

Virutex Edge Banders Operating Manual Model EB-10

1- Initial set up

2- Learn the machine (do not turn the machine on)

- A- Feeding the tape in, adjusting for different tape widths
- B- Feeding the board and adjusting for board thickness
- C- Back cut blade sets
- D- Top+Bottom motorized flush trim station

3- Control panel

4- Power feeder

5- Test runs to find the right temperature

6- Cleaning the machine

7- Banding curved panels

1- Initial Set up (15 minutes)



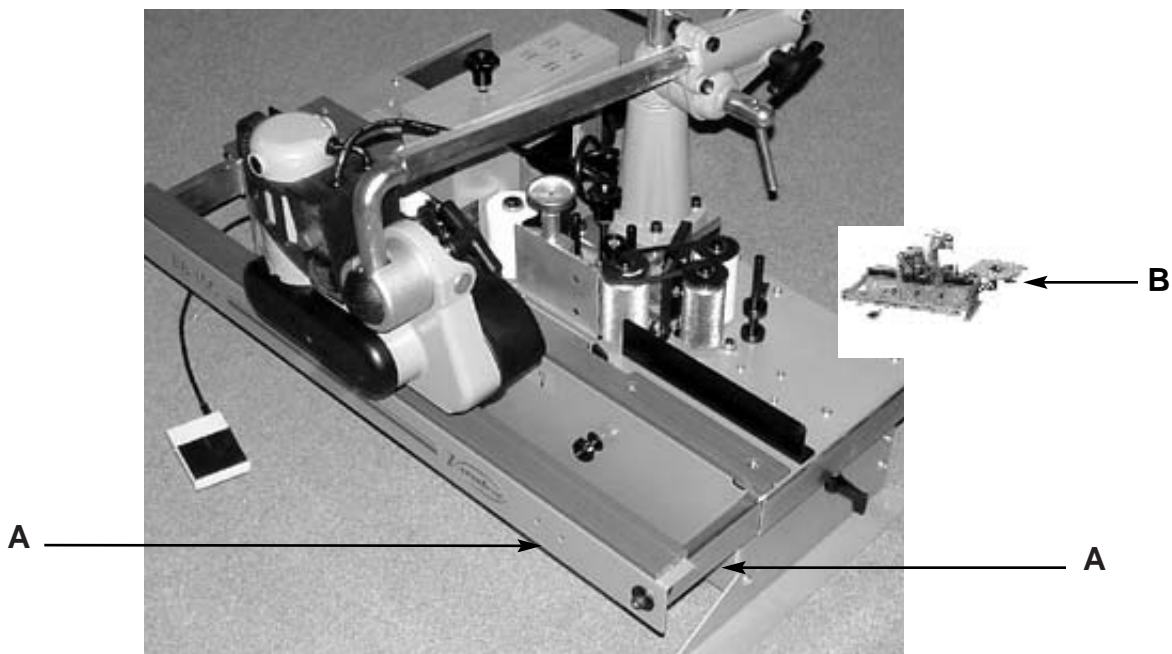
A - Install front fence lateral extensions and two cross bars



B Install bracket and tape Tray



C- Wire the blue plug
220 Volts single phase 15 Amps

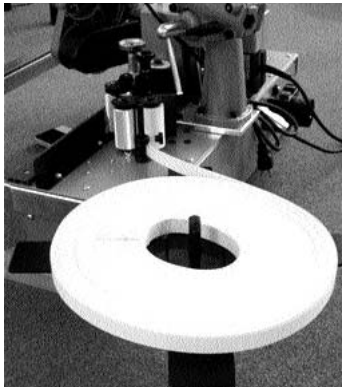


2- Learn the machine (do not turn the machine on)

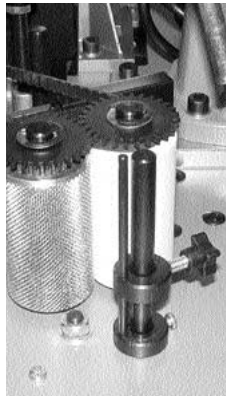
It takes about 15 minutes to learn different functions of the machine. Do not turn the machine on. feed the tape in, swing open the feeder. Take a board trough the machine, as if you are the feeder, and see how every thing works in an open and slow mode.

- A- Feeding the tape in, adjusting for different tape widths
- B- Feeding the board and adjusting for board thickness
- C- Back cut blade sets
- D- Top+Bottom motorized flush trim station

A- Feed the tape into machine



Place the roll on tape holder



Knob **A** should be about 1/16" above the tape to regulate height movement



Stop the tape at the tip of the back blade set located under the protective cover

B- Feeding the board and adjusting for board thickness

The machine is pre-set at the factory for 3/4" wide board which requires 7/8" wide tape. **The tape must always be 1/8" wider than the board.**

It would take less than 5 minutes to adjust the machine for different board thickness. To make adjustments::



Tape Tracking Guide

Move top black knob up or down to be 1/16" higher than the tape. Top & bottom tracks prevent tape from moving up or down & should hug the tape loosely. Push tape trough tracks manually to assure smooth pass



Top & Bottom Trim Station

Turn knob for a tight hug of the board. Need not be precise Spring loaded bearing guides self adjust blade heights. See page 4 for details



Power Feeder

Adjust the height of the feeder. Refer to separate feeder instruction manual. We recommend speed of 12 to 15 feet per minute.

Board & tape infeed system

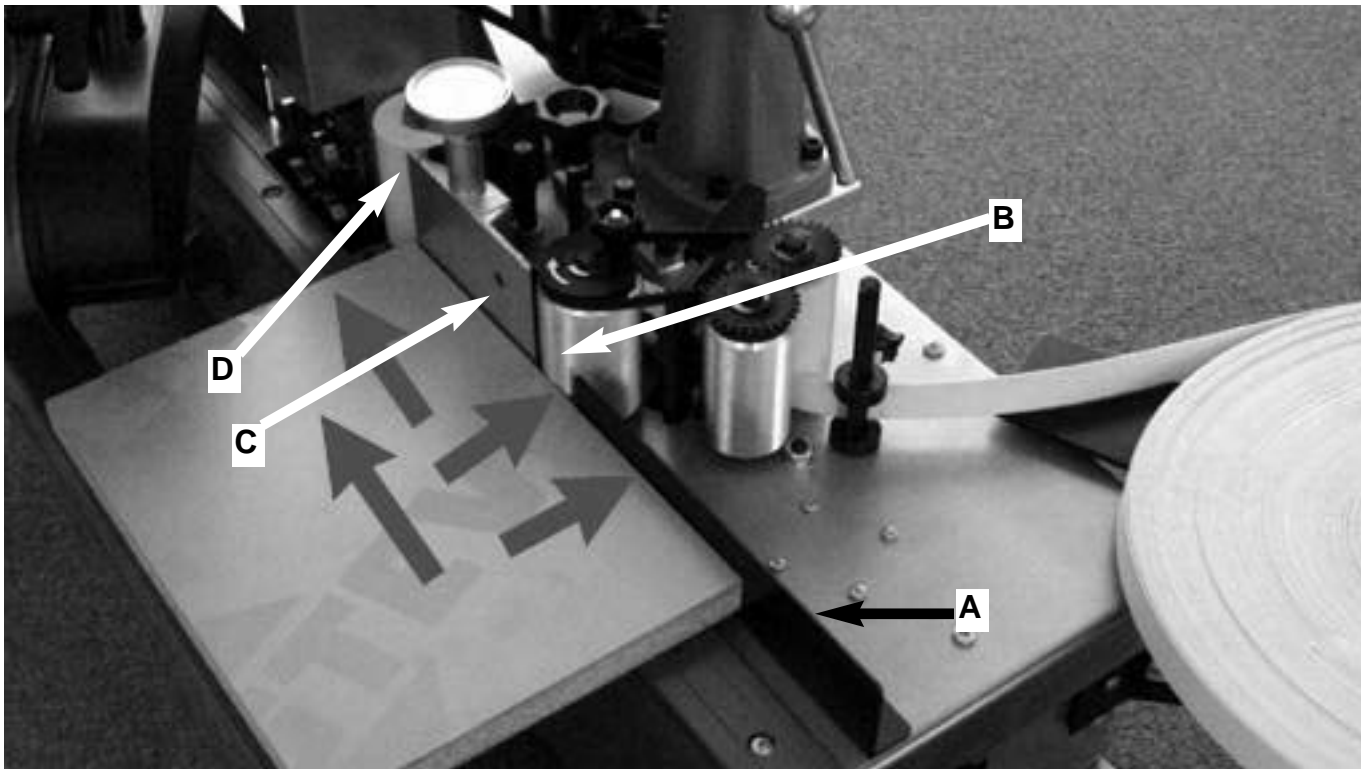
The power feeder takes the board through the machine automatically.

BUT

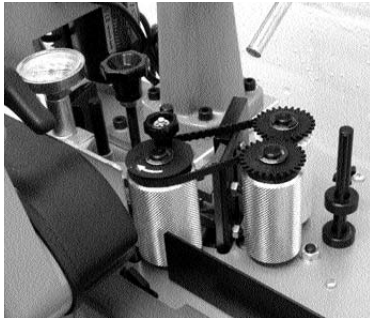
We recommend you first take the board through the in-feed section by hand.
This way you can see how the board is pulling the tape into the machine.

- 1- Shut down the main switch and open the power feeder.
- 2- Push the board against the metallic fence **A** and move forward as shown with arrows.
The board should be pushed left into the machine, and yet be pressed completely against the fence **A**
The board will then hit and turn the metallic roller **B** which activates the infeed of tape.
The entire length of board should press against the metallic roller **B**
- 3- Metal plate **C** pre-heats the board without direct contact.
- 4- The tip of the board will then pick up the tape right at rubber roller **D** and will continue to pull the tape from there on. The glue is already melted when the tape reaches roller **D**
- 5- The board will then enter the top+bottom motorized trimming station.

Do not take the board into the top+bottom trimming station manually.
You will find it hard to push the board manually through the top+bottom bearing guides of trimming station because a tight grip is required.
However, the power feeder will do that with no problem.
This station is pre-set at the factory for 3/4" thick board, and 7/8" tape.



C- Back cut blade set



Back cut blade set includes a fixed and a movable blade and are under the protective cover as show on the picture. They activate once the board passes over the first micro switch lever on the deck. When the lever pops up, the magnet (located below the deck under the blade) closes the open blade. A spring, under the deck will return the blade back to open position.

To reach the return spring on the back cut blade set, turn the machine up side down, open the bottom fence and reach different parts.

D- Top & bottom motorized flush trim station



This trim station is pre-set at the factory for 3/4" thick board.

To adjust for different board thickness, use the top black knob to increase or reduce the distance between the blades. The 2 top and 2 bottom spring loaded guide bearings move the blades according to any slight variations in thickness of the board.

A set of scrapers constantly clean the glue off of the bearing guide rollers. Non-stick sprays can be used to keep the blades clean from glue build up. Virutex brand Silicon free spray keeps the blades clean. Silicon free is recommended in case lacquering is needed. It is important to keep the machine clean and blades free of glue build up.

The machine also does not have a buffing station, and clean up of glue line may be needed after the edge is banded.

Changing Carbon Brushes

Take out trim station, remove covers per pictures shown below. Remove motor end cap, and replace carbon brushes



Blades for top & bottom trim station

The two blades, can be resharpened.

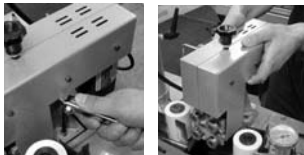
Video instructions show how to change the blades

What activates the trim station

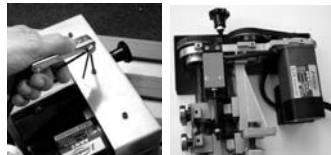
To have less noise, and less wear on the motor, the trim station activates only when the board opens bearing rollers **A**. Once the rollers are pushed apart, They push bar **B** to make contact with switch box **C** and activate the motor.

The bearing guides should always give a very tight hug to the board. After several height adjustments, you see motor not activating, first use the top black knob to make sure the bearing guides grip the board tightly. If that does not work, you

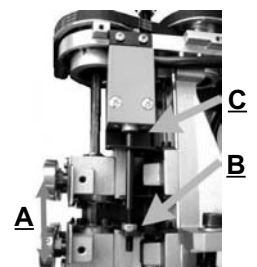
1- Remove trim station



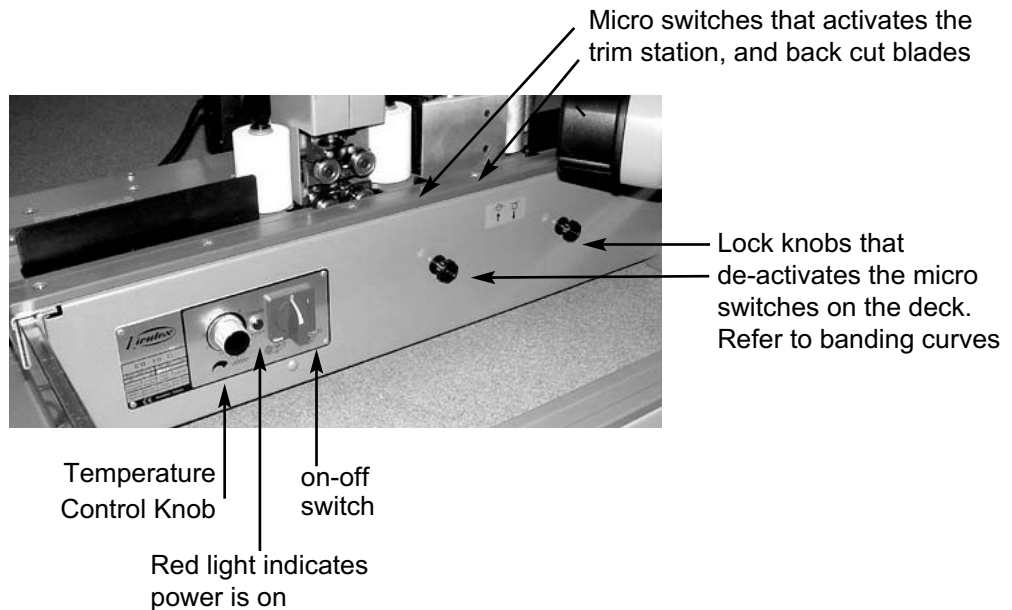
2- Remove covers



3- Unlock the nut in the bottom of bar **B**. Start twisting the bar. The bottom of the bar is threaded. You need to make the bar go higher or lower to adjust the contact made from top of the bar and the switch box. Re-lock the nut, and run a board. You may have to adjust more than once.

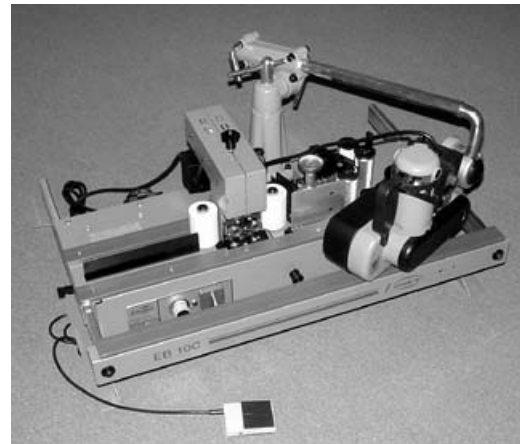


3- Control Panel



4- Power Feeder

The power feeder is pre-set at the factory for 3/4" thick board. The small feeder on EB-10C has a variable speed. Speed of 15 feet per minute is recommended. Once you find out the right temperature for a particular tape use the same speed and temperature to get consistent bond. For all feeder adjustment, refer to a separate feeder instruction manual



5- Finding the right temperature

Run a board starting at low heat increase temp. to find the best bond

We recommend a constant speed of 15 feet per minute for small feeder on EB10C. Constant speed will reduce the number of variables involved in finding the right temperature for an ideal bond. You need to determine the right melting point for the glue used on your tape. Start with a low temperature of about 250F°, run a board and peel off the tape. Repeat this step by increasing the temp. by 50F°. Continue the test until you find it hard to peel off, or when peeling the tape, the substrate elements comes off too. Allow a few minutes for curing before attempt to peel off the tape.

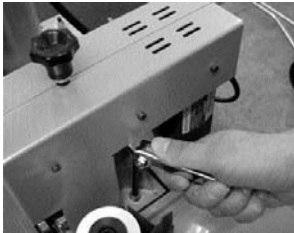
6- Cleaning the machine

It is essential that edgebanding machines to be cleaned and free of glue build up

Cleaning top+bottom trimming station (time to reach the blades: 5 minutes)

The glue build up occurs on the area of the top and bottom trimming station. The 4 bearing guides are automatically being cleaned by a set of scrapers. The blades need to be cleaned, and covered with a non-stick spray. The glue and material particles can be cleaned away with the air hose

1- To remove trim station, Take out one screw, loosen the other, swing away under mount bracket



2- Take out trim station



3- Remove 2 covers



4- Clean top & bottom blades with a brush and solvent. No need to remove blades for cleaning.



Cleaning the tape infeed track and back end cut blades

(time to reach back blade: 3 minutes)

The glue also **may** build up in this section. If a board enters the power feeder in an incorrect position (explained in page 3) it may cause the tape not to come out in time to be picked up by the board. A piece of tape remains in the infeed track. Remove the tape track assembly, take the tape out & clean the inside tracks with solvent & brush.

7- How to edge band curved panels

It will take about 15 minutes to modify the machine for banding curve panels

First you need to remove the power feeder, the trim station, the roller and metal fence.

Second Lock down the two micro switch levers on the deck

4- Remove trim station, the white roller to the left, and the metal fence all the way to the left.

2- Press down the micro switches that activates the trim station, and back cut blades



1- Loosen lock knobs that de-activate the micro switches on the deck.

3- Lock the knobs to keep the switches pressed down

5- Use foot pedal to cut the back end of the board