INSTRUCTIONS MANUAL

EDGE BANDING MACHINE

OF HOT- MELT GLUE

- **Model: ALPHA**
- **Document: Rev. 1**

TECHNICAL DETAILS:

THICKNESS BOARD	MÍN.	8 mm
	MAX	40 mm
WIDE BOARD	MÍN.	75 mm
LONGITUDE BOARD	MÍN.	120 mm
THICKNESS EDGING	MAX.	2 mm
SPEED ADVANCES		5.5 m/mi

ELECTRIC CONNECTION:

VOLTAJE			FN		
			Total	Total	Total
			CV	KW	AMP.
230		monofasica	3,15	2,32	11,9

END TRIMMING: **EC-1**

TRIMMING UNIT: **JC-1**

MOTOR: 2 x 0.27 Kw.

GLUE SCRAPPER: **RR-7 (OPTION)**

DRAG UNIT:

MOTOR: 0.37 Kw.

CE Declaration of Conformity

We ROBLAND NV, KOLVESTRAAT 44, 8000 BRUGGE - BELGIUM

Declare, under our only responsibility, that the product

EDGEBANDER MACHINE ALPHA

Serial Nº:

Considered a machine according to the Machine Regulation 2006/42/CE.

And to which this declaration refers, fulfils the following regulations or regulatory documents.

EN 14121:2007;
EN 60204-1:1999;
EN 13849-1:2008;
EN 953: 1998;
EN 1088: 1996;
EN 13850:2007

The product described herein fulfils the following European Regulation:

2006/95/CE Low Tension Regulation
2004/108/CE CEM Regulation
2006/42/CE Machine Regulation

Gert Muijs

01/10/2015
Brugge

(Name, Signature, Place and Date)

1 INTRODUCTION:

1.1 Purpose of the operating manual:

This manual is aimed at the operator and especially the personnel responsible for using the machine correctly and thereby achieving good safety at work. It is, then, recommended that the manual be read through carefully, paying particular attention to the sections on warnings, precautions and methods of use, and that it is kept close to hand for future reference, preferably next to the machine itself.

1.2 Presentation:

ALPHA edge banding machine is automatic machine equipped with a bottom vertical gluing station, pressure rollers, end trimming station and trimming station.

1.3 Reference standards:

ALPHA edge banding machine is designed and built in accordance with the following standards:

- Community Directives: 2006/95/CE, 2004/108/CE, 2006/42/CE
- Harmonized norms: EN 14121:2007, EN 60204-1:1999, EN 13849-1:2008, EN 953:1998, EN 1088:1996, EN 13850:2007

1.4 General warnings and recommendations:

Proper use of this machine involves perfect knowledge of these instructions for use and of all the risks arising out of improper use. The machine must therefore only be used by authorised personnel.

Safety when using this machine is only guaranteed for the functions and materials specified in these instructions for use. ROBLAND N.V. accepts no responsibility in cases where the machine has been used for purposes other than those indicated in and complying with these instructions for use.

ROBLAND N.V. accepts no responsibility in matters related with machine safety, reliability and performance in cases where the warnings and suggestions in this manual have not been respected, in particular concerning the activities of erection and assembly, use, routine and special maintenance and repair.

The electrical installation for the machine must comply with CEI 64.8 (CENELEC HD 384-IEC 408) standards. The machine builder renounces all types of responsibility in cases where the machine has not been correctly connected to the earthed (grounded) equipotential installation, such that the protective devices behind the machine itself are not operative. For this reason, explicit reference is made to the entire contents of the chapter relating to the characteristics of the electrical installation.

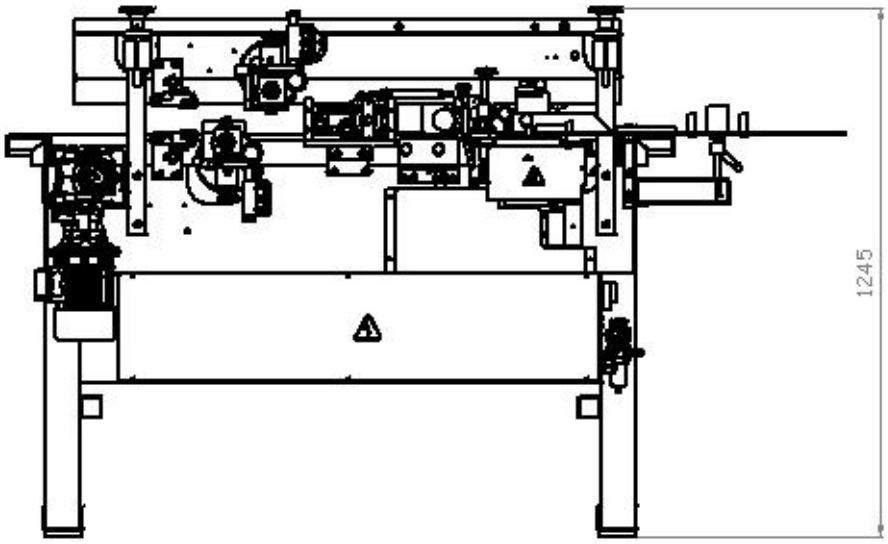
Original spare parts only must be used for special maintenance and repair work.

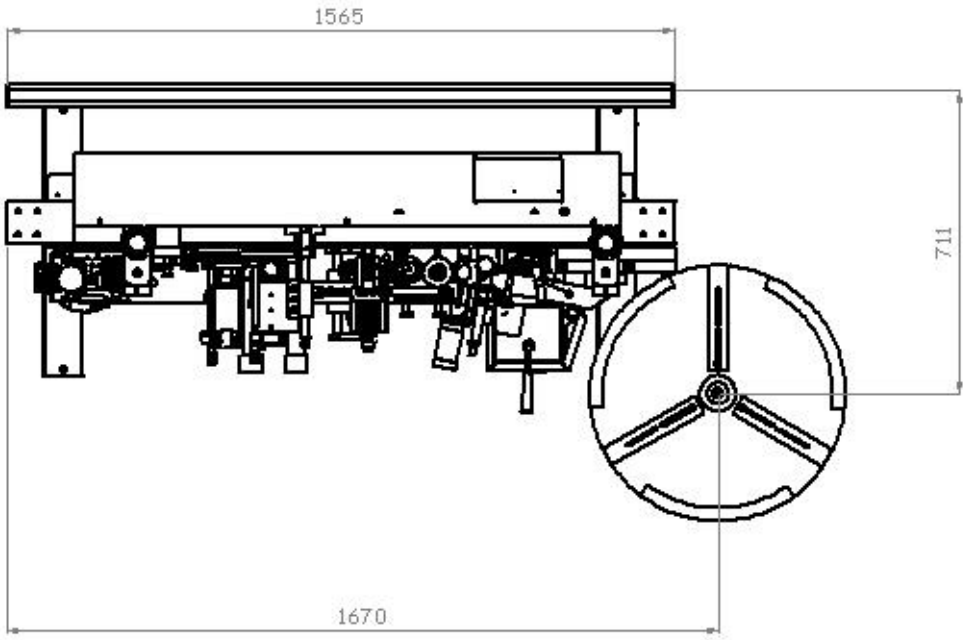
It is always advisable to contact our technical assistance service concerning repairs. The responsibility for perfect machine operation rests solely with the user, if the equipment has not been repaired or maintained by personnel authorised by ROBLAND N.V..

1.5 Technical details:

- Dimensions of machine:

Dimensions of the edge banding machine it is shown in a following shape: (Measures mm)





More details:

- Dimension cable: Electric cable 3x2.5
- Protection necessary y for the installation of the machine:
  Automatic diferencial swich pole 25 Amp. Sensibility 300 mA.
- Pneumatic pressure of work / maxim: 6 / 8 Kg/cm^2 .Consumtion 1.5 L/min
- Diameter machine`s mouth aspiration 50 mm (2).
- Air consumption 110+110 m^3/h. Speed min. 20 m/sec
- Noise emitted by the machine. Empty 81 dB(A), Full Charge 83 dB (A).
- Weight machine: 350 Kg.

1.6 Placa características máquina:

Always specify to the manufacturer for any information, request for spare parts, consultation etc…

2 MACHINE INSTALLATION:

2.1 General safety rules at the ALPHA edge banding machine installation:

- The person in charge of the machine must be instructed in how to use the machine correctly and informed of the relevant safety devices and tools and accessories.
- The devices fitted to the edgebander must be correctly set up and adjusted.
- The appropriate routine and special machine maintenance tasks must never be neglected.
- Before starting each job and before switching the machine on, check that the control and working stations are free from chippings of previously removed material.
- The machine operator must always wear suitable safety clothing bearing in mind the type of activity being carried out, protective gloves, safety footwear and spectacles or goggles for example. Remember never to wear clothing or objects that may get caught in the machine such as loose clothing, ties, watches, rings and so on.
- Before beginning any operation, check that there are no persons or other obstacles in the vicinity of the machine that may present a risk.
- Make sure the cable connecting the machine to the electrical supply is fully unwound and not coiled up.
- Do not situate inflammable substances near the machine to prevent the risk of an accidental spark causing fire or explosion.

- The machine operator must always consider the possible consequences before moving his hands towards the most dangerous zones.
- Never remove the yellow protections located on the gluing set, as they prevent the risk of burns to the operator.
- The operator must always be particularly careful when working the pedal that sets the machine into operation.
- Always keep the machine switched off when not in use.
- Do not enter, touch or handle zones where movements take place before switching the machine off.

2.2 Limits of use:

This machine has been designed to work with the following materials:

- Solid wood
- Laminated or unlaminated chipboard
- M.D.F.
- Various compound materials, provided they are wood-based

The machines have been designed and built to work in closed industrial environments. Sitting the machine in an unsuitable location must be considered as improper use. The machines are not intended for edge banding materials other than those described, and any such use must also be considered as improper.

To trim edges made of the following materials:

- Laminated plastics
- ABS
- PVC
- Melamine products
- Wood band in roll form
- Strip up to 2mm thick

The command post of machine is easily accessible for workers, and is located outside danger zone for them. From that zone and to be in position to operate the controls, worker is the increased visibility of the machine, being away and protected from danger zone.

The staff required for the work of the machine ALPHA will be as maximum of two operators. One located at the entrance to introduce boards and other to collect boards mechanized. The space required for these, is found in paragraph 2.4.

The connection of the machine should be carried out only by authorized personnel.

Before any handling in the machine and safety and proper functioning of the machine, must be read with care this manual.

2.3 Personal Protective Kit

Work must wear an appropriated and authorized protection kit.

- Ear Protection: When machining pieces by shaving cutting.

- Eye Protection: For preparation tasks.

- Safety Footwear: Worker must wear safety shoes while working.

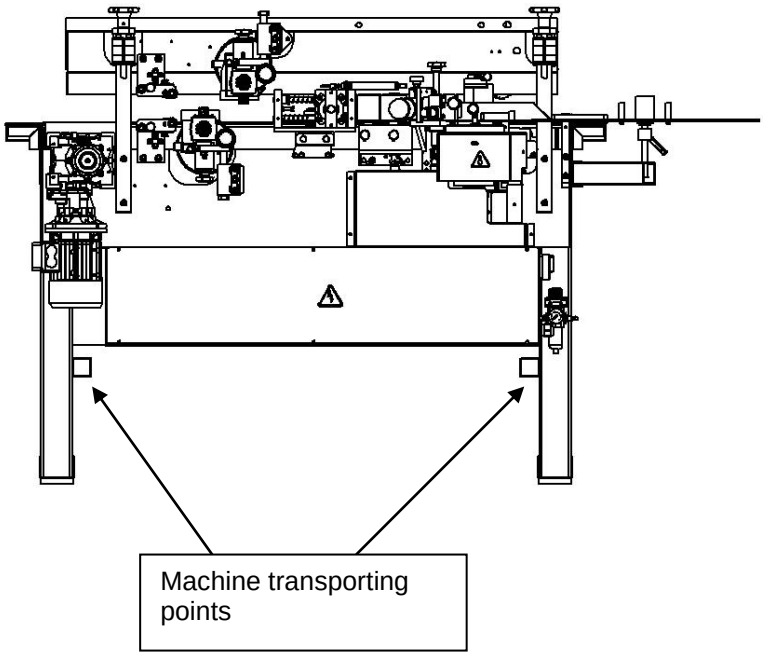
- Dust Protection mask: Worker must wear protection mask when processing materials without dust aspiration device.

- Hand Protection: Worker must wear gloves when handling hot pieces, glue or cutting tools.

2.4 Machine movement and sitting:

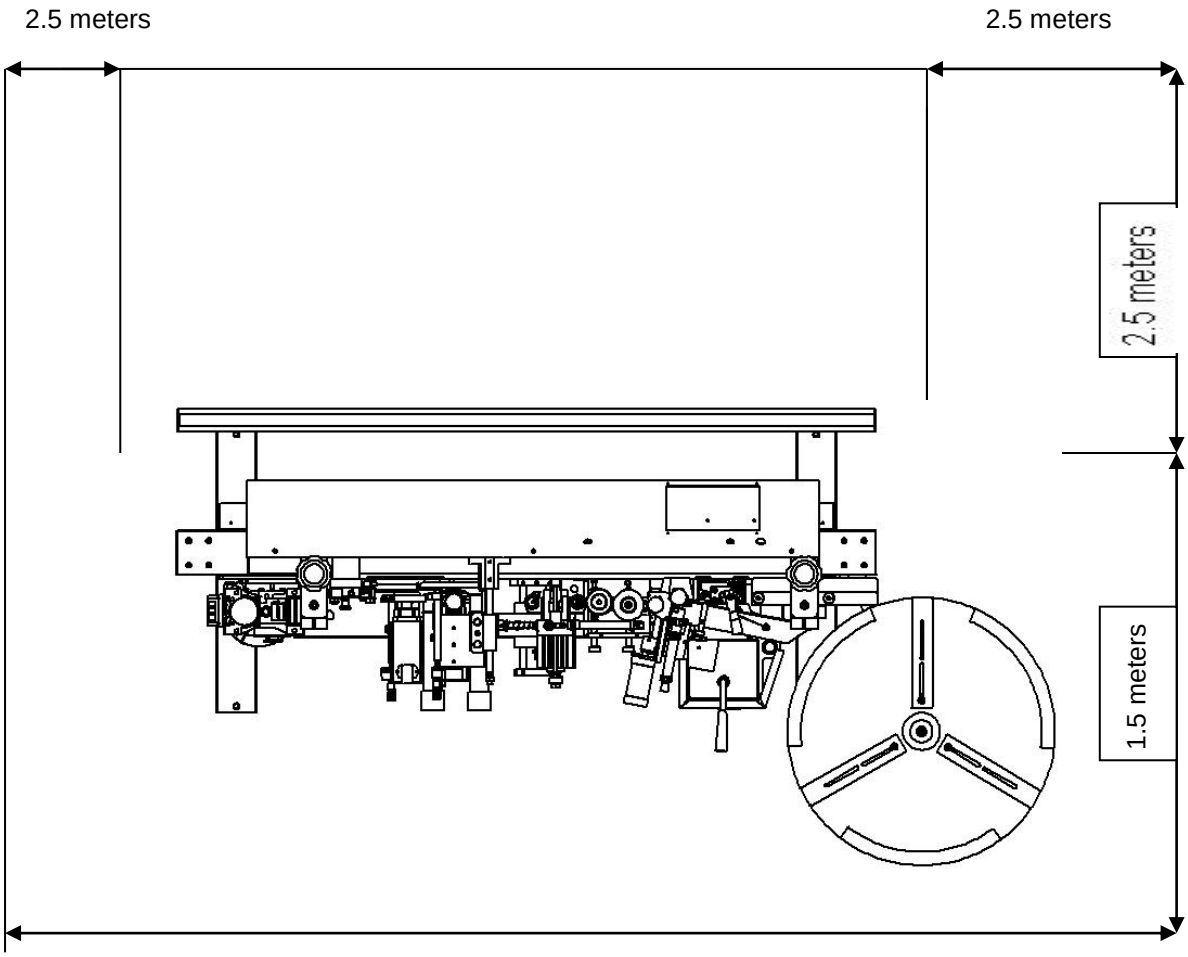
The machine must be lifted and transported taking into consideration that the support points must be as close as possible to the transporting bars. Take all possible precautions in machine lifting, handling and moving operations to avoid the risks of unforeseen movements which could endanger persons or property.

The machine must be sited on a flat surface able to withstand the weight of the machine. Site it in an optimum position with regard to operational requirements, where electrical connection is easy and with enough light to ensure that all parts of the machine are visible. If the machine is unstable once in position, the support bolts should be adjusted until the machine is stable and level.



2.5 Dimensions and safety zones:

The utmost care must be taken to avoid allowing objects that obstruct correct working from occupying the safety zones as detailed in the figure below.



2.6 Electrical installation:

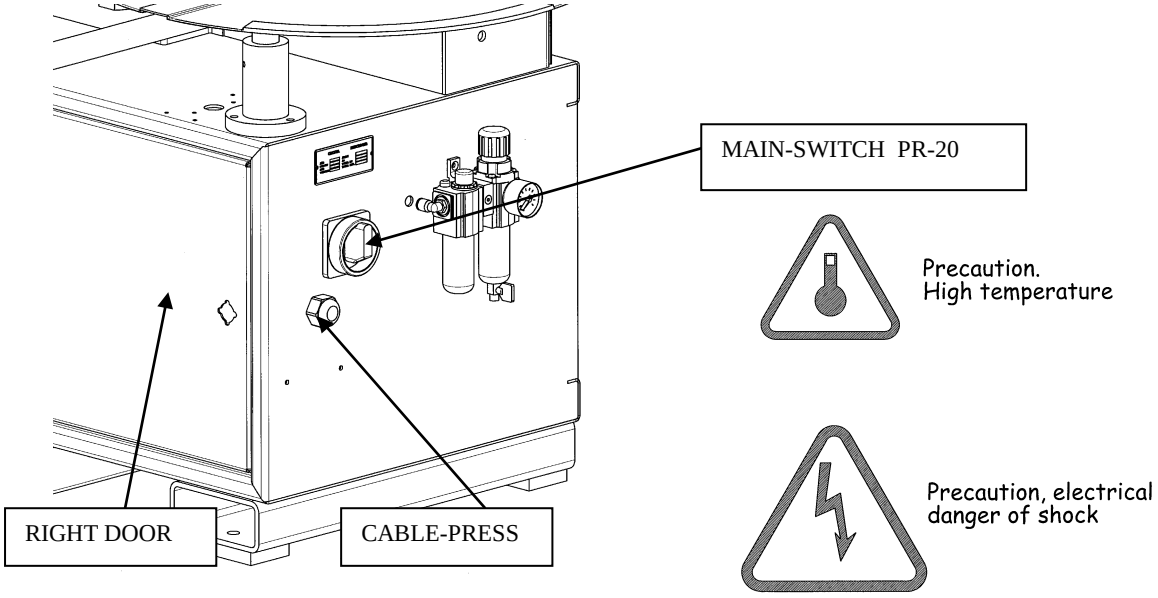
The electrical connection to the bottom right of the machine interior must be opened to make ready the electrical installation. It is recommended that the machine is not connected up the electricity supply until it is in its final position, and a check has confirmed that the line voltage is the same as that shown on the machine nameplate at the top of the main supply connection box. A check must also be made to confirm that the main electrical supply to be connected to the machine complies with the following safety requirements:

The installation must conform to IEC 408 standards.

Presence of earthed equipotential supply.

Presence of fuses or circuit-breakers to guard against short circuits on each conducting cable, except the earth cable.

ATTENTION: Before switching on the machine please ensure that the voltage between terminals L1 and L2 (MAIN-SWITCH) reads **220 V.**
If incorrectly connected it will lead to irreparable damage to the frequency changers on the machine and **THIS INVALIDATES ANY WARRANTY CLAIM.**



To make the connection, insert the cables from the main supply in the terminals L1 and L2 (MAIN SWITCH), securing them with the cable-press and fixing the earth cable using the appropriate nut. Connection is via terminals, and the cable cross-section must be at least 2.5mm.

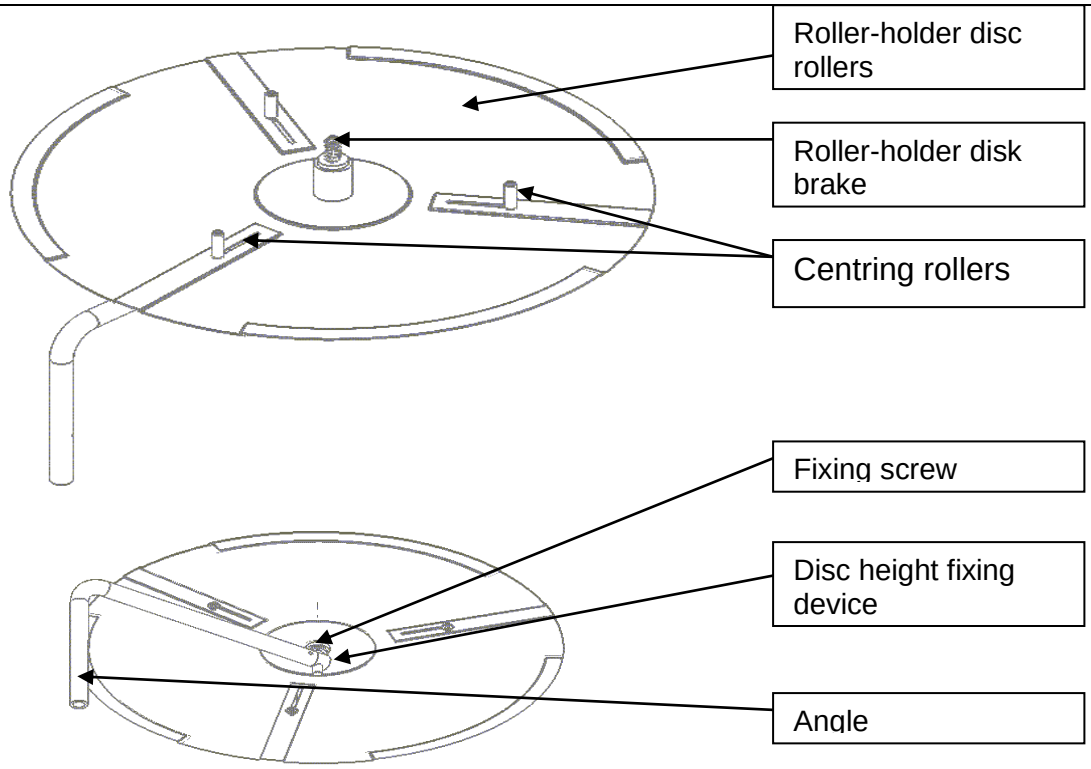
2.7 Pneumatic installation:

Connection to the line is made with a rubber or nylon tube of 6mm minimum inside diameter, 10/12mm being ideal. Connect the air service (FRL) unit using a minimum ¼" female fitting (supplied with the machine). Pressure must be at least 6 atmospheres, with a maximum of 7 atmospheres.

The air service unit consists of a Filter, to clean the air of dust and humidity capable of damaging the valves and seals on the pneumatic cylinders; a pressure Regulator to adjust the machine's working pressure to its optimum value.

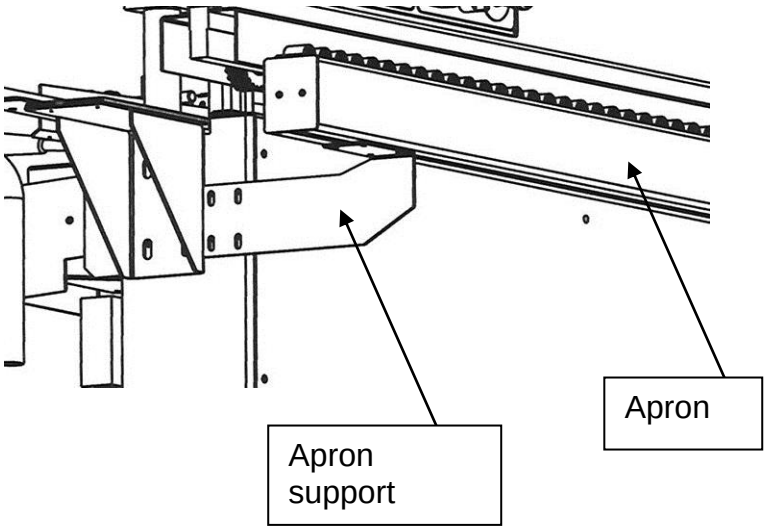
2.8 Fitting the roll-holder tray:

This accessory is supplied dismantled for transport purposes. Assembly consists simply of fitting the crosspiece to the angle, then inserting the roll-holder disc, securing it with the lever as shown in the figure.



2.9 Fitting the apron:

Fit the supports and finally fix the apron. Correct apron level is 1mm below the tops of the chain rollers, its function being to help to introduce the board. If at a level higher than the chain, it would put a slope on the board and spoil the finish on the final piece.



3 SETTING UP AND STARTING THE MACHINE:

3.1 Start-up and stop the machine

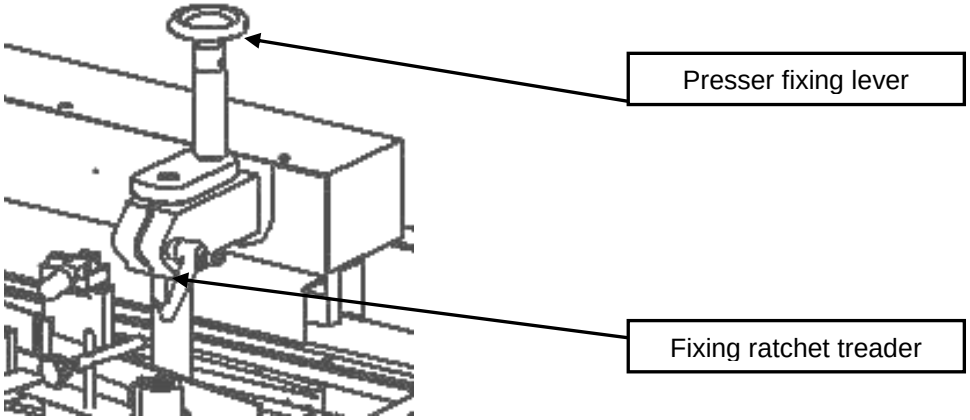
To start the machine, turn the main switch to ON. The general voltage pilot lamp must be illuminated.

BEFORE CARRYING OUT ANY TASK AT OR AROUND THE MACHINE, MAKE SURE IT IS COMPLETELY STOPPED, THAT IT CANNOT POSSIBLY MAKE ANY MOVEMENT AND THAT THE MICROSWITCHES CANNOT BECOME ACTIVE: DO THIS BY PRESSING ANY OF THE EMERGENCY STOPS.

- Make sure there is enough glue in the container for the job to be done.
- Operate the resistances On selector. (Q3)
- Select the desired working stations.
- Insert the strip as far as the first pressure roller.
- Adjust the height of the presser to suit the panel to be passed through.
- When the heating pot temperature reaches the set point figure, reset the machine by deactivating the emergency stop, then pressing the green reset button. The motors may now be switched on by pressing the motor On and chain activated buttons.
- The machine is totally stopped by opening the cabin, operating any of the emergency stops or turning the main switch to OFF.

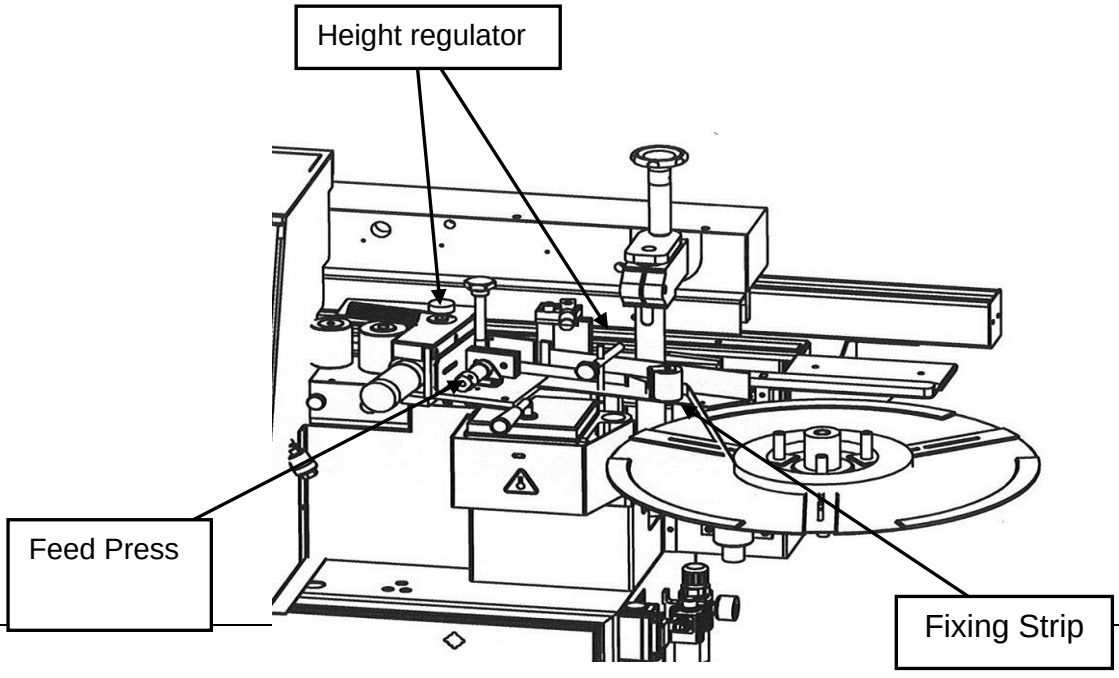
3.2 Adjusting presser height:

The height of the presser needs resetting every time the thickness of the board to be edged changes. This simply involves loosening the levers on the presser fixing pads, and using the lever to raise or lower the presser to the required value as indicated on the numerical counter.



3.3 Loading and regulating the band in roll form:

To introduce the roll in the tray carries roll in having felt schedule, to go the first song by the fixation roller, until it surpasses the centre of pressure roller. To adjust the regulators of height of the song, leaving a small separation so that this it can move easily. Set the pressure on the feed press using the pressure regulator located on the door under the heating pot to a pressure of approximately 2,5 bar. To observe that so much the faucet of the piston of ribbon feeding as that of the cutter is open. Finally to adjust the pressure of the rollers of pressure by means of their regulators to the wanted value, for further detail to look at "rollers base. To adjust the pressure of the cutter according to the thick of the material 2-5 bar.



3.4 Regulating surplus strip:

AT THE FRONT: The amount of surplus may be adjusted via the feed time regulator timer in the PLC:

- More time: more surplus at the front.
- Less time: less surplus at the front.

AT THE BACK: This involves regulating micro S-13.

- Moving the micro to the left increases the surplus at the back.
- Moving the micro to the right decreases the surplus at the back.

4 WORKING STATIONS:

4.1 Glue pot station:

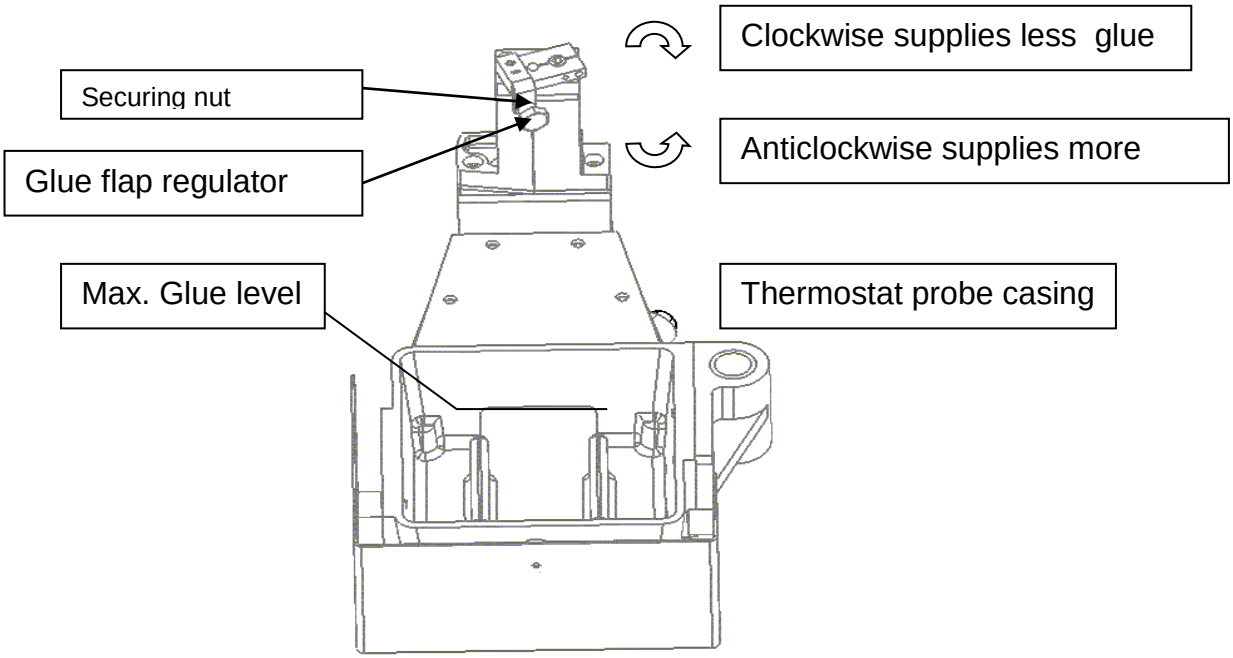
This consists of a roller to glue the band. It must trace 2mm on the board and with no type of extra regulation must dispense the exact amount of glue on the different sizes of board, in terms of both width and height.

Hot-mel adhesive for industrial applications, work temperature 180-200 ºC.

4.1.1 Dispensing glue:

The thickness of glue on the dispensing roller is regulated by the regulator finger on the glue flap.

- TURNING CLOCKWISE REDUCES THE AMOUNT OF GLUE.
- TURNING ANTI-CLOCKWISE INCREASES THE AMOUNT OF GLUE.



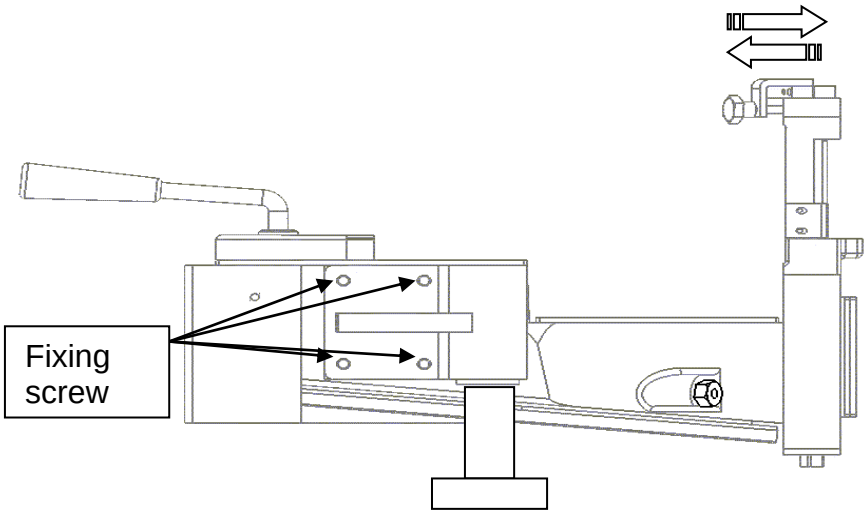
4.1.2 Glue level in the tank:

For correct operation, the level must not cover the access door to the inner tank, because if this happens the gases produced will only be able to escape through the glue nozzle, and this may cause irregularities in the amount of glue supplied to the edge. On the other hand, with a very low level the glue would burn, losing its properties and even forming a layer of encrusted glue that would insulate the glue from the heating resistances in good conditions, leading to an increase in heating time.

4.1.3 Setting up for correct gluing:

If the glue is not evenly dispensed after adjusting and checking the points above, for example if there are parts on the top without glue, the first thing to check is that the panel is being cut square. Then check that the scoring disc has not made too great an incision in the board. If neither of these is the problem, turn the glue pot fixing screws and slope the station forwards if there is not enough glue on the top, and backwards if there is not enough on the bottom. In other words, attempt to get the glue roller and board parallel to each other.

The best way of doing this is first to take the distance between glue nozzle and the wall of the presser, then to slightly loosen the glue pot fixing screws and slope the station as necessary. Then retighten these four screws and measure the distance between nozzle and presser again to check the inclination that the station has been given.



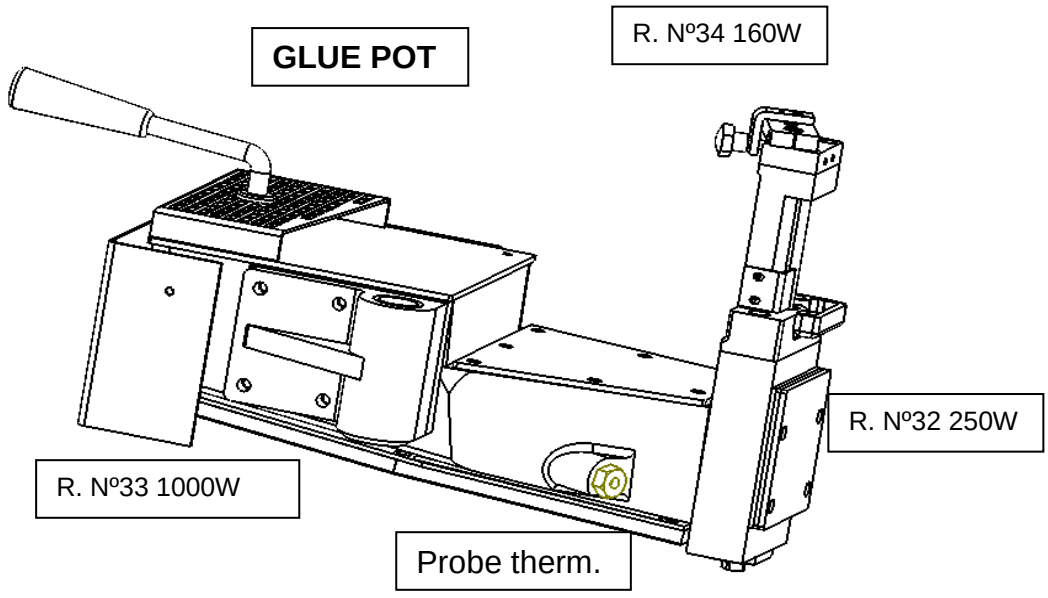
4.1.4 Replacing heating resistances:

Once the tray has been withdrawn, to remove the pot first unplug and take out the thermostat probe, then simply lift until it comes out from the pot swing pin.

GLUE POT M5: From outside it is easier to access the fixing cover for the bottom and front heating resistances (Nº19,22). Having extracted these and the cable through plate (nº42), there is full access to the resistances, which are protected by an asbestos sheet (Nº20,23).

RESISTANCE Nº	RESISTANCE VALUE
32	250 W
33	1000 W
34	160 W

The removal of any element of security installed in the machine absolve the manufacturer of liability for any damage.



4.1.5 Security:

When the edge banding machine alight, the glue pot station it is a high temperature, therefore misuse may cause severe burns. These burns could occur by direct contact with glue pot station or spill hot-melt glue. It may be recalled that the Hot-melt glue in a position to work is at a temperature of 200 ° C approximately. Therefore it is necessary extra precautions when handling the glue pot station.

Only allow the use of the machine to authorized personnel. Glue pot station contains various safeguards to prevent inadvertent contact. These protections are in the machine properly marked in yellow.

4.2 Roller base:

This group has two rollers: one plane roller of larger diameter, and one plane roller smaller diameter.

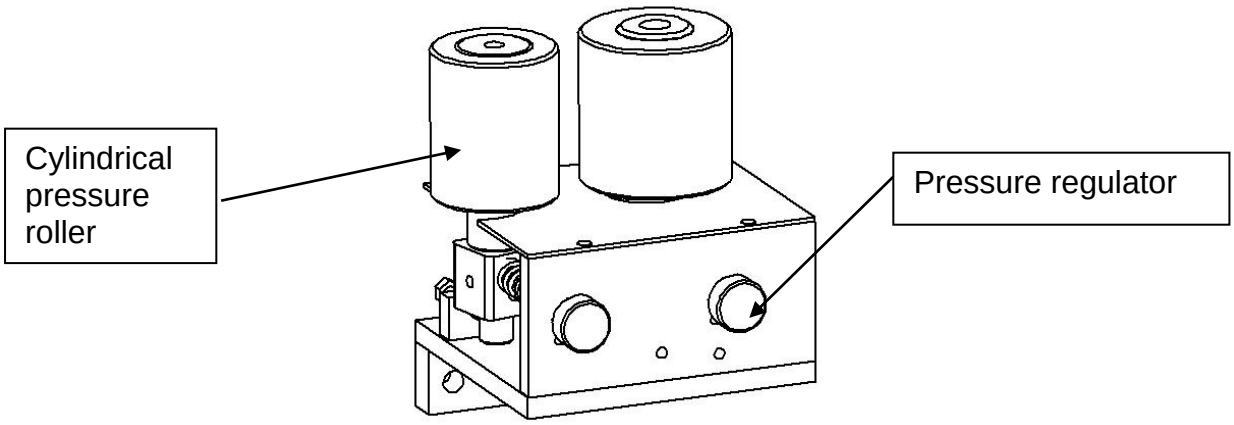
Tracing on the panel with the edge already stuck must not be greater than 1.5mm.

There are two regulators to adjust pressure, one for each roller. Turning clockwise reduces pressure, while turning anti-clockwise increases it. When you change the thickness of the edge gluing. You should act upon pressure regulation.

As mentioned above, for correct edge banding tracing must not be excessive, as excess tracing not only causes the board to move, but also produces a small arc at both the entry and exit of the edged panel. Another small maladjustment that can cause the same problem is too much surplus edging band at the beginning and end of the panel; this should be the minimum possible (for adjustment, see “loading and regulating band in roll form”).

When the thickness of the glued edging band is changed, simply slacken the fixing lever and enter the new measurement in the numerical regulator. Turning clockwise moves the station back, while turning anticlockwise moves it forward.

To avoid the risk of damage, no type of rigid article (blades, chisels, etc.) should be used to clean the rollers. Any dirt that builds up should be removed with a cloth soaked in solvent or other cleaning product.



4.2.1 Security:

For proper handling and cleaning of roller base it is essential disconnection the drag chain, through the selector box controls. Otherwise can cause damage by trapping on the fingers. Roller base are protected to prevent damage by inadvertent contact.

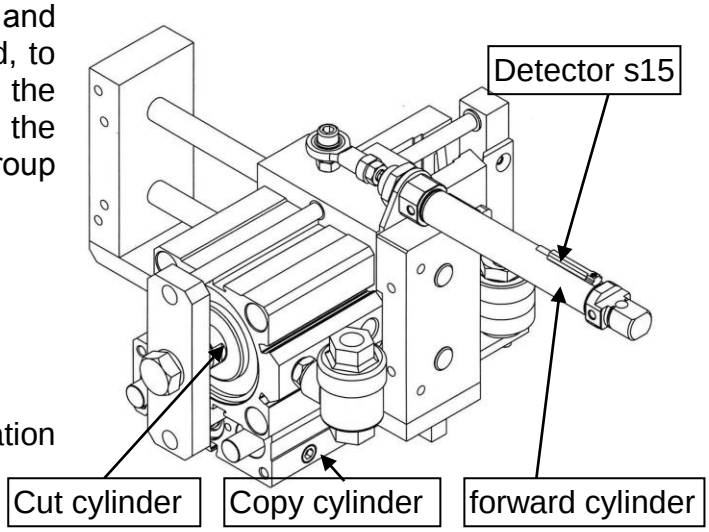
The removal of any element of security installed in the machine absolve the manufacturer of liability for any damage.

4.3 End trimming station EC-1:

Is formed by two pneumatic cylinders and two blades, and its task is to trim off the surplus edging band at both front and back. The whole group is mounted on a linear unit, which makes the front board copied pneumatically.

4.3.1 Pneumatic regulation:

The operation is as follows: • When the board actuates the micro S14, the blade is positioned in front of the board and when the front panel, contact with the blade, cuts off the excess lead. • The cutter block back and move in the opposite direction to the board, to trim the rear. When the board has passed, the accompanying knife and then cut off the excess back from the board. • The group returns to its home position (S15).



MR1	1 bar	Unit Pressure
MR2	2.6 bar	Forward/Backward

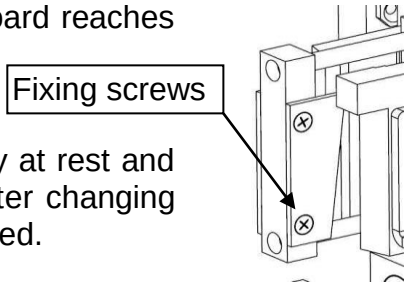
4.3.2 Safety systems:

Within its work program, the station incorporates some safety systems which guarantee that in the event of an inappropriate working condition, the machine stops its task or even stops altogether to avoid damage.

The removal of any element of security installed in the machine absolve the manufacturer of liability for any damage.

4.3.3 Working limits:

The minimum distance between boards must be respected. This is shown on the sticker on the side of the machine: when the back of the board reaches this sticker, the next board can be introduced.



4.3.4 Replacing the end trimmer blades:

First make completely sure that the machine is totally at rest and turned off at the main switch. Remove the fixing screw. After changing blades, always check that the fixing screws are firmly tightened.

Maintenance tools: For optimum cut, the glue remains attached to the blade must be removed (with a cloth moistened with solvent); taking steps necessary security because they are pieces of cut.

4.4 Trimming station:

This is driven by two high frequency motors (200Hz, 12000 r.p.m.), each rated at 0'27 kW.

The station is used to trim the excess strip at both top and bottom exactly, and to provide a radiused or flat finish by a simple, easy adjustment.

4.4.1 Adjustment with flat cutters:

One must keep in mind that for the design of the group the motor will always remain in horizontal position, that is to say, 0º.

For the adjustment you must verify that the group makes so much the one copied vertical as horizontal when passing a panel. To adjust the one trim in the superior group you should act on the vertical regulator of the tracer one, the one which if one makes rotate in having felt clockwise it makes go up the tracer one with what the cutters trims more and if one makes rotate in having felt anti-clockwise the tracer one vertical low with what trims less. For the one recast inferior it should be kept in mind that when making rotate the vertical knob regulator of the tracer one in having felt clockwise the copying one vertical it ascends with what trims less and when making rotate in having felt anti-clockwise the tracer one vertical low with what trims more. next by means of the horizontal knob regulator of the tracer one to make it rotate in having felt schedule so that the tracer one is delayed, being the discovered cutters, with what trims more, or in the case that is wanted that it trims less to rotate this same knob in having felt anti-clockwise so that the tracer horizontal advance.

Due to the position of the motor the regulation of the one trim of radios it was carried out by means of the vertical adjustment of the tracer one and the horizontal tracer, until getting the wanted radius.

4.4.2 Replacing cutters:

To replacing cutters, first disconnect completely the machine with the general switch, to remove the electrical connectors and come in the following way:

Hold the motor firmly with a hand and with the other one it loosens the Screw fixing motor plate completely.

Without loosing the motor it loosens the knob motor regulator completely and move away it following the plate guided to avoid the contact of the cutters with the tracer.

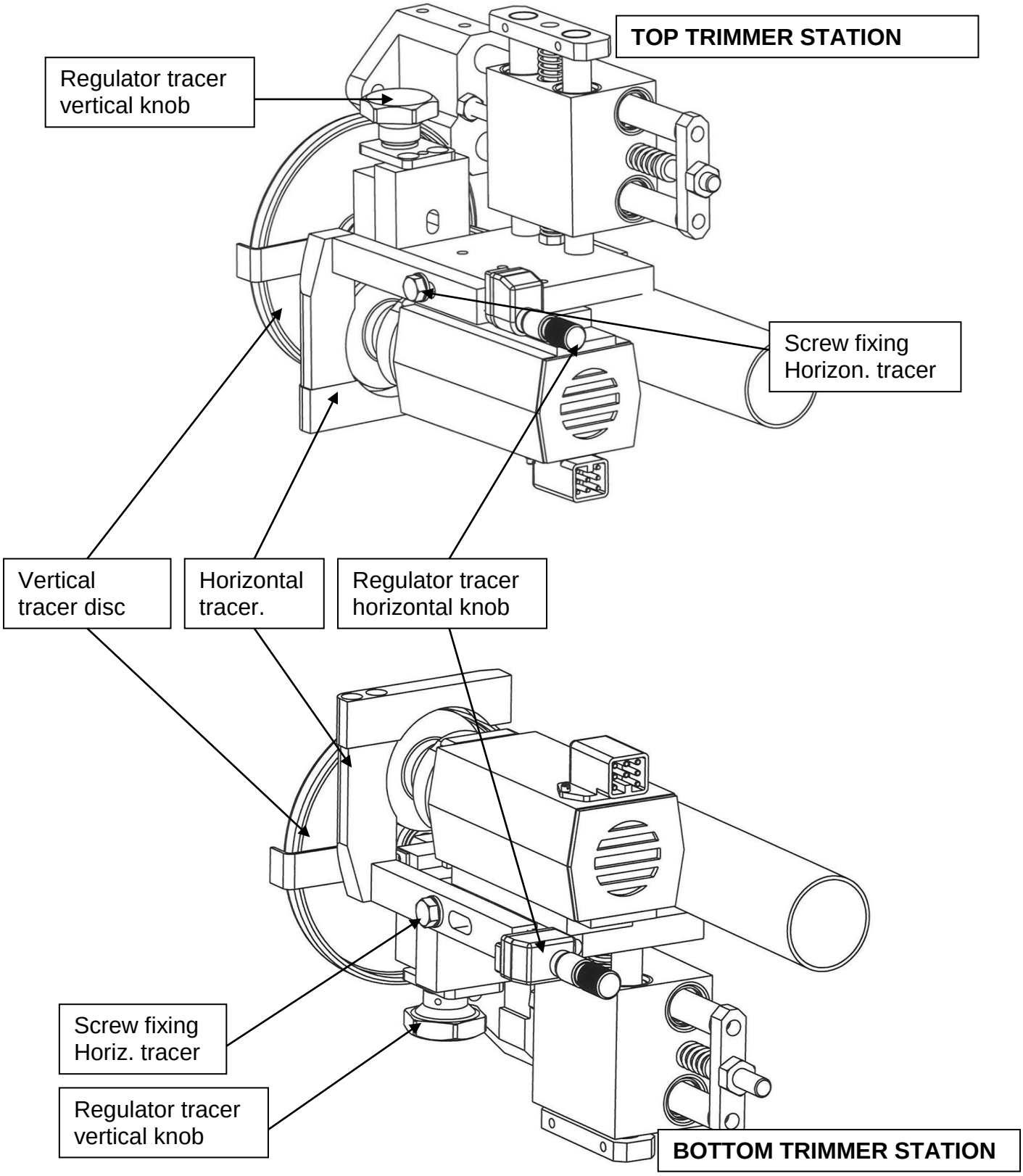
Once it left they can extract the cutters easily with the given tools.

Remember that when mounting the motor again after the cutters change it should make coincide the plate correctly of having guided to avoid a possible break of the cutters in the event of making contact with the tracer.

4.4.3 Security

Trimming station has two blades court under a misuse of the group could cause serious damage.

Therefore, for proper handling trimming station it is essential disconnection of the same. The group incorporates within its programme of work some security systems, which assure us that in the case of having any improper working conditions annulling. **The removal of any element of security installed in the machine absolve the manufacturer of liability for any damage.**



5 MAINTENANCE:

- **THE MACHINE MUST BE FULLY DISCONNECTED BOTH ELECTRICALLY AND PNEUMATICALLY BEFORE UNDERTAKING EITHER ROUTINE OR SPECIAL MAINTENANCE WORK.**

- **THIS PROCESS SHOULD BE CARRY OUT BY WELL EDUCATED WORKER.**

5.1 Routine maintenance:

The maintenance below is carried out daily before running the machine, and consists of:

- Before starting the machine, check that there is nothing obstructing movement of the station and motors that could lead to damage or personal injury.
- Check that pressures are correct.
- Make sure that all micros (the rods) are correctly positioned (vertically, waiting to contact the work piece), that they are firmly tightened and that they move as they should.

These maintenance points are carried out at the close of each working day:

- Clean the work zone.
- Make sure that the main supply cable shows no signs of cuts or burning.
- Check the condition of cutters and tracers.

5.2 Special maintenance:

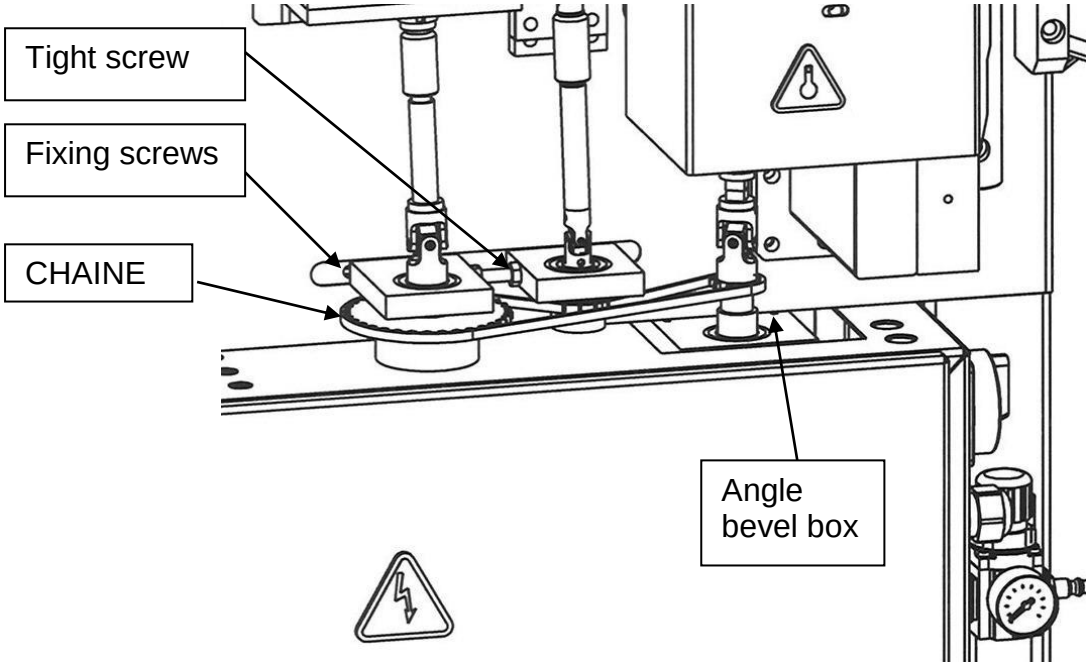
This maintenance is carried out weekly:

- Carry out all routine maintenance operations.
- Check the safety of the electrical installation.
- Check locking of mechanical components.
- Examine cable insulation, operation of devices and continuity of protective conductor.
- Check the cutters for wear.
- Clean the chain wheels and rubbers with a cloth dampened with neutral solvent (that damages neither silicon nor rubber). Do this after lifting the presser, having completely stopped the machine.
- Use a little machine oil (SAE-10) and a cloth to clean the tracer bearings, then dry off and apply a thin film of grease..
- Transport Chain: Take off protection of the chain and apply oil with brush on the chain pieces on contact with chain guide.
- Check the condition and tension of the transmission pinions inside the cabinet under the tray and glue pot.
- Transmission set: This refers to all the equipment under the glue pot whose function is the synchronised transmission of chain movement to the glue roller,

band feed system and first press roller. You need check the chain status. For tight chain you must loose the screws and move the big pinion.

- Glue Pot: Old and burned scraps of glue must be eliminate. Process: “Clean Glue pot” Only for qualified personal.

Chain condition and tension needs periodic checking. The Chain is tensioned by simply loosening the fixing screws and moving the big pinion to achieve the required tensioning.



6 TROUBLESHOOTING:

6.1 Machine does not start:

- Check the machine air inlet pressure (it must be between 6 and 7 bar). If it is lower than 4 bar for even a moment, the machine will stop or fail to start.
- Check that the emergency stops are not activated (the two at the presser ends). If so, turn them smoothly to deactivate them.
- The cabin must be completely closed for the cabin micro to allow machine start-up.
- Check if appear some alarm in DISPLAY control. After checking these, the only remaining check is on the thermal cutout relays. To do this, press the reset buttons; any making a different noise indicates that this particular relay was activated. Make a note of the number (e.g. F-14), and check on the power diagram to see which motor it is protecting. Then examine the motor involved, as a thermal cutout trips because of overworking, unsuitable working or very poor tool condition (the relay is set to the rated consumption of the motor it is protecting, and trips if this consumption is exceeded to avoid damaging the motor).
- Check the fuses and input voltage.

6.2 Irregular band feed:

- First check that machine air inlet pressure is correct (between 6 and 7 bar).
- Carry out a feed and check that the pressure supplied to the pressure piston is approximately 0.9 bar as measured on pressure gauge MR-3 (bear in mind that this usually reads zero, and only gives a pressure reading when actually being supplied, for a time of about 1.5 seconds). If air pressure is too high, the edge is compressed so much that it cannot move forward properly, while insufficient air pressure means the weight of the strip can`t be pulled through.
- Check the condition of the angle bevel box transmission pinion, as it will very probably need tensioning (follow the instructions given in the special maintenance section).
- Feed rollers in poor condition or not correctly positioned (check they are properly fitted in their securing slots).
- Make sure the roll of edging isn`t obstructed in any way that prevents it moving normally (e.g. small strips of adhesive tape stuck to the bottom of the roll and difficult to see at first sight).

6.3 Router trimming diminishes:

- If both chain and wheels are dirty and covered with a layer of dust, they lose their adherence, and bearing in mind that all the stations exert pressure on the board, in the end it is expelled and the tracing station is lost.
- If dirt on the chain and wheels or poor trimming station adjustment means that when the board arrives it is moved, then the start of routing will be traced (trimmed correctly) but as the board passes through it will lose the tracer due to following a non-parallel line. In the end the cutter will be so far separated that proper trimming will be impossible.

6.4 The board moves:

- As the above points have shown, keeping the chain and wheels clean is very important for the piece to keep to the same line. On occasions, when it moves the presser tends to drop. It is certainly possible to tighten a millimetre more with respect to the panel measurement, especially with small pieces, but more than one millimetre would mean overloading the drive motor, possibly to the extent that the thermal cutout trips due to motor overheating. The presser wheels and rubbers would also experience excessive wear, when the solution is simply to clean them.
- It is very important to keep the presser fixing levers tightened to avoid the presser lifting as the board passes through, leading to a loss in pressure making the board very liable to move.
- Check pressure roller tracing. See the “Pressure rollers” section for further details.

6.5 Uneven gluing:

- Read the “Glue pot station” section carefully.
- Check the condition of the glue.
- Check tracing and glue pot pressure. If more tracing is needed, make sure that none of the stations is moving the board before touching the tracer stop screw (see “The board moves” section for further details).
- Process: “Clean Glue pot” Only for qualified personal.