02012506	6,00x12,00x1,00mm washer	4080441	Internal engine cabin / flat cabin M4x8mm dimension 7991screw
P02012507	decrement gauge	4080478	6mm zinc coat stainless steel pressure washer
P02012510	clockwise pedometer	4080720	Internal extension S/ cabin M8x06mm dimension 916screw
P02012513	bottom cutting machine support component	4150047	Manual bakelite 4631-M10 F/Liso C/Lat M5 Baquelite
P02012514	bottom cutting machine horizontal bearing guide	4160103	04160103 - pressure spring 14,00x34,00x1,50mm
P02012515	bottom cutting machine support component guide	4160104	Pressure spring 14,00x40,00x1,50mm
P02012516	bottom copier	4170243	Elastic ring P/ retainer hole dimension 24,00mm
P02012517	bottom odometer stents		



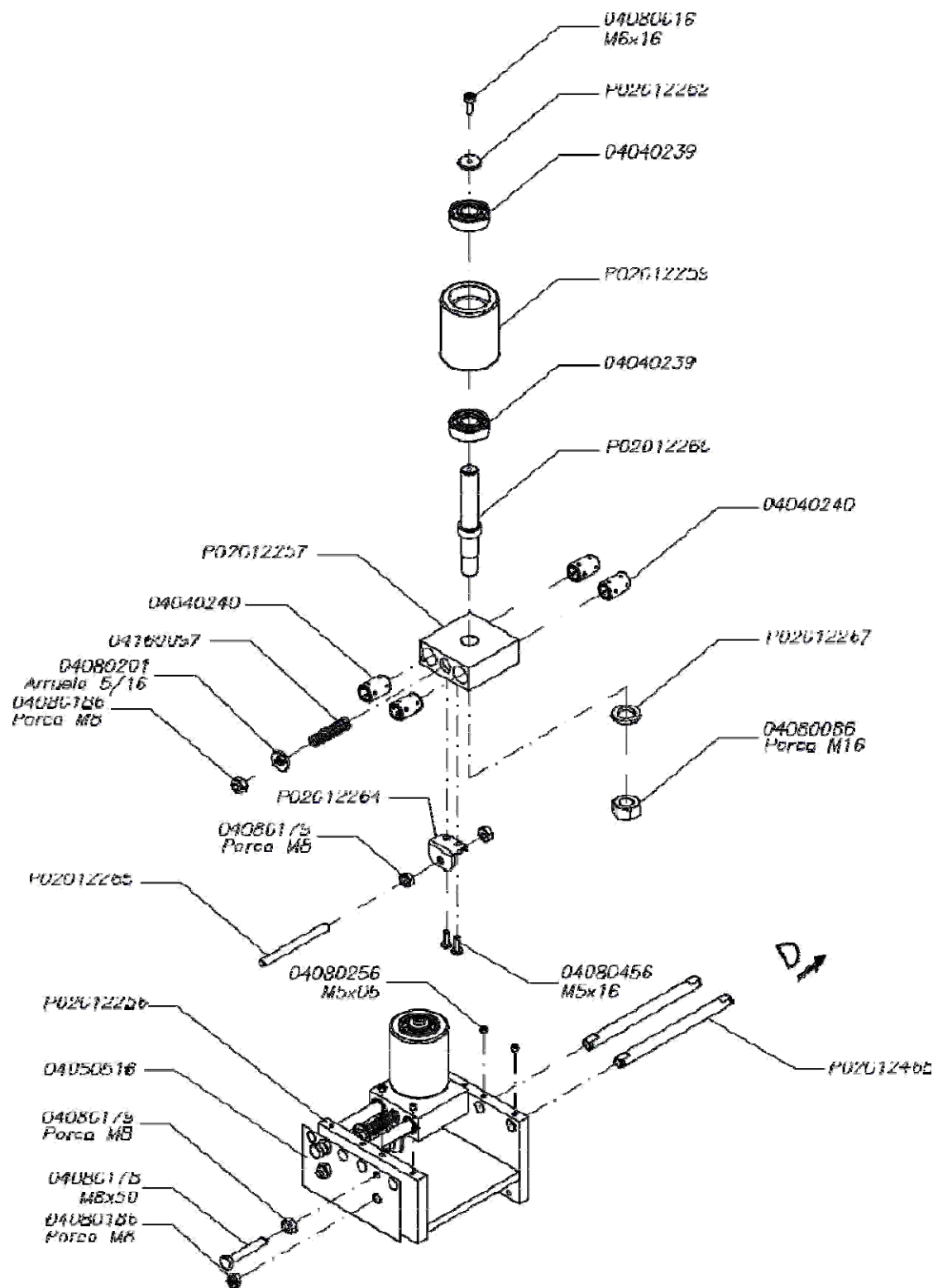
Code	Description	Code	Description
P02012469	16x9,5x1,5mm washer	P02012482	typegearbox gear
P02012470	current tensioner support	P02012483	typegearbox crown
P02012471	current tensioner bearing	04040009	Bearing 6004 DDU AR2S1 NSK
P02012471	current tensioner bearing	04080019	Internal engine cabin / cabin M6x25mm dimension 912 screw
P02012472	small gearbox gear axis	04080026	Internal engine cabin / cabin M8x20mm dimension 912 screw
P02012473	big gearbox gear axis	04080028	Internal engine cabin / cabin M8x30mm dimension 912 screw
P02012474	Washer of big gearbox gear axis	04080057	Internal extension S/ cabin M6x10mm dimension 916 screw
P02012475	Bucha Gear Esticador Corrente current tensioner gear bearing	04080089	Internal engine cabin / cabin M6x10mm dimension 912 screw
P02012476	Gear 13 gear No.6B-1 current tensioner	04080200	Flat washer 1/4 oil galvanized stainless steel
P02012477	Gear 10 gear No. 06B-1 apron	04080201	Flat washer 5/16 oil galvanized stainless steel
P02012477	Gear 10 gear No. 06B-1 apron	04080207	Internal engine cabin / cabin M5x12mm dimension 912 screw
P02012478	gearbox support	04080264	Internal extension Esq M6x30mm dimension912 screw
P02012479	gearbox bearing support	04170074	Elastic ring P/ retainer shaft dimension20,00mm
P02012480	gearbox wheel bearing	04170093	Elastic ring P/ retainer hole dimension42,00mm
P02012481	gearbox assembly shell	04170242	Elastic ring P/ retainer shaft dimension10,00mm



Number	Description	Number	Description
P02012290	Glue container unit handle mounting bracket	P02012441	Thermocouple members
P02012301	Coleiro mounting plate	P02012443	3/8screw thread 28 Connector Conduite Termopar Rosca 3/8 28 Fios
P02012352	Adjusting shaft	P02012446	Thermocouple tube
P02012353	Adjusting shaft	P02012467	Active glue device Glue container plate
P02012354	Glue-applying device M8 Adjusting rod	P04070299	1/8-inch silencer
P02012355	Active glue device plate	04080007	M4x10mm DIN 912 Hexagon socket head screw
P02012356	Active glue device Rear stuffy plug	04080018	M6x20mm DIN 912 Hexagon socket head screw
P02012357	Active glue device Bolster	04080025	M8x16mm DIN 912 Hexagon socket head screw
P02012358	Active glue device mounting plate	04080027	M8x25mm DIN 912 Hexagon socket head screw
P02012360	Active glue device mounting plate	04080028	M8x30mm DIN 912 Hexagon socket head screw
P02012361	Active glue device plate M8 Column nut	04080030	M8x40mm DIN 912 Hexagon socket head screw
P02012362	Active glue device 250w Front resistance	04080034	M8x70mm DIN 912 Hexagon socket head screw
P02012363	Active glue device 1000w Rear resistance	04080066	MA 5mm hexagonal zinc plated nut
P02012364	Active glue device 160w Column resistance	04080119	M6x25mm DIN Zinc plated hexalobular head screw
P02012365	K thermocouple detector	04080177	Ma 6mm DIN 934 hexagonal zinc plated nut
P02012366	male/female connector	04080200	1/4 inch Zinc plated stainless steel plain washer
P02012393	Active glue device Glue adjusting nozzle	04080201	5/16 inch Zinc plated stainless steel plain washer
P02012394	Active glue device front mounting bracket of bolster	04080207	M5x12mm DIN 912 Hexagon socket head screw
P02012395	Active glue device Rear wooden backboard	04080256	M5x05mm DIN 916 Hexagon socket screw
P02012396	Active glue device Glue container	04080704	M16x12mm DIN 916 Hexagon socket screw
P02012397	Active glue device plate	04120992	M20x1.5mm PG9 Reducer union (gray)
P02012398	Active glue device mounting bracket of bolster	04150014	Merkbak Ca-137 M8 phenolic plastic handle
P02012406	Glue container unit handle mounting bracket washer	04170248	Viton-75b O annular diameter 9.25xs1.78mm
P02012439	10x280mm Stainless steel side resistance tube	04170255	Viton-75b O annular diameter 14.5xs1.00mm

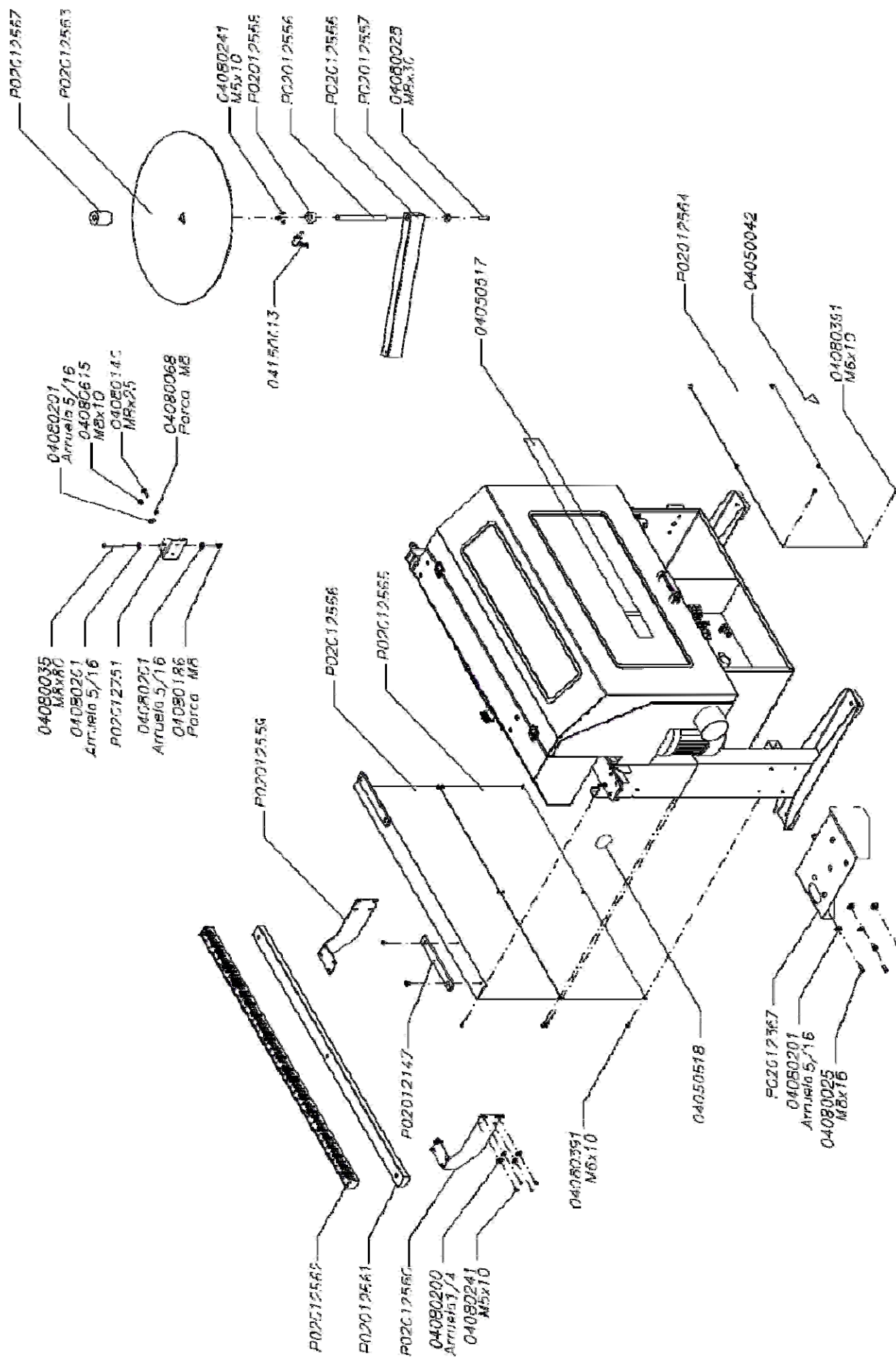


Number	Description	Number	Description
P02012256	Wheel support	04050516	Wheel specification label
P02012257	Wheel shaft block	04080016	M6x16mm DIN 912 Hexagon socket head screw
P02012259	(Z) D58 Wheel	04080086	MA 16mm DIN 934 Glaze hexagon nut
P02012260	Wheel axis	04080178	M8x50mm Hexalobular head screw
P02012262	(Z) Wheel axis washer	04080179	Ma 8mm Zinc plated hexagon nut
P02012264	Wheel(Z)Adjusting flap	04080186	Ma 8mm self-prevailing torque zinc plated hexagon nut
P02012267	18.00x28.00x3.50mm (Z) Washer	04080201	5/16 inch Zinc plated Stainless steel plain washer
P02012468	Wheel shaft	04080256	M5x05mm DIN 916 Hexagon socket screw
04040239	6203DDU 2l Bearing	04080456	M5x16mm Hexagon socket arched head screw
04040240	KH 1228 PP Linear bearing	04160097	11.00x53.00x1.80mm Compression spring





Number	Description	Number	Description
P02012147	Phenolic wood plate	04050042	Polycarbonate charged label (kinked line)
P02012367	Glue-applying unit groove bracket	04050517	Front Logo Label
P02012555	plate mounting rod	04050518	Touch-dangerous label
P02012556	plate mounting shaft	04080025	M8x16mm DIN 912 Hexagon socket head screw
P02012557	8.50x30.00x2.00mm gasket	04080028	M8x30mm DIN 912 Hexagon socket head screw
P02012558	plate bracket gasket	04080035	M8x80mm Din 912 Hexagon socket head screw
P02012559	Right side project blocks	04080068	M8 Din 934 Glaze hexagon nut
P02012560	Left side project blocks	04080140	M8x25mm Zinc plated hexalobular head screw
P02012561	Extension scale	04080186	Ma 8mm self-prevailing torque zinc plated
P02012562	Extension roll scale	04080200	1/4 inch Zinc plated Stainless steel plain washer
P02012563	Seal plate	04080201	5/16 inch Zinc plated Stainless steel plain washer
P02012564	Rear door	04080241	M5x10mm Hexagon socket arched head screw
P02012565	Front door	04080391	M6x10mm Hexagon socket arched head screw
P02012566	Upper front door	04080615	M8x10mm Zinc plated hexalobular head screw
P02012567	Seal guide	04150013	M8x16mm plastic nut handle
P02012751	Plate bracket		

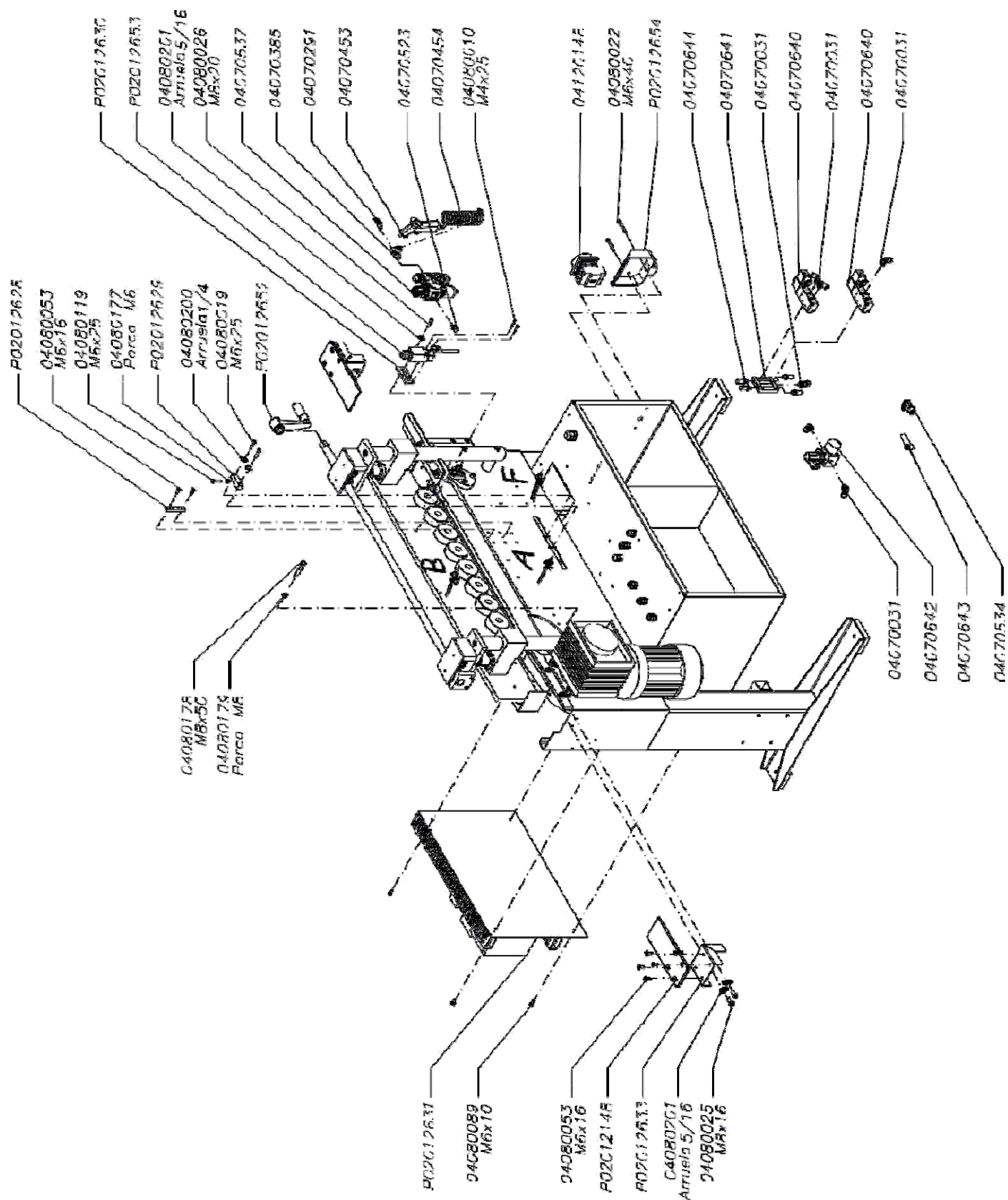


Number	Description	Number	Description
P02012149	Glue-applying unit protection	04080018	M6x20mm DIN 912 Hexagon socket head screw
P02012286	Feeding unit protection	04080026	M8x20mm Din 912 Hexagon socket head screw
P02012293	Polycarbonate protective plate 750x317x3mm	04080065	M4 Grace hexagon nut
P02012294	Polycarbonate protective plate 750x150x3mm	04080113	M4x12mm Din 912 Hexagon socket head screw
P02012297	Right conveying wheels	04080168	4mm Glaze zinc plated steel gasket
P02012568	Left conveying wheels	04080177	Ma 6mm DIN 934 Zinc plated hexagon nut
P02012569	Counter mounting bracket	04080179	Ma 8mm Zinc plated hexagon nut
P02012570	Conveying wheel plate	04080200	1/4 inch Zinc plated Stainless steel plain
P02012571	Control panel top	04080201	5/16 inch Zinc plated Stainless steel plain
P02012573	Top cover plate mounting rod	04080260	M6x20mm Din912 Left Hexagon socket screw
P02012574	Control panel screen	04080293	M4x40mm Din 912 Hexagon socket head
P02012656	counter-clockwise counter	04080391	M6x10mm Hexagon socket arched head screw
04030233	Rubber plug 20x40x2mm	04120248	Relay RW27 D 4-6.3A
04050517	Front Logo Label	04122484	Safety switch 1NA+1NF (TZ93C-PT) (04122485)
04050519	Panel label	04122485	Safety switch starter 1NA+1NF TZ93C-PT (TZ93-03)
04050520	Glue-applying perform label	04150018	180-degree flat hinge with holes (91413)
04050521	Thickness warning label 45 X 90 mm	04150036	Plastic banded cable 133
04050524	Up label 27 X55 mm	04170208	H-type solid rubberframe 15.00x15.00x3.00x2.00mm

P02012146	Assisted gear axis	P02012626	Glue-applying unit mounting plate axis fixed gasket
P02012575	Glue-applying unit mounting plate bearing	P02012670	(Z) Rear mounting plate gasket
P02012576	Seal guide block	P02012672	(M) Rear mounting plate
P02012577	Seal guide rod	P03000365	Copper alloy bushes 24.00x28.00x10.00mm
P02012578	Glue-applying unit height restriction frame mounting plate	P03000367	24.00mm Universal rotary assembly
P02012579	Spring tension device mounting plate	04040009	Bearing 6004 DDU AR2S1 NSK
P02012580	Seal traction and transmission mounting plate	04080012	M5x08mm DIN 912 Hexagon socket head screw
P02012581	34 teeth 06-B1 assisted rear	04080028	M6x40mm DIN 912 Hexagon socket head screw
P02012582	Seal Steering universal rod	04080053	M6x16mm DIN 7991 Hexagon socket plain head screw
P02012583	Assisted rear washer	04080056	M5x10mm Din 916 Hexagon socket screw
P02012583	Assisted rear washer	04080057	M6x10mm Din 916 Hexagon socket screw
P02012584	Seal traction15 teeth 06b-1 Assisted rear	04080069	Ma 10mm Zinc plated hexagon nut
P02012585	Top seal Steering universal rod	04080098	M6x25mm DIN 916 Hexagon socket screw
P02012586	Cross head	04080099	M8x30mm Zinc plated hexalobular head screw
P02012586	Cross head	04080119	M6x25mm DIN Zinc plated hexalobular head screw
P02012587	Assisted rear mounting plate	04080177	Ma 6mm DIN 934 Zinc plated hexagon nut
P02012588	Cardan shaft	04080179	Ma 8mm Zinc plated hexagon nut
P02012589	Glue-applying unit mounting plate shaft	04080201	5/16 inch Zinc plated Stainless steel glaze washer
P02012590	Glue-applying unit expansion washer	04080207	M5x12mm DIN 912 Hexagon socket head screw
P02012591	Slide unit spring tension device	04080269	M8x25mm DIN 916 Hexagon socket screw
P02012595	Glue-applying unit spring tension device	04080351	M6x06mm DIN 916 Hexagon socket screw
P02012596	Seal traction mounting plate control rod	04150046	3526-M8 F/glaze C/Lat M5 Phenolic plastic hand wheel
P02012597	Chains	04170196	Plastic axis fixed ring D24.00mm

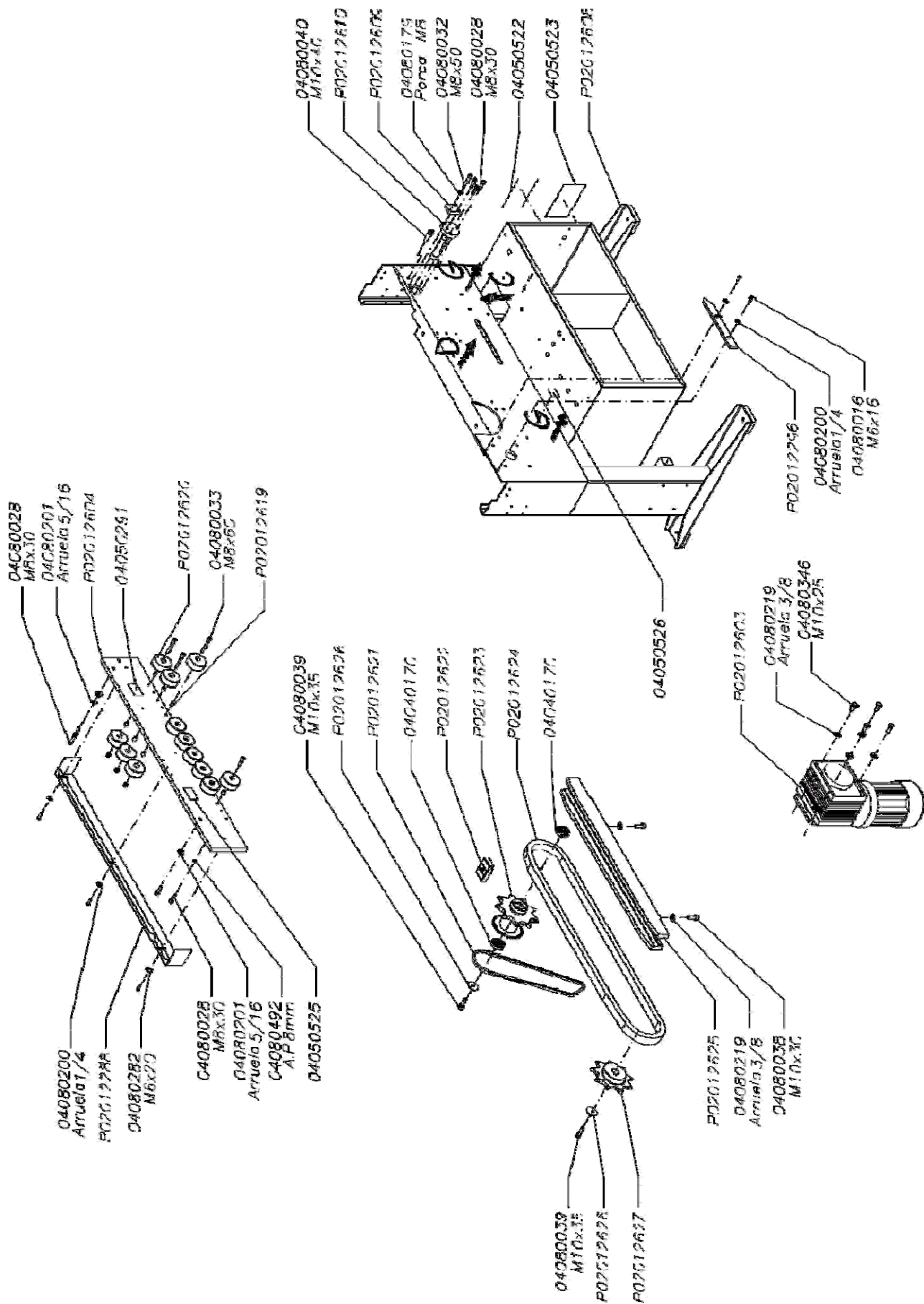


Number	Description	Number	Description
P02012148	Import phenolic sheet	04070642	Pressure equalizer 1/4 (Imp.)
P02012628	Cutter support guide tod	04070643	Electromechanical pressure switch improve with pressure unit (Imp.)
P02012629	Cutter Align support	04070644	Copper alloy plane silencer 1/4 (Imp.)
P02012630	Rial terminal mounting plated	04080010	M4x25mm DIN 912 Hexagon socket head screw
P02012631	Electrical module	04080019	M6x25mm DIN 912 Hexagon socket head screw
P02012633	import and export plated support	04080022	M6x40mm DIN 912 Hexagon socket head screw
P02012652	pressing crank	04080025	M8x16mm DIN 912 Hexagon socket head screw
P02012653	wood rial terminal and seal cutting switch	04080026	M8x20mm DIN 912 Hexagon socket head screw
P02012654	Plus power protection	04080053	M6x16mm DIN 7991 Hexagon socket plainhead screw
04070031	Connector L R1/4 inch x8mm (Olp)	04080089	M6x10mm DIN 912 Hexagon socket head screw
04070291	Piton 1/4x5/16 inch	04080119	M6x25mm DIN Zinc plated hexalobular head screw
04070453	Cleaning air hole 1/4 inch	04080177	Ma 6mm DIN934 Zinc plated hexagon screw
04070454	Spiro-tube 6.00mmx3.5m C/ 01 heat isulation 1/4 Bsp with springs	04080178	M8x50mm Zinc plated hexalobular head screw
04070523	connector R R1/4 inch x8mm (Imp)	04080179	Ma 8mm Zinc plated hexagon screw
04070534	T shape charger connector 8mm (Imp)	04080200	1/4 inch Zinc plated Stainless steel glaze
04070537	A-set filter tip with counting support and with support and manual drain pressure gauge 1/4inch Pc	04080201	5/16 inch Zinc plated Stainless steel glaze washer
04070640	Simple flow air valve 5/2 entryway 1/8 inch with air vents (Imp)	04080385	3/4 inch screw pile
04070641	Air vents divided by air pressure (Imp)	04120148	Three subsectional izing switch 2 Pos



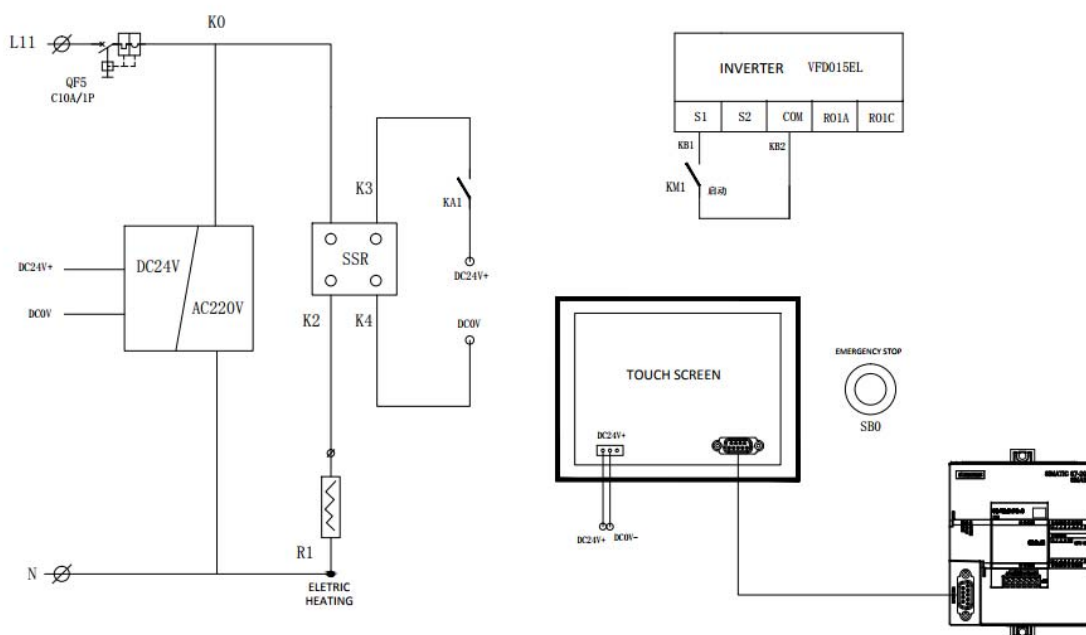
Number	Description	Number	Description
P02012288	Wheel protection	04050522	Pressure warning label
P02012296	wood traction plate	04050523	90 X 140 Mm Warning label
P02012603	Motor	04050525	Regulation of top material insert
P02012604	Roller plate	04050526	Regulation of bottom material insert
P02012608	Main body	04080016	M6x16mm DIN 912 Hexagon socket head screw
P02012609	track aligned plate	04080028	M8x30mm DIN 912 Hexagon socket head screw
P02012610	track rear shaft	04080032	M8x50mm DIN 912 Hexagon socket head screw
P02012619	Roller pulley bushes	04080033	M8x60mm DIN 912 Hexagon socket head screw
P02012620	Roller pulley	04080038	M10x30mm DIN 912 Hexagon socket head screw
P02012621	Drive chain	04080039	M10x35mm DIN 912 Hexagon socket head screw
P02012622	Pedal	04080040	M10x40mm DIN 912 Hexagon socket head screw
P02012623	Track move rear	04080179	Ma 8mm Zinc plated hexagon screw
P02012624	track chain	04080200	1/4 inch Zinc plated Stainless steel plane washer
P02012625	Track path	04080201	5/16 inch Zinc plated Stainless steel plane washer
P02012626	Glue-applying unit mounting plate axis fixed gasket	04080219	3/8 inch Zinc plated Stainless steel glaze washer
P02012626	Glue-applying unit mounting plate axis fixed gasket	04080282	M6x20mm Hexagon socket arched head screw
P02012627	Electric motor rear	04080346	M10x25mm Zinc plated hexalobular head screw
04040170	Bearing 6005 DDU	04080492	Zinc plated Stainless steel serrated lock gasket
04050291	glue regulation label		





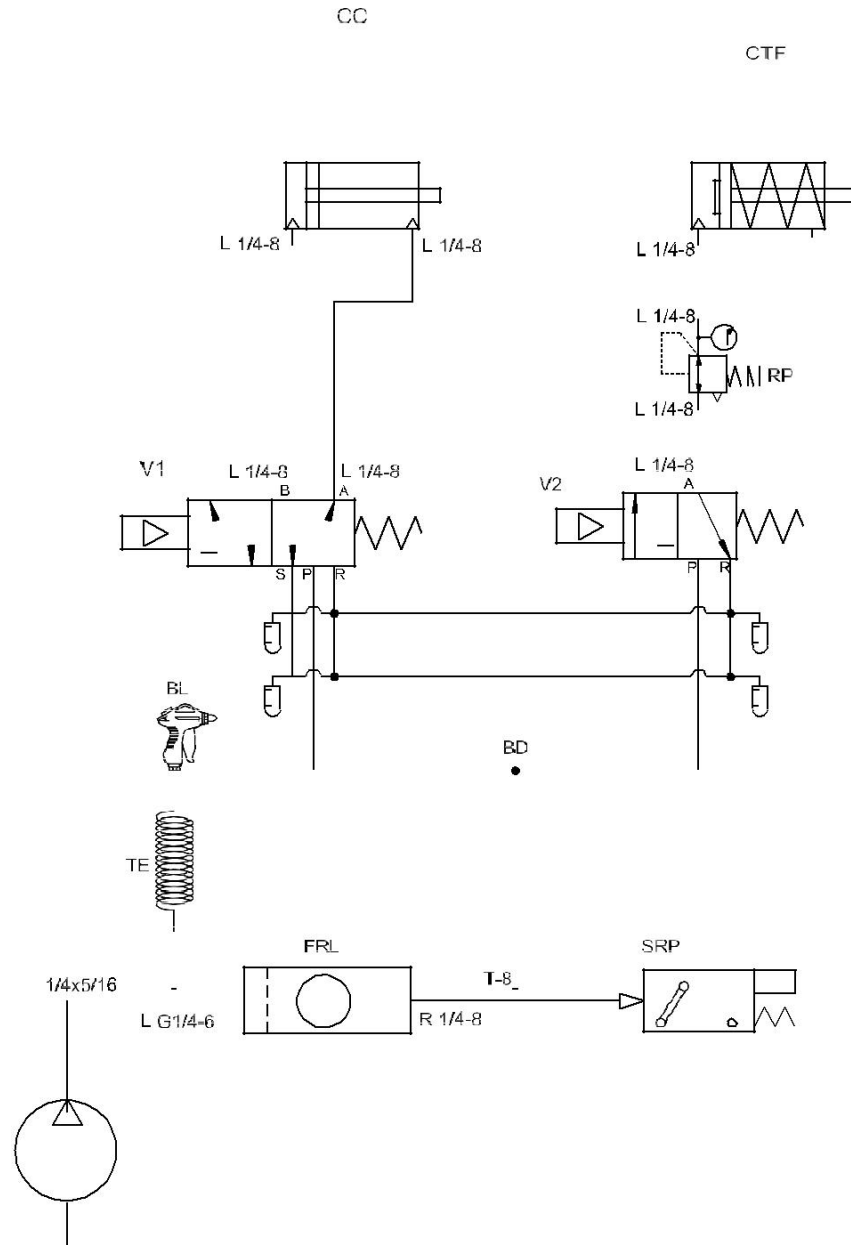
Number	Description	Number	Description
P02012598	6.50x25.00x1.50mm Washer	P02012651	Roller axis without plug
P02012599	Roller rear without plug	04040135	Main bearing 51103
P02012600	Washer 17.00x30.00x2.00mm	04040142	Main bearing 51104 (Imp)
P02012601	Regular height roller bearing	04080018	M6x20mm DIN 912 Hexagon socket head screw
P02012602	Feeding mounting plate	04080019	M6x25mm DIN 912 Hexagon socket head screw
P02012605	Regular height mounting rod	04080021	M6x35mm DIN912 Hexagon socket head screw
P02012607	Roller screw without plug	04080040	M10x40mm DIN912 Hexagon socket head screw
P02012611	Timber import trough	04080056	M5x10mm DIN 916 Hexagon socket screw
P02012612	Entrance bottom plate	04080200	1/4 inch Zinc plated Stainless steel glaze washer
P02012613	Import frame mounting plated	04080309	M8x55mm Hexagon socket head screw
P02012614	Roller shaft	04080391	M6x10mm Hexagon socket arched head screw
P02012615	Roller mounting plated shaft	04080660	6.00mm inch Zinc plated Stainless steel glaze
P02012616	Roller mounting plated shaft pillow	04080721	M10x75mm DIN 912 Hexagon socket head screw
P02012617	Roller mounting plated washer	04170256	Plug 20.00x23.00x30.00x16.5mm
P02012618	Roller right mounting plated	04170257	Plug 20.00x23.00x15.00mm

## ME-207





# PNEUMATIC SCHEME



Mark	Number	Description
L 1/4-8	04070031	Left/right connector 1/4 inchx8mm (OLP)
V1	04070640	Simple flow air valve 5/2 entryway 1/8 inch with air vents (Imp)
V2	04070640	Simple flow air valve 5/2 entryway 1/8 inch with air vents (Imp)
CC	P02012552	Seal cutting column
CTF	P02012553	Seal guiding column
BD	04070641	Air vents divided by air pressure
T-8	04070534	T shape charger connector 8mm (Imp)
SRP	04070643	Electromechanical pressure switch improve with pressure unit (Imp.)
FRL	04070537	A-set filter tip with counting support and with support and manual drain pressure gauge 1/4inch Pc
R1/4-8	04070523	connector R R1/4 inch x8mm (Imp)
LG1/4-6	04070031	L G1/4 inchx6mm Universal female connector
RP	04070642	Pressure equalizer 1/4 (Imp.)
TE	04070454	Spiro-tube 6.00mmx3.5m C/ 01 heat insulation 1/4 Bsp with springs
BL	04070453	Cleaning air hole 1/4 inch
E1/4x5/16	04070291	Piton 1/4x5/16 inch
SI	04070644	Copper alloy plane silencer 1/4 (Imp.)

## **WARRANTY.**

The legal warranty provides for 6 months of coverage from the date of issue on the mechanical components, tires and various parts of the machine. (For America, Africa and the Far East, warranty will start 30 days after the date of issue).

The parts considered consumables, engines, electrical and electronic equipment are not considered in the warranty.

The financial warranty, in the event that it is necessary for , the free intervention by our technicians or, as the case may be, one authorized by us. Travel and stay expenses are a charge of the buyer.

When a spare part is sent as warranty, the customer must return by their own courier within a period of 30 days. If shipment is not made by then, will invoice it to customer.

No type of imputation to due to production stops or damages will be admitted. For any type of conflict or litigation that may arise from the acquisition of this machine

## **CAUSES OF CANCELLATION OF WARRANTY.**

The constructor declines any responsibility for the following cases that may create faults or damage to the machine under warranty.

Disregard the instructions for use and maintenance and for the improper use of the machine for jobs for which it has not been designed.

Repairs or manipulations not authorized by or by unauthorized technicians.

Incorrect line feed, inconsistent or irregular; 4  $\Omega$  upper ground.

Pneumatic feeding with unfiltered compressed air, which is not dry or insufficient.

Use of tools with different characteristics from those indicated in our manual, unbalanced or in a way not in accordance with the instructions of the tool manufacturer.