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FESTOOL

Instruction manual - Edge bander

Page 6

IMPORTANT: Read all instructions before using.

Guide d'utilisation - Plaqueuse de chant

Page 20

IMPORTANT: Lire toutes les instructions avant de démarrer les travaux.

Manual de instrucciones - Canteadora

Página 36

IMPORTANTE: Lea todas las instrucciones antes de usar.

**Instruction manual
Guide d'utilisation
Manual de instrucciones**

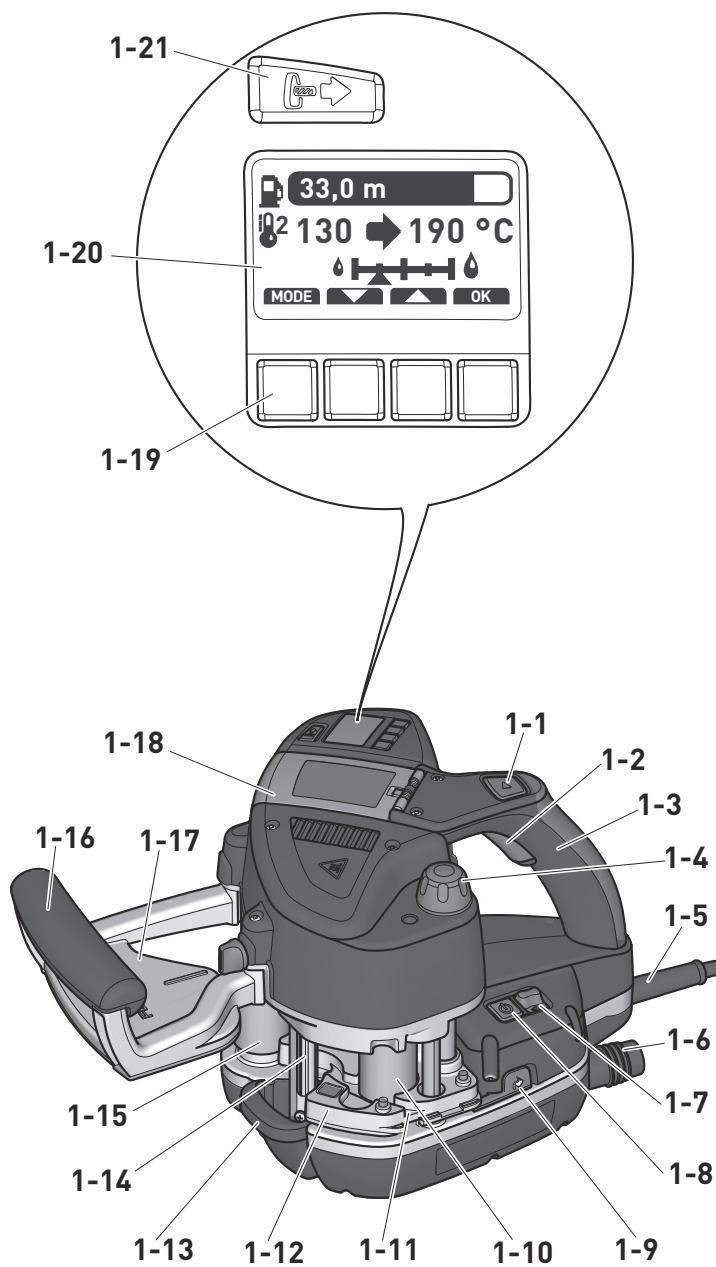
KA 65



707918_001



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About this manual



Save these instructions

It is important for you to read and understand this manual. The information it contains relates to protecting **your safety** and **preventing problems**. The symbols below are used to help you recognize this information.

	DANGER	Description of imminent hazard and failure to avoid hazard will result in death.
	WARNING	Description of hazard and possible resulting injuries or death.
	CAUTION	Description of hazard and possible resulting injuries.

	NOTICE	Statement including nature of hazard and possible result.
	HINT	Indicates information, notes, or tips for improving your success using the tool.

Symbols

V	volts		Warning of general danger
A	amperes		Risk of electric shock
Hz	hertz		Read the Operating Instructions/Notes!
~	alternating current		Wear a dust mask.
a.c.			Wear protective gloves.
---	direct current		Wear protective goggles.
d.c.			CAUTION. Danger of crushing fingers!
n_0	no load speed		Do not throw in the household waste.
	Class II construction		
rpm	revolutions per minute		
min^{-1}			
"	inch		
lb.	pound		
	diameter		
	hint, Tipp		
	Burning risks from hot surfaces!		



Tip or advice



Handling instruction

°C degree centigrade

°F degree Fahrenheit

Nm Newton metre

mm millimetre

Ah amps hour

Wh watt hour



delay fuse with 4 amps

T 4A

Safety instructions

General safety instructions



WARNING! Read all safety warnings, instructions, illustrations and specifications provided with this power tool. Failure to follow all instructions listed below may result in electric shock, fire and/or serious injury.

Save all warnings and instructions for future reference.

The term “power tool” in the warnings refers to your mains-operated (corded) power tool or battery-operated (cordless) power tool.

1 WORK AREA SAFETY

- a. **Keep work area clean and well lit.** Cluttered and dark areas invite accidents.
- b. **Do not operate power tools in explosive atmospheres, such as in the presence of flammable liquids, gases or dust.** Power tools create sparks which may ignite the dust or fumes.
- c. **Keep children and bystanders away while operating a power tool.** Distractions can cause you to lose control.

2 ELECTRICAL SAFETY

- a. **Power tool plugs must match the outlet. Never modify the plug in any way. Do not use any adapter plugs with earthed (grounded) power tools.** Unmodified plugs and matching outlets will reduce risk of electric shock.
- b. **Avoid body contact with earthed or grounded surfaces, such as pipes, radiators, ranges and refrigerators.** There is an increased risk of electric shock if your body is earthed or grounded.
- c. **Do not expose power tools to rain or wet conditions.** Water entering a power tool will increase the risk of electric shock.
- d. **Do not abuse the cord. Never use the cord for carrying, pulling or unplugging the power tool.**

Keep cord away from heat, oil, sharp edges or moving parts. Damaged or entangled cords increase the risk of electric shock.

- e. **When operating a power tool outdoors, use an extension cord suitable for outdoor use.** Use of a cord suitable for outdoor use reduces the risk of electric shock.
- f. **If operating a power tool in a damp location is unavoidable, use a residual current device (RCD) protected supply.** Use of an RCD reduces the risk of electric shock.

3 PERSONAL SAFETY

- a. **Stay alert, watch what you are doing and use common sense when operating a power tool. Do not use a power tool while you are tired or under the influence of drugs, alcohol or medication.** A moment of inattention while operating power tools may result in serious personal injury.
- b. **Use personal protective equipment. Always wear eye protection.** Protective equipment such as dust mask, non skid safety shoes, hard hat, or hearing protection used for appropriate conditions will reduce personal injuries.
- c. **Prevent unintentional starting. Ensure the switch is in the off-position before connecting to power source and/or battery pack, picking up or carrying the tool.** Carrying power tools with your finger on the switch or energising power tools that have the switch on invites accidents.
- d. **Remove any adjusting key or wrench before turning the power tool on.** A wrench or a key left attached to a rotating part of the power tool may result in personal injury.
- e. **Do not overreach. Keep proper footing and balance at all times.** This enables better control of the power tool in unexpected situations.
- f. **Dress properly. Do not wear loose clothing or jewellery. Keep your hair, clothing and gloves**

away from moving parts. Loose clothes, jewellery or long hair can be caught in moving parts.

- g. **If devices are provided for the connection of dust extraction and collection facilities, ensure these are connected and properly used.** Use of dust collection can reduce dust-related hazards.
- h. **Do not let familiarity gained from frequent use of tools allow you to become complacent and ignore, tool safety principles.** A careless action can cause severe injury within a fraction of a second.

4 POWER TOOL USE AND CARE

- a. **Do not force the power tool. Use the correct power tool for your application.** The correct power tool will do the job better and safer at the rate for which it was designed.
- b. **Do not use the power tool if the switch does not turn it on and off.** Any power tool that cannot be controlled with the switch is dangerous and must be repaired.
- c. **Disconnect the plug from the power source and/or battery pack from the power tool before making any adjustments, changing accessories, or storing power tools.** Such preventive safety measures reduce the risk of starting the power tool accidentally.
- d. **Store idle power tools out of the reach of children and do not allow persons unfamiliar with the power tool or these instructions to operate the power tool.** Power tools are dangerous in the hands of untrained users.
- e. **Maintain power tools. Check for misalignment or binding of moving parts, breakage of parts and any other condition that may affect the power tool's operation. If damaged, have the power tool repaired before use.** Many accidents are caused by poorly maintained power tools.
- f. **Keep cutting tools sharp and clean.** Properly maintained cutting tools with sharp cutting edges are less likely to bind and are easier to control.
- g. **Use the power tool, accessories and tool bits etc. in accordance with these instructions taking into account the working conditions and the work to be performed.** Use of the power tool for operations different from those intended could result in a hazardous situation.
- h. **Keep handles dry, clean and free from oil and grease.** Slippery handles do not allow for safe handling and control of the tool in unexpected situations.

5 SERVICE

- a. **Have your power tool serviced by a qualified re-**

pair person using only identical replacement parts. This will ensure that the safety of the power tool is maintained.

Machine-related safety instructions

- **Always hold the machine by the insulated handles because the heating unit and adhesive nozzle can become very hot. Risk of burns!**
- **Always use the machine in well-ventilated rooms.** Otherwise there is a risk that excessive quantities of vapour will develop during work.
- **Do not use the machine for overhead work.** When performing overhead work, there is a danger of hot liquid adhesive dripping on the machine operator.
- **Protect the machine from moisture.** Moisture can cause electric shocks.
- **Protect the cable from heat sources, oil and sharp edges and keep away from hot machine components.** Damage to the cable can cause electric shocks.
- **Check the plug and the cable regularly to avoid hazards and have them replaced by an authorised after-sales service workshop if they become damaged.** A defective plug or cable can cause electric shocks.
- **Do not pull the plug from the socket by the cable.** The plug or cable may become damaged and cause electric shocks.
- **Always use an extension cable with protective earth conductor.** If an extension cable is used without a protective earth conductor, the machine's electrical system is no longer protected, which can cause electric shocks.
- **CAUTION! To provide continued protection against risk of electric shock, connect to properly grounded outlets only.**
- **Always remove melted adhesive cartridges by purging.** Adhesive cartridges that are not melted can be removed by hand.
- **CAUTION! Clean the system no more than six hours after using PU adhesive.** If instructions in the operating manual or other documents accompanying individual machines relating to the connection, installation, commissioning, operation, use and maintenance of machines are not followed, any claim to warranty will be lost.
- **Wear suitable personal protective equipment:** dust mask for reducing the risk of inhaling hazardous vapours, protective gloves for handling hot machine components, safety goggles.
- **The Festool edge bander should always be mounted on work benches using the stationary**

fixture supplied by Festool. The electric power tool may become unsafe and cause serious accidents if installed in benches from other manufacturers or self-manufactured work benches.

- **Always use original Festool accessories and adhesive cartridges.** Only products tested and approved by Festool are harmless to health and

perfectly adapted to the machine and application. Please refer to the safety data sheet for additional specifications. See Festool catalogue or www.festool.com.

- **Observe national safety regulations!**

Technical data

Edge bander		KA 65
Power		1050 W
Power supply		120 V~
Mains frequency		60 Hz
Edge height		18 - 65 mm (0.7 - 2.6") *
Edge thickness		0.5 - 3.0 mm (0.02 - 0.1") *
Inner radius		> 50 mm (2.0") *
Heating time		approx. 8 min
Default melting temperature setting	Setting 1	190 °C
	Setting 2	200 °C
Melting temperature setting range	Setting 1/2	100 - 210 °C
Feed speed	1st gear	2 m/min
	2nd gear	4 m/min
Safety class		I
Weight (without adhesive cartridges and mains cable)		7.9 kg (17.4 lbs)

* Depending on material

Functional description

The pictures for the functional description are on a fold-out page at the beginning of the instruction manual. While reading the manual you can fold out the page for comparison and quick reference.

- [1-1]** Start button
- [1-2]** Feed speed button
- [1-3]** Handle
- [1-4]** Rotary knob for adjusting the edge height
- [1-5]** Mains power cable
- [1-6]** Extractor connector
- [1-7]** Switch for temperature selection
- [1-8]** On/Off switch
- [1-9]** Safety lever for purging

- [1-10]** Inlet roller
- [1-11]** Edge inlet
- [1-12]** Central plate
- [1-13]** Drip catcher
- [1-14]** Adhesive nozzle
- [1-15]** Contact roller
- [1-16]** Handle
- [1-17]** Support base with start marking
- [1-18]** Flap
- [1-19]** Menu buttons
- [1-20]** Display
- [1-21]** Refill button

Accessories shown or described are sometimes not included in the scope of delivery.

Intended use

The edge bander is suitable for:

- Attaching edge bands made of wood, materials similar to wood and plastic using **Festool adhesives**.



WARNING

The user bears the responsibility for damage and accidents caused by improper use; this also includes damage and wear caused by continuous use in industry.

Operation



WARNING

Unauthorised voltage or frequency!

Risk of accident

- ▶ The mains voltage and the frequency of the power source must correspond with the specifications on the machine's name plate.
- ▶ In North America, only Festool machines with the voltage specifications 120 V/60 Hz may be used.

Initial operation

- ▶ Remove protective foil from underneath the support base [1-17] and display [1-20].



The machine may generate large quantities of smoke and a pungent odour when operated for the first time.

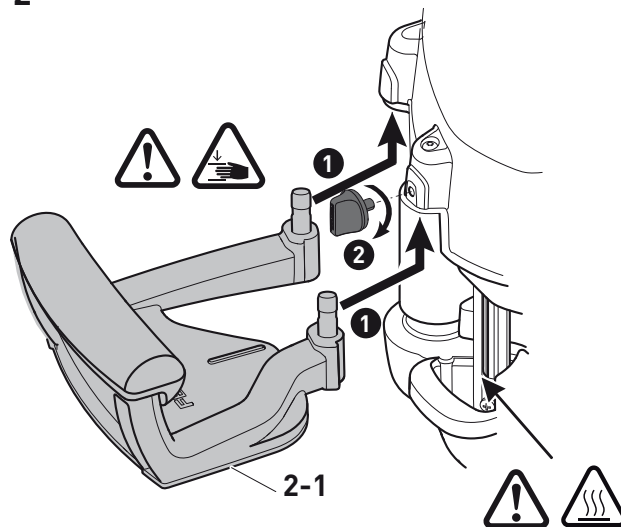


Do not use the machine and working materials below 15 °C. Recommendation: room temperature.

Preparing for operation

- ▶ Install the support base [2].

2



- ▶ Insert the plug into an earthed socket.
- ▶ Insert a minimum of two adhesive cartridges in the magazine (**chapter** Refilling an adhesive cartridge [6]).
- ▶ Set the heating temperature for the relevant adhesive cartridges.

Temperature selection [1-7] according to the default setting:

Setting 1 = 190 °C

Setting 2 = 200 °C



The temperature can be adjusted by pressing the menu buttons [1-19] (**chapter Menu buttons [1-19]**). After independent changes are made, the last temperature used is automatically

saved to the selected setting and replaces the default setting.

Switching on

- Press the on/off switch **[1-8]** once and hold until the Festool logo appears on the display **[1-20]**.

*The machine increases the temperature in heating mode until the setpoint temperature is reached (display **[1-20]** lights up red).*

*Machine switches to warming phase (display **[1-20]** flashes red/green).*

*Machine is ready for operation (display **[1-20]** lights up green).*

NOTE

Do not leave the machine unattended!

- When taking a break of less than 15 minutes, switch the machine to cooling mode (chapter Switching off).
- When taking a longer break, switch off the machine completely.

Switching off

- Press the on/off switch **[1-8]** < 1 s

The machine reduces the temperature in cooling mode and then switches off.

*Display **[1-20]** lights up red, fan symbol is displayed.*

- Press the on/off switch **[1-8]** and hold > 1 s

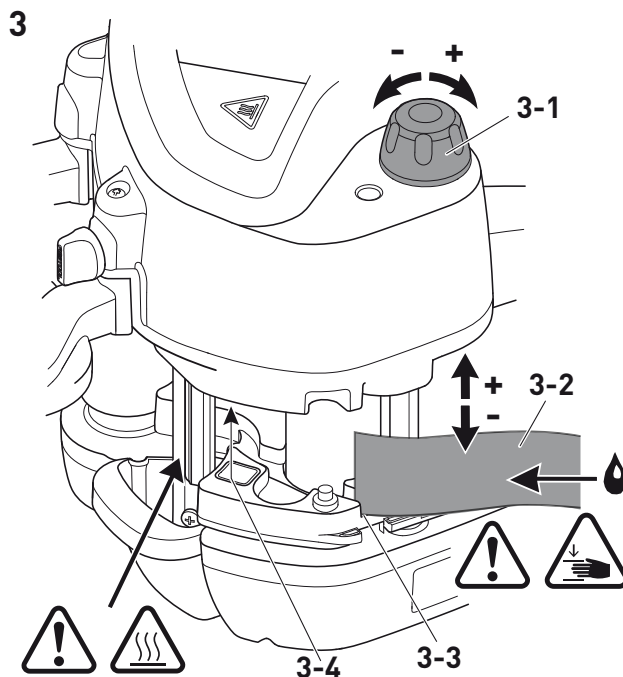
The machine switches off immediately.

Settings

Adjusting the edge height [3]



The edge height can only be adjusted **at operating temperature!** Ignoring this instruction may result in machine damage.



- Guide the edge band **[3-2]** into the edge inlet **[3-3]**.
- Use the rotary knob **[3-1]** to adjust the height of the edge inlet **[3-3]** until the edge band **[3-2]** rests against the top and bottom of the inlet.
- Turn back the rotary knob by one locking position so that the edge band **[3-2]** can slide through smoothly without becoming caught.

Adapting the adhesive quantity

The necessary adhesive quantity is automatically adjusted to the current edge height.

Press the menu buttons **[1-19]** to adapt the adhesive quantity (layer thickness) to different work-piece materials (**chapter Menu buttons [1-19]**).

Selecting the feed speed

The feed speed can be adjusted and adapted to the contour of the workpiece at any time by pressing the button **[1-2]**.


1st gear = 2 m/min



2nd gear = 4 m/min

Menu buttons [1-19]

The following settings can be modified using the menu buttons **[1-19]**:






- Adhesive quantity
- Setpoint temperature
- Units of measurement










 If no menu buttons are pressed within 10 seconds, the menu is closed automatically and the changes are discarded.

MODE	Mode button Press the button to select the value you wish to change (flashes).
 	Arrow buttons The selected value can be adjusted.
OK	OK Press <OK> to save any changes.

Display [1-20]

The current settings and information graphics are shown on the display **[1-20]**.

 	Temperature selection [1-7] Setting 1 (190 °C) / Setting 2 (200 °C)
  	Feed speed[1-2] 1st gear (2 m/min) / 2nd gear (4 m/min)
°C/m, °C/ft, °F/ft, °F/m	Units of measurement Select from °C/m, °C/ft, °F/ft or °F/m. °C = degrees Celsius m = metres °F = degrees Fahrenheit ft = feet

 33,0 m	Remaining edge length** Edge band length in relation to the remaining quantity of adhesive.
	Adhesive quantity Setting for the required adhesive quantity.
130 ➔ 190 °C	Actual and setpoint temperature Display [1-20] lights up red during heating mode.
190 °C	Setpoint temperature Ready for operation, display [1-20] lights up green.
	Refill button [1-21]pressed Adhesive feed is reversed for refill process.
	Open flap [1-18] Adhesive feed was reversed for refill process. Flap [1-18] can be opened.
	Insert adhesive cartridges The magazine can be refilled with adhesive cartridges.
	Close the flap [1-18] Work can continue after the flap [1-18] is closed.
	Refill process complete Adhesive feed moves forward and pressure builds in the adhesive cartridges.
	Edge inlet ready Guide the edge band into the edge inlet [1-11] within 20 seconds. The remaining time is displayed. If the edge band is not inserted within the specified time, the start button [1-1] must be pressed again.
	Edge band to start position Now press the start button [1-1] to glue the edge band. The inlet starts up and transports the edge band through the machine.

	Remove the edge band An edge band was detected when the machine was switched on. Request for removal of the edge band. Press the start button [1-1] and hold until the edge band has passed through.
	Purging position reached Central plate [1-12] has been lowered completely and moved to purging position.
	Purging process starts Start button [1-1] was pressed. The purging process starts after one second.
	Purging process is carried out Adhesive nozzles are open, pressure has built in the adhesive cartridges. Display of the current status.
	Cooling mode The machine reduces the temperature in cooling mode and then switches off. Cooling mode is activated when: <ul style="list-style-type: none"> – on/off switch [1-8] is pressed < 1 s – no controls are actuated for more than 15 minutes The machine is switched on again by pressing the start button [1-1] or the on/off switch [1-8] .

	Fault symbol Troubleshooting (chapter).
--	--

** Automatic calculation of currently detected edge height

Dust extraction



CAUTION

Vapours emitted during the glueing process!

- Ensure there is good ventilation.
- Use an extractor.
- Always observe national regulations.

An extractor hose with a diameter of 27 mm can be attached to the extractor connector **[1-6]**.

Working with the machine



WARNING

High temperatures on the heating unit and adhesive nozzle!

Risk of burns when touched

- Wear suitable protective gloves.
- Always hold the machine by the insulated handles **[1-3]**, **[1-16]**!



WARNING

Moving workpiece!

Risk of injury from sliding workpiece

- Always secure the workpiece in such a manner that it cannot move.



CAUTION

Hardened PU adhesive has settled inside the machine.

Risk of damage to the machine – loss of warranty

- Clean the system no more than six hours after using PU adhesive (**see section** Purging to remove PU adhesive from the machine).

Glueing the edge band

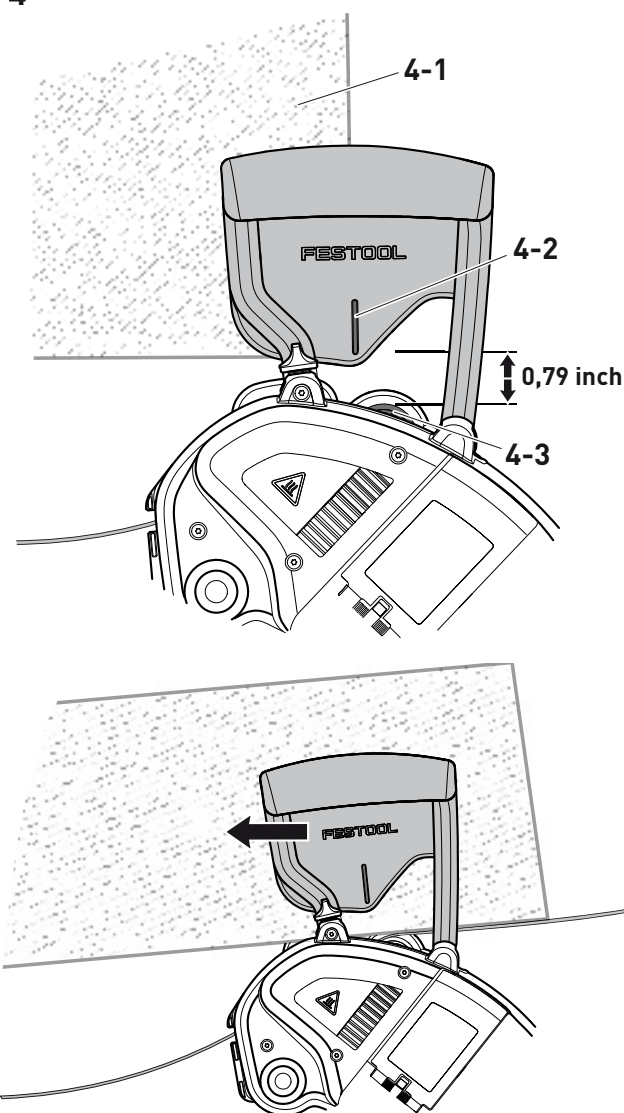
- Cut the edge band down to size, leaving an allowance of approximately 10 cm.
- Switch on the machine **[1-8]**.
- Select the temperature setting **[1-7]**.
*Display **[1-20]** lights up red = actual and set-point temperature are displayed. Machine is not yet ready for operation.*
*Display **[1-20]** lights up green = operating temperature reached. Setpoint temperature is displayed.*
Machine is now ready for operation.
- Adjust the relevant settings (**chapter** Settings).
- Press the start button **[1-1]** once.
Edge inlet mechanism starts up.
- Guide the edge band into the edge inlet within 20 seconds **[1-11]**.
*The time remaining is shown on the display **[1-20]**.*
*The edge band is drawn in automatically up to the light barrier **[3-4]**.*
Inlet stops.
- Position the machine on the workpiece **[4-1]** approx. 2 cm away from the contact roller **[4-3]** with reference to the start marking **[4-2]** **[4]**. The start marking **[4-2]** and edge of the workpiece must be flush with one another.
- Press the start button **[1-1]** again.
Inlet starts.
Wait until the edge band with adhesive is visible.
- Push the machine down onto the workpiece and guide lengthways from right to left **[5]**. Exert

pressure on the support base and against the workpiece. Applying pressure in the feed direction is not necessary.

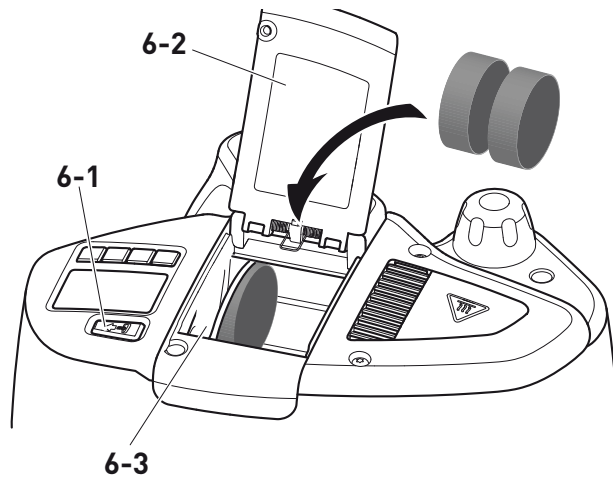
The edge feed mechanism moves the machine forwards automatically.

Once the edge band has passed through the feed completely, the mechanism stops automatically after a short delay.

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Refilling an adhesive cartridge [6]



- ▶ Press the refill button [6-1].
Adhesive feed [6-2] moves back.
- ▶ Open the flap [6-3].
- ▶ Insert adhesive cartridges in the magazine.
- ▶ Close the flap [6-3].
- ▶ Wait until the adhesive feed [6-2] mechanism has moved forward and pressure has built up in the adhesive cartridges.

The refill process is complete, machine operation can resume.

Purging of adhesive cartridges



WARNING

Adhesive may escape immediately after actuating the safety lever [1-8] and simultaneously lowering the central plate [1-12] (purging position)! Risk of burns, damage to property from hot adhesive

- ▶ Remove the drop catcher and place a larger container such as a cardboard box under the machine.
- The colour of adhesive cartridges is changed
- Changing from EVA to PU adhesive
- Purging PU adhesive from the machine using cleaning cartridges

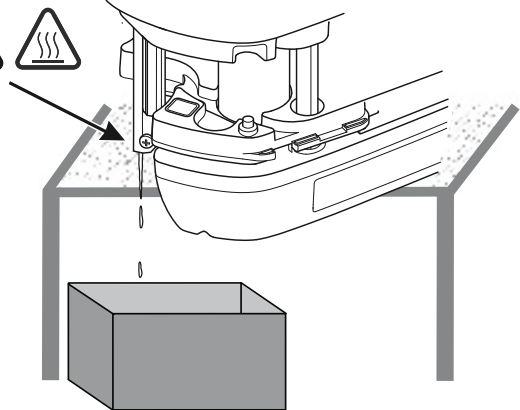
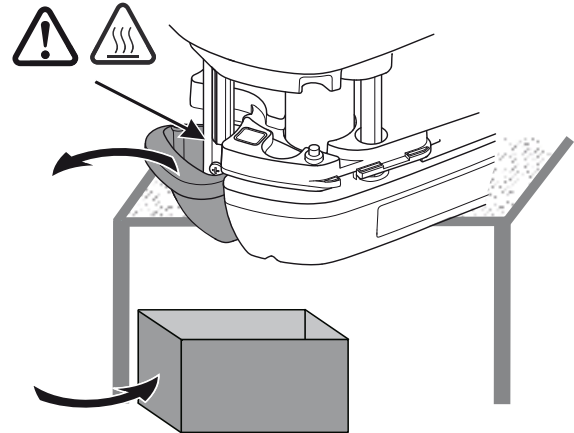


Approximately three adhesive cartridge are required to purge the machine completely.



If necessary, press the refill button [1-21] for other adhesive cartridges and repeat the procedure.

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- ▶ Position the machine at the edge of the bench [7].
- ▶ Remove the drop catcher [1-13].
- ▶ Place the container for catching hot adhesive into position.
- ▶ Press the refill button [1-21].
Adhesive feed moves back.
- ▶ Open the flap [1-18].
- ▶ Remove all the adhesive cartridges.
- ▶ Insert new adhesive cartridges.
- ▶ Close the flap [1-18].
- ▶ Set the edge height to maximum using the rotary knob for adjusting the edge height [1-4].
- ▶ Actuate the safety lever for purging the machine [1-9] while simultaneously turning the rotary knob for adjusting the edge height [1-4] clock-

wise until the central plate **[1-12]** rests against the bottom of the machine.

Purge position is reached.

- ▶ Press the start button **[1-1]** and hold > 1 s.
The purging preparation symbol appears on the display [1-20]. The process starts after 1 s.
- ▶ Continue purging until new adhesive appears in the adhesive nozzle **[1-14]**.
Adhesive nozzles are open, pressure has built in the adhesive cartridges.
The purging symbol appears on the display [1-20] together with a status indicator.
- ▶ Interrupt purging: press the start button **[1-1]** again.
Adhesive nozzles are open, pressure stops building in the adhesive cartridges.
- ▶ Stop purging and leave purging position: turn the rotary knob for adjusting the edge height **[1-4]** clockwise.
Central plate moves upwards, adhesive nozzles are closed, pressure stops building in adhesive cartridges. Display [1-20] indicates normal standby status.
- ▶ Insert the drop catcher **[1-13]** again.

Special instructions on working with PU adhesive

- ▶ Pre-program the temperature settings to 140 °C and 190 °C (**see section** Preparing for operation).
- ▶ Set the temperature to 140 °C.
- ▶ Open the tin of PU adhesive using a tin opener and remove the adhesive cartridge.
- ▶ Remove the paper liner surrounding it.

- ▶ Insert the cartridge as normal and glue the edges.



The PU adhesive cartridge must be pressed completely through the system in order to entirely fill the system with PU adhesive.

Purging to remove PU adhesive from the machine



Directly after completing the work, or six hours afterwards at the latest, purge the system in order to prevent a chemical reaction from taking place within the system.

- ▶ Switch the machine to purge mode (**see section** Purging of adhesive cartridges).
- ▶ Set the temperature to 140° C.
- ▶ Insert a purging cartridge and purge the entire system.
- ▶ Reset the temperature to 190° C.
- ▶ Purge the system using at least three EVA adhesive cartridges until all the purging material has been removed from the machine and the system is completely full of EVA adhesive.

After finishing work

- ▶ Switch off the machine and allow to cool.
- ▶ If necessary, clean the adhesive nozzle **[1-14]** carefully using a strip of wood. Do not use metallic or highly flammable materials!
- ▶ Remove the drip catcher **[1-13]** and turn upside down to clean.

Observe the following instructions:

- Allow the **machine to cool completely** before placing in a Systainer.
- Do not transport the machine in purging mode otherwise adhesive may escape.

Service and maintenance



WARNING

Any maintenance or repair work that requires opening of the motor or gear housing should only be carried out by an authorised Customer Service Centre (name supplied by your dealer)!

- ▶ Maintenance or repair work carried out by an unauthorised person can lead to the wrong connection of the power cord or other components, which in turn can lead to accidents with serious consequences.



WARNING

To prevent accidents, always remove the plug from the power supply socket before carrying out any changes or maintenance work on the tool!

- ▶ Do not use compressed air to clean the electrical tool! Do not try to clean parts inside the tool in this way, as you could let foreign objects in through the openings of the tool housing.



CAUTION

Certain cleaning agents and solvents are harmful to plastic parts.

- Some of these include, but are not limited to: Gasoline, Acetone, Methyl Ethyl Ketone (MEK), Carbonyl Chloride, cleaning solutions containing Chlorine, Ammonia, and household cleaners containing Ammonia.
- Always keep the machine clean. Read **chapter Purging of adhesive cartridges** and **After finishing work!**
- If the plastic sliding plate **[2-1]** (wear part) is damaged, the plate can be replaced by loosening the 4 screws underneath the support base **[1-17]**.

- Keep the ventilation slits on the electric power tool clean and unobstructed to guarantee adequate cooling.
- Store in a cool location that is free of dust.



Customer service and repair only through manufacturer or service workshops: Please find the nearest address at: www.festoolusa.com/service



Use only original Festool spare parts! Order No. at: www.festoolusa.com/service

Accessories

Use only original Festool accessories and Festool consumable material intended for this machine. These components are designed specifically for this machine. Using accessories and consumable material from other suppliers will most likely affect the quality of your results and limit warranty claims. Machine wear or your own personal workload may increase depending on the application. Protect yourself and your machine, and preserve your warranty claims by always using original Festool accessories and Festool consumable material!

The order numbers of the accessories and tools can be found in the Festool catalogue or on the Internet under "www.festoolusa.com".

Systainer

Many Festool products are shipped in a unique system container, called "Systainer". This provides protection and storage for the tool and accessories. The Systainers are stackable and can be inter-

locked together. They also can be interlocked atop Festool CT dust extractors.

To open the Systainer



Turn the T-loc **[8-1]** to this position.

To lock the Systainer



Turn the T-loc **[8-1]** to this position.

To connect two Systainers

Place one Systainer on the top of the other (Fig. **[8A]**).

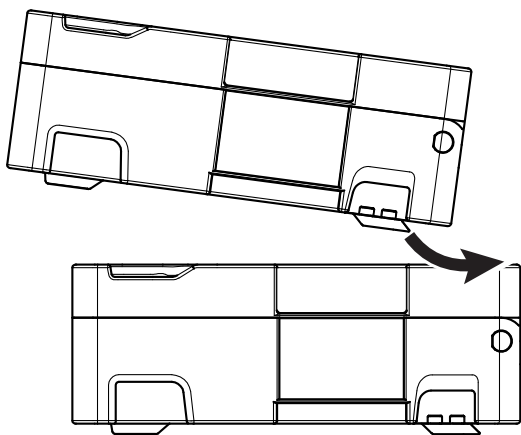


Turn the T-loc **[8-1]** to one of this positions (Fig. **[8B]**).

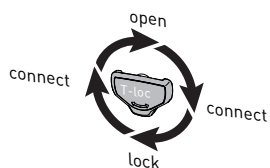
The Systainers are connected and locked.

- ① A new generation Systainer is connectable on top of a previous generation Systainer by the four latches of the previous Systainer.

8

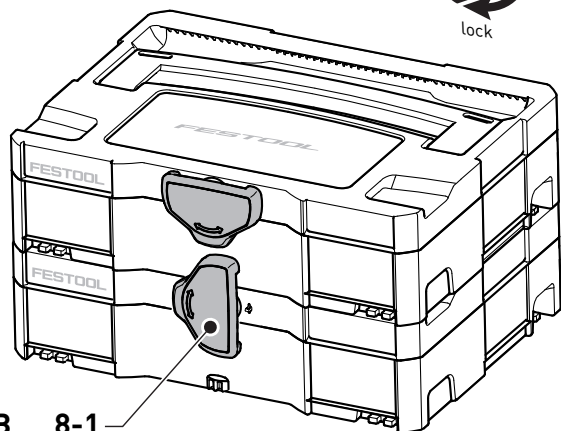


A



B

8-1



Environment

Do not dispose of the device as domestic waste!
Dispose of machines, accessories and packaging at

an environmentally responsible recycling centre.
Observe the respective national regulations.

Troubleshooting

Problem	Possible causes	Remedy
Machine stops operating.	Flap [1-18] is open. The supply of adhesive stops if the flap is opened during operation. However, the feed mechanism continues to operate.	Close the flap [1-18] .
	Error message (appears on the display [1-20]): edge band not yet inserted.	Remove the edge band.

Problem	Possible causes	Remedy
The machine switches off.	The machine is in cooling mode < 50 °C	Press the start button [1-1] to switch on the machine again.
Display lights up red.	The machine switches to cooling mode after an idling time of 15 minutes.	Press the start button [1-1] to switch on the machine again.
Inlet switches off before the edge band is inserted.	The time window of 20 seconds has been exceeded.	Press the start button [1-1] to start the drive again.
Inlet does not switch off even though the edge band has passed through the machine.	Light barrier [3-4] is dirty.	Clean the light barrier [3-4] carefully.
The display shows the prompt to remove the edging although no edging is inserted.		
Edge band does not adhere.	Surface dirt/nozzle holes are blocked.	Initiate the purging process to remove any dirt (chapter Purging of adhesive cartridges).
		If the contamination is more severe, raise the central plate completely and pierce the lower nozzle holes during operation.
Adhesive too runny/too firm, too much/too little	Incorrect temperature, incorrect amount of adhesive set.	Adjust temperature to adhesive cartridges used using the menu keys [1-19] . – Adhesive too runny: Temperature -10 °C – Adhesive too firm: Temperature +10 °C If required, adjust amount of adhesive with [1-19] .
Insufficient adhesive applied to thin edge bands (approx. 0.5 - 0.8 mm depending on material) at the start of glueing	Lack of edge band pressure on the adhesive nozzle.	At the start of gluing, place an additional piece of edge band (approx. 20 cm) with the same edge height behind the main edge band. This additional piece is guided into the edge inlet after the edge band.
Error symbol appears on the display [1-20] .	The machine electronics have detected a serious error.	Switch off the machine by pressing the on/off switch [1-8] and allow to cool for a few minutes. Switch on the machine again by pressing the on/off switch [1-8] . If the error symbol appears again, contact after-sales service.