

OPERATION SPECIFICATIONS FOR THE HOMAG EDGEBANDER

MACHINE CAPABILITIES

- ◆ Thickness ranges for a work piece are 9.5mm (.375") – 60mm (2.375").
- ◆ Width ranges of a work piece are as follows:
2.156" minimum for panels up to .866" thick – 3.937" minimum for panels over .866" - 2.375" thk
- ◆ Length ranges of a work piece are as follows:
6" and above is optimum – less 6" to 3" minimum requires caution and extra care
- ◆ Edge thickness ranges are as follows:
.4mm (.016) – 20mm (.787) coil cut-off max is 3mm
- ◆ Edge materials may vary from PVC coils to HPL strips and solid wood edges.
- ◆ The feed rate is infinitely adjustable 12m/min – 24m/min.
- ◆ Equipped with 9 workstations that can be engaged or disengaged and are as follows:
 - 1) Joint Trimmer – Used for preparing edge for edgebanding or removing old edgebanding
 - 2) Edge Preheater – Preheats the edge of part prior to applying glue to allow a finer glue line
 - 3) Gluing Unit – Applies glue (black or natural) and edgebanding is applied here
 - 4) End Trimming – Trims front and back edges, units operate independently, allows for flush trimming or chamfer trimming in its own single cycle
 - 5) Rough Trimming – Trims top and bottom edges in preparation for fine trim
 - 6) Fine Trim – Final trimming for top and bottom edges
 - 7) 3mm Profile Trimming – Profile trims the ends of 3mm edges with blended corners
 - 8) 3mm Scrapping – Scraps top and bottom 3mm edges to remove chatter
 - 9) Buffing – Buffs top and bottom edges or allows for sanding top and bottom edges

STANDARDS

- ◆ General thickness allowances are as follows:
PVC = .5mm (.020") 3mm = 3mm (.118") HPL general purpose = 1.3mm (.050")
HPL vertical grade = .8mm (.030")
- ◆ HPL edgebanding strips must 1st be sized with a mixture consisting of 50/50 white glue and water.
- ◆ .090" is the maximum trim allowance for each top and bottom edge or .180" overall.
- ◆ .75" is the general allowance for each end trim or 1.500" overall per edge.
- ◆ .50" will work for each end trim or 1" overall per edge for coiled edgebanding material.
- ◆ General feed rates for the following edgebanding materials are as follows:
 - ✓ PVC or similar thin materials use 22 – 25 m/min (72 – 82 ft/min)
 - ✓ HPL materials use 18 – 22 m/min (59-72 ft/min)
 - ✓ 3mm PVC use 16 – 18 m/min (52-59 ft/min)
- ◆ The hotmelt glue that used is an ethylene vinylacetate (EVA) type and must be applied at the temperature range 190-210 C (374-410 F). Typical settings are 195 C run temperature and 157 C idle temperature.
- ◆ Fine edge trimming is set at 7° and a 3mm (.118") profile radius on 3mm EB.

OPERATION

- ◆ Parts are fed with approximate 45" space between parts.
- ◆ The most experienced operator must work on the receiving end to monitor quality & machine settings.
- ◆ Monitor the glue reservoir to avoid constant pumping when it runs out.
- ◆ Monitor edgebanding material to avoid running out and stopping the machine.
- ◆ Always use preset programs when possible.

WO #	Reason	Target	Completed	Closed	Procedure	Actual Hours
19220	6000 M	8/15/2022	7/13/2022	7/15/2022	6000 M	0
18657	6000 M	6/20/2022	5/20/2022	5/20/2022	6000 M	1
18251	6000 M	5/19/2022	6/17/2022	6/17/2022	6000 M	1
17995	6000 Quarterly	4/26/2022	4/19/2022	4/19/2022	6000 Quarterly	1
17900	6000 M	4/21/2022	3/15/2022	3/15/2022	6000 M	1
17542	replace guides and bearings on rear snipper uni...	3/22/2022	3/21/2022	3/21/2022	6000 M	5
17346	6000 M	2/28/2022	1/26/2022	1/26/2022	6000 M	1
16937	6000 Quarterly	1/27/2022	1/13/2022	1/13/2022	6000 Quarterly	1
16799	6000 M	1/10/2022	1/28/2022	1/28/2022	6000 M	1
16733	6000 M	1/10/2022	12/10/2021	12/15/2021	6000 M	1
16150	6000 M	12/9/2021	11/2/2021	11/3/2021	6000 M	1
15873	Replace lower snipper motor bought rebuilt from...	11/9/2021	10/27/2021	10/28/2021	6000 M	1
15799	6000 M	11/8/2021	9/13/2021	9/13/2021	6000 M	1
15632	6000 Quarterly	10/25/2021	10/7/2021	10/11/2021	6000 Quarterly	1
15125	Replace Inverter For Homag edgebander Stiles ...	9/15/2021	8/23/2021	7/14/2021	6000 M	1
14898	6000 M	8/23/2021	7/13/2021	7/13/2021	6000 M	0.1
14373	Replace inverter marked #172 Had Andy in to tro...	7/13/2021	7/13/2021	7/13/2021	6000 M	0
14372	INSTALL NEW TRACKING PADS AND NEW PRESSURE BELT	7/13/2021	7/23/2021	7/30/2021	6000 Quarterly	1
14317	6000 Quarterly	7/7/2021	7/23/2021	7/30/2021	6000 M	1
14251	6000 M	7/5/2021	6/4/2021	6/4/2021	6000 M	1
13007	6000 M	5/14/2021	4/14/2021	4/15/2021	6000 M	1
12711	6000 M	4/19/2021	4/7/2021	4/7/2021	6000 Quarterly	1
12618	6000 Quarterly	4/7/2021	4/7/2021	4/7/2021	6000 M	1
12390	Replace Counter Pressure Roller On Edgebander	4/5/2021	3/17/2021	3/18/2021	6000 M	1
12165	6000 M	3/11/2021	1/28/2021	1/29/2021	6000 M	1
11815	6000 M	1/28/2021	1/27/2021	1/28/2021	SR-Priority 2	1
11695	Old edgebander has light out Bulb was replaced...	1/21/2021	1/7/2021	1/12/2021	6000 Quarterly	1
11588	6000 Quarterly	1/6/2021	12/28/2020	12/28/2020	6000 M	1
11481	6000 M	1/1/2021				1

Cooper Enterprises, Inc



Purchase Order 1033

Printed 8/22/2022 - 6:03 AM (Duplicate Copy)

To:

Stiles Machinery, Inc.
3965 44th Street SE
Grand Rapids, MI 49512
Attn: Trevor Dejong

Ship To:

Cooper Enterprises
89 Curtis Drive
Shelby, Ohio 44875
Attn: Jim Hoak

Purchasing Agent: zzUser, CooperEnt
Date of Issue: 7/6/2021 11:39:35 AM
Date Requested: 7/6/2021 11:39:28 AM

Payment Terms:
Ship Via:
Freight Terms:
F.O.B.

#	Item Barcode	Order Qty	Issue Qty	Description	Vendor Item #	Unit Price	Discount %	Line Total
1		1 Each	1	INVERTER KEB (EDGE-INVERTER)	4-008-39-0551 R	\$ 2,881.00	0%	\$ 2,881.00
		Total						

Subtotal: \$ 2,881.00
Tax: \$ 0.00

Total: \$ 2,881.00

Approvals

Date
7/6/2021 11:39:28 AM

Description

Initials
CU

Cooper Enterprises, Inc



Purchase Order 1032
Printed 8/22/2022 - 6:02 AM (Duplicate Copy)

To:

Stiles Machinery, Inc.
3965 44th Street SE
Grand Rapids, MI 49512
Attn: Trevor Dejong

Ship To:

Cooper Enterprises
89 Curtis Drive
Shelby, Ohio 44875
Attn: Jim Hoak

Purchasing Agent: zzUser, CooperEnt
Date of Issue: 7/6/2021 11:11:37 AM
Date Requested: 7/6/2021 11:11:30 AM

Payment Terms:
Ship Via:
Freight Terms:
F.O.B:

#	Item Barcode	Order Qty	Issue Qty	Description	Vendor Item #	Unit Price	Discount %	Line Total
1		1 Each	1	PRESSURE BELT (EDGE-BELT)	4-007-03-0261	\$ 4,339.00	0%	\$ 4,339.00
2		272 Each	272	TRACKING PAD (EDGE-PAD)	4-060-18-0059	\$ 16.75	0%	\$ 4,556.00
		Total						

Subtotal: \$ 8,895.00
Tax: \$ 0.00

Total: \$ 8,895.00

Approvals

Date
7/6/2021 11:11:30 AM

Description

Initials
CU

PURCHASE ORDER NO.

EF-081419

TO: Stiles Machinery Inc. 3965 44th Street SE Grand Rapids, MI 49512			SHIP TO: Cooper Enterprises, Inc. P.O. Box 50, 89 Curtis Dr. Shelby, OH 44875 Attn: Edward Friebel	
Rebuild 800-424-3232			PHONE: 419-347-5232 Ext: 220	
Date Ordered 08-14-19	Date Required 08-15-19	Ship VIA FedEx	Terms: Net 30 Days	<input type="checkbox"/> Taxable <input checked="" type="checkbox"/> Exempt
Quantity	DESCRIPTION		Unit Cost	Total Cost
1	Item No. 16-206-21150R, Left Hand High Volume, mfg. 2-006-21-0541 Rebuilt Glue Pot		\$ 4,925.00	\$ 4,925.00
	Shipping			\$86.75
	Old Glue Pot Returned for Exchange		\$ - 700.00	\$ - 700.00
	Total			4,225.00
	Re: Equipment No. 6000 Homag EB Model No. SE-9800/S2 Serial No. 0-200-08-4198, O KL 78/A20			
	Received 08/15/19 Jim Hoak <i>Closed 08/19/19 J.H.</i>			

PLEASE ACKNOWLEDGE RECEIPT OF THIS ORDER. IF DELIVERY CANNOT BE MADE BY DATE SPECIFIED, NOTIFY US AT ONCE.

Edward Friebel

SIGNED