

LAGUNATOOLS.

MEB6100-0050

MEB5201-0050

Semi-Automatic

Edge Banding Machine

USER'S MANUAL

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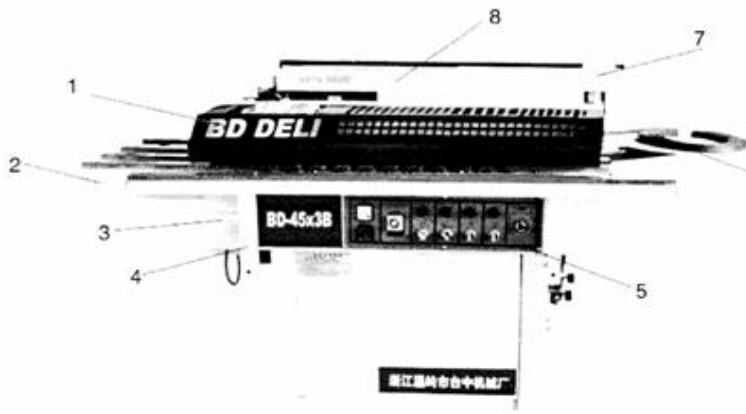
1. Capability of product

The price of this machine is very near manual edge banding machine, but the quality of cementation and production efficiency are superior to manual edge banding machine. This machine solves many problems like raw materials waste aroused by unbalance of gelatinizing, failure of cementation, workforce waste and length reserves out of control. The machine is the perfect machine because it can ensure quality, save workforce, materials and fund.

Technical Parameters:

The size of operating platform :	2050 X 800mm
Minimum Panel Length :	280mm
Minimum Panel Width :	140mm
Panel Thickness :	12-40mm
Pace of auto-convey belt :	6.4m/min
Trimming tools :	Φ70z 6-R2.5
Delivery outlet for offal :	60mm
Power of arrestment :	1250W
Pace of trimming component eddy :	10000r/min
Power :	1.4kw
Fore and after extension plate/horizontal extension shelf :	400mm
Banding belt uphold set :	550mm

2. Introduction of appearance

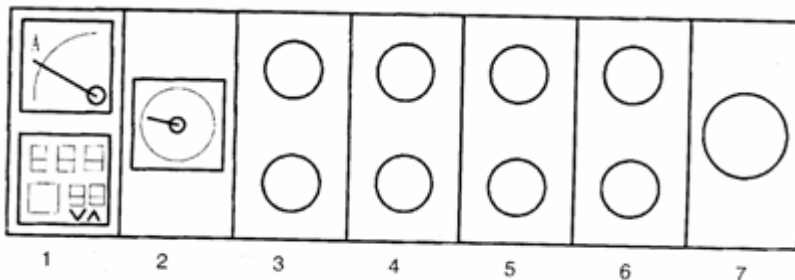


- (1) Panel belt conveyor
- (2) Lgthen
- (3) Band end cutting motor base
- (4) Extension Self
- (5) Control Panel
- (6) Banding belt uphold set
- (7) Elevator
- (8) Deburring cover

(Figure 1)

3. Control Panel:

- a) Ampere meter, temperature controller
- b) Time relay
- c) Power switch
- d) Banding switch
- e) Deburring switch
- f) Band end cutting switch
- g) Urgent stop switch



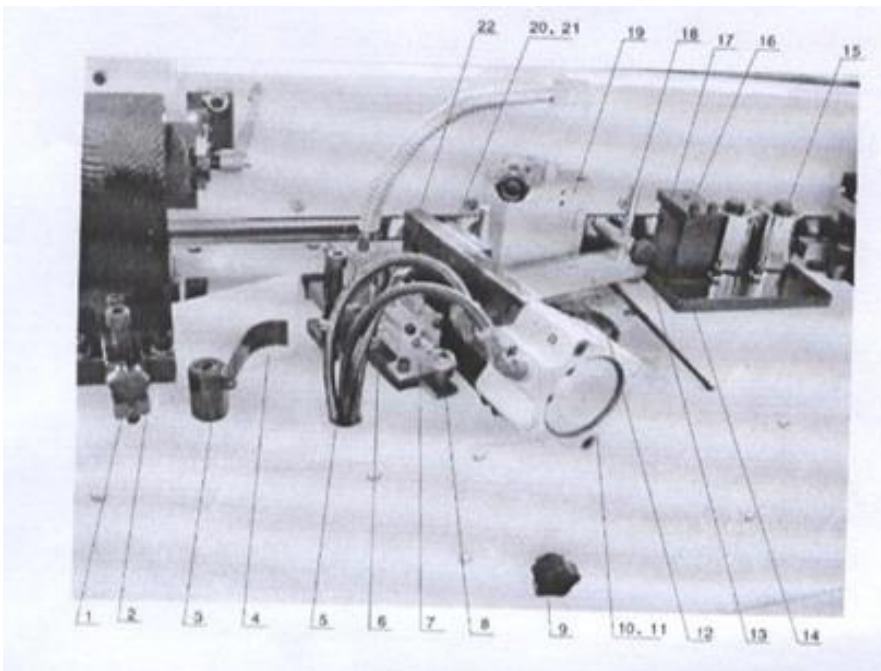
(Figure 2)

Function of control panel:

- (1) Ampere meter: show ampere bulk, know the calefaction part is broken or not.
- (2) Temperature controller: control and adjust glue temperature.
- (3) Time relay: control banding belt length reserves require.
- (4) Power switch: after turn on this switch all the facilities will have electric, the temperature light will on and also can adjust temperature. [3]

- (5) **Banding controller switch:** open this switch after the glue temperature up to useful, and then start to band.
- (6) **Deburring blade start-up switch.**
- (7) **Band end cutting blade start-up switch**
- (8) **Urgent stop switch:** use this switch when happens urgent matter or another matters.

4. Adjustment of edge banding



BD45 x 3B edge banding assembly (1)
(Figure 3)

- | | |
|--|----------------------------------|
| 1. Belt feeding guide strip | 12. Belt width adjustment handle |
| 2. Belt width adjustment handle | 13. Belt width adjustment board |
| 3. Rolling wheel fixing board | 14. Belt location base |
| 4. Pressing wheel I | 15. Belt location board |
| 5. Pressing wheel base | 16. Belt feeding wheel |
| 6. Pressing wheel II | 17. Belt pressing wheel |
| 7. Pressing adjustment for belt feeding (long) | 18. Belt pressing cylinder base |
| 8. Glue spreading assembly | 19. Belt pressing guide board |
| 9. Pressing block | 20. Glue pot adjustment handle |
| 10. Blade | 21. Belt cutting cylinder |
| 11. Knife base (east) | 22. Belt pressing cylinder |

Load the edge banding belt through the belt width adjustment handle and board.

When the glue temperature reaches the set point start edge banding operation by turning on the main switch.

When the panel is placed in position and triggers the stroke switch, the air-driven device works pressing the belt onto the driving roller to carry it on, and the length reserve is controlled by the external time relay. The material is fed, the panel disengages from the stroke switch, and the belt is cut automatically by the blade.

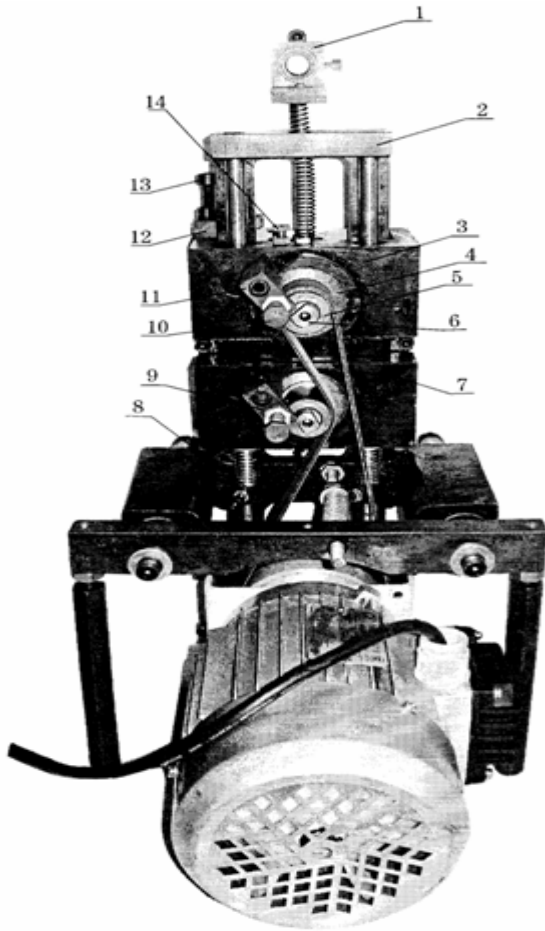
The cutting blade operates when the panel triggers the stroke switch. By default, the length reserve setting (20X2) has been done when machine delivery. Adjust the external time relay to meet individual case. The pneumatic components are designed for 3mm belt. Tune up your cutting device depending on the belt material properties (softness, thickness) to guarantee the smooth movement of the belt. When the adjustment is done, tighten up the cutting blade device.

The belt location components are to secure the belt's accurate movement carried by the feeding components to the unwrought panel. Change the perpendicular gap between the belt and both of the boards to the minimum with smooth movement of the belt.

The glue pot intends to spread the melt glue onto the panel. Please follow the instructions for its proper function:

- a. pour a certain amount of hot-melt glue into the pot;**
- b. set up the temperature needed (the preset value is 160-190°C when machine delivery);**
- c. After the glue is completely melt, start the machine for a normally 5-10 minutes idle running to obtain better adhesive quality.**

5. Adjustment of edge trimming



1. Adjustment block
2. Edge trimming bracket
3. Upper edge trimming block
4. Knife shaft sleeve
5. Pulley belt
6. Knife shaft
7. Lower edge trimming block
8. Spring ring
9. Lower pressing block
10. Non-standard screw
11. Upper pressing block
12. Edge trimming adjustment base
13. Adjustment screw for positioning base
14. Setscrew for shaft sleeve

Figure 4

This part is to work on the belt excess on both sides for beautiful appearance. A variety of styles can be achieved like common angle, bevel angle, and arc etc, by using different blades and belts of different thickness.

There are two knife chucks $\Phi 65$ installed rotating clockwise and counterclockwise respectively, with 6 X R2.5 round blades mounted on each chuck. Choose other chucks for your own needs. Milling knife rotating speed 10000 RPM.

The two rollers function to secure belt's adhesion onto the panel. All the calculation work is previously done to ensure the belt reaches the desired cooling temperature before it is cut off. No need to further adjust the rollers but keep them always clean from glue residue.

6. Adjustment of up and down bracket (see Figure 1)

It is used to adjust to work on panels with different thickness.

7. Adjustment of pulley belt tension force (see Figure 5)

The feeding system is made of high density abrasion-resistant pulley belt. The pulley belt carries the panel forward, and guides it along glue spreading rollers with the aid of the rubber table rollers without any damage of the work piece. Adjust the tension force by using the side screws.

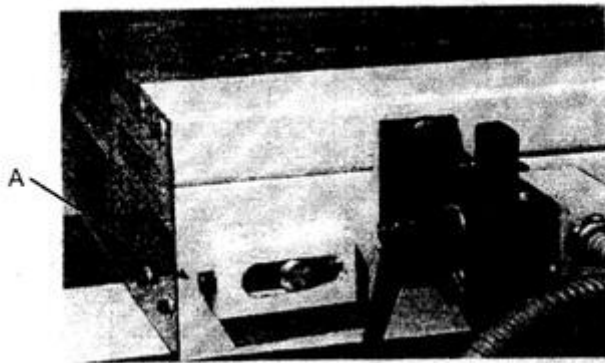


Figure 5

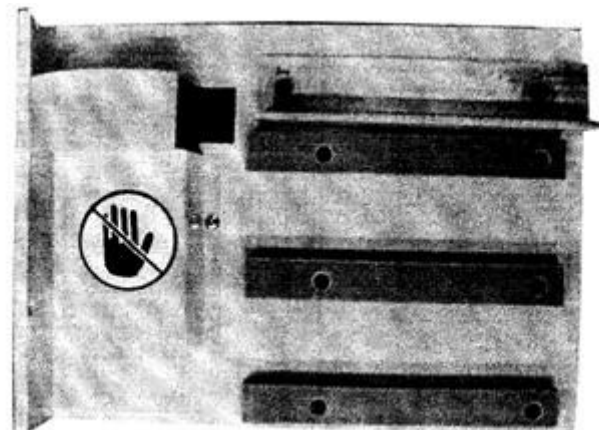
8. End cutting saw

Its role is to cut off the edge banding belt excess at both ends after the panel is wrought.

Follow the working steps below:

1. Push the button (6) to rotate the saw;
2. Insert the excessive belt on one side between the baffle board (see Figure 4) and the saw, press the panel against the baffle board and push leftwards. When the left side of the panel touches the baffle board, the belt excess is cut off.

[7]



Commodity Description: Semi-Automatic Linear Edge-Banding Machine

Item Model: BD-45X3B

Delivery No.: _____

The item complies with technical specifications and norms after inspection and is qualified for shipment.

Delivery No. : _____

Cert. Department of Approval: _____

Cert.No.of Approval: _____

Delivery date: _____

[8]

Guarantee Card
(USER'S COPY)

Commodity Description: Semi-Automatic linear Edge-Banding Machine

Commodity Model : BD-45X3B

Delivery Number :

Delivery Date :

1. Term of Guarantee: It is warranted for one year from the date of purchase.

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2. Repair record sheet (reserved for repairer)

S/N	Repair Date	Repair Description	Quantity	User's Signature	Repairer's Signature	Remark

Commodity Description: Semi-Automatic Linear Edge-Banding Machine

Item Model: BD-45X3B

Delivery No. :

Contents:

S/N	Commodity Description	Specification	Unit	Quantity	Remark
1	Semi-Automatic Edge-banding machine	BD-45X3B	Set	1	
2	User's Manual			1	
3					
4					

[10]

Packaging No.:

Packaging Date: