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PROUDLY MADE

EDGEBANDER

STAR COMPACT 308 DSA

OPERATION MANUAL

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STAR COMPACT
308DSA

The Easy Change Edgebanding Machine STAR COMPACT 308DSA is a small model but heavy-duty machine designed to meet the needs of private factories. Despite its compact size, this machine offers powerful performance and a range of features. With its seven functions and fully automatic operation, the STAR COMPACT 308DSA streamlines the edge banding process and delivers efficient results.

PREFACE

Thank you for purchasing our product.

Please read the following notes carefully after receiving your machine:

1

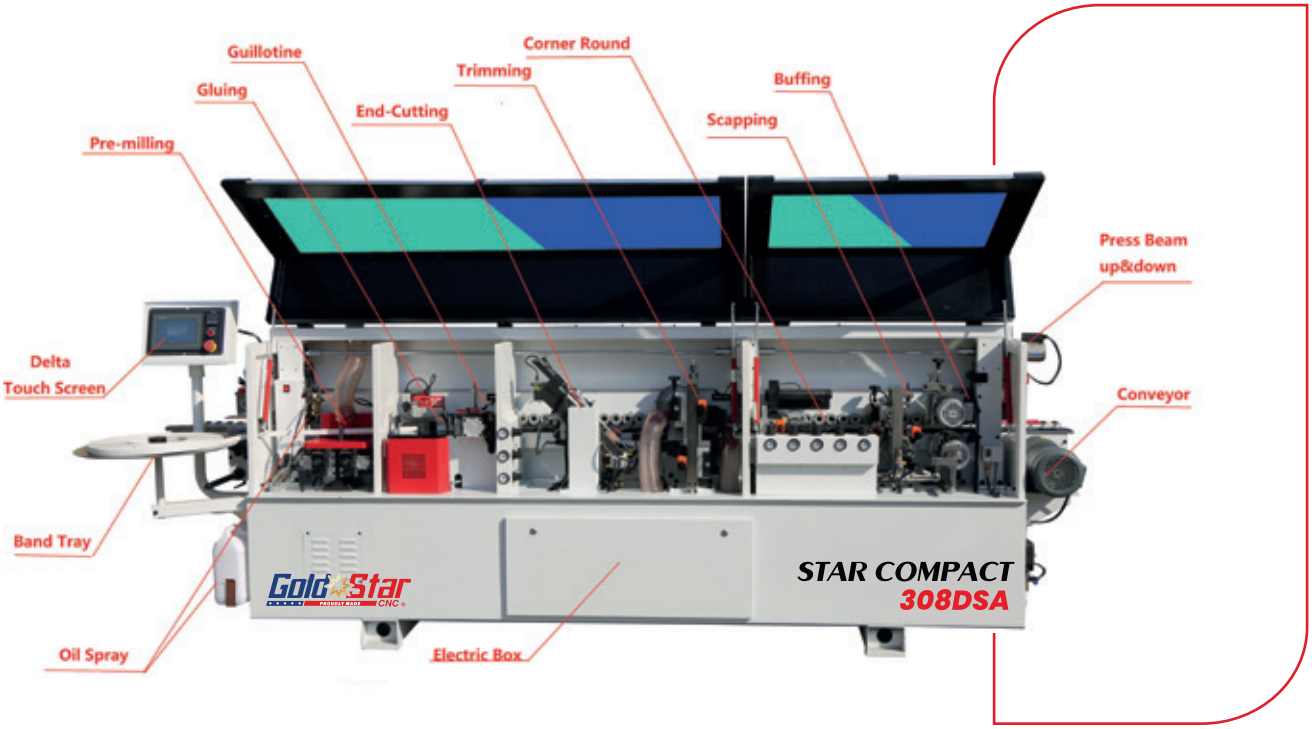
Read the following pre-installation precautions and check whether the installation environment of the machine is suitable to avoid unnecessary trouble for your installation and use.

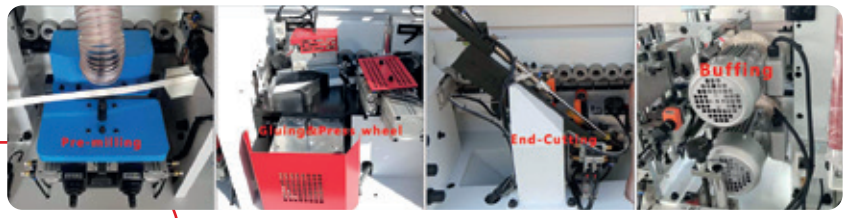
2

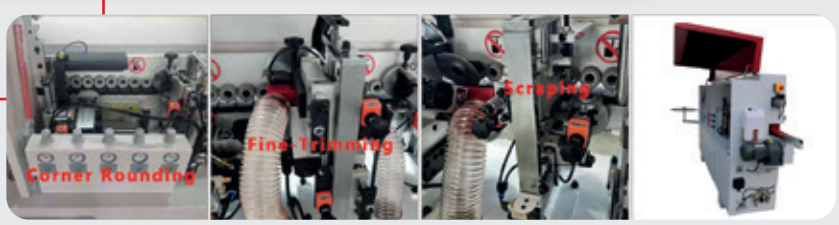
Check the appearance and packaging of the machine to see if there is any damage.

* Some technical parameters involved in this manual are subject to change without further notice.

Machine overview







OPERATION AND MAINTENANCE MANUAL

Our company reserves the right to change the edge banding technology and concept of each component to improve our machines continuously. The pictures and data in this manual help you understand the content.

FUNCTION LIST

308DSA: Pre-Milling → Gluing → End trimming(2 motors) → Edge trimming → Corner Rounding→Scraping→Buffing

308DSP: Pre-Milling→Gluing→End trimming(2 motors) →Edge trimming→Scraping →Buffing

308DSR : Gluing → End trimming(2 motors) → Edge trimming → Corner Rounding → Scraping→Buffing

308DS : Gluing→End trimming(2 motors) →Edge trimming→Scraping→Buffing

General Introduction

The address of the manufacturer and other data is on the nameplate on the machine body. Machine Model: 308DSA

Serial Number:

Voltage/Power:

V/KW:5.86kg

Weight：680KG Manufacturer：

Address：

In the event of any issues with the machine, the owner must contact the detailers or service department for assistance. Please provide the following information:

- Machine Model - Serial Number - Date of Purchase - Run Time

Ensure that you adjust and maintain the machines according to the instructions in this manual.

* If the issue is not addressed in this brochure, it should be handled by professionals authorized by the manufacturer. Any repairs conducted by unauthorized personnel will be at the buyer's risk.

INDEX

1. Basic Information

1.1 General Information

Automatic edge banding machines can glue and band panels with tape with little labor.

End-cutting and edge-trimming capacity can be working at the same time.

This machine can only process panels with a right angle.

Only materials mentioned in the brochure are permitted to be used on this machine.

1.2 Overall Dimension:

Length×Width×Height：12.5 ft × 3.0 ft × 4.8 ft.

1.3 Technical Data

Model Name	308DS	308DSP	308DSA
Min. panel width	3.2 ft	3.2 ft	3.2 ft
Panel thickness	0.3 -1.5 ft	0.3 -1.5 ft	0.3 -1.5 ft
Min. Min. panel length	3.9 ft	3.9 ft	3.9 ft
Feeding speed	32.8, 39.4, 52.5ft/min	32.8, 39.4, 52.5 ft/min	32.8, 39.4, 52.5 ft/min
Rotation speed of edge trimming motor(common/high-speed)	9000/12000 rpm	9000/12000 rpm	9000/12000 rpm
Rotation speed of buffing motor	1400 rpm	1400 rpm	1400 rpm
Power of heating capacity	1.7 HP	1.7 HP	1.7 HP
Power of buffing motor	0.2 HP × 2	0.2 HP × 2	0.2 HP × 2
Power of end-cutting motor	0.5 HP	0.5 HP	0.5 HP
Total power	12.1 HP	15.0 HP	15.6 HP
Net weight	1631 lbs	1874 lbs	1984 lbs
The diameter of the tube for the dust collector	3.9 in	3.9 in	3.9 in

1.4 Safety Caution

Before operating the machine, please seriously read the instruction brochure first. Pay attention to the caution mentioned and always operate the machine carefully.

The operator must be trained to be able to operate this machine.

Many accidents are caused by clothes and personal belongings (bracelets, wristwatches, necklaces, etc.). Please make sure that button up clothes, ribbon long hair behind your head, and never wear

a necktie, wear the right shoes and glasses to protect your eyes.

Please keep clean in working area, and well lit. No barrier is in the working area.

Please operate the machine as technology type and designed purpose. Any illegal behavior may cause potential damage.

Safe facilities must be used forcedly and never permitted to be removed, changed, or damaged.

If safe facilities are changed, the manufacturer is free of responsibility.

In special operating conditions, safe facilities may not be fully installed. Thus, you are responsible for installing all other necessary safe facilities.

Only professional electricians are permitted to change electric accessories. Others are forbidden to open the electric door.

Please make sure that the power is off, before maintaining the machine. Please disconnect the pressed air tube. Make sure that the machine is reopened by qualified operators or authorized personnel.

Please make sure that all cutters are sharp and all parts coordinate well.

1.5 Warning sign

Please pay attention to the protection cover, separation net, high-temperature sign, and electrified sign. All dangerous parts are signed by a warning sign. (See Pic 1-2)

Please wear goggles when working

Dont touch

Be careful with fingers

Be aware of electrical hazards

Stay Away from fire

Pay attention to high -temperature

1.6 Dust Collector

Dust will be produced in edge trimming capacity. Please connect the machine with a highly efficient dust-exhaust system to ensure not less than 20mt/1min.

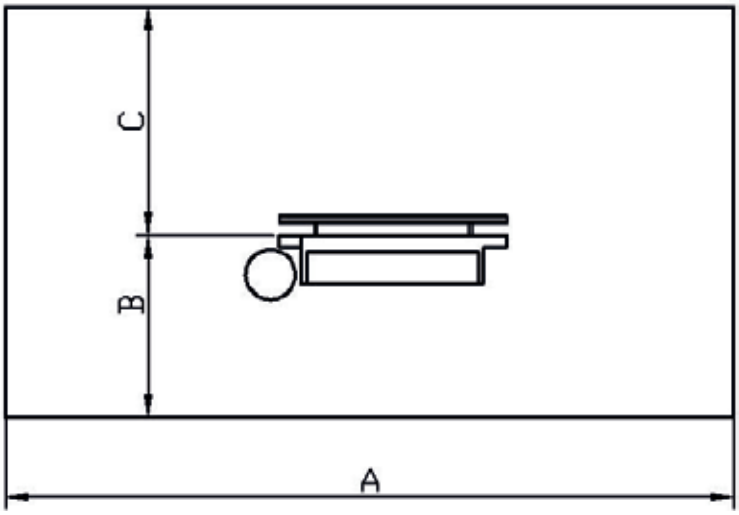
1.7 Position of Operator

The position of the operator is shown in pic. 1-3. In this position, it is easy and efficient to operate. All the areas are shown in pic. 1-3 must be kept empty and clean to maintain and operate

Machines.

A: 3000mm+ Double length of panels B: 2000mm

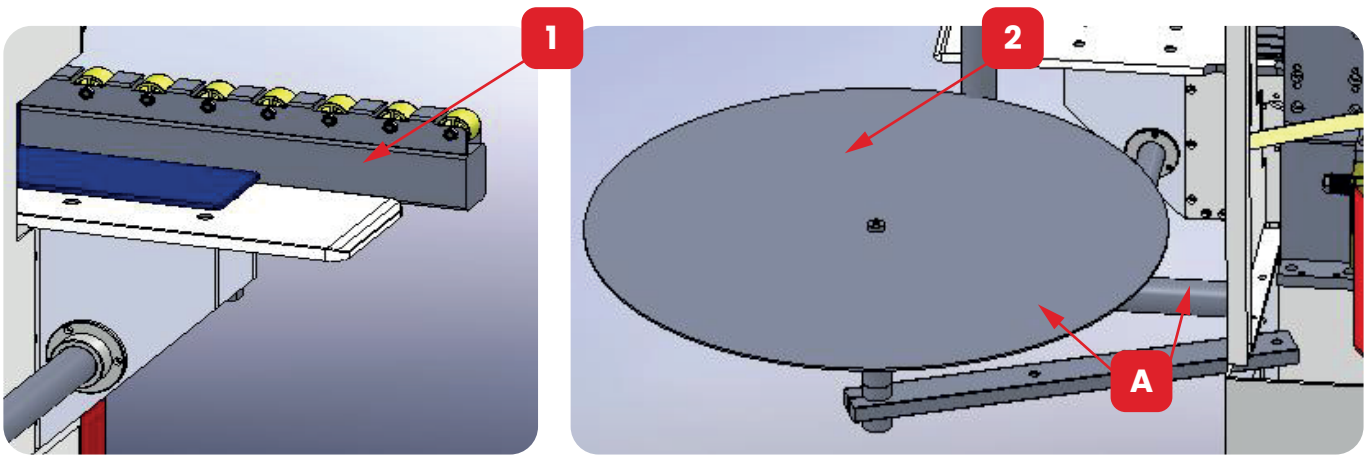
C: 1000mm+ Max. Width of panels



2. Installation

2.1 Position of machine

This machine is packed with a wooden case. To transfer it more easily, some parts of the machine are packed separately. Part 1 and part 2 need to be assembled, see picture 2-1



Picture 2-1 Parts packed separately

Please consider the dimensions of the machine, the way to position it, and how to arrange the workpieces before placing the machine in its final spot. Make sure that there is enough space for the operator. (See pictures 1-3)

The machine base must be located on a hard and flat floor.

2.2 Assemble the separately packed parts

All parts are tested and adjusted before delivery. It is easy to assemble the following parts.

Arms of tape platform: loosen the bolt (part A, picture 2-1), and draw out the arm, tighten the screw on the second arm hole.

Panel fence on end of conveyor: fix the fence by tightening the bolts. See picture 2-1

2.3 Connect wires

All must be connected by a qualified wireman.

Check the actual power voltage and frequency, and make sure that they are the same as the data on the nameplate.

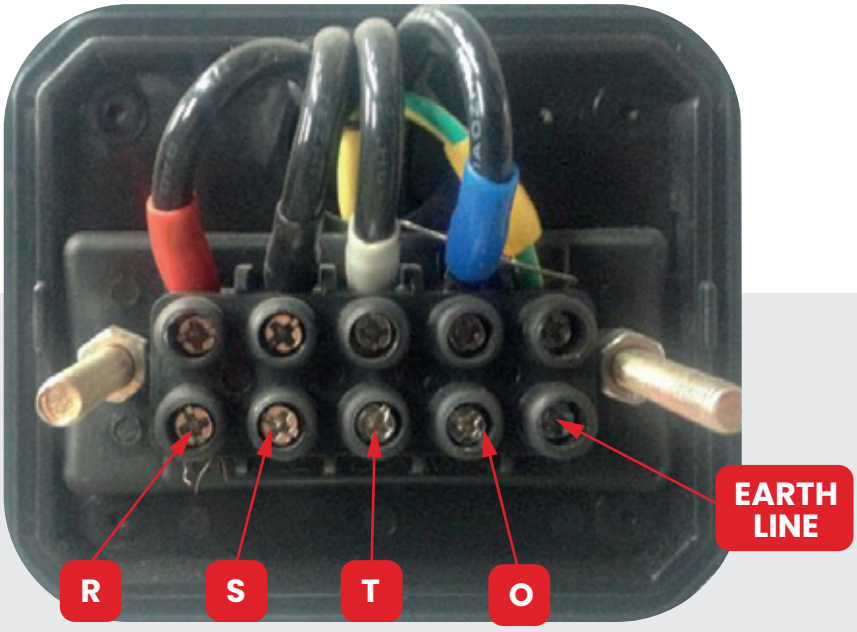
Please use qualified wires of 5*2.5, make sure it can burden the total power. Do not connect the neutral line to the earth.

The main power system must be connected with a neutral line and ground line.

Open the power shell, and connect the wire. Please connect the neutral line with N and the earth line with the last one.

Start the buffing capacity on the control panel. Make sure that the buffing wheels are rotating in the right direction (anticlockwise, look from the front side of the machine).

See picture 2-2.



* Picture 2-2 Line in the main power box

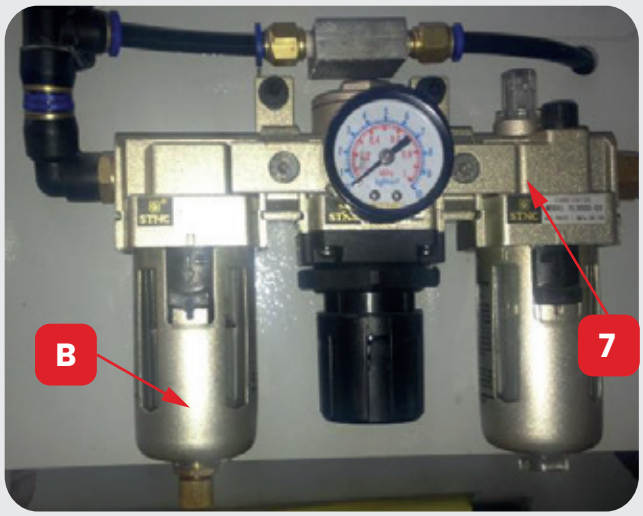
2.4 Connect air tubes

The air filtration and pressure regulator are located on the right hand. See pictures 2-3.

To keep the air dry, air through the machine tubes is filtered and dried. Also, air can be oiled if you fill in oil in the oil cup.The air service unit must be installed to connect with the air inlet tube. The air unit does not need any lubrication.

Air with oil may break some of the air accessories.

The switch will be pushed up by condensation. See part B, picture 2-3.



*Picture 2-3 Air filter/pressure conditioner

2.5 Dust collector

Please connect the dust tube with a highly efficient dust collector system. The tube joint is on the left of the machine. It is available to use a central dust collector.

The dust collector system must be working while edge trimming is on. Please regularly check the dust collector to keep it working well.

2.6 Upload the lock parts

To protect the machine, all the parts are locked before transporting. Please upload all the lock parts before starting the machine.

Warning: Manufacturers burn nothing if the machine is broken, for the reason that buyers do not follow the above items.

2.7 Check items after the machine is installed

Please check the following items before starting the machine for the first time: Unlock all the parts that are locked for transport.

Make sure the power supply is larger than the total power of the machine. Connect all the power lines and joints.

Connect all the dust collector tubes.

Take off all the assist parts, and fasten the accessories.

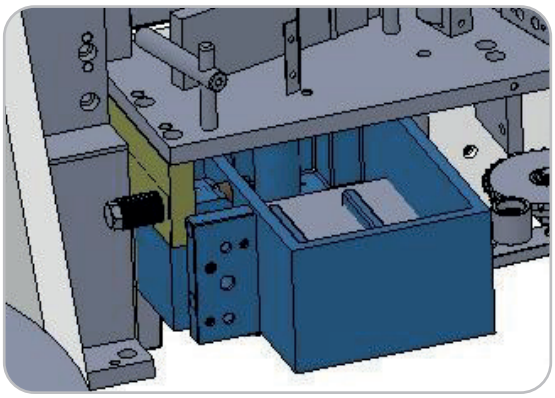
Make sure that all the parts, control panel, and others are installed correctly and work well. Operators need to read and understand the manual brochure. The brochure is suggested to be laid beside the machine, to be easily reached by operators.

Notice: the manual brochure is laid in the toolbox with tools. Please read it first after opening the box.

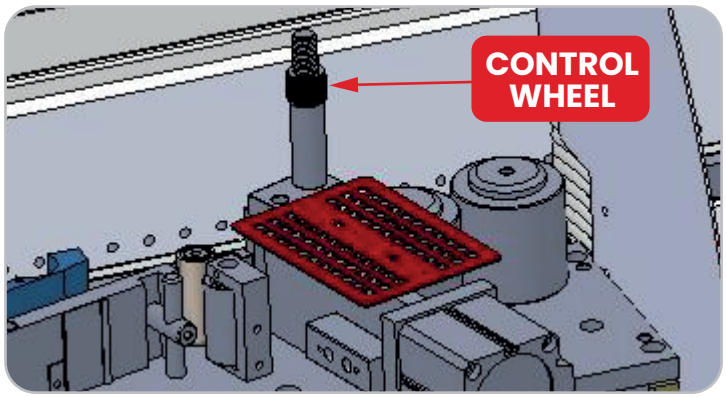
3. Capacities of machine

3.1 Prepare before starting machine

- Fill in glue in the tank (picture 3-1C).
- Lock all the adjustable handles.
- Adjust the hand wheel to fit the thickness of workpieces;(picture 3-1A).
- Set the temperature controller (see the manual of temperature controller).



Picture 3-4 Glue tank



Picture 3-5 Limited wheel for tape height

3.2 Control Panel

Push the emergency button once dangerous happens.

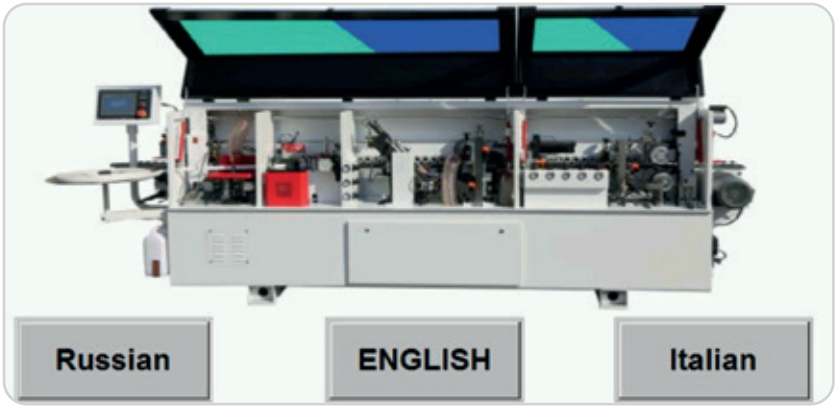
Notice: Technical data may be different for different models of machines.

Steps to start the machine:

Connect the general power wires and air tubes. Turn on the general power switch, by rotating it to ON (in red). Then turn on the touch screen button. (see picture 3-2).

Step to shut down the machine:

Turn down all the capacity buttons, turn down the heating switch, and at last turn off general power.



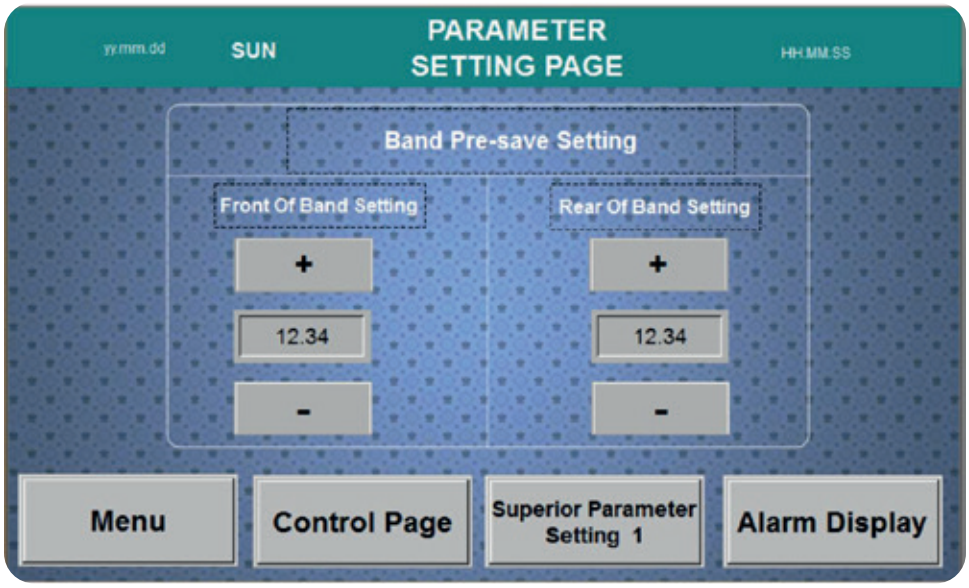
Picture 3-6 Boot screen

Touch the button “Automatic Control”, and enter the auto-control interface. See pictures

Picture 3-7 Auto-control interface.

Picture 3-11 input target temperature

Press the “Tape Surplus” button (button 10), and enter the following Tape Surplus Setting



Picture 3-12 Tape surplus setting

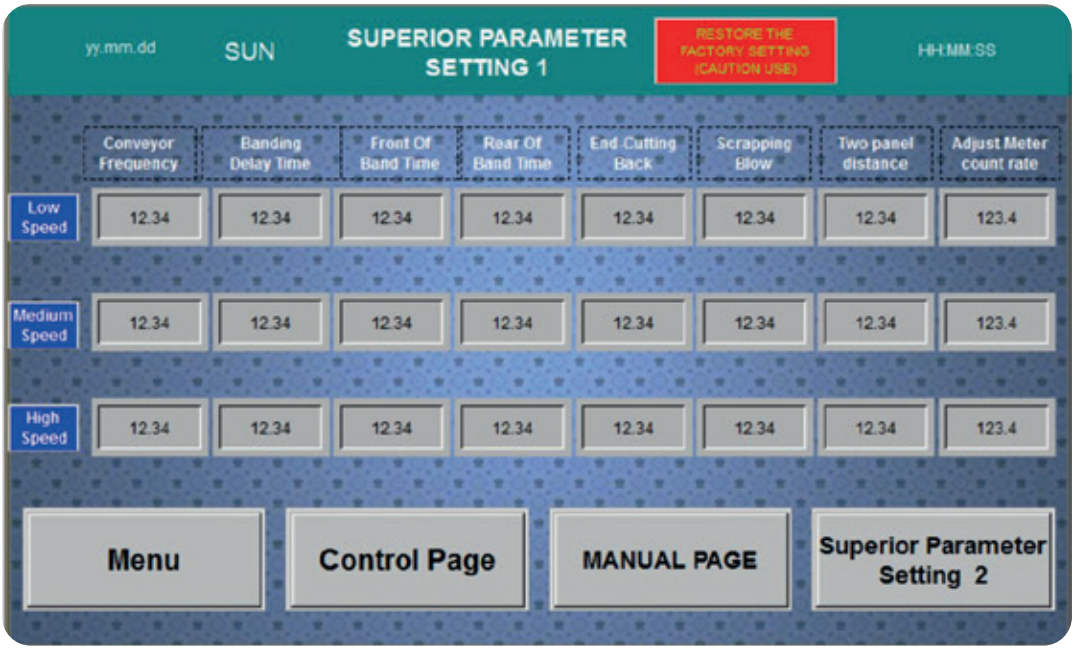
You can change the two parameters to adjust the surplus in front of and behind panel ends.

Length in front of panel: adjusting the tape surplus in front of the panel, the surplus length is proportional to the value in the box.

Length behind panel: adjusting the tape surplus in the back of the panel, the surplus length is proportional to the value in the box

Factory setting is: Length in front of panel = 2.5S, Length behind panel is 1.0S. Usually, it is not necessary to change the values.

Press the “set parameter” button, it will show the "set parameter” interface.



Picture 3-13 Advance parameter setting

1-Restore to factory setting: If machine power is off for a very long time. Please reset all settings to factory settings to avoid mistakes.

2-Conveyor frequency: it means the different speed frequencies, match Low, Middle, and High speed.

3-Banding Delay Time: it's the time for conveyor edge banding before Guillotine.

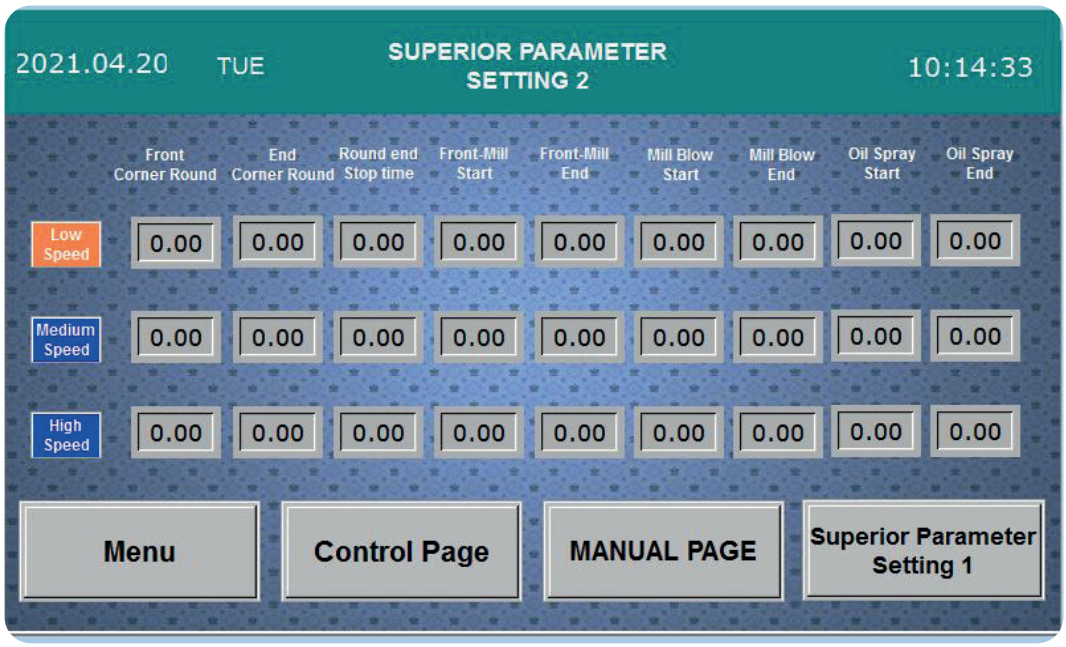
4-Front of Band time: for adjusting front band length.

5-Rear of Band Time; for adjusting Rear Band length.

6-End-Cutting Back: for control after End trim finish work, how long does it take back

7-Two Panel distance: for adjusting the two-panel distance, adjust, the input air cylinder protects time will change.

8-Adjust Meter Count Rate: it counts how many lengths of the board working, and the edge banding length.



9-Front Corner Round: To adjust the Front Corner Round time, how long does it work after the board touches the Rounder Routh Switch (to arrange start Rotate).

10-End Corner Round: To adjust the End Corner Round time, how long does it work after the Rounder Routh Switch back to Normal Position (for arrange start Rotate End Corner).

11-Round End Stop Time: Rear Round work time.

12-Front Mill Start: the board touches the switch then how long time the pre-milling starts work (the first Milling motor).

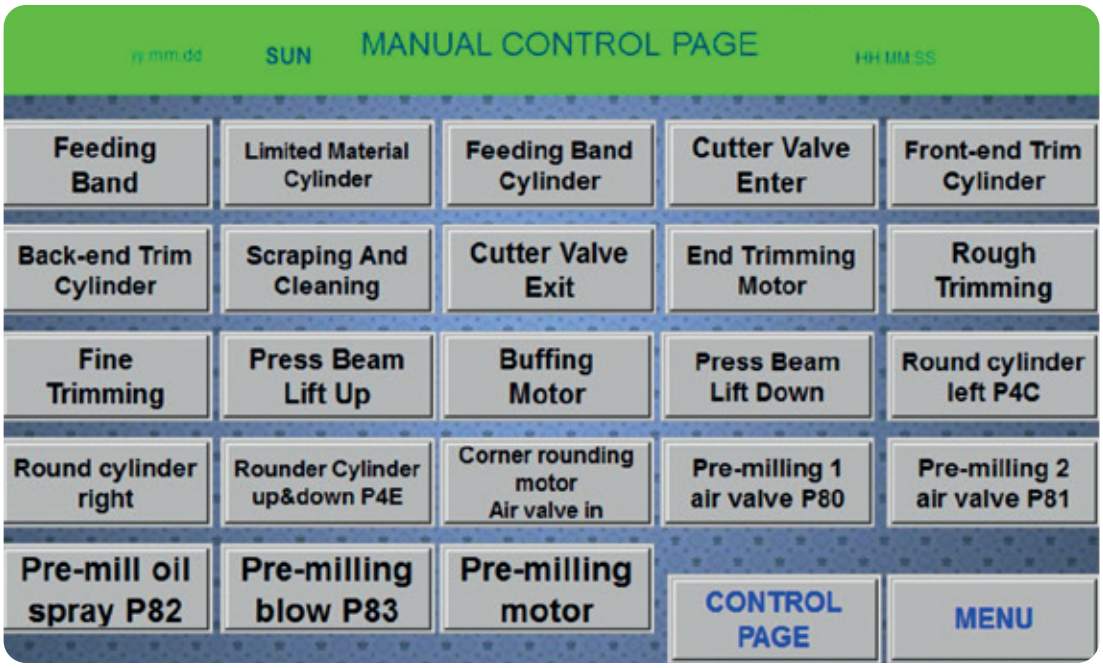
13-Front Mill End: If the board is far away from the switch, then how long time the pre-milling end work (the first Milling motor).

14-Mill Blow Start: when the board touches the switch, the milling blow starts to work

15-Mill Blow End: when the Board leaves the switch, the milling blow ends to work .

16- Oil Spray, it is for an optional function, to clean the glue, (Start & End).

Manual Control Page



17-Feeding Band: for test conveyor motor.

18-Limited Material cylinder: infeed protects the cylinder.

19-Feeding Band cylinder: for test edge banding cylinder work .

20-Cutter valve enter: for test Guillotine cylinder.

21-Front-End Trim cylinder; for test Front-End Trim cylinder .22- Back-End Trim cylinder; for test Back-End Trim cylinder.

22-Scrapping and Cleaning: for test Scrap blow electric valve 24- Cutter Valve exit: for test Guillotine cylinder back.

25-End Trimming Motor: for test End-Trimming motor.

26-Rough Trimming：For starting Rough Trimming (but your machine without Rough Trimming).

27-Fine Trimming: for start trimming motor.

28-Press Beam Lift up: Press Beam up 29- Buffing Motor；Buffing Motor.

30-Press Beam Lift Down: Press Beam Down 31- Round Cylinder left P4C: Round cylinder left.

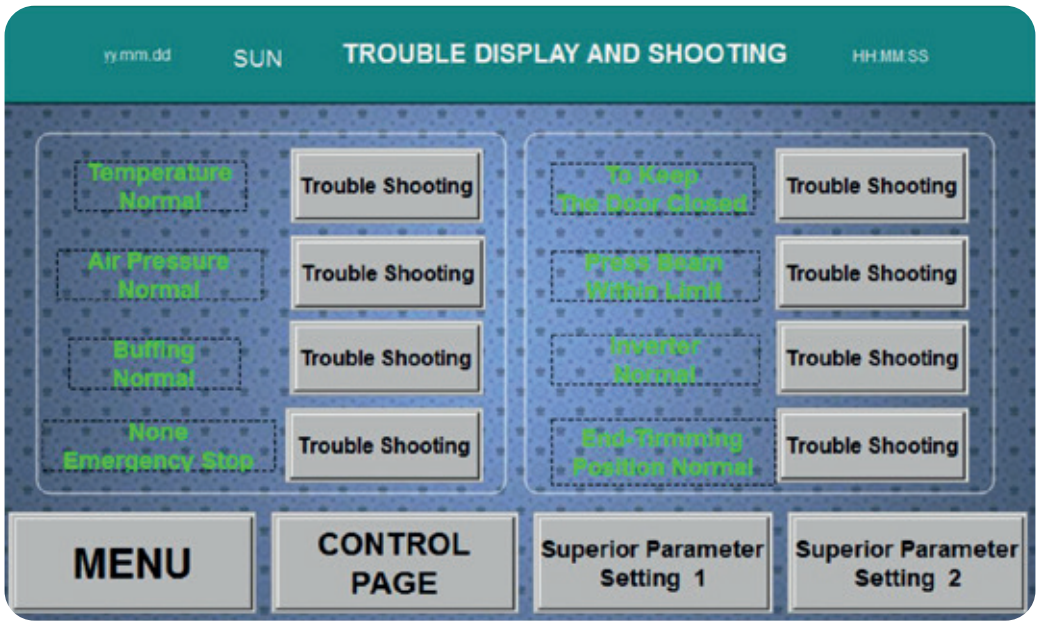
32-Round Cylinder Right: the cylinder for control Round cylinder right 33- Corner Rounding motor air valve in motor prepare to work.

34-Pre-Milling 1 air valve P80: pre-milling motor 1 work 35- Pre-Milling 2 air valve P81: Pre-milling motor 2 work 36- Pre-mill Oil Spray P82: For start oil Spray P82 the switch.

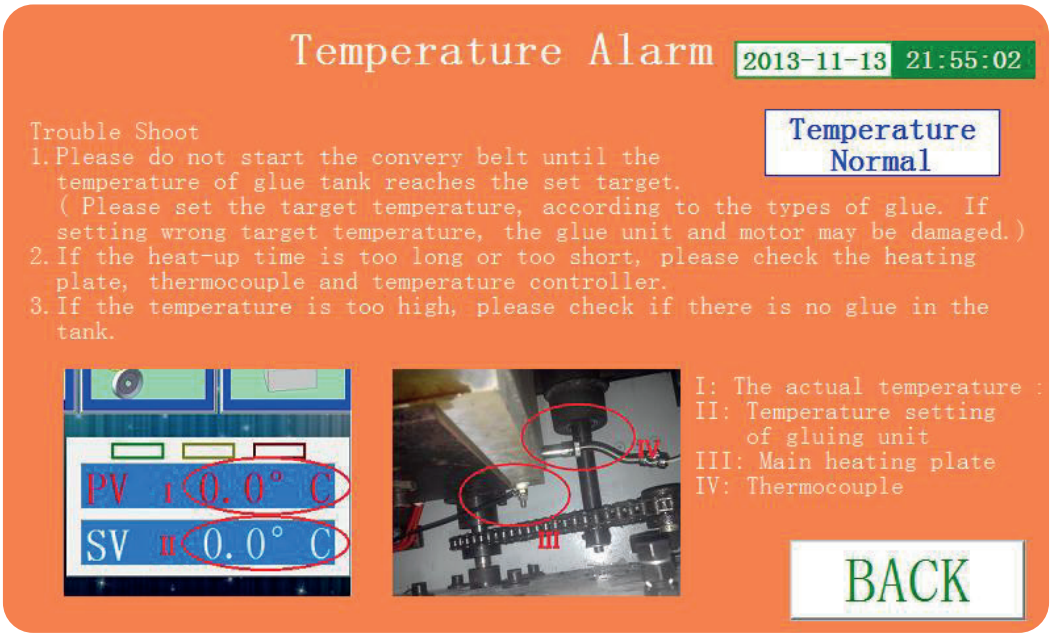
37-Pre-milling Blow P83: for Control the milling blow.

38-Pre-milling Motor: For start Pre-milling Motor.

Press the “Alarm instruction” button, and you can enter the “alarm light instruction” interface:



Picture 3-14 Alarm light instruction interface

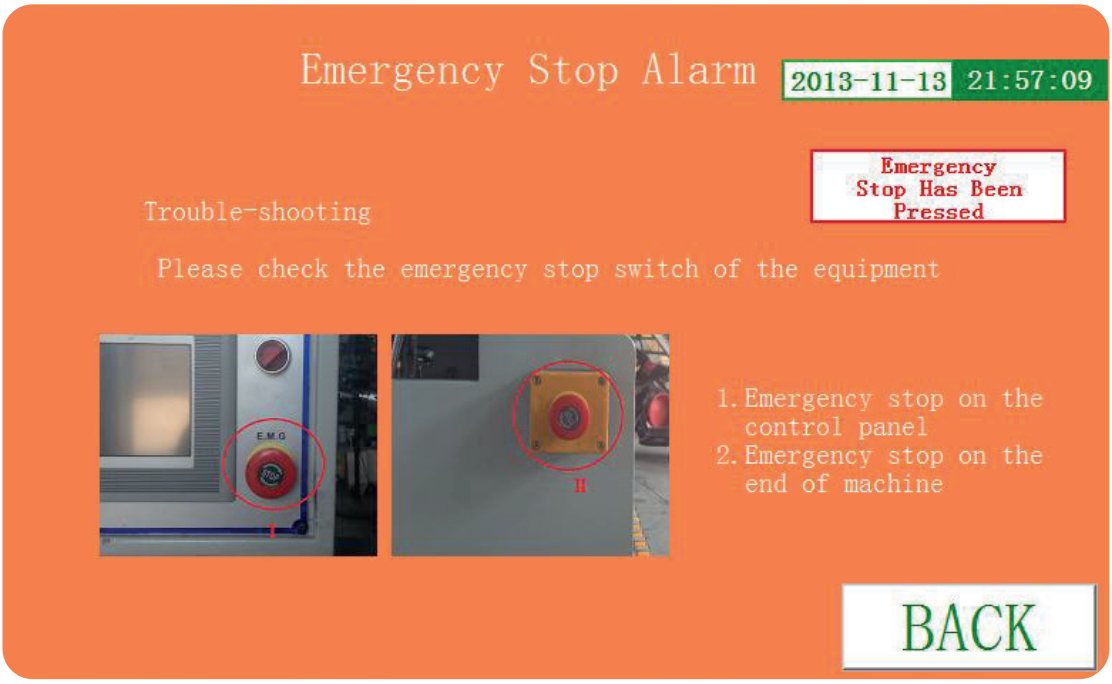


Picture 3-15 Temperature alarm

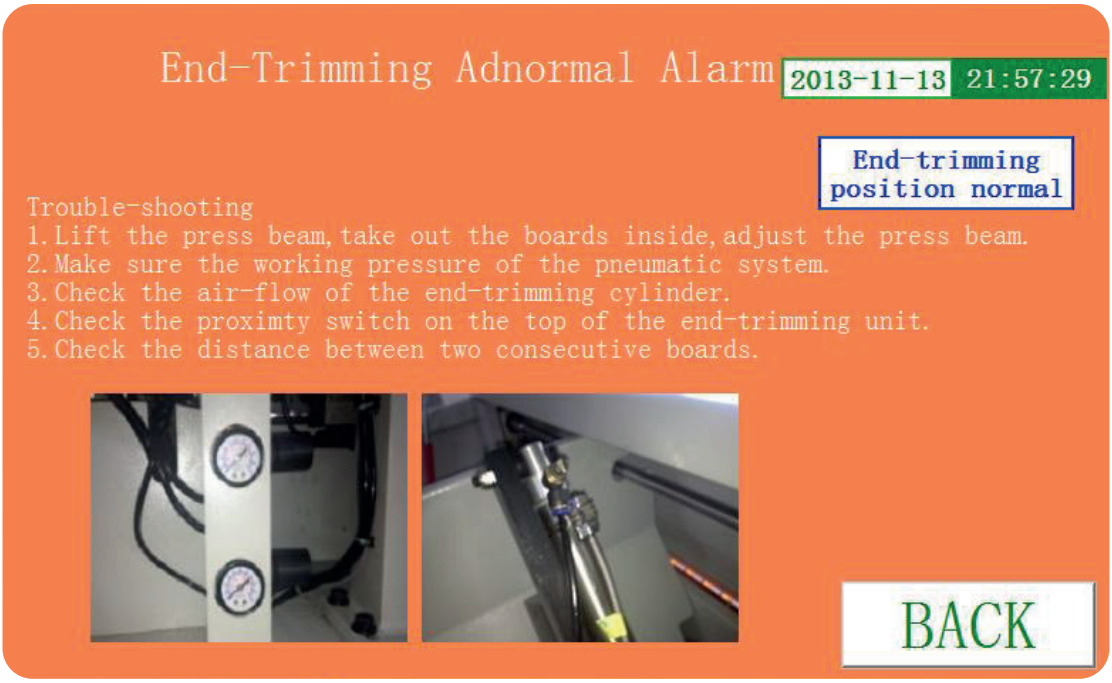
Picture 3-16 Air pressure alarm

Picture 3-17 Buffing overload

Picture 3-18 Gluing overload alarm



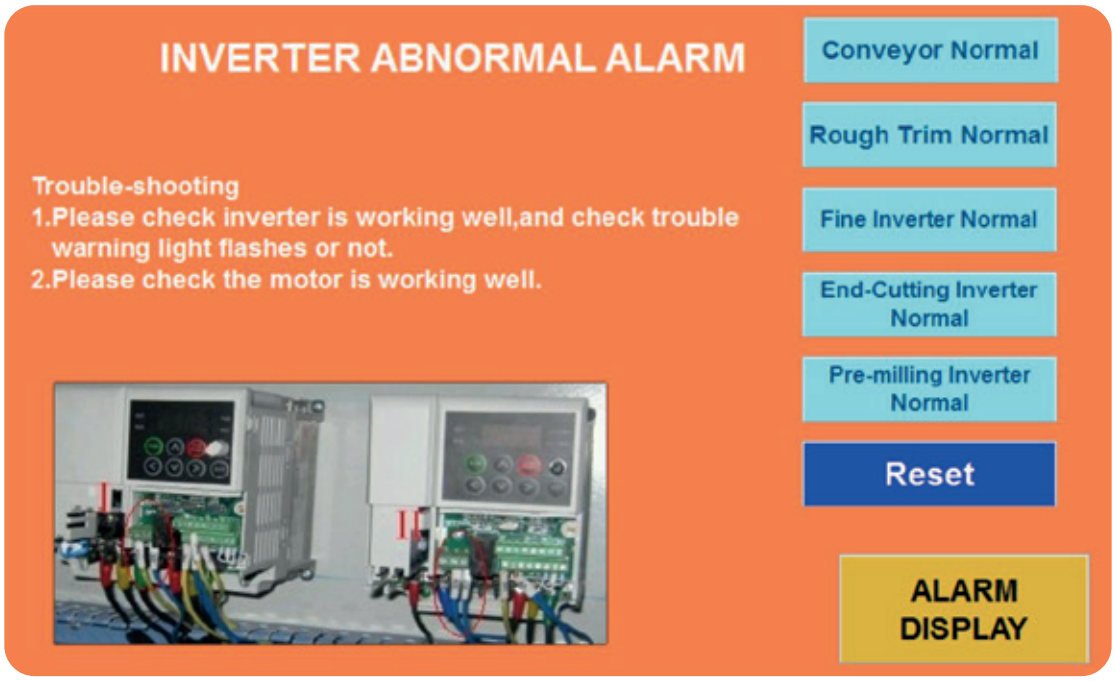
Picture 3-19 Emergency stop alarm



Picture 3-20 End trimming abnormal alarm

Picture 3-21 End trimming frequently changer alarm

Picture 3-23 Door safety switch alarm



4. Description of Capacity Units

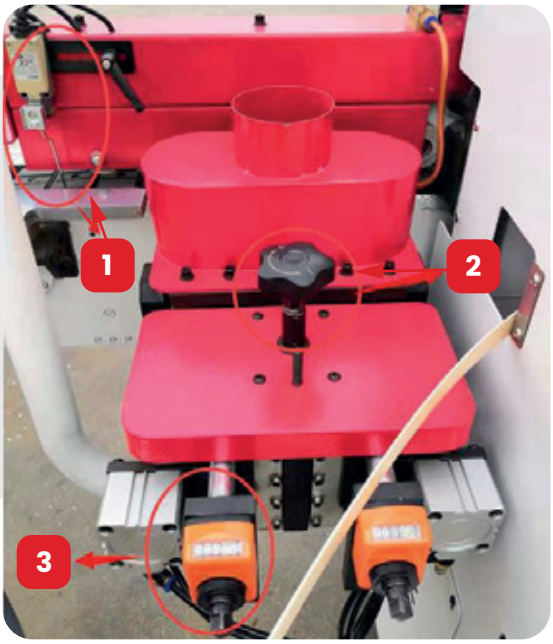
All the parts are tested and adjusted to ensure it is well before delivery. If any problem, please check the following:

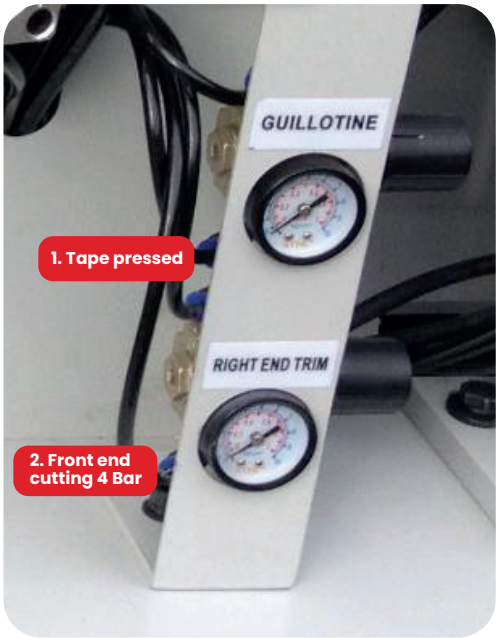
- Air system, pressure, hydraulic pressure, clear air, etc.
- Clean up the sliding fence.
- Other problems except for end trimming and edge trimming units.
- Workpiece, quantity, effect of end cutting.
- Sharpness of cutter.
- Hot-melt glue.

If the protection cover is not closed, the machine will shut down automatically, and disconnect the air system.

4.1 Pre-Milling Unit

1. Switch for control Pre- milling working and Cleaning.
2. For adjust motor up&down.
3. For adjust milling thickness.





Picture 4-1 Air pressure gauge

4.2 Adjust the air control system

The air system is set before delivery. It is usually not necessary to test it again
If it does not work or needs maintenance, please contact a professional technician.See picture 4-1:

1- Tape pressed roller. It is used to set the pressure of the tape cutter.

2- Front end cutting. It is used to set the pressure of front-end trimming.

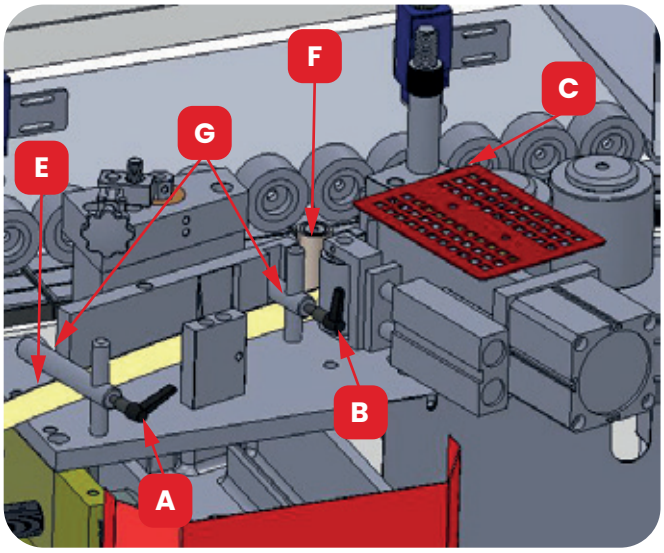
Notice: Please keep the air pressure within the proper range, never too high or too low. The manufacturer will not guarantee to keep the machine in warranty if the machine is broken down by adjustment against the manual.

4.3 Positioning of tape

It is necessary to adjust the tape positioning system, every time the operator uses a new tape of a different type (height, thickness, material).

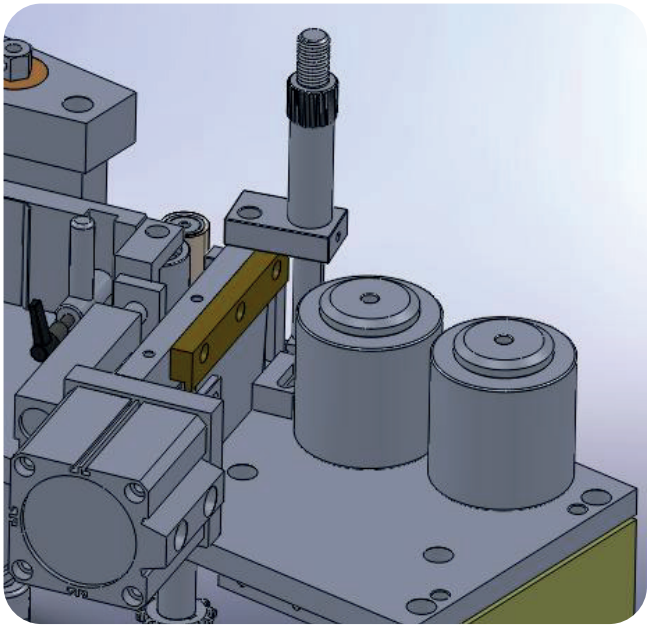
Set the tape E into gap G (see pictures 4-2). Position the poles A, B, and C at a proper height according to the width of the tape. Push the tape into feeding roller F carefully to protect it from being bent.

Notice: The width of the tape must not be over 2mm than the thickness of the panel. (For example, if the thickness of the panel is 0.71 in, the width of the tape must not be more than 0.87 in).



Picture 4-2 Tape positioning part

4.4 Air pressure rollers



Picture 4-3 Pressure roller

Air pressure rollers can press the tape and workpiece together solidly. The quantity, diameter, and interval are all calculated and tested, to make sure that the glue cools down. The operator does not need to be adjusted but should clear the glue on rollers at regular intervals to keep it clean.

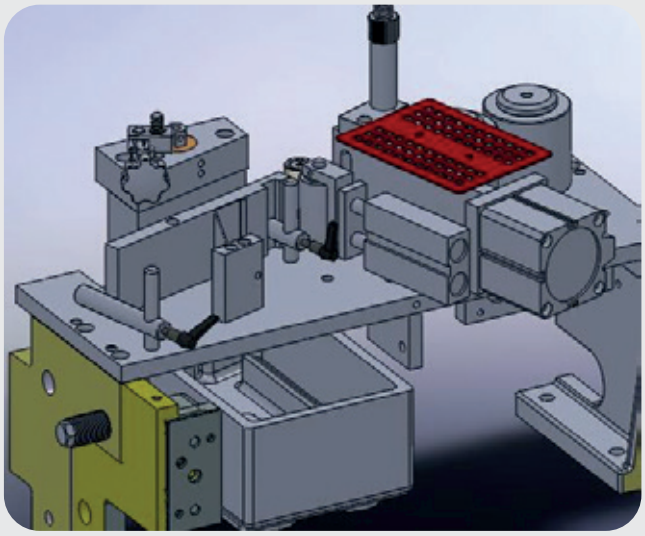
Rollers are made of metal and can press very thin tape. They can flatten and smooth the surface of tape on the panel side. Floating rollers are suitable for unsmooth panels. If the panel is very rough, it is better to use rubber rollers.

Notice: Rollers are different but the effect is the same.

4.5 Tape feeding and cutting unit

Tape feeding system (pictures 4-4; more details on pictures 3-2). The length of tape surplus in front of the panel can be adjusted by changing the data of time delay relay A (pictures 4-5). Factory setting is 1.55 seconds. Longer time, longer surplus.

The length of tape surplus in the back of the panel can also be adjusted by changing the data of time delay replay. Factory setting is 0.44 seconds. Longer time, longer surplus.



Picture 4-4 Tape feeding system

Notice: different models of machines have different settings. Operators are not suggested to change the time delay relay. It is not be in warranty if the operator changes the time delay relay, not follow this manual instructions.

4.6 Commissioning of gluing unit

To keep the machine working well, the tape must be 2mm lower than the gluing rollers. If the difference is less than 2mm, the tape may destroy the gluing roller.

Glue tank

The glue tank can supply the hot-melt glue on the workpiece. To keep it well work, please obey the following rules strictly:

Please fill the glue in the tank, and keep the height of the glue at least 1cm shorter than the top edge of the tank.

Please fill the tank with the glue of the right temperature.

Temperature must be set at a suggested number. (Usually, it is 370 °F)

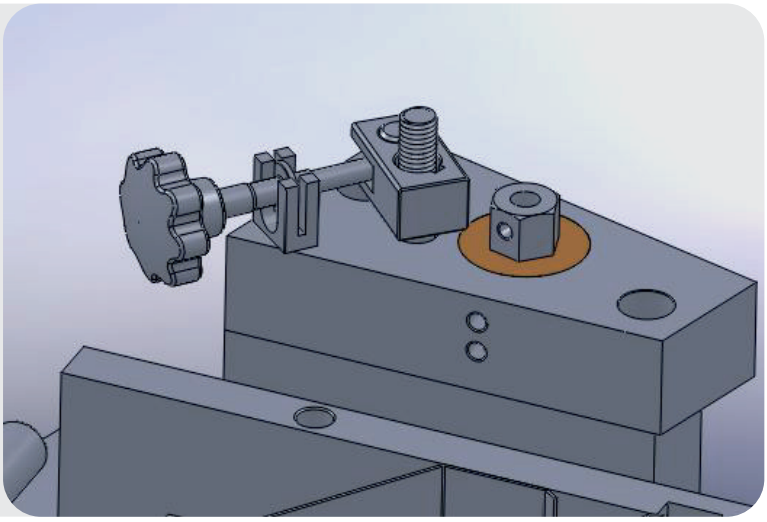
Please do not run the gluing roller until the glue reaches the target temperature and all is melted.

The yield of glue can be adjusted by the pole A. (Picture 4-6). It has been tested and set at a proper position before delivery.

Notice:

Take care of the hot glue tank. It may scald you. Avoid the bits of wood from getting into the tank.

Use the right hot-melt glue for your machine. Check the temperature controller and remaining glue regularly.



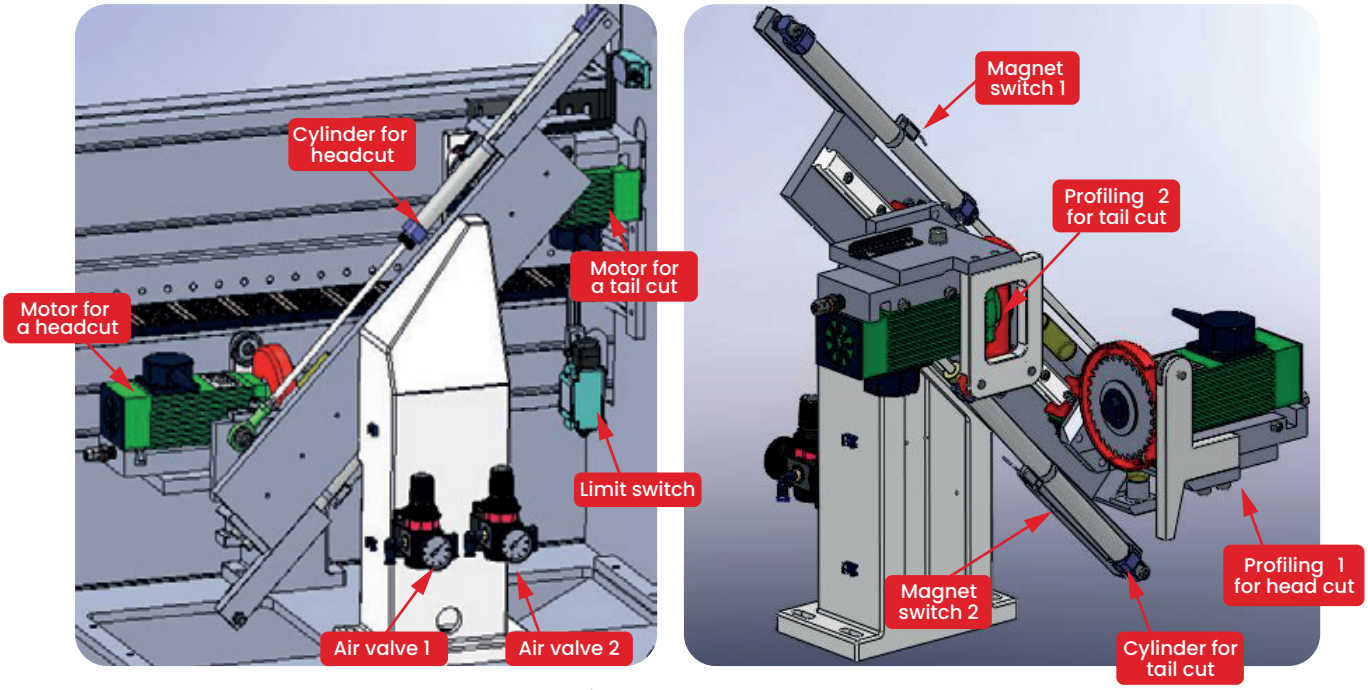
Picture 4-6 Role to adjust glue flow

If the working interval is more than 20 minutes, please turn the heating button off.

Perfect edge banding effects are determined by so many factors, like the type of tape, type of workpiece, the effect of sizing, and the temperature of the environment, that it is necessary to test sometimes to commission the machine at its best state.

There are 2 types of glue tanks to choose from. One is driven by chain, the other by gear. Both of them are adjusted similarly.

4.7 End cutting unit



Picture 4.7-1

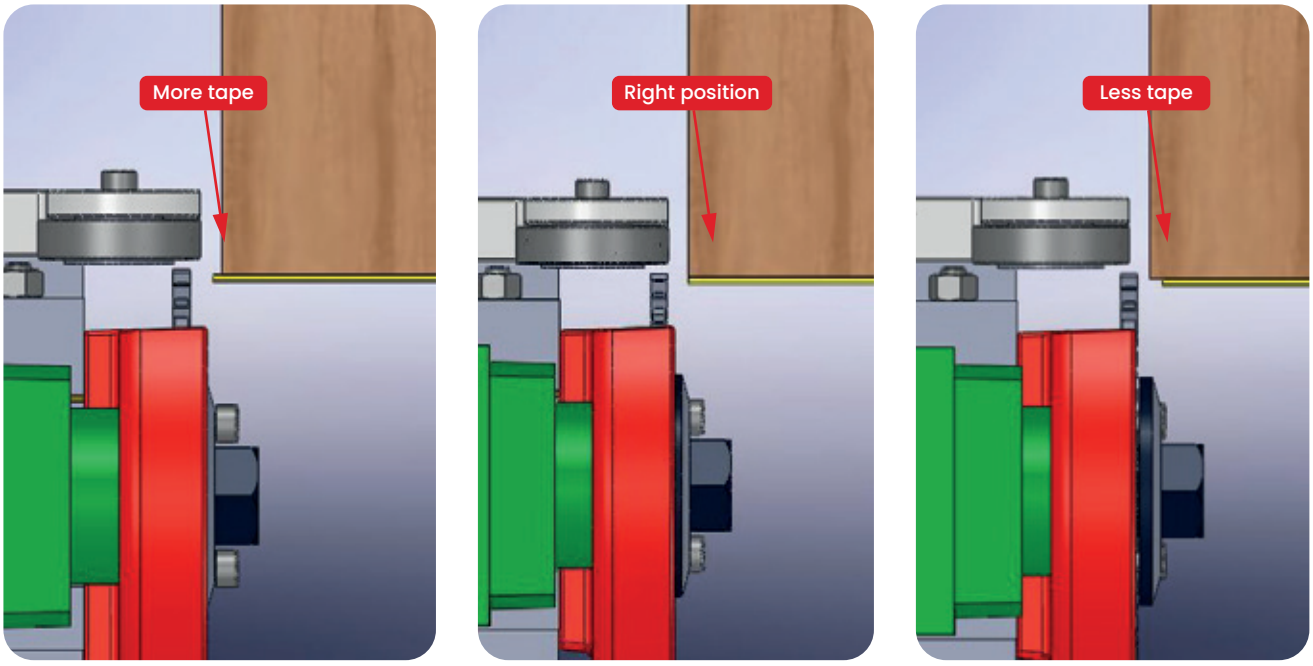
The end cutting unit is to cut the tape surplus, in front and back of the panel. It makes the tape as long as the panel length and also cuts the tape edge with a little angle.

a) Principle of working

When the panel goes through, it will start the limit switch, and then the unit will work. The panel front is close to profiling 1, and profiling 1 moves to the left bottom while the panel moves forward. Besides, profiling 2 is also close to the panel topside by wheels. Once the panel front passes profiling 1, the front cutter will cut down the tape surplus in front of the panel. When the end of the panel gets past profiling 2, the second cutter will cut down the tape surplus. The end-cutting process is over and the motors reset to their original position.

Air valve 1 is used to adjust the action of front cutting, and in common it is set on 3~4 bar. Air valve 2 is used to adjust the action of panel end cutting, and it is set on 2 bars.

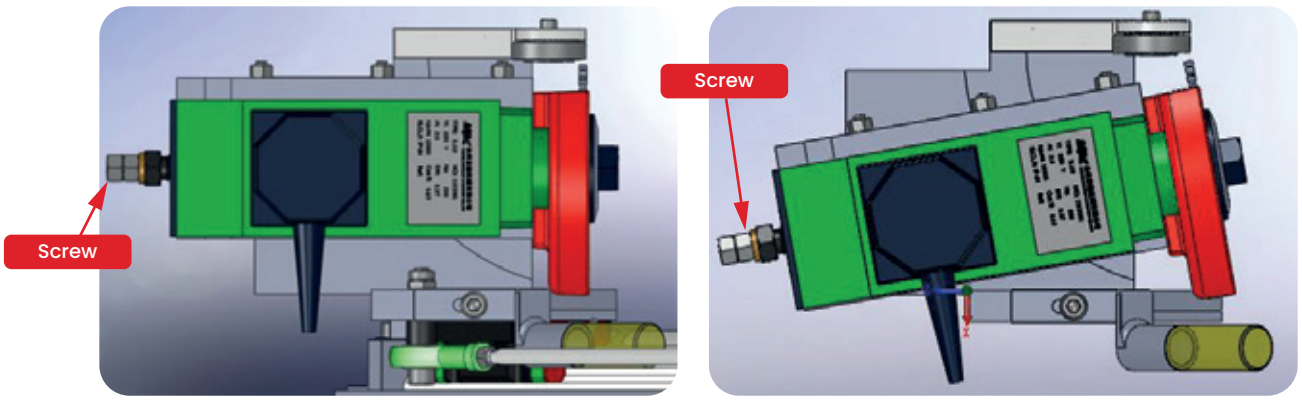
b) How to adjust



Picture 4.7-2

Please check the cutting effect after the panel goes through. See pictures 4.7-2, if the tape is beyond the panel end, please twist the screw clockwise, shown in pictures 4.7-3. If the tape is shorter than the panel end, please twist the screw in anti-clockwise. While twisting, the cutter will move forward or backward. Please set it to the right position.

Besides, you can also adjust the titled angle of cutters.



Picture 4.7-3

Notice: please clean the tape debris on the rail and wash it with cleaner. Otherwise, the rails may be broken after a long time of work.

4.8 Edge trimming unit

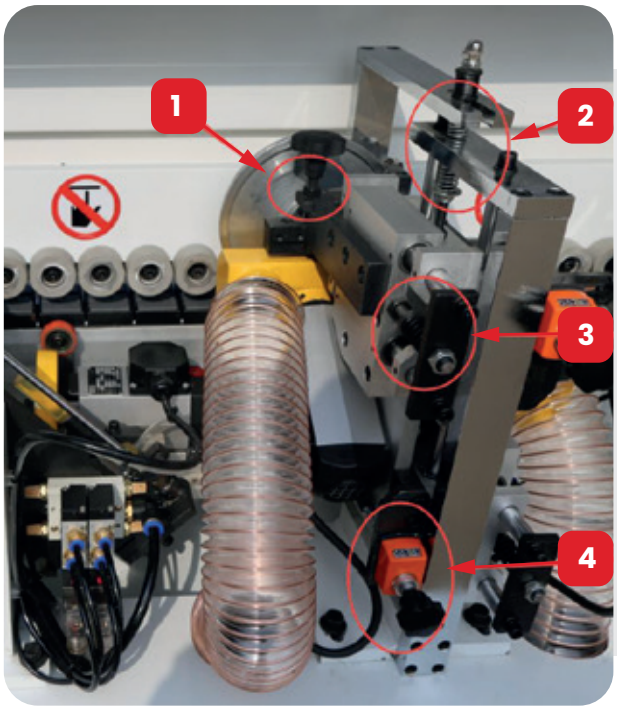
Edge trimming unit standard features:

There are 2 motors in the edge trimming unit, one for top trimming and the other for bottom trimming. Each cutter has 4 blades.

Max. diameter of the cutter is approximately 3.228 in. Min. diameter of the cutter is approximately 2.756 in. The diameter of the main spindle is approximately 0.591 in. Max. width of the cutter is approximately 0.551 in. The weight of the cutter is 0.440 lbs. The rotation speed of the common motor is 9000 r/min. The rotation speed of the high-speed motor is 12000 r/min.

Notice: each cutter can clear a maximum of approximately 0.079 in of surplus tape. There are double dust hoods for the edge trimming unit. They are connected to the dust collecting system.

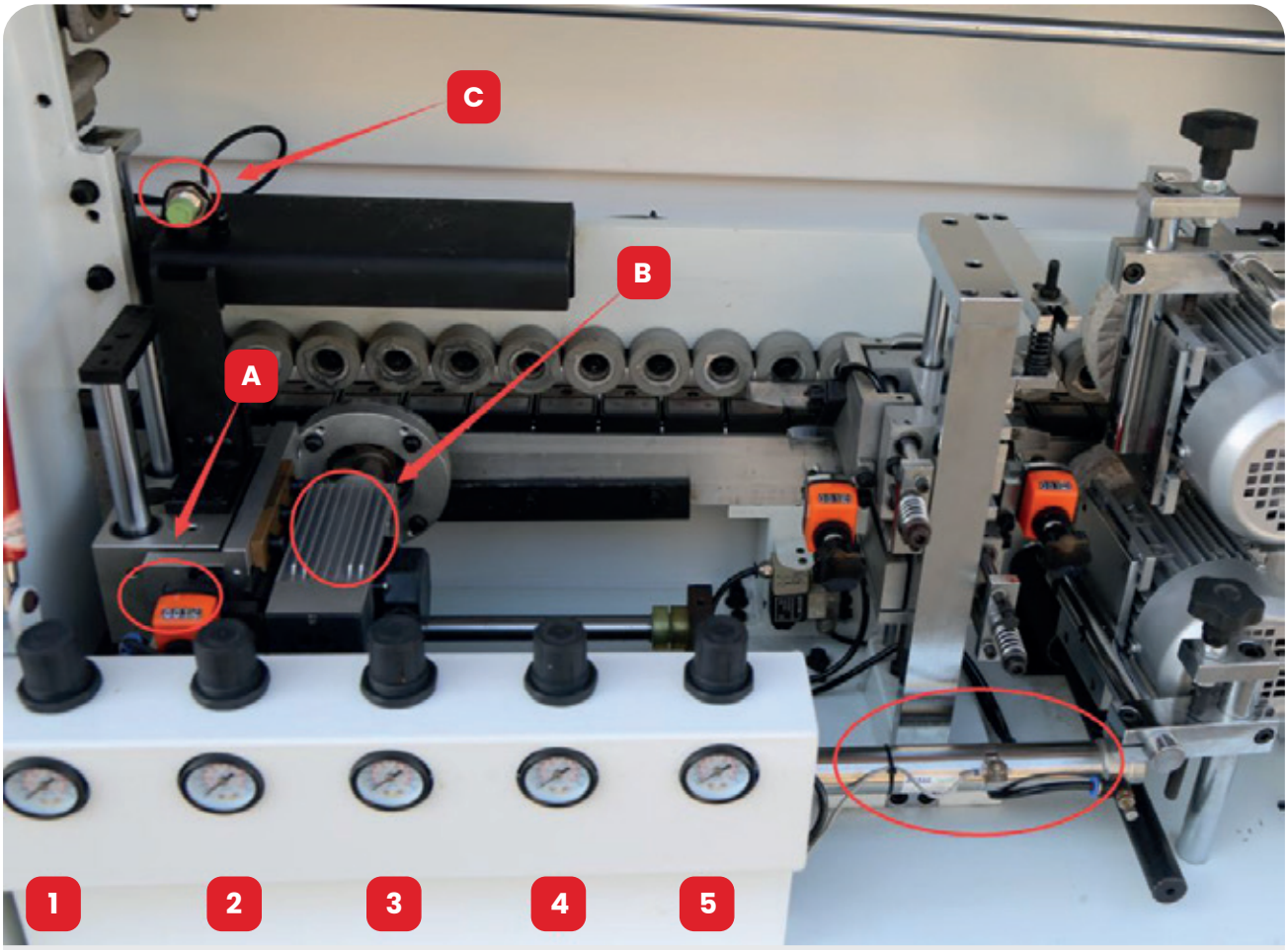
Commissioning of edge trimming unit (pictures 4-9):



Picture 4-9 Edge trimming unit

1. For adjust Up height of the band (the band higher than the board surface).
2. For adjust up unit pressure condition.
3. Forward and backwards pressure.
4. The Round big or Small.

4.9 Corner Rounding Unit



1: 2-0 Bar, the cylinder for control Left & right

2: 0-3 Bar, Up & Down Cylinder

3: 3-0 Bar, Up & Down Cylinder

4: 0-4 Bar, let it left (the tetragonum Cylinder)

5: 3.5-3 Bar, The Motor Forward & backwards a; for adjust rounding motor forward & backwards

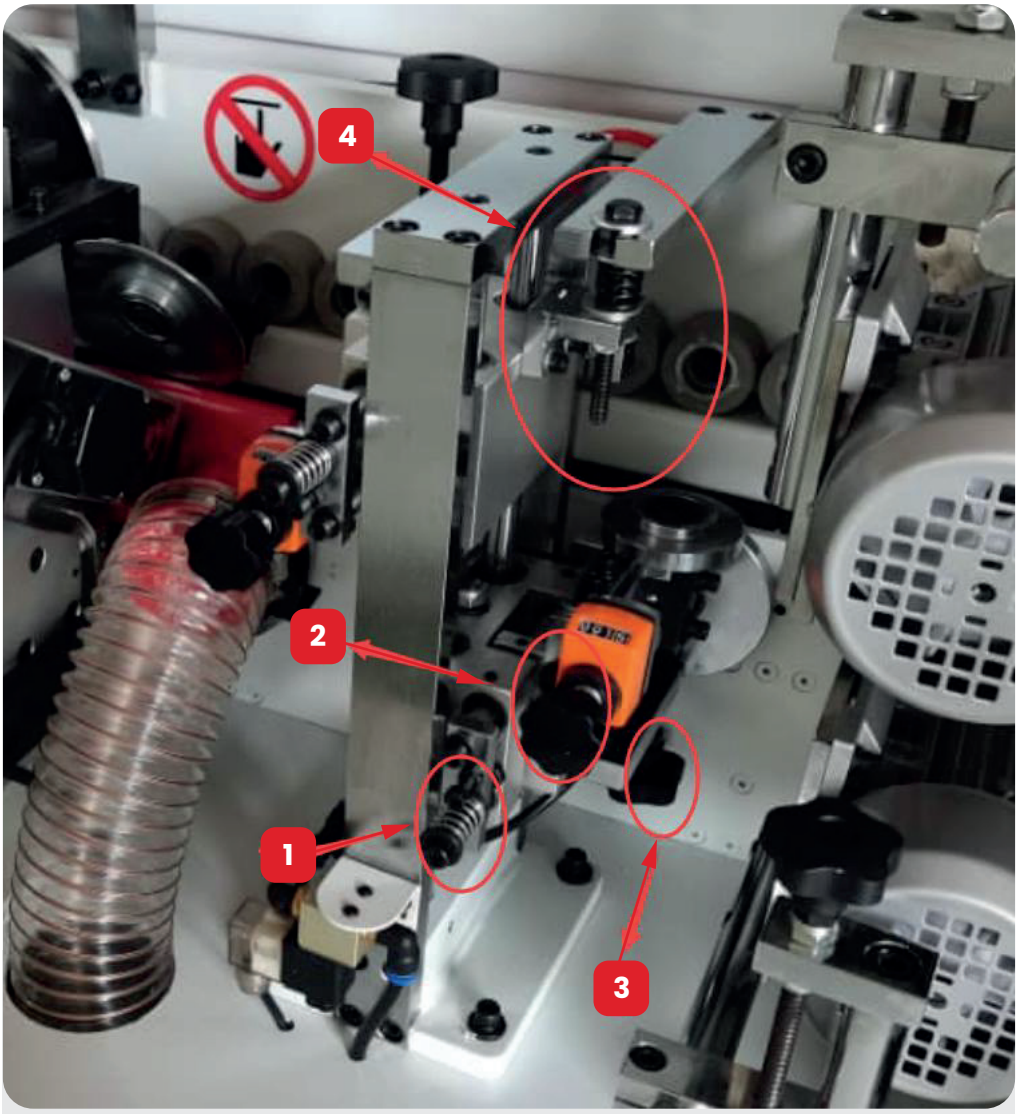
B; Rounding Motor

C; to Detect the Motor Up the right Position

4.10 Scraping unit

Scraping unit standard features:

- There are 2 cutters in the scraping unit, one for top scraping, and the other for bottom scraping.
- The cutter can scrape out tapes, which max. Thickness is 0.079 in. Commissioning of scraping unit (pictures 4-10):



Picture 4-10 Scraping unit

1. Forward and backwards pressure.
2. The Round big or Small.
3. For adjust Up height of the band (the band higher than the board surface).
4. For adjust up unit pressure condition.

4.11 Buffing unit

Function: The buffing unit can clear out the redundant glue on the panel surface. Make your panel looks smother.

Technical data:

Max. diameter of the buffing wheel is 1.42 in

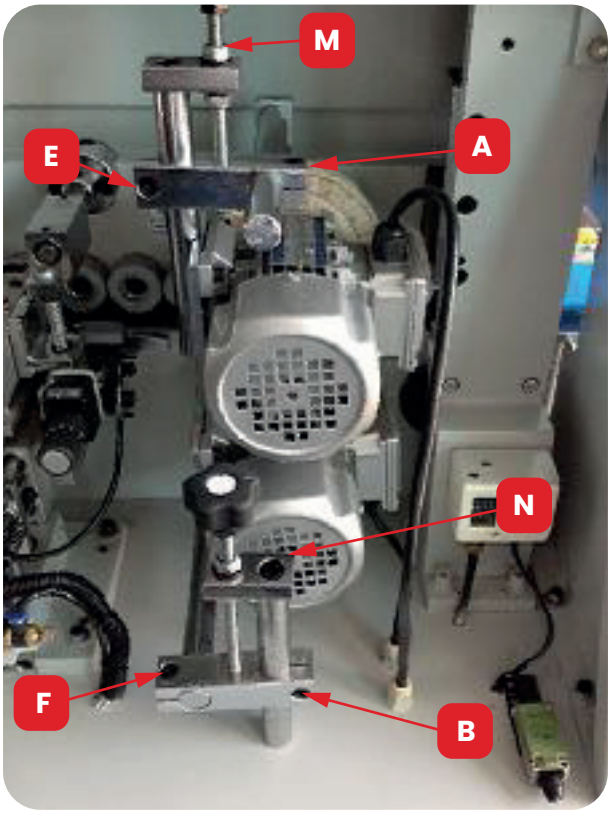
Diameter of the motor spindle is 0.78 in

Max width of the buffing wheel is 1.38 in

Weight of the buffing wheel is 0.44 lbs

The rotation speed of the motor is 1400r/min. The direction of rotation is against the conveyor.

Please adjust the lock screws according to the thickness of the panel. See pictures 4-10 Loosen/tighten the screw A/B, and then adjust the position of N/M to adjust the height of the buffing wheels; adjust the position of E/F, to move the buffing wheels forward/back.



Picture 4-10 Buffing unit

Notice: If the buffing wheels press into panels too tightly, the wheels may be worn rapidly. Please keep the wheels in the panel at a proper thickness.

4.12 Feeding system

The panel conveying system is durable and efficient. It is designed specially and with high friction. The gluing roller can push the panel moving forward with a side thrust. Feeding speed is 39ft/min. The beam is controlled by a hand wheel, see A, picture 4-11. The height of the beam is adjusted according to the thickness of the panel. The exact date of height is shown on the readout N. Besides, beam height can be adjusted by a power motor.

The joint lever W (pictures 4-14), can lift/drop the top edge trimming unit when the beam goes.

Up/down. While the protection shell is open, the safety switch (part V picture 4-13) will shut off. The edge trimming unit will stop at a safe position.

Notice: the height of the beam must be exact and proper. Even ± 0.19 in error will matter the conveyor.

Picture 4-11

Picture 4-13 safety switch for protection shell

Picture 4-12

4.13 Panel conveyor

The conveyor belt must be tight. When changing the belt, please loosen the lock bolt and adjust both of them equally. If the conveyor belt is not tight enough, the workpiece may wear the gluing roller. Notice: After the first running of 20-25 hours, please check the tension of the conveyor belt. Please regularly check and commission the belt.

4.14 The gluing roller

Little slant rollers are installed on the work platform. They can improve the side thrust on the panel. This part need not be maintained.

4.15 The guide fence

A guide fence is used to keep the panel parallel to the conveyor. It was tested before delivery and is not necessary to adjust its position.

4.16 Frequency converter

The frequency converter can change the frequency of high-speed motors in the edge trimming unit. In that way, it can control the rotation speed of motors and save time and energy.

It is not suggested for operators to change the value of the frequency converter. To avoid faulty operation, they are locked. See more details on the related brochures.

It starts once the general power is on. The number displayed on it is the output frequency. Usually, the number is 200HZ (frequency of motor). The converter will inspect itself when power is on, so please do not turn on/off the general power frequently.

The sensor is sensitive to the work environment. Please check the requirements on the related brochures.

Notice: Do not modify the unauthorized data on the frequency converter. The attached brochures are just for searching the fault reason. It is out of warranty if buyers change any data and break the machine down.

4.15 Detailed setting of frequency converter

All the parameters are tested before delivery. Please do not change the value at will. The parameters are as follows:

LSLV-C100 series inverter parameters		
Code	**Description**	**Parameters**
F21	Max. Frequency	200
F22	Rated frequency	200
H30	Motor capacity	0.75
H31	Motor pole number	2
H33	Rated current	3.8
ACC	Accelerate time	5
DEC	Decelerate time	6
DVR	Control mode	3
000	Target frequency	150

Notice: All the data are suited to the LSLV-C100 series frequency inverter; the other parameters are all factory set; please read the brochures about detailed methods of setting.

5. Maintenance and repairment

5.1 Clean

Please keep the machine clean.

Turn the general power off (on O position). Disconnect the compressed air pipes.

Clear out the residue with solvent. Clear out the stack clips. Check the dust collector system, and keep the system and pipes clear. Please check the rails to keep them clean.

Notice: please make sure the parts cool down before clearing the residue with solvent. Please make sure the pressure rollers, cutting parts and gluing parts are all clear, especially the gluing unit. It will do a lot of help for the maintenance.

5.2 Lubrication

Please ensure the general power is off (on O position). Disconnect the compressed air pipes. Please lubricate the motor regularly every month.

5.3 Replace cutters

Keep the power off (on the O position). Disconnect the compressed air pipes.

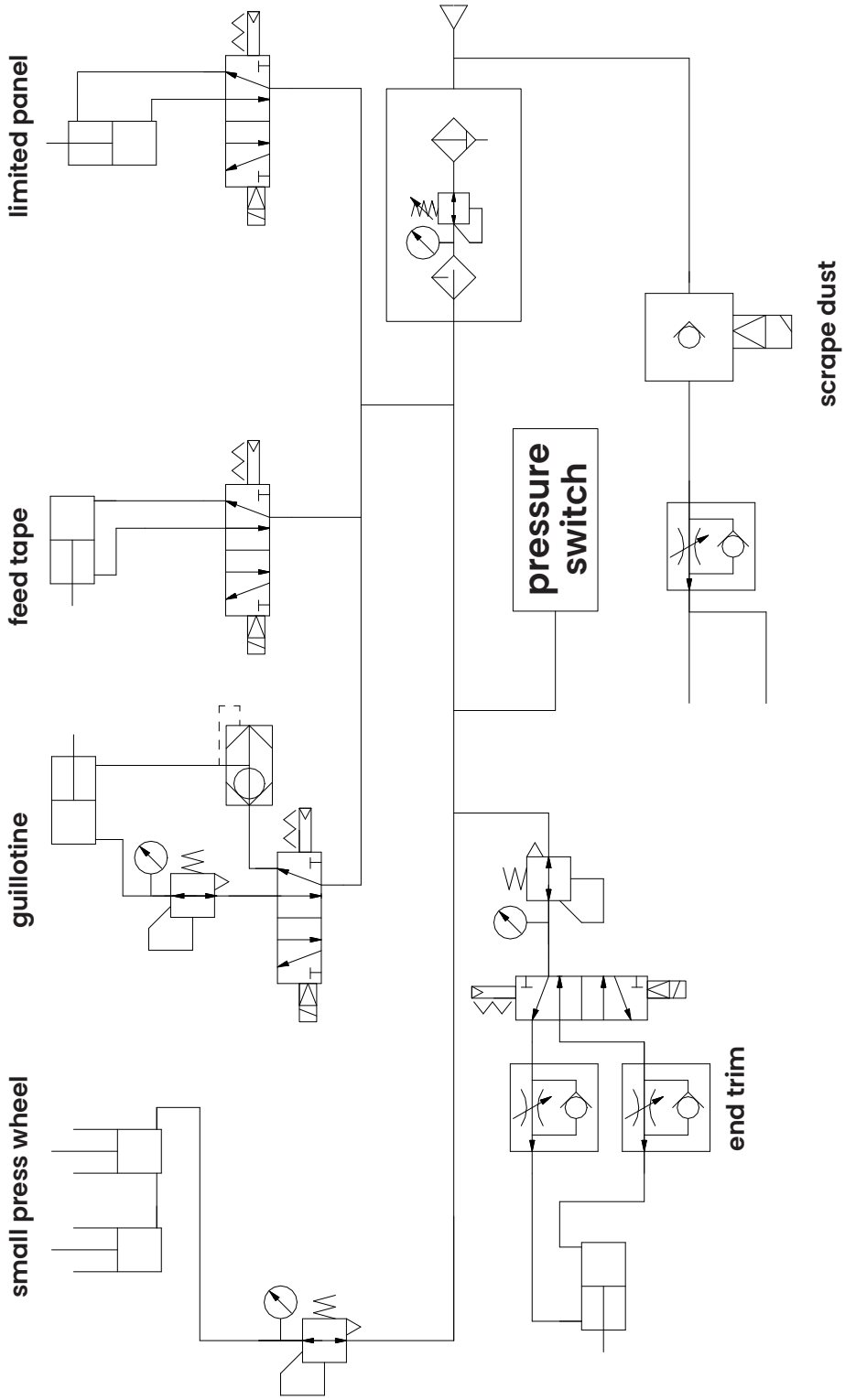
End trimming cutters: Uncover the protection shell. Remove the cutters and replace new ones. Please make sure the fastening bolts are tightened up, then install the protection shell.

Edge trimming cutters: Uncover the dust hood first. Then replace the cutter.

Notice: please loosen the bolts carefully. The upper bolts are tightened clockwise; however, the bottom bolts are tightened anticlockwise. Please use the common wrench and cutters.

Buffing fabric wheel: loosen the bolts first. Then replace the new wheels and tighten the bolts. Notice: fabric wheels are quick-wear parts. Please check it regularly and replace it in time.

6. Electrical and pneumatic diagram



EB102 PNEUMATIC DIAGRAM

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