

FELDER®

Operating Manual

GER = Original operating manual language
Other languages = Translation of the original operating manual

Edgebander with glue pot G 200 / G 220



Keep this manual handy and in good condition for continual reference!



Attention: The machine must be inspected immediately on arrival. If the machine was damaged during transport or if any parts are missing, a written record of the problems must be submitted to the forwarding agent and a damage report compiled. Be sure also to notify your supplier immediately.



For the safety of all personnel, it is necessary to conscientiously study this manual before assembly and commissioning. This manual must be kept in good condition, as it belongs to the machine! Furthermore, keep the manual to hand and in the vicinity of the machine so that it is accessible to personnel when they are using, maintaining or repairing the machine.



Important Notices!

Please note, that depending on the model of the machine, not all described functions are present, or additional functions and buttons are available (e.g. machines with special functions).

FELDER | A product of the FELDER GROUP!

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General

1 General

1.1 Explanation of symbols

Important technical safety instructions in this manual are marked with symbols. These instructions for work safety must be followed. In all

these particular cases, special attention must be paid in order to avoid accidents, injury to persons or material damage.



Warning: Risk of injury or death!

This symbol marks instructions that must be followed in order to avoid harm to one's health, injuries, permanent impairment or death.



Warning: Danger – electric current!

This symbol warns of potentially dangerous situations related to electric current. Not observing the safety instructions increases the risk of serious injury or death. Required electrical repairs may only be carried out by a trained electrical technician.



Attention: Risk of material damage!

This symbol marks instructions which, if not observed, may lead to material damage, functional failures and/or machine breakdown.



Attention:

This symbol marks tips and information which should be observed to ensure efficient and failure-free operation of the machine.

1.2 Information regarding the manual

This manual describes how to operate the machine properly and safely. Be sure to follow the safety tips and instructions stated here as well as any local accident prevention directives and general safety regulations. Before beginning any work on the machine, ensure that the manual, in particular the chapter entitled „Safety“ and the respective safety guidelines, has been read in its

entirety and fully understood. This manual is an integral part of the machine and must therefore be kept in the direct vicinity of the machine and accessible at all times. If the machine is sold, rented, lent or otherwise transferred to another party, the manual must accompany the machine.

General

1.3 Liability and warranty

The contents and instructions in this manual were compiled in consideration of current regulations and state of the art technology as well as based on our know-how and experience acquired over many years. This manual must be read carefully before commencing any work on or with this machine. The manufacturer shall not be liable for damage and or faults resulting from the disregard of instructions in the manual. The texts and images do not necessarily represent the delivery contents.

The images and graphics are not depicted on a 1:1

scale. The actual delivery contents are dependent on custom-build specifications, add-on options or recent technical modifications and may therefore deviate from the descriptions, instructions and images contained in the manual. Should any questions arise, please contact the manufacturer. We reserve the right to make technical modifications to the product in order to further improve user-friendliness and develop its functionality.

1.4 Copyright

This manual should be handled confidentially. It is designated solely for those persons who work on or with the machine. All descriptions, texts, drawings, photos and other depictions are protected by copyright and other commercial laws. Illegal use of the materials is punishable by law.

This manual – in its entirety or parts thereof – may not be transferred to third parties or copied in any way or

form, and its contents may not be used or otherwise communicated without the express written consent of the manufacturer.

Infringement of these rights may lead to a demand for compensation or other applicable claims. We reserve all rights in exercising commercial protection laws.

1.5 Warranty notice

The guarantee period is in accordance with national guidelines. Details may be found on our website, www.felder-group.com

1.6 Spare parts



Attention! Non genuine, counterfeit or faulty spare parts may result in damage, cause malfunction or complete breakdown of the machine. The original spare parts that have been authorised for use are listed in a separate spare parts catalogue, enclosed in the documentation package supplied with the machine.

If unauthorised spare parts are fitted into the machine, all warranty, service, compensation and liability claims

against the manufacturer and their contractors, dealers and representatives shall be rejected.

General

1.7 Disposal

If the machine is to be disposed of, separate the components into the various materials groups in order to allow them to be reused or selectively disposed of. The whole structure is made of steel and can therefore be dismantled without problem. This material is also easy to dispose of and does not pollute the environment or

jeopardise public health. International environmental regulations and local disposal laws must always be complied with.



Attention: Used electrical materials, electronic components, lubricants and other auxiliary substances must be treated as hazardous waste and may only be disposed of by specialized, licensed firms.

Safety

2 Safety

At the time of its development and production, the machine was built in accordance with prevailing technological regulations and therefore conforms to industry safety standards.

However, hazards may arise should the machine be operated by untrained personnel, be used improperly or employed for purposes other than those it was designed for. The chapter entitled „Safety“ offers an overview of all the important safety considerations necessary to opti-

mise safety and ensure the safe and trouble-free operation of the machine.

Additionally, in order to further minimize risks, the other chapters of this manual contain specific safety instructions, all marked with symbols. Besides the various instructions, there are a number of pictograms, signs and labels affixed to the machine that must also be heeded. These must be kept visible and legible and may not be removed.

2.1 Intended use

The machine described in this manual is intended solely for processing wood and similar machinable materials.

Operational safety is guaranteed only when the machine is used for its intended purposes.



Attention: Any use se outside the machines intended purposes shall be considered improper and is therefore not permitted. All claims regarding damage resulting from improper use that are made against the manufacturer and its authorized representatives shall be rejected. The operator shall be solely liable for any damage that results from improper use of the machine.

The term „proper use“ also refers to correctly observing the operating conditions as well as the specifications and instructions in this manual.

The machine may only be operated with parts and original and or genuine accessories from the manufacturer.

2.2 Manual contents

All those appointed to work on or with the machine must have fully read and understood the manual before commencing any work. This requirement must be met even if the appointed person is familiar with the operation of such a machine or a similar one, or has been trained by the manufacturer. Knowledge about the contents of this manual is a prerequisite for protecting personnel

from hazards and avoiding mistakes so that the machine may be operated in a safe and trouble-free manner. It is recommended that the operator request proof from the personnel that the contents of the manual have in fact been read and understood.

2.3 Making changes and modifications to the machine

In order to minimize risks and to ensure optimal performance, it is strictly prohibited to alter, retrofit or modify the machine in any way without the express consent of the manufacturer. All the pictograms, signs and labels affixed to the machine must be kept visible, readable and

may not be removed. Pictograms, signs and labels that have become damaged or unreadable must be replaced promptly.

Safety

2.4 Responsibilities of the owner operator

This manual must be kept in the immediate vicinity of the machine and be accessible at all times to all persons working on or with the machine. The machine may only be operated if it is in proper working order and in safe condition. Every time before the machine is switched on, it must be inspected for visible defects and general condition. All instructions in this manual must be strictly followed without reservation.

Besides the safety advice and instructions stated in this manual, it is necessary to consider and observe local accident prevention regulations, general safety regulations

as well as current environmental stipulations that apply to the operational range of the machine.

The operator and designated personnel are responsible for the trouble-free operation of the machine as well as for clearly establishing who is in charge of installing, servicing, maintaining and cleaning the machine. Machines, tools and accessories must be kept out of the reach of children.

2.5 What is required of personnel

Only authorized and trained personnel may work on and with the machine. Personnel must be briefed about all functions and potential dangers of the machine. „Specialist staff“ is a term that refers to those who – due to their professional training, know-how, experience, and knowledge of relevant regulations – are in a position to assess delegated tasks and recognise potential risks. If the personnel lack the necessary knowledge for working on or with the machine, they must first be trained. Responsibility for working with the machine (installation, service, maintenance, overhaul) must be clearly defined and strictly observed. Only those persons who can be expected to carry out their work reliably may be given permission to work on or with the machine. Personnel

must refrain from working in ways that could harm others, the environment or the machine itself. It is absolutely forbidden for anyone who is under the influence of drugs, alcohol or reaction-impairing medication to work on or with the machine. When appointing personnel to work on the machine, it is necessary to observe all local regulations regarding age and professional status. The user is also responsible for ensuring that unauthorised persons remain at a safe distance from the machine. Personnel are obliged to immediately report to the operator any irregularities with the machine that might compromise safety.

2.6 Work safety

Following the safety advice and instructions given in this manual can prevent bodily injury and material damage while working on and with the machine. Failure to observe these instructions can lead to bodily injury and damage to or destruction of the machine. Disregard of the safety advice and instructions given in this manual as

well as the accident prevention regulations and general safety regulations applicable to the operative range of the machine shall release the manufacturer and their authorised representatives from any and all liability and compensation claims.

Safety

2.7 Personal safety

When working on or with the machine, the following must be strictly observed:



Persons with long hair who are not wearing a hairnet are not permitted to work on or with the machine.



**It is prohibited to wear gloves while working on or with the machine.
All jewellery (rings, bracelets, necklaces, etc.) must be removed before starting work on or with the machine.**

When working on or with the machine, the following must always be worn by personnel:



Protective gear (overalls, safety goggles, dust mask, hairnet to contain long hair, etc.)
Sturdy, tight-fitting clothing (tear-resistant, no wide sleeves).



Protective footwear
That protects the feet from heavy falling objects and prevents sliding on slippery floors.



Ear protection
To protect against loss of hearing.

2.8 Hazards arising from the machine

The machine has undergone a hazards analysis. The design and construction of the machine are based on the results of this analysis and correspond to state-of-the-art technology.
The machine is considered operationally safe when used

properly.
Nevertheless, there are some residual risks that must be considered.
The machine runs with high electrical voltage.



Warning! Danger – electric current: Electrical energy can cause serious bodily injury. Damaged insulation materials or defective individual components can cause a life-threatening electrical shock.

- Before carrying out any maintenance, cleaning and repair work, switch off the machine and secure it against being accidentally switched on again.
- When carrying out any work on the electrical equipment, ensure that the voltage supply is completely isolated.
- Do not remove any safety devices or alter them to put them out of commission.

Safety

2.9 Other risks



Warning! Risk of injury! Even if the safety measures are complied with, there are still certain associated risks that must be considered when working on the machine:

- Be wary of sharp edges to avoid cutting yourself, in particular when changing the tooling.
- Verletzungsgefahr bei Kontakt mit dem rotierenden Fräswerkzeug.
- Risk of injury from workpieces or other workpiece parts jamming in the machine or being ejected.
- Risk of injury from workpiece kickback.
- Hearing damage as a result of high noise levels
- Health impairments due to the inhalation of airborne particles, especially when working with beech and oak wood.
- Risk of injury through being crushed, cut, caught, wound up or sliced.
- Risk of burning yourself on the hot mechanical parts (in particular the glue pot).
- It is strictly forbidden to climb onto the machine - danger of falling.

Declaration of Conformity

3 Declaration of Conformity



EC-Declaration of Conformity
according to Machine Guidelines 2006/42/EC

We hereby declare that the machine indicated below, which corresponds to the design and construction of the model we placed on the market, conforms with the health and safety requirements as stated by the EC.

Manufacturer:

**Felder KG
KR-FELDER-STR.1
A-6060 Hall in Tirol**

Product designation:

Edgebander with glue basin

Make:

FELDER

Model designation:

G 200 / G 220

The following EC guidelines were applied:

**2006/42/EG
2014/35/EU
2014/30/EU**

The following harmonised norms were applied:

EN ISO 18217

This EC Declaration of Conformity is valid only if the CE label has been affixed to the machine.

Modifying or altering the machine without the express written agreement of the manufacturer shall render the warranty null and void.

The signatory of this statement is the appointed agent for the compilation of the technical information

Hall in Tirol, 1.1.2017

A handwritten signature in black ink, which appears to read 'Johann Felder'.

Johann Felder, Managing Director FELDER KG
KR-FELDER-STR.1 • A-6060 Hall in Tirol

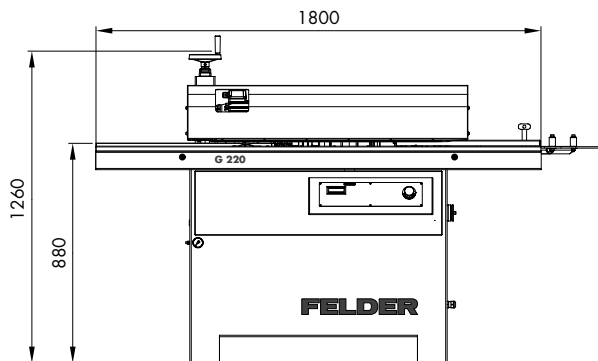
Technical data

4 Specifications

Edge thickness	0,4 – 2 mm
Workpiece feed speed	5,5 m/min 7,0 m/min (Valid from 2020)
Speed Spindle moulder unit	9000 min-1
Ø-WIDIA moulder	70 mm
Heating power Gluepot	1135 W
Working temperature (min./max.)	20/210° C
Ø-Extraction connection	120 mm
Workpiece dimensions	
Length (min.)	250 mm
Width (min.)*	90 mm
Workpiece thickness (min./max.)	10 – 45 mm

! Attention! Risk of material damage!
When processing very narrow workpieces, the workpiece may tilt slightly. This means that the workpiece will not be processed evenly.
*) The minimal workpiece width varies depending on the workpiece length, height and type of surface.

4.1 Dimensions and weight



Total height	1310 mm
Transport width	min. 650 mm
Weight net	310 kg
Working table dimensions	1800 x 300 mm
Extensible support	320 mm
Machine including packaging	
Length	2100 mm
Width	990 mm
Height	1400 mm

Fig. 1: Machine description

4.2 Operation and storage conditions

Operating/room temperature	+18 max. +40 °C
Storage temperature	-10 max. +50 °C

4.3 Drive motor

Electrical equipment	
Power rating	4 kW
Motor (electric data)	3 x 380-440V/ 50-60 Hz
	3 x 220-240V/ 50-60 Hz
	1 x 220-240V/ 50-60 Hz

Technical data

4.4 Electrical connection

mains voltage according to specification plate	±10%
Safeguarding	see circuit plan
Power supply cord (H07RN-F)	3x2,5 mm ² / 5x2,5 mm ²
Triggering characteristic	C



Warning! Danger! Electric current!

All electrical repairs must be carried out by a qualified electrician.



Attention! A wrong connection (for instance inverting a phase with the neutral or not connecting the neutral) DAMAGES IRREPARABLY: heating elements, motors.

It is forbidden to connect the neutral to the earth.

The main power system must be provided with a neutral and an efficient earth line.

Intervention with the fuses or servo motors requires you to open the electrical box behind the control panel, using a flat screwdriver. Maximum safety precautions must be taken before carrying out these operations. Pull the main power supply plug out of the socket.

4.5 Particle emissions

The working areas of this machine comply to DGUV Information 209-044 and are classed as dust reduced.

The maximum concentration level of 2 mg/m³ of inhalable dust in the air will not be exceeded.

This only applies if the conditions that are specified in the section >Extraction< are adhered to.

See chapter entitled >Setup and installation<

Technical data

4.6 Pneumatic connection

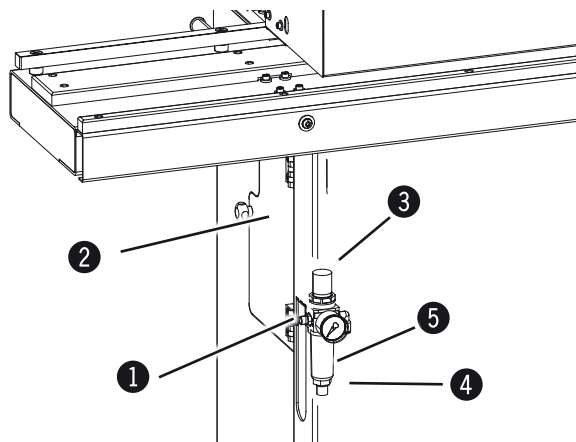


Fig. 2: Pneumatic connection

- ① Compressed air supply connection
- ② Plate door
- ③ Knob
- ④ Handle
- ⑤ Condensation receptacle

The machine is equipped with a compressed air connection.

Always connect the machine to the compressed air unit. Open plate door and with knob adjust the pressure to 6,5 bar. The machine has tested with this pressure. The pneumatic system does not need lubrication. Adding lubricants to the pneumatic system can damage the machine.

To outflow the condensation push button upwards.

Never fill the condensation collecting cup with lubricant oils!

4.7 Noise emission

The specified values are emission values and therefore do not represent safe workplace values. Even though a relationship exists between particle emission and noise emission levels, an inference cannot be made about whether additional safety measures need to be implemented. Factors which can significantly affect the emission level that presently exists at the workplace include duration of the effect, characteristics of the workspace,

and other ambient influences. The permissible workplace values may also differ from country to country. Nevertheless, this information is provided to help the operator better assess hazards and risks. Depending on the location of the machine and other specific conditions, the actual noise emission values may deviate significantly from the specified values.



Attention!

Authorised noise emissions depend on the specific country regulations in which the machine is operated. If on a rare occurrence, the noise emission should exceed the country specific limits as a result of particular circumstances, the operator is obliged to provide additional protection against the noise.

The noise emission level was measured with the following workpiece:

Panel material: Chipboard 45 mm Edge material: PVC 2 mm

All values in dB(A) and with a measurement uncertainty factor of 4 dB(A).

	Sound power level EN ISO 3746	Workplace emissions values EN ISO 11202	
		AP 1	AP 2
Idle	91	71	71
Working	93	73	73

Assembly

5 Assembly

5.1 Overview

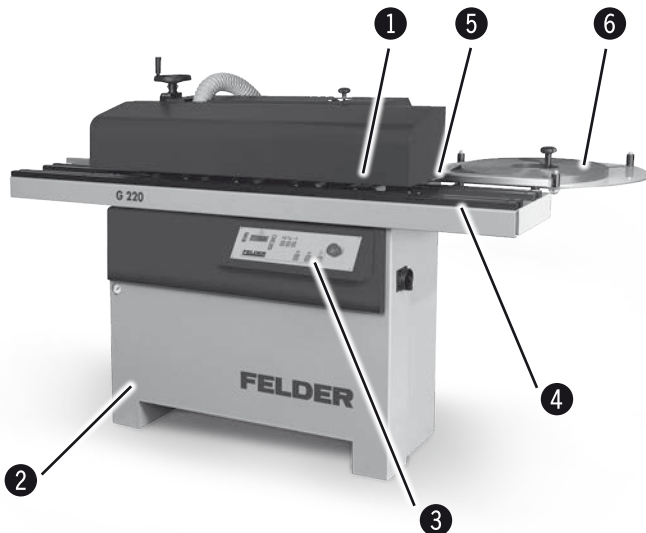


Fig. 3: Overview 1

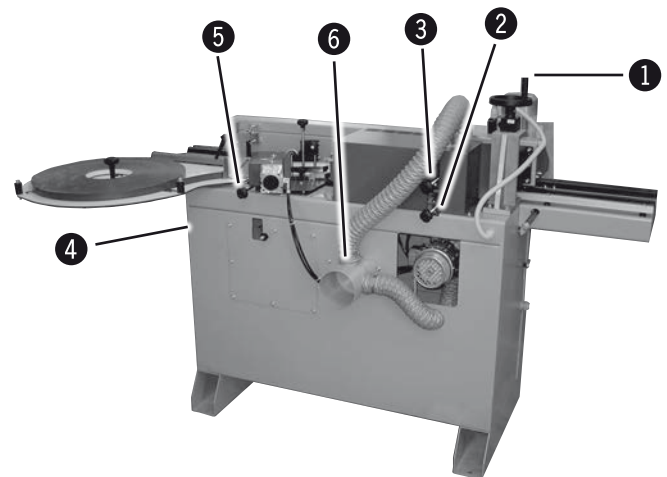


Fig. 4: Overview 2

- ① Panel belt feeder
- ② Machine frame
- ③ Control panel
- ④ Front extensible table
- ⑤ Infeed guide
- ⑥ Tape coil support with plate

- ① Height adjustment Workpiece
- ② Top flush trimming adjustment
- ③ Bottom flush trimming adjustment
- ④ Identity plate
- ⑤ Knob for feeding roller opening
- ⑥ Centralized dust collector (Opt.)

5.2 Data plate


KR-Felder-Straße 1, 6060 HALL in Tirol AUSTRIA, Tel. +43 (0) 5223 58500 info@felder-group.com			FELDER www.felder-group.com	
TYPE : XXXXXXXX				
NR.: XXX-XXX/XX-XX				
V: 400	PH: 3		HZ: 50	A: X.X
KW: X.X S1				
Baujahr / year of construction / ANNEE DE CONSTR.: 20xx				

Fig. 5: Data plate

The data plate displays the following specifications:

- Manufacturer info
- Model designation
- Machine number
- Voltage
- Phases
- Frequency
- Capacity
- Electricity
- Year of construction
- Particulars for the motor

Assembly

5.3 Electrical operation

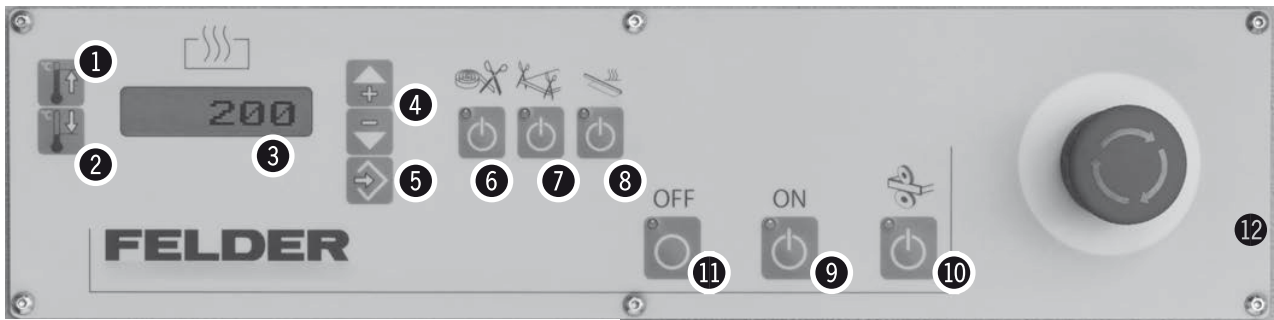


Fig. 6: Electrical operation

Thermoregulator to control the temperature of the glue pot with double display

- ① Operating temperature (SP1)
- ② Stand-by temperature (SP2)
- ③ Digital temperature indicator
- ④ "+" and "-" set the value desired for SP1 and SP2
- ⑤ Enter key

Choice switch ON/OFF

ON: Active: LED lights up
OFF: Deactivated: Light off

- ⑥ Guillotine unit
ON: Edge roller
OFF: Strip material
- ⑦ End trimming unit

- ⑧ Heated guide ruler (Option G300)

Start/Stop buttons for the unit

- ⑨ ON: Feed rate and Flush trimming unit
- ⑩ Start Buffing unit (Option G300)
- ⑪ OFF: Stops all the functions started by 7-8
- ⑫ EMERGENCY STOP button
Stops immediately all functions. Hold back type, that is to say, once it has been pushed in it stays in blocked position; to reset to normal position it is necessary to pull it. N.B.: Even if possible to use it to stop machine in normal functions it is unadvised.

5.4 Safety devices - Safety break switches

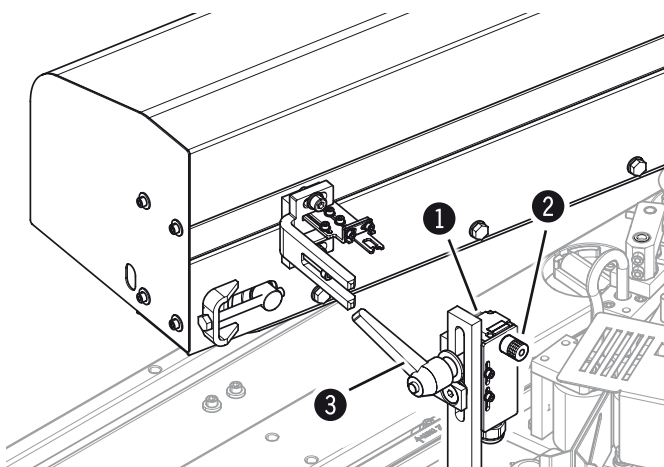


Fig. 7: Electrical operation

- ① Safety break switches
- ② Thumb screw
- ③ Clamping lever

Your machine is equipped with a security switch. The machine can only run when the switch is closed. (shut workpiece feeding unit)

Tilting away:

1. Switch the machine off and ensure that it cannot be switched on again.
2. Loosen the thumb screw.
(Anti-clockwise - up to stop)
3. Release the clamping lever.

Prepare the machine to operate:

1. Close workpiece feeding unit.
2. Clamp the clamping lever.
3. Tighten the thumb screw.
(Clockwise - up to stop)

Transport, packaging and storage

6 Transport, packaging and storage

6.1 Safety instructions



Warning! Risk of injury: There is a risk of injury due to falling parts while transporting, loading or unloading the machine.



Attention! Risk of material damage: The machine can be damaged or destroyed if it is subjected to improper handling during transport.

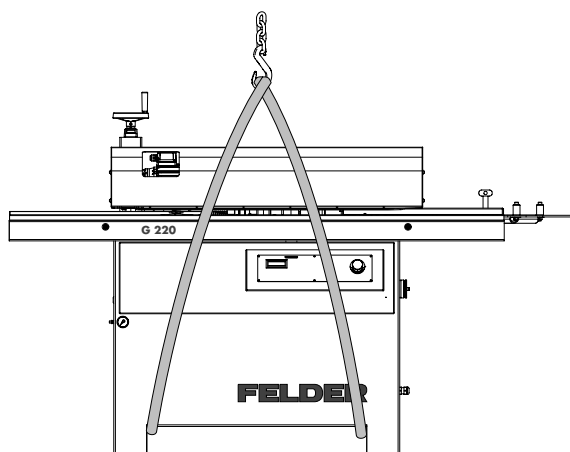
For this reason the following safety instructions must be observed:

- Never lift loads over a person.
- Always move the machine with utmost care and precaution.
- Only use suitable lifting accessories and hoisting devices that have a sufficient load-carrying capacity.
- The machine should never be lifted using protruding parts (e.g. fences, sliding table etc.).
- Consider the machine's centre of gravity when transporting it (minimise the risk of it tipping over).
- Take measures to prevent the machine from slipping sideways.
- Ropes, strops or other hoisting devices must be equipped with safety hooks.
- Do not use torn or worn ropes.
- Do not use knotted ropes or strops.
- Ensure that ropes and belts do not lie against sharp edges.
- Transport the machine as carefully as possible in order to prevent damage.
- Avoid subjecting the machine to shocks.
- When transporting the machine overseas, ensure that the packaging is air-tight and that a desiccant is added to protect the metal parts against corrosion.

6.2 Transport



Attention: Transport the machine only according to the enclosed transport and assembly instructions. Do not lift the machine by its work table, extension frames or handwheels. Ropes, belts and chains may only be fastened to the base.



Unless otherwise agreed, the machine is delivered partially dismantled on a pallet.

The machine can be transported with a crane, forklift, pallet jack or rolling carriage.

When moving the machine with a forklift or pallet jack, bolt the transportation device (option) onto the housing.

Fig. 8: Unloading

Transport, packaging and storage

6.3 Transport inspection

Upon arrival, inspect the shipment to ensure that it is complete and has not suffered any damage. If any transport damage is visible, do not accept the delivery or accept it only with reservation. Record the scope of the damage on the transport documents/delivery note. Initiate the complaint process.

For all defects that are not discovered upon delivery, be sure to report them as soon as they are recognized because claims for damage must be filed within a certain period, as granted by law.

6.4 Packaging

If no agreement has been made with the supplier to take back the packaging materials, help to protect the environment by reusing the materials or separating them according to type and size for recycling.



Attention! Dispose of the packaging materials in an environmentally friendly way and always in accordance with local waste disposal regulations. If applicable, contract a recycling firm to dispose of the packaging materials.



Attention: Help preserve the environment! Packaging materials are valuable raw materials and in many cases they can be used again or expediently reprocessed or recycled.

6.5 Storage

Keep items sealed in their packaging until they are assembled/installed and be sure to observe the stacking and storage symbols on the outside of the packaging.

Store packed items only under the following conditions:

- Do not store outdoors.
- Store in a dry and dust-free environment.
- Do not expose to aggressive substances.
- Protect from direct sunlight.
- Avoid subjecting the machine to shocks.
- Storage temperature: -10° to +50° C.
- Maximum humidity: 60%.
- Avoid extreme temperature fluctuations (condensation build-up).
- Apply a coat of oil to all bare machine parts (corrosion protection).
- When storing for longer than 3 months, apply a coat of oil to all bare machine parts (corrosion protection). Regularly check the general condition of all parts and the packaging. If necessary, refresh or re-apply the coat of anti-corrosive agent.
- If the machine is to be stored in a damp environment, it must be sealed in air-tight packaging and protected against corrosion (desiccant).

Setup and installation

7 Setup and installation

7.1 Safety instructions



Warning! Risk of injury: Improper assembly and installation can lead to serious bodily injury or equipment damage. For this reason this work may only be carried out by authorised, trained personnel who are familiar with the operation of the machine and in strict observance of all safety instructions.

- Ensure that there is sufficient space for working around the machine. Ensure there is ample distance between the machine and other solid constructions such as a walls or other machines.
- Keep the work area orderly and clean. Components and tools that are not put in their correct place or put away may be the cause of accidents!
- Install the safety equipment according to the instructions and check that it functions properly.



Warning! Danger – electric current: Work on electrical fittings may only be carried out by qualified personnel and in strict observance of the safety instructions.

Before assembling and installing the machine, check to make sure it is complete and in good condition.



Warning! Risk of injury: An incomplete, faulty or damaged machine can lead to serious bodily injury or equipment damage. Assemble and install the machine and other units only if they are complete.



Attention! Risk of material damage: Only operate the machine in ambient temperatures from +10° to +40° C. If the instructions are not followed, damage may occur during storage.

7.2 Installation

Characteristics of the installation site:

- Operation/room temperature: +10° to +40° C.
- Ensure that the work surface is sufficiently stable and has the proper load-bearing capacity.
- Provide sufficient light at the workstation.
- Ensure there is sufficient clearance for or from neighbouring workstations.
- Risk of injury! Keep machines, tools and accessories etc. out of the reach of children.
- Vacuum hoses and electrical wires should be layed in such a way as to avoid tripping over them.

Setup and installation

7.2.1 Space requirements/ Measurements

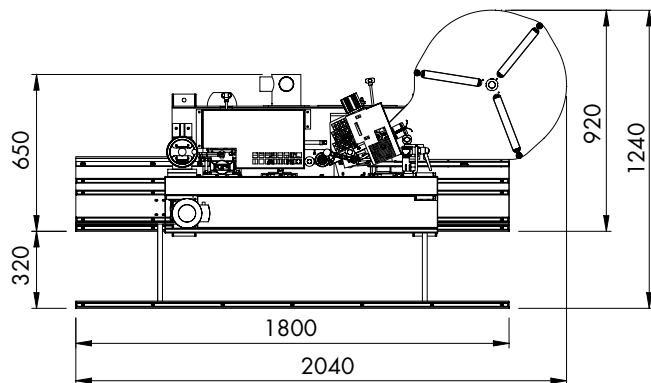


Fig. 9: Space requirements G 200

The machine can also be bolted to the floor if required.

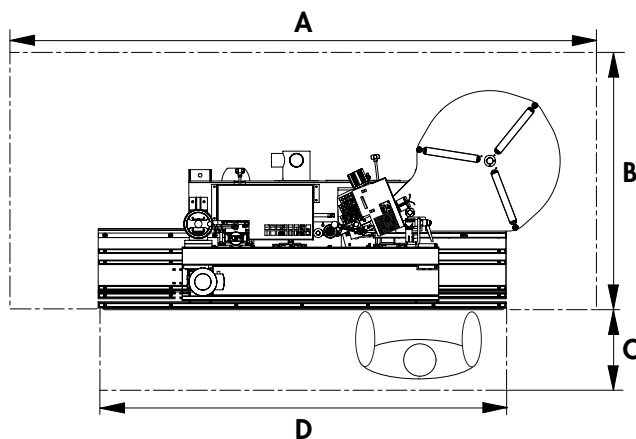


Fig. 9-1: The workspace shown

The workspace shown in the picture makes it possible for the operator to operate the control elements easily. The workspace for maintenance and cleaning is also pictured.

A	3000 mm
B	2000 mm
C	1000 mm
D	1750 mm

7.2.2 Array of the machine

The machine is delivered with a nylon protection or carton; in both cases, for transport necessities, some parts of the machine are detached. To assemble and adjust these parts (see Fig. 11).

Locate the machine in a suitable place, considering the dimensions of the machine, space needed for stacking, loading and offloading workpieces, leaving sufficient space for the operator to move freely (Locate the machine

in a suitable place, considering the dimensions of the machine, space needed for stacking, loading and offloading workpieces, leaving sufficient space for the operator to move freely (see Fig. 11).

The machine base must be laid on a even solid surface. Make sure, by using a water level or any other equivalent good quality level, that the working table is levelled in both directions. Tolerance $\pm 0,25$ mm in longitudinal direction.

Setup and installation

7.3 Dust extraction



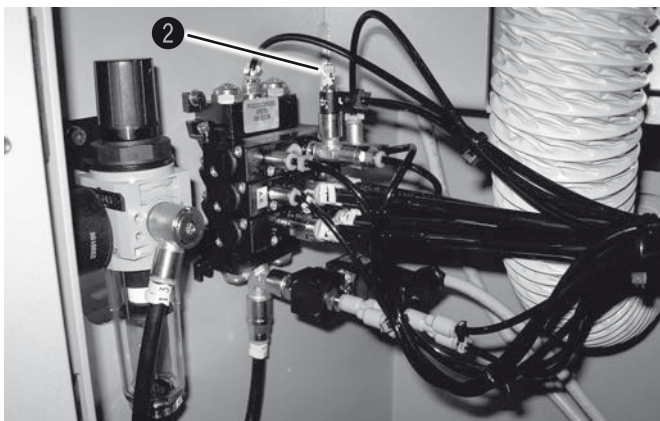
Warning! Risk of injury! The dust extraction hose must be non-flammable and must not conduct electricity! For this reason, only use genuine FELDER dust extraction hoses!



Note: As a rule, all units must be vacuumed during use. A time delayed socket is available as an accessory.

- In addition, the vacuum performance must be sufficient to achieve the required negative pressures and an air speed of 20 m/s at the connector. (see "Technical data")
- Check the air speed before putting the machine into operation for the first time and after essential changes.
- The dust extractor setup must be controlled before the machine is put into operation for the first time. Check for obvious defects on a daily basis and the efficiency on a monthly basis.
- The dust extractor must be connected to the machine in such a manner that it runs in unison with the machine.
- The dust extraction hoses must be electrically conductive and grounded to prevent electrostatic build up.
- Use dust extractors with reduced dust emission to clean dust from the machine.

7.4 Pneumatic control



The pneumatic control unit is mounted under the machine rack and is reachable by the security door.

The control unit is adjusted factory made. A sample workpiece was made to do the engagement for the machine. It is supplied with the machine.

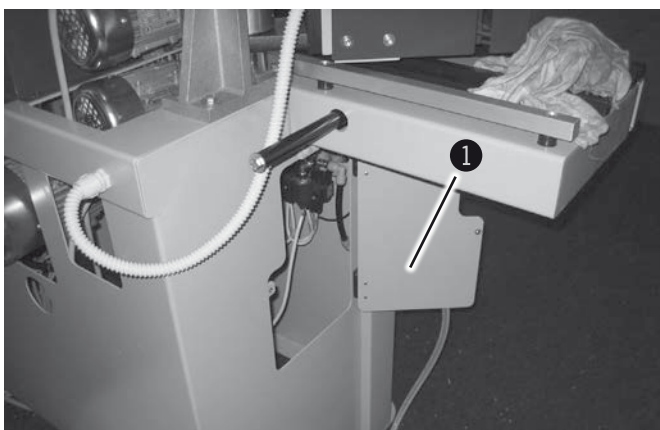
If you are dissatisfied with your deliverable then you can justify the control unit as follows:

How to justify trail speed of the cutting unit

This adjustment is very delicate and it is advisable not to misplace the screw.

Before making any changes, check that the pressure of the compressed air system is not less then 6 bar. Also check the cleanness of the workpiece guides.

If you have to misplace the screw E nevertheless, mark the position of the screw with a felt pen, that you can get back to the old position.



- ① Door
- ② Screw

Fig. 10: Pneumatic control

Setup and installation

7.5 Electrical connection



Warning! Danger! Electric current!

All electrical repairs must be carried out by a qualified electrician.



Attention! Risk of material damage!

Before hooking up the machine to the power supply, compare the specifications on the data plate with those of the electrical network. Only hook up the machine if the two sets of data correspond to each other.



Note: The machine's circuit box may only be opened with the express consent of the FELDER service team. Violating this stipulation shall render the right to make claims under the warranty null and void.



Attention! Risk of material damage!

The machine must be secured with an automatic fuse (including a Residual current protection (RCCB)).

Machines with a frequency converter:

A universal residual current circuit breaker Type B $\geq 300\text{mA}$ must be fitted.

The dimensioning of the current value for the overcurrent protection device and residual current circuit breaker can (e.g.) be taken from the circuit diagram.

The switch-off times according to EN 60204-1 must be observed.

Checking the loop impedance and the suitability of the overcurrent protective device must take place at the location where the machine is to be commissioned!



Fig. 2-12: Direction of the Motor rotation

1. Connect the plug to the power supply.
2. Switch on and let the machine run briefly.
3. While the motor is running, check its direction of rotation.
4. Should a change in the direction of rotation be necessary, switch the two phases on the power cable.

Electrical connection requirements

- The machine must be earthed with electrical conductors.
- The voltage fluctuations in the mains supply may not exceed $\pm 10\%$.
- The switch cabinet must be fitted with a circuit breaker (DIN VDE 0641).
Number of terminals: 3 (three phase current motors)
- The unit must only be used in TN-Systems (neutral connected to earth)! (only 3x400V)
- Power supply cable H07RN-F at least 5x 2,5 (rotary-current motor) or 3x 2,5 (alternating-current motor).
- Safeguarding/Power supply cord:
see "Technical data"
- The power supply cable must be protected against damage (e.g. armoured conduit).
- The power supply cable must be laid in such a way so it does not overbend or chafe and there is no risk of tripping over it.



Note: The machine's power cable is delivered with an open cable end, i.e. without a plug.

The operator is responsible for fitting the machine's power cable with a suitable plug in accordance with any country's specific regulations.

The electrical outlet must have the appropriate socket (for a three-phase alternating current motor, CEE).

Making adjustments and preparations

8. Making adjustments and preparations

8.1 Safety instructions



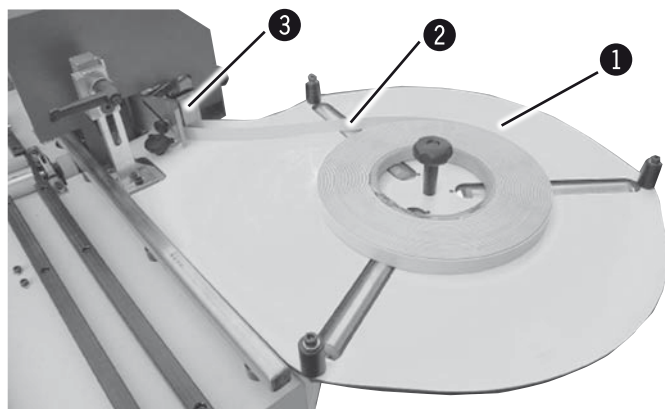
Warning! Risk of injury: Improper adjustment and working setup can lead to serious bodily injury or material damage. For this reason this work may only be carried out by authorised, trained personnel who are familiar with the operation of the machine and in strict observance of all safety instructions.

- Before beginning any maintenance work on the machine, switch it off and secure it against accidentally being turned on again.
- Before commencing any work with the machine, inspect it to ensure that it is complete and in technically good condition.
- Ensure that there is sufficient space for working around the machine.
- Keep the work area orderly and clean. Components and tools that are not put in their correct place or put away may be the cause of accidents!
- Install the safety equipment according to the instructions and check that it functions properly.



Warning! Danger – electric current: Work on electrical fittings may only be carried out by qualified personnel and in strict observance of the safety instructions.

8.2 Edge tape positioning

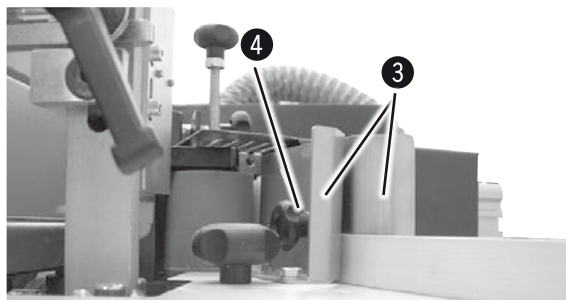


Proceed as follows to change the type of edge tape (height, thickness and material).

Place the edge band onto the outrigger in such a way so that it still turns easily.

The tape must be threaded between the two plates.

Use the knob to adjust the vertical position of the tape. The knob can be moved in the 45° slot depending on the width of the tape. Only tighten the knob so much that it is still possible to move the tape manually (0,5 mm clearance).



- ① Outrigger
- ② Tape
- ③ Plates
- ④ Handle grip

Fig. 12: Edge tape positioning

Making adjustments and preparations

8.3 Edge tape feeding

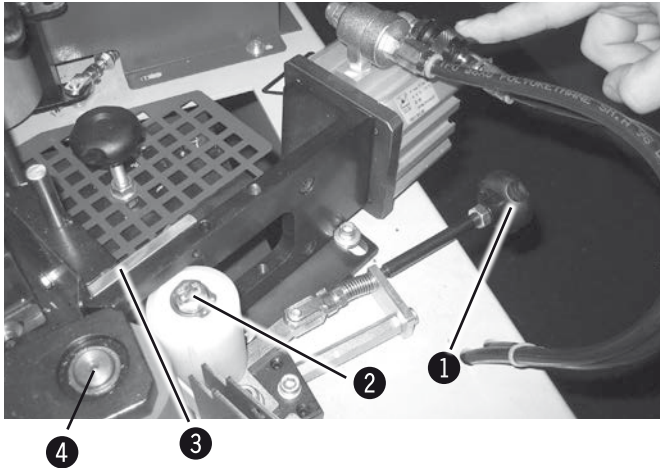


Fig. 13: Edge tape feeding

- ① Handle grip
- ② Pressure roller
- ③ Feed stop
- ④ Tape feeder roller

The function of this unit is to bring the edge tape and the workpiece together (up to the first pressure roller).

To clamp a new edge tape you can pivot the roll by using knob.
Thread the tape up to the point so as to be able to press the roller again onto the knob.

The edge tape is fed through as a result of the workpiece moving over the roller, which through a gearbox, causes the tape feeder roller to move.

8.4 Tailor edge band from coil

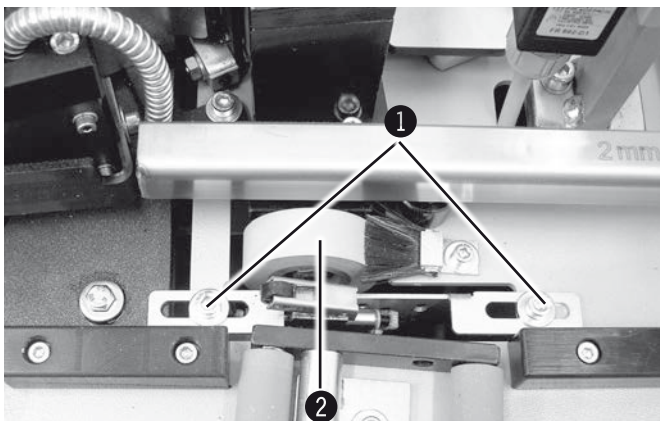


Fig. 14: Infeed fence

- ① Break switch
- ② Screws

This step used to cut edge tape from the coil.
The cutting unit works pneumatically. It is controlled by the micro switch O01 and is tripped by the overrunning workpiece.

The protrusion of the glued on edge tape is justified factory-made.

If you need to change this protrusion you have to open the two screws.

Now you can displace the micro switch O01 into the direction of ingress (reduces the protrusion) into the direction of discharge (increases the protrusion).

Making adjustments and preparations

8.5 Edge tape fence

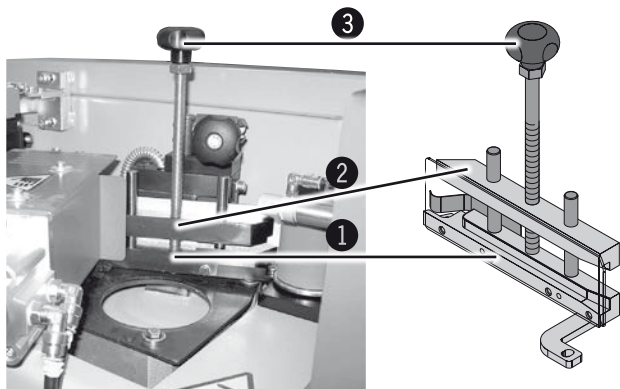


Fig. 15: Edge tape fence

- ① Edge guide 1
- ② Edge guide 2
- ③ Handle grip

Pull the tape manually until it reaches the edge guides. The lower guide is adjusted to the height of the worktable.

The fence must be adjusted to the width of the edge tape (the upper guide is justified). The knob adjusts the width. The vertical play must be within 0,5 mm.

8.6 Infeed fence

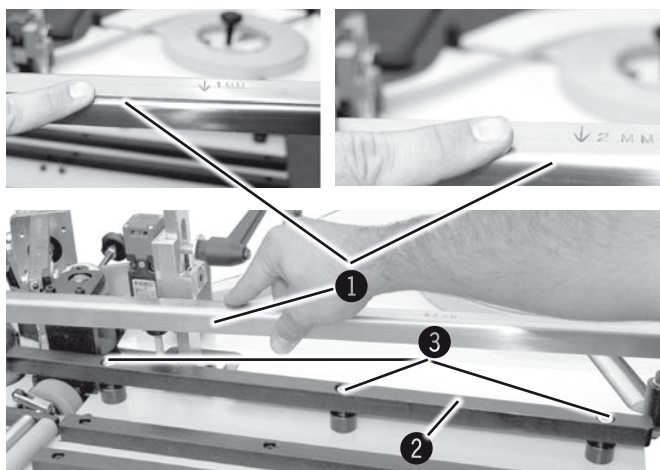


Fig. 16: Infeed fence

Per edge tape width there are different devices. These devices must be attached onto the infeed fence to have a parallel guide of the workpiece.

0,4 – 0,8 mm	no device necessary
1 – 1,5 mm	1 mm device
2 mm	2 mm device

- ① Devices
- ② Infeed fence
- ③ Fixing screws



Attention! Never loosen the fixing screws of the infeed fence!

Making adjustments and preparations

8.7 Pneumatic shears with trail

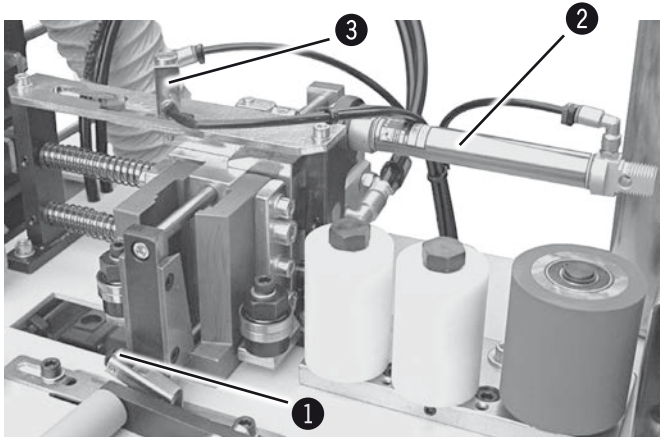


Fig. 17: Pneumatic shears with trail

- ① Break switch
- ② cylinder
- ③ Valve

This unit is relevant to dislodge the protrusion of the tape (at the outset and the end).

As soon as the workpiece passes the valve, the shear cuts of the protrusion at the beginning. The shear stays closed till the workpiece has passed valve. The scissors opens and cylinder moves the whole unit with the workpiece. The unit reaches the workpiece at the valve and cuts the protrusion at the end. The scissor unit stays closed and on place until the valve is pushed.

The sheere opens and is waiting for the next workpiece.

8.8 Automatic workpiece-feed



Fig. 18: Automatic workpiece-feed

- ① Handwheel
- ② Display

The feed system of the workpieces to be edged consists of a belt drive with a special surface, so as to retain a high friction and not to damage the workpiece.

It also has a good wearout strenght. The transversed positioned rolls give the workpiece the side shunted to glue the workpiece together.

The feed speed is 5 m/min, to get a good quality workpiece. The motor which has 3 phases is well dimensioned.

Making adjustments and preparations

8.8.1 Height adjustment workpiece feeder

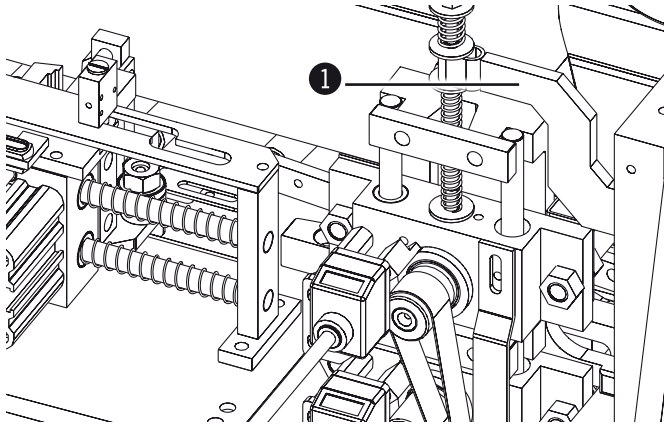


Fig. 19: Height adjustment workpiece feeder

① Contact bar

Before you change the height of the workpiece feeder open handle.

The hand wheel adjusts the height of the workpiece thickness. You can see the measure on the display.

The contact bar is coupled with the flush trimming unit. If you change the height of the belt feeder then the shaping unit is misplaced automatically.

Remark:

If you exchange the height of the belt feeder you have to do it exactly. Only a difference of 0,5 mm can anticipate the wearout of the belt drive.

Always adjust the height in small steps.

Equalize the thread play by turning in a counter wise direction.

8.8.2 Security closure workpiece feeder

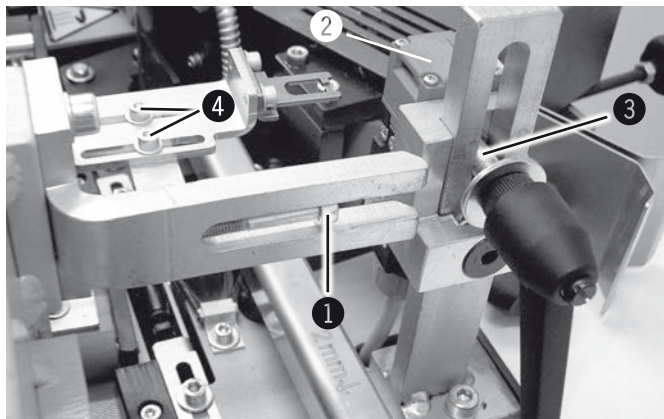


Fig. 20: Security closure workpiece feeder

- ① Screw 1
- ② Special contact
- ③ Screw 2
- ④ Screws

The security closure has many functions:

- a) The screw adjusts the angle of the workpiece feed and thus the sideways shear, which makes the gluing together process possible. Do not overextend the angle, as this will overload the system unnecessarily.
- b) Everytime you open the belt feeder a special electric contact turns off the machine.

If you open the belt feeder it causes the same situation as a emergency stop switch. Switch the machine back on as instructed. It is dangerous to manipulate the security switch.

- c) For special requirements (e.g. edge tape sensitive materials) it is possible to reduce the side pressure by loosening the screws, which serve as a fence to the belt feeder. It is necessary to adjust the special contact by adjusting the screws.

Making adjustments and preparations

8.8.3 Processing of thin workpieces

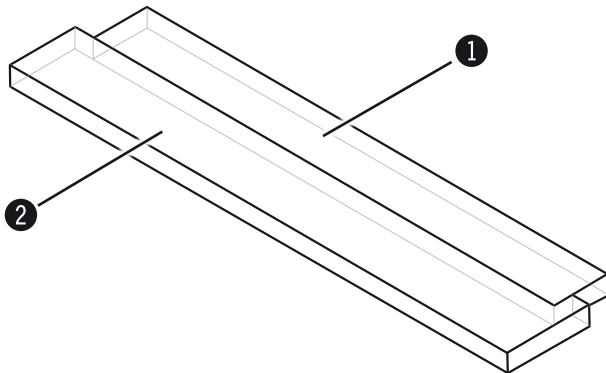
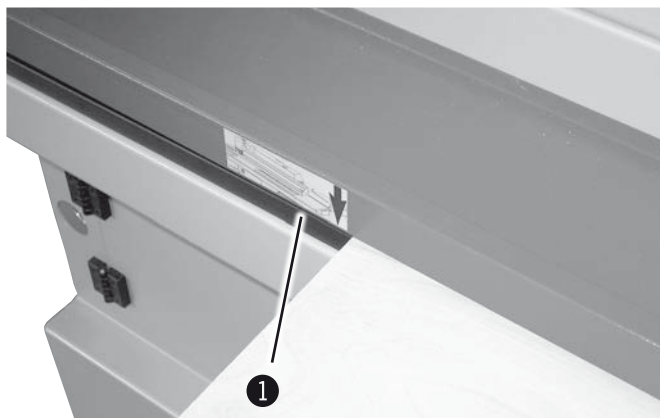


Fig. 21: Processing of thin workpieces

If the workpiece to be machined is narrower than the drive belt (smaller than width of 72 mm) you must edge tape the workpiece together with a wooden plate of the same type and thickness.

- ① Workpiece
- ② Sliding panel

8.8.4 Infeed of two workpieces



You can infeed a second workpiece when the first workpiece has passed the arrow.

If you disregard then the front tape shear doesn't work for this operation.

- ① Sticker

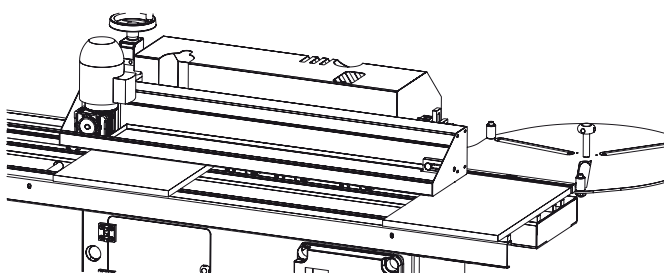


Fig. 22: Infeed of two workpieces

Making adjustments and preparations

8.9 Glue pot

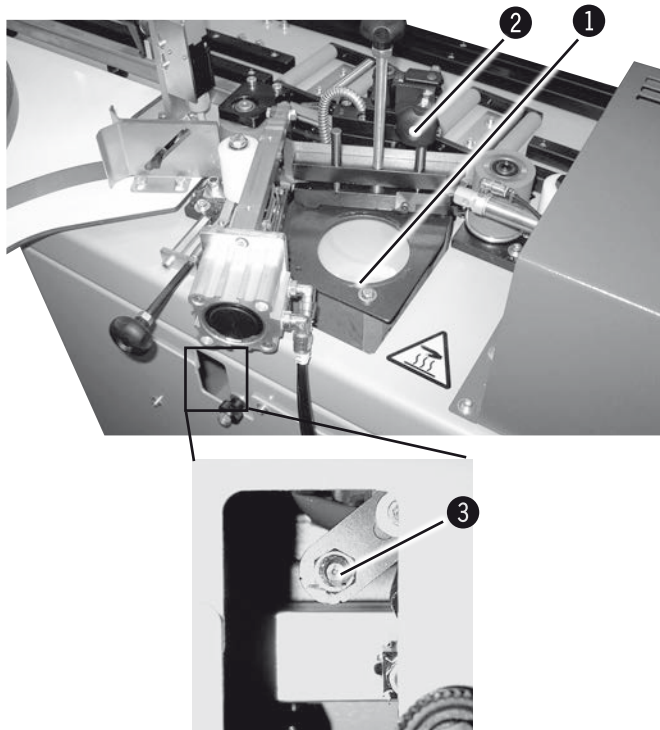


Fig. 23: Glue pot

- ① Glue pot
- ② Knob
- ③ Hole

The glue pot unit has the function to heat the glue to up to working temperature and to spread the hot melting glue on the workpiece to be edged. For a correct functioning of this unit, carefully follow these instructions:

1. Fill up the glue pot to approximately 1 cm underneath its edge with the hot melting granulated glue. Make sure that the type of glue used is compatible with the conditions and the technical characteristics of the machine.
2. Adjust the electronic thermostat at the temperature corresponding to the one suggested by the manufacturer (normally adjusted at 200° C at the factory).
3. The glue spreader starts turning automatically when the temperature reaches 190° C. The quantity of gluespread is adjustable by turning the knob; by turning clockwise it increases, by turning unclockwise it decreases. During edging control the amount of the glue and refill if necessary.
4. When lubricating, machine must be switched off. Lubrication is done with the provided grease gun pointing the nozzle in the hole. Use the lubricant for high temperature bearings AREXONS GC 300. By intensively use maintenance machine every second day.
5. The visible screw positioned on the rear of the machine fix the spring which pushes the glue pot. Do not need any further adjustment.



Attention! Risk of burning! Do not mix glue with wood chips or wood dust. Carefully take note of the hot melting glue manufacturers advice. To avoid the deterioration of the glue always check the thermostat adjustment and the quantity of the remaining glue. It is advisable to reduce the temperature of at least 50° C for the working breaks which last longer than 15 minutes. Since the good edge finishing depends upon many factors, such as type of edge, type of workpiece, cutting quality, environment temperature etc. it is therefore necessary to effect various tests to find the correct adjustment.

Making adjustments and preparations

8.10 Control of thermostat

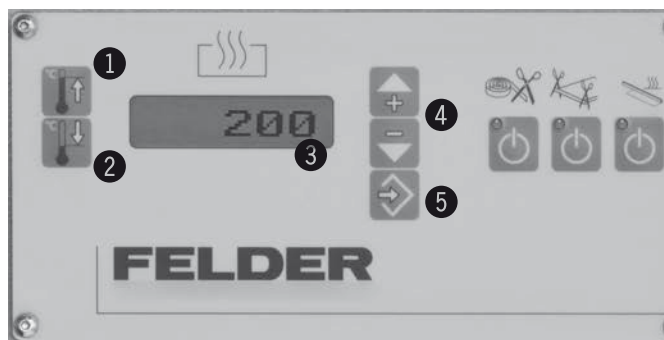


Fig. 24: Control of thermostat

The five touch-sensitive membrane keys on the front panel are used to program and operate the display. Depending on the operating mode, the keys may have additional functions

- ① Operating temperature (SP1)
- ② Stand-by temperature (SP2)
- ③ Digital temperature indicator
- ④ "+" and "-" set the value desired for SP1 and SP2
- ⑤ Enter key

Making adjustments and preparations

8.10.1 Setting the glue temperature



Note: The machine has an automatic temperature reduction system:

If the machine is idle for 20 minutes the temperature will reduce automatically to the SP2 value specified. If the glue is to be reheated to operational temperature (SP1), then this process can be started by pressing SP1 twice.

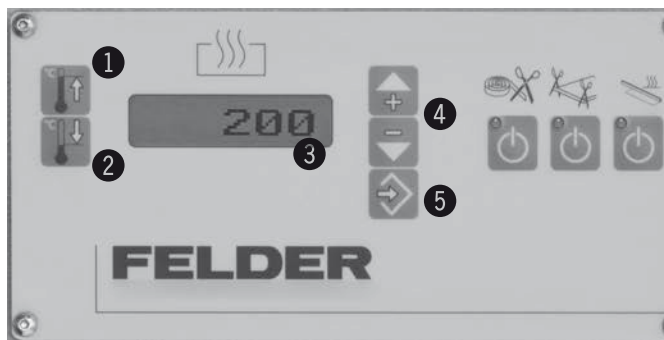


Fig. 25: Setting the glue temperature

The electronic temperature adjuster must be set to the temperature recommended by the glue manufacturers (in factory normally adjusted to 200°C). The glue application roller starts automatically once the glue is liquid and has reached 190°C.

Depending on the type of glue, working temperatures may be approx. 180°–210° C (356°–410° F).

To ensure that the glue maintains its quality, the glue pot must be kept at the operational temperature for as short a time as possible.

Standard equipment: Manual adjustment

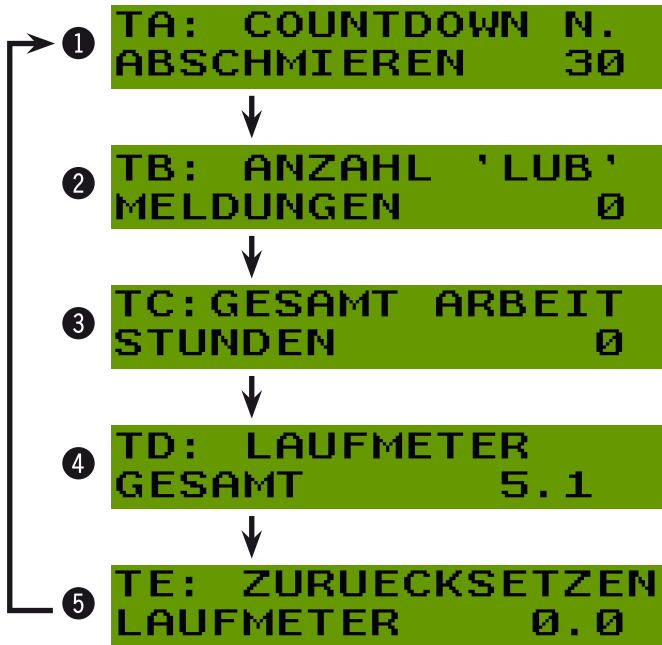
- Press either SP1 or SP2
- Adjust the value using “+” or “–” and press ENTER to confirm

- ① Operating temperature (SP1)
- ② Stand-by temperature (SP2)
- ③ Digital temperature indicator
- ④ “+” and “–” set the value desired for SP1 and SP2
- ⑤ Enter key

The values selected by you are stored in a non-volatile memory.

Making adjustments and preparations

8.10.2 Display machine information / Setup



1. Operating temperature (SP1):
press and hold (approx. 10 seconds)
 2. The following value appears in the display:>TA:
COUNTDOWN<
Use the arrow keys to scroll through parameters:
 3. Save changes with >OK< key and exit menu.
-
- ① Display of the maintenance intervals (Countdown)
The setting is carried out by FELDER employees on delivery.
The following value appears in the display >LUB<:
Reset meter:
OFF key - press and hold (approx. 10 seconds)
 - ② The setting is carried out by FELDER employees on delivery.
 - ③ Operating hour meter:
Meter (total material used)
 - ④ Odometer for total meters of material used:
Meter (total material used)
 - ⑤ Odometer for total meters of material used: Meter
resettable
Reset meter:
Operating temperature (SP1) - press and hold (approx. 10 seconds)

Making adjustments and preparations

8.11 Flush trimming unit

8.11.1 Flush trimming unit

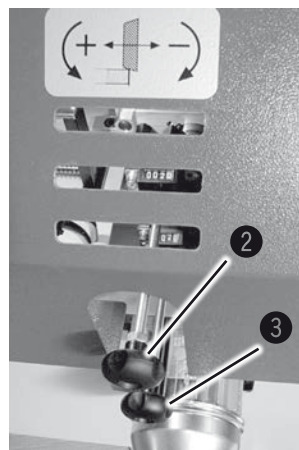
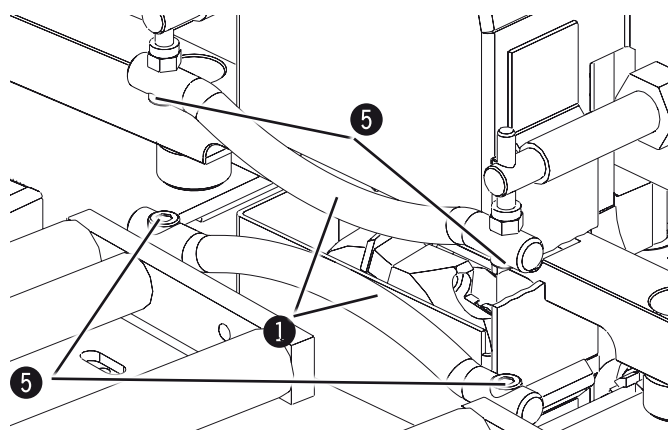


Fig. 26: Flush trimming unit

- ① Pad feelers
- ② Handle 1
- ③ Handle 2
- ④ Sticker
- ⑤ Screws
- ⑥ Edge protrusion

This unit is used to trim the edge protrusion on both workpiece sides. It depends on the trimming unit and workpiece thickness to do a sharp, beveled or a rounded edge.

The unit is equipped with 2 counter rotating cutters (70 mm diameter) with 4 WIDIA-knives with a tilted cut of approximate 15°. As a special accessory you can use other trimmers too. Rotational speed about 9000 rpm.

The two shapers have a floating mounting and copy the workpiece shape with the 2 pad feelers.

If you change the thickness of the workpiece, the height of the shaper above justifies automatically. Both flush shapers are equipped with suction pipes Ø 60 mm. It is absolutely necessary to work with an efficient dust extraction system.

The choice of your shaper tools depend on following parameters:

- admissible diameter: 70 mm
- spindle diameter: 12 mm
- max. width shaper: 20 mm
- max. weight per shaper: 250 g
- max. RPM: 15.000

The axial regulation can be done by actuating the two knobs. Thereby the size of the bevel misplaces. This adjustment will have to be carried out frequently. Justify the tool when it is spinning and pay attention to the sticker (on the machine back).

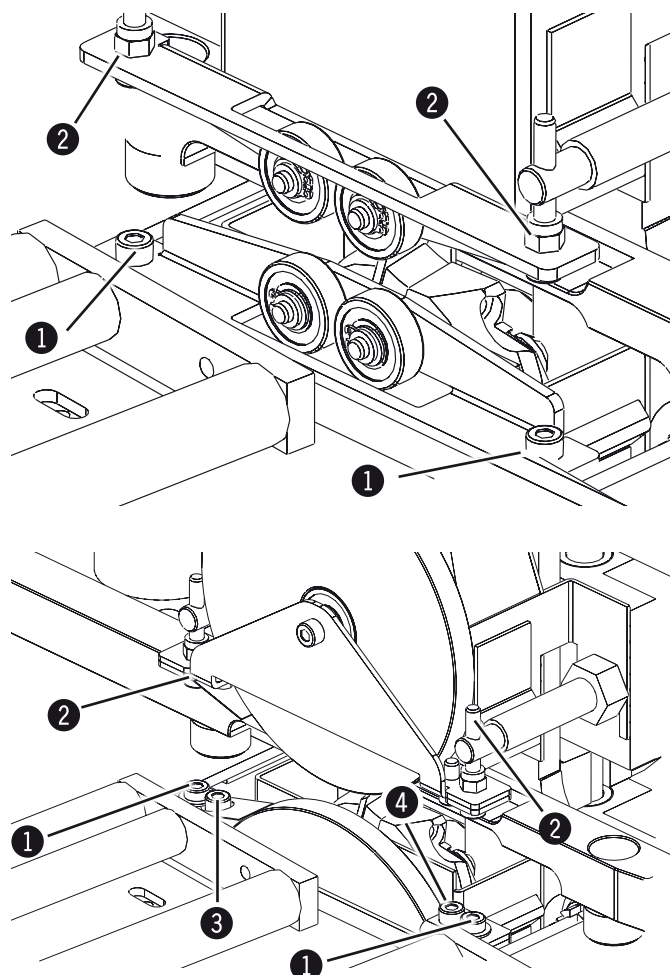
The vertical fent is done by the screws. The screws adjust the height of the pad to match the trimmer.



Attention! Spin the screws with the same number of turns that the copy pad feelers stay parallel to the working table. You can shape maximum 2 mm of edge protrusion on both sides A2.

Making adjustments and preparations

8.11.2 Option Flush trimming unit



The machine can be equipped with tracing ball bearings or with a tracing roller. Both systems can be adjusted with the screws. Always the same rotations on both sides.

Never open the screws of the tracing roller system!

- ① Screw 1
- ② Screw 2
- ③ Screw 3
- ④ Screw 4

Fig. 27: Option Flush trimming unit

Operation

9 Operation

9.1 Safety instructions



Warning: Risk of injury: Improper operation may lead to severe bodily injury or material damage. For this reason this work may only be carried out by authorised, trained personnel who are familiar with the operation of the machine and in strict observance of all safety instructions.

Before starting work:

- Before assembling and installing the machine, check to make sure it is complete and in good condition.
- Ensure that there is sufficient space for working around the machine.
- Keep the work area orderly and clean. Components and tools that are not put in their correct place or put away may be the cause of accidents!
- Ensure that all safety devices have been properly installed.
- Adjustments to the machine or tool replacement may only be conducted once the machine has stopped.
- Only clamp authorised tools to the machine.
- Install the vacuum system according to the instructions and test its function.
- Only process workpieces that can be safely placed on the machine and guided.
- Carefully inspect workpieces for foreign matter (nails, screws) which might impair processing.
- Support long work-pieces with additional surface equipment (e.g. Table extensions, Roll supports).
- Ensure that each unit is rotating in the proper direction.
- Keep tools for handling short and narrow workpieces close at hand.
- Before switching on the machine, always check to make sure that there are no other persons in the immediate vicinity of the machine.

During operation:

- When changing to another workpiece or when there is a malfunction, first switch off the machine and then secure it against being switched on again accidentally.
- Do not switch off, circumvent or decommission protective and safety devices during operation.
- Do not overload the machine! It is safer and performs better if operated within its power range.

When working on or with the machine, the following must be strictly observed:

- Persons with long hair who are not wearing a hairnet are not permitted to work on or with the machine.
- It is prohibited to wear gloves while working on or with the machine.
All jewellery (rings, bracelets, necklaces, etc.) must be removed before starting work on or with the machine.

When working on or with the machine, the following must always be worn by personnel:

- Sturdy, tight-fitting clothing (tear-resistant, no wide sleeves).
- Protective footwear that protects the feet from heavy falling objects and prevents sliding on slippery floors.
- Ear protection to protect against loss of hearing.



Attention: Risk of material damage: Only operate the machine at an operating/room temperature of +18 to +40 °C. If the instructions are not followed, damage may occur during storage.



Warning: Danger – electric current: Work on electrical fittings may only be carried out by qualified personnel and in strict observance of the safety instructions.

Operation

9.2 Switching on the machine



Warning: Risk of injury due to insufficient preparation!

It is only permitted to switch on the machine if, for the work at hand, the required preconditions are fulfilled and any preliminary work is completed. For this reason the instructions for adjusting, fitting and operating (see the corresponding chapters) must be read before switching on the machine.

9.3 Switching off the machine



Attention! Never actuate the EMERGENCY STOP switch to switch off the machine as this will wear out the brake shoes very quickly. The EMERGENCY STOP switch is only to be actuated in case of an emergency!

9.4 Emergency stop

Only use the emergency stop switch in case of an emergency!

If you want to switch the machine on again, you need to disengage the EMERGENCY STOP switch: Pull the EMERGENCY STOP switch out and repeat the starting process.

9.5 Working techniques

9.5.1 Authorised work techniques

All uses which differ from the following work techniques have not been intended for this machine and are therefore not authorised.

- Applying coiled edge material (0.4 - 2 mm) onto right-angled edges

9.5.2 Prohibited working techniques

The following working techniques are prohibited on this shaping unit:

- Use of single units
- Use for circular workpieces
- Working with pre-glued edging material.
- Insertion cuts - the workpiece is not worked over its entire length

Operation

9.5.3 Handling of shaping tools

Shaping tools must be handled with special care.

If possible, use special protective containers or hanging arrangements for storage.

9.5.4 Processing phases

It is quite simple to obtain good edge banding results; anyhow it is necessary to keep in mind a good number of variations, of which each one contributes to the best final results.

The aspects are summarized in 4 groups:

1. Workpieces to be edgebanded
2. Edge bands used
3. Hot melting glues
4. Adjustment of the machine

1. Workpieces to be edgebanded:

- It is advisable to use good quality workpieces with a sufficient density.
- Cutting must be smooth, without chipping and with a straightness of at least + 0,1 mm per linear metre.
- The area to be edgebanded must be free from dust and humidity.
- The cut must be perfect at (90°) both on surface and in thickness.

2. Edge bands used:

- Use good quality pre-glued edge bands.
- Keep them in a dry storage place.
- Check that manufacturing date is written on the wrapping (the glue loses defensibility with time).
- Check that manufacturer indicates suggested melting temperature.
- Avoid the use of PVC edge bands of limited thickness, since they are very difficult to apply.

3. Hot melting glues:

- Use hot melting glues suitable for the machine characteristics and carefully respect the manufacturers specifications.
- Check that the glue is spread uniformly on the panel.
- Effect various tests to find the right quantity of glue, using lever to adjust the amount of the glue.
- The glue must not overflow, otherwise the cutters will get stained.

4. Adjustment of the machine:

Turn on the main switch and all other functions and dust outlet system, make some edge banding tests checking following points:

- Height of panel feeder equal to the workpiece thickness
- Sideway push
- Glue melting temperature
- Belt feeder
- Cutting nipper adjustments
- Flush trimming unit

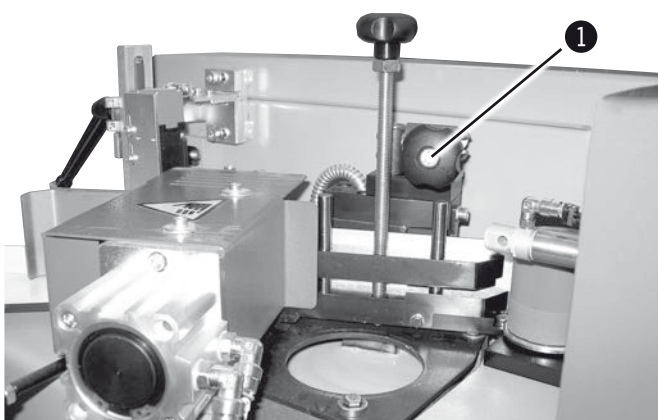


Fig. 28: Processing phases

- ① Lever - Setting the glue quantity

Maintenance

10 Maintenance

10.1 Safety instructions



Warning! Risk of injury: Improper maintenance can cause serious injury or damage. For this reason this work may only be carried out by authorised, trained personnel who are familiar with the operation of the machine and in strict observance of all safety instructions.

- Before beginning any maintenance work on the machine, switch it off and secure it against accidentally being turned on again.
- Ensure that there is sufficient space for working around the machine.
- Keep the work area orderly and clean. Components and tools that are not put in their correct place or put away may be the cause of accidents!
- Following the maintenance work, re-install the guards and check that they are functioning properly.



Warning! Danger – electric current: Work on electrical fittings may only be carried out by qualified personnel and in strict observance of the safety instructions.

10.2 Maintenance work



**Read individual operation instructions:
Maintenance and preservation guidelines (in particular intervals)
Edgebanders - with belt feed drive**

All maintenance, upkeep and adjustment measures may only be performed with the main switch of the machine turned off.

Failure to perform the prescribed maintenance will invalidate the warranty!

10.3 Maintenance schedule

10.3.1 Cleaning



Attention! Before you start to clean the machine, control if the machine parts have cooled down!

We recommend cleaning the machine of dust and chips daily, especially the table-, roll- and guide surfaces. The required cleaning and care products are available as accessories. Contact the manufacturer of the edging glue tapes for

information on the appropriate solvent to remove glue residues. Remove cutting residues from the machine regularly.

Maintenance

10.3.2 Lubrication

Generally there is no lubrication necessary, because the ball bearings are free of maintenance and the sliding

bushes and linear guiding are self-lubricating.

10.3.3 Exchanging tools

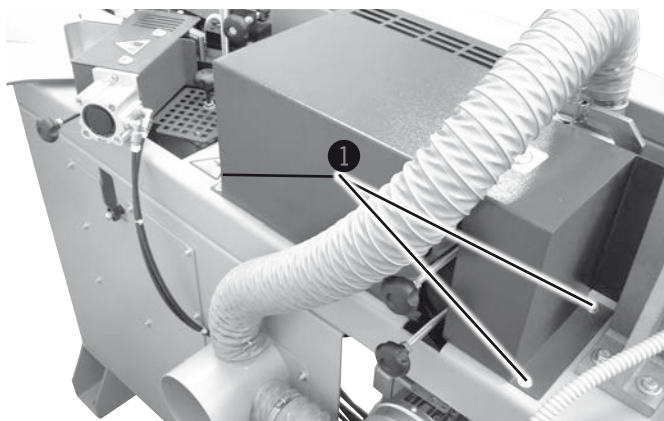


Fig. 29: Exchanging tools

Exchanging tools of edge tape cutting unit:

1. Open belt feeding unit and take off security plate by loosening the socket wrenches. Now you can reach the knives of the end trimming unit.
2. Exchange the knives by loosen the screws.
3. At the installation go ahead in reversed order. Tighten the screws and check that the knives hold tight.
4. Mount the security plate again.
5. Proceed in a similar fashion for the front cutting unit.

Grinding the knives:

1. Remove the knives to be grinded (as described above).
2. Mark the knife so it can be assembled in the same position again.
3. Grind the knives only on the bevel side. Repeat the process for the other knife.

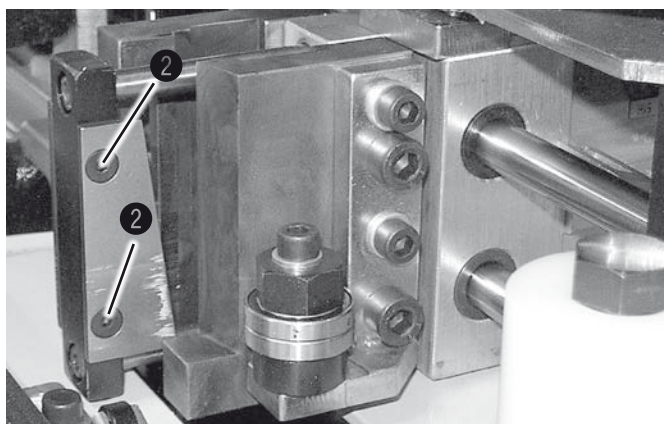


Fig. 30: Exchanging tools

- ① Socket head cap screws
- ② Fixing screws

Maintenance

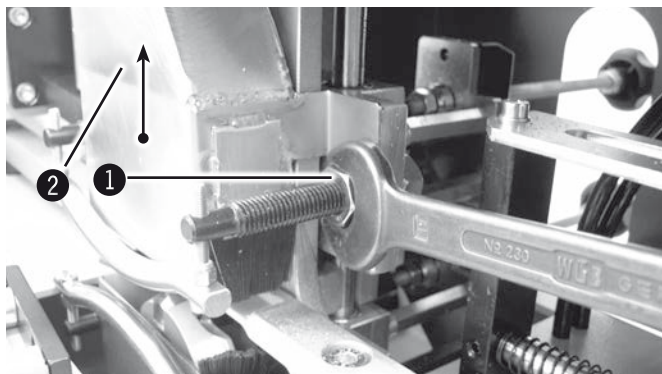


Fig. 31: Exchanging tools

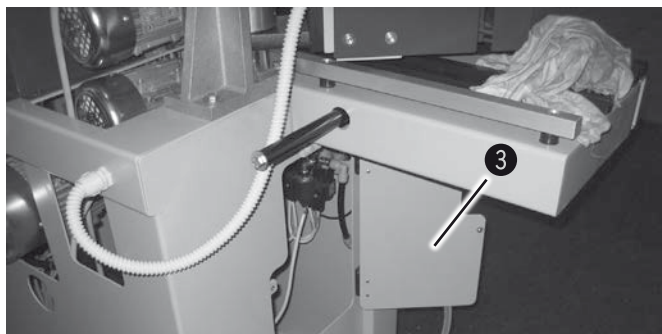
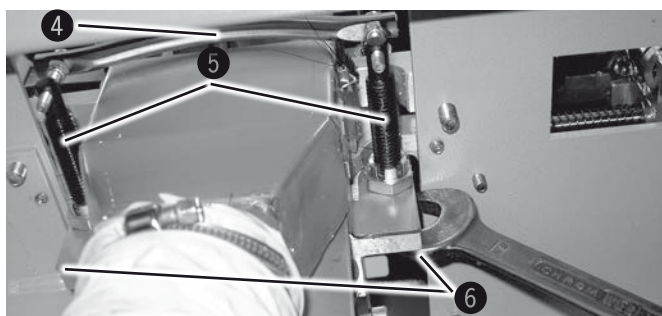


Fig. 32: Exchanging tools

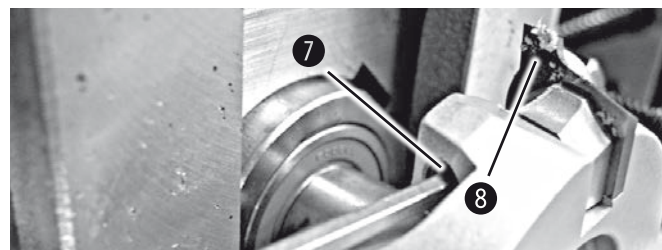
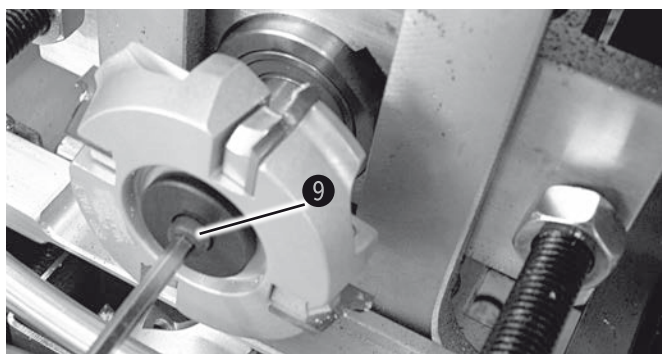


Fig. 33: Exchanging tools

Exchanging turn cutter plates flush trimming:

- Upper flush trimmer:
Loosen the screws, which hold the extraction hood. Pull out extraction hood. The upper shaper is laid open and you can change the whole shaper and also turn cutter plates comfortably.
- Below flush shaper:
The height of the below flush shaper must be misplaced as far as possible. Then you can easily exchange the turn cutter plates. If you want to exchange the whole shaper it is necessary to remove the under extraction hood. (you can reach it by opening security door) Misplace the below sliding shoe by loosen the the screws. Only take away the rear nuts.
- Exchanging Cutterplates:
Loosening the screws allows the cutter plates to be turned around or exchange.
- Exchanging Shaper:
Demount the shaper by rotating the blockage screw clockwise.

- ① Nut
- ② extraction hood
- ③ Plate door
- ④ Sliding shoe
- ⑤ Screws
- ⑥ Rear nuts
- ⑦ Screw
- ⑧ Cutter plates
- ⑨ Blockage screw

Maintenance

10.3.4 Adjustable rollers on the table

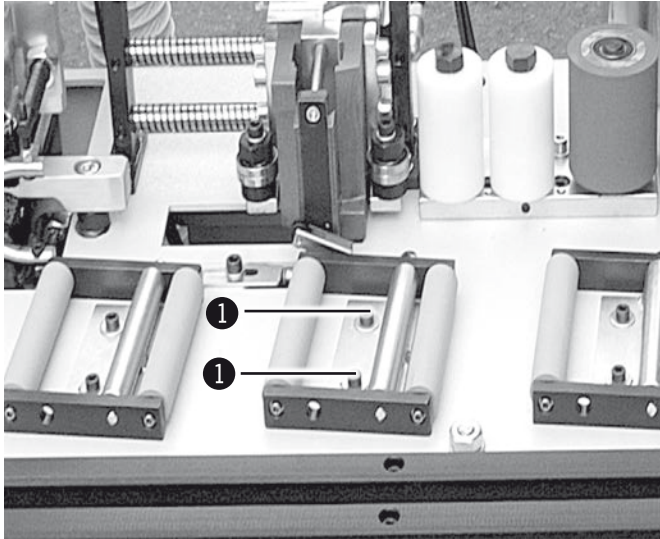


Fig. 34: Exchanging tools

This model is equipped with small adjustable rollers on the table, besides making more efficient the panel feeding it also assure side pressure.

To adjust the side pressure slacken the screws, move the roller with the right tilt. Tighten the screws.

Repeat the operation to the rollers. The rubber rollers are rectified with a very high precision and the bushings assuring a regular feeding and straight line of the panel.

① Screws

10.3.5 Adjusting the belt tension

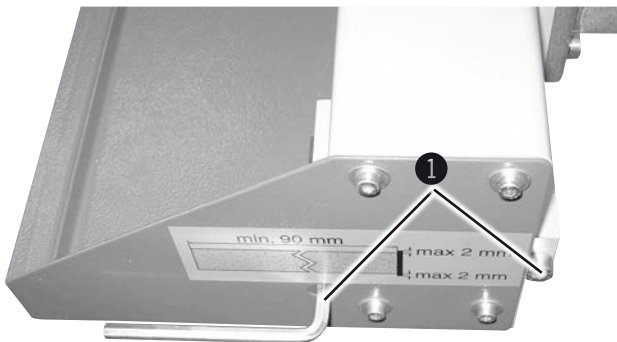


Fig. 35: Belt tension

The belt tension is tensioned factory made. In case further adjustment is necessary, (e.g.: when changing the belt) turn screws and do the same adjustment on both sides. Carry out tension adjustment with belt feeder in operation.

If the belt tension is not correct, this can create a panel feeding problem but also damage the rubber motorized roller.

Ensure that the belt tension is still correct after the first 20-25 operating hours.

① Screws

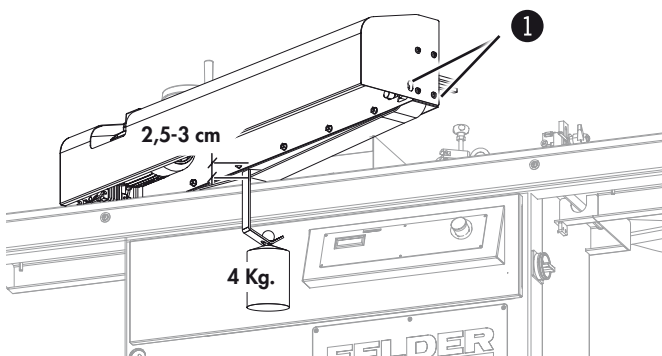


Fig. 36: Belt tension

Maintenance

10.3.6 Replacing fuses/ Re-setting automatic switches

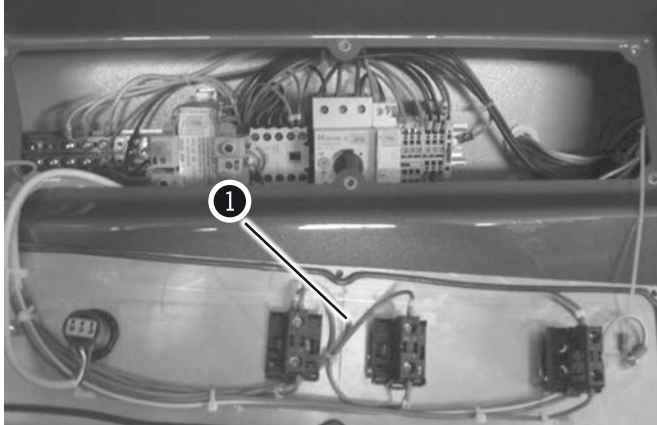


Fig. 37: Changing the fuses

Access the electrical box in the control system panel to replace the fuses. Proceed as follows:

- Switch off the main power supply.
- Position the main switch on 0/OFF and padlock it.
- Disconnect the compressed air power supply tube.
- Unscrew the screws which lock the electrical panel.
- Open the box.
- Replace the burnt fuses and repeat the procedure in reverse order.

① Control panel

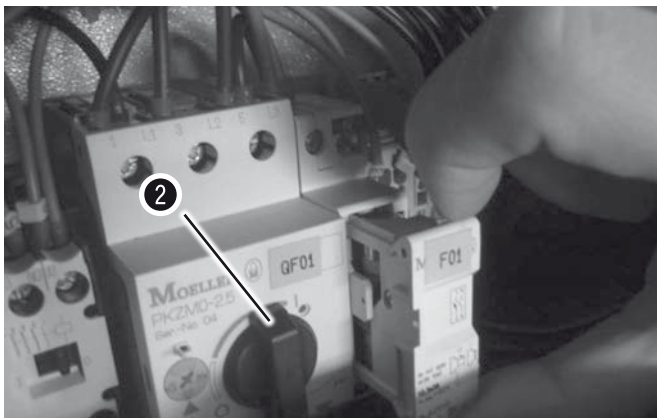


Fig. 38: Changing the fuses

Reset of overload cutout switches:

- Switch off the main power supply.
- Position the main switch on 0/OFF and padlock it
- reset to ON the overload cutout switches

If it is still necessary to re-set the switches it is important to verify that:

- the value set is correct,
- the movement connected to the motors are free to move,
- the motors temperature is not too high (80-90° C) and
- the motors are free of brake circuit.

It is important that these controls will be done by a electrical technician.

The access to the electrical box is not foreseen for other operations, but only for special maintenance to be carried out by a qualified electrician or authorized technical personnel of manufacturer.

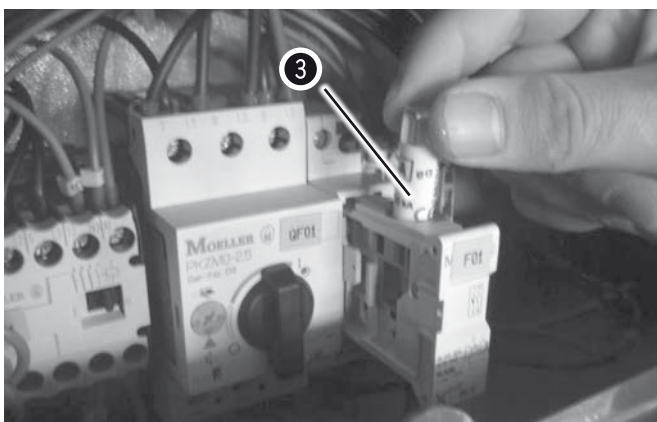


Fig. 39: Changing the fuses

② Switch

③ Fuse

Maintenance

10.3.7 Replacing the burnt glue

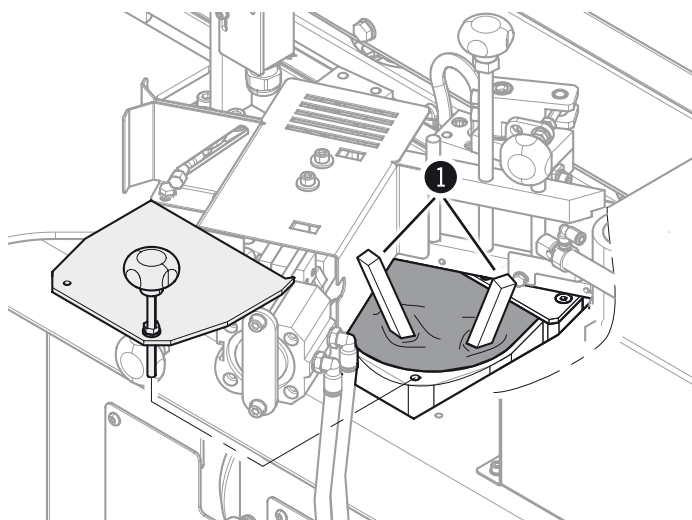


Warning! Risk of burns and serious injuries!

During filling and re-filling, periodic maintenance and whilst cleaning the glue pot, be aware that the glue has an operational temperature of 200°C.

Use all suitable methods of protection to prevent severe injury.

The used glue must be disposed of according to the regulations of the country where the machine is installed.



1. Heat the glue to the operating temperature. Insert two wooden batons into the liquid glue.
2. Then, leave the glue to cool down completely and warm up again. As soon as the glue detaches itself from the walls of the glue pot, remove the glue from the glue pot with the wooden batons.
3. Remove burnt glue residues with a wooden spatula. Clean the cooled down glue pot with rags and a glue remover.

① Wooden batons

Fig. 40: Replacing the burnt glue



Attention! Risk of material damage!

Do not use pointed or abrasive objects or auxiliaries to clean the glue pot.

Maintenance

10.3.8 Safety instructions about the hot melt adhesives



Environmentally
unfriendly



Harmful



Do not smoke

Excerpt from the safety data sheets

Please read the complete data sheet of each hot melt adhesive!

Application purpose:

EVA - Glues (ethylene vinyl acetate) - Basic adhesive

Danger indications:

R50/R53 = very poisonous to water organisms
may be harmful to waters in the long-term

Individual precautionary measures:

Ensure that the area is well ventilated.

Toxic vapours may be released if heated above the break-down point (carbon monoxide, hydrocarbons, acetic acid).

Personal protective equipment:

Observe the conventional precautionary measures when handling chemicals.

Avoid skin contact with the glue. Do not breathe in fumes.

Respirator: a respirator is necessary if ventilation/dust extraction is insufficient.

Gloves: thermally insulating gloves made of leather or thick material.

Eye protection: goggles are recommended when transferring the glue.

Personal protection: standard protective work clothing.

First aid measures:

If your skin has come into contact with the glue, apply cold water to cool down.

Do not peel off hardened glue from your skin. Consult a doctor.

Rinse your eyes with clean running water for several minutes if some of the product has gone into your eyes.

Contact a doctor.

Consult a doctor if you suffer continued complaints after swallowing some of the product.

Measures to fight fire:

Appropriate extinguisher: CO₂, foam (alcohol ?), fire extinguishing powder or water spray.

Notes on disposal:

Leave to harden, remove mechanically. Small amounts may be disposed of in domestic waste.

Dispose of according to local authority regulations. The product's valid waste code can be found in the European Waste Catalogue.

Faults

11 Faults

11.1 Safety instructions



Warning! Risk of injury: Repairing faults incorrectly can result in personal injury or damage the machine. For this reason this work may only be carried out by authorised, trained personnel who are familiar with the operation of the machine and in strict observance of all safety instructions.



Warning! Danger – electric current: Work on electrical fittings may only be carried out by qualified personnel and in strict observance of the safety instructions.

11.2 What to do if a fault develops

Strictly speaking:

- In the event of a breakdown which creates danger for either personnel or equipment the machine should be stopped immediately, by activating the emergency stop.
- Also disconnect machine from the mains and secure it from being switched on again.
- Inform those responsible for machine faults immediately.
- Type and extent of fault should be determined by an authorised professional, as well as the cause and repair.

11.3 What to do after rectifying the fault



Warning! Risk of injury!

Before switching the machine back on:

- the fault and its cause are professionally repaired,
- all safety equipment has been replaced and is working correctly,
- people are not located in the danger area of the machine.

12 Wiring diagram



Attention! The electrical diagrams supplied are only for the use of qualified electricians or authorized technical personnel of manufacturer. These diagrams do not authorize you in any way to change the electrical parts or logic functioning.

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