



MANUAL DE INSTRUCCIONES *Español* (p. 2)

OPERATING INSTRUCTIONS *English* (p. 9)

MODE D'EMPLOI *Français* (p. 12)

GEBRAUCHSANWEISUNG *Deutsch* (s. 15)



Aplacadora de cantos manual de cola caliente

Portable edge bander

Plaqueuse de chants portative à bac à colle

Kantenanleimgerät

PORTABLE EDGE BANDER PEB50

(Illustrations in page 21)



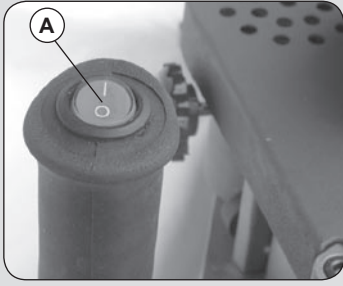
**Read these OPERATING INSTRUCTIONS and the attached GENERAL SAFETY INSTRUCTIONS LEAFLET carefully before using the machine. Make sure you have understood them before operating the machine for the first time.
Keep both sets of instructions for any future queries.**

1. ADDITIONAL SAFETY RULES FOR PORTABLE EDGE BANDER PEB50



Carefully read the GENERAL SAFETY INSTRUCTION LEAFLET enclosed with the machine documents.

- "Always Keep" hands away from rotating rollers.
- "Do Not" touch any heated parts.
- "Always" carry the machine with "Two Hands" during the operation.
- "Do Not" "lean on" or "tip over" the machine when it's heated.
- "Always" make sure you've enough extension cord and they won't be in your way during the operation.
- "Do Not" make any repair or maintenance while heated.
- "Do Not" operate machine near any flammable or explosive material. Never work in wet rooms or in the rain.
- "Vapours" arise by heated glue. Always work in rooms with good air supply or wear protective mask.
- "Safety rules" of glue fabricator must be regarded.
- "Be sure" Edgebander is cooled down before placing it into Styrofoam casing.



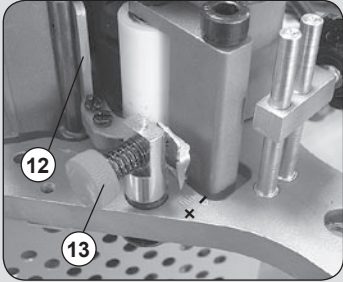
2. IMPORTANT REMARKS BEFORE STARTING YOUR EDGEBANDER

Glue Selection: Melting temperature – up to 150°C.; Viscosity – up to 15000 mPa.

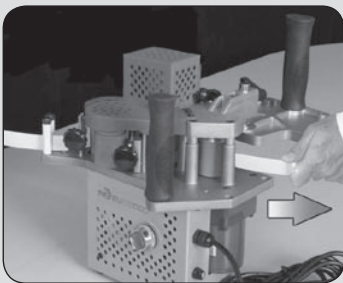
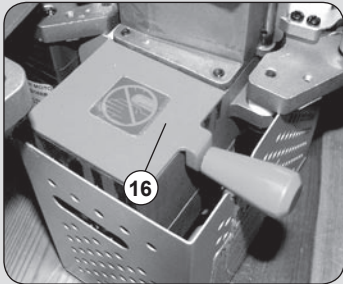
Recommended Glue: Virutex especially developed granulate for PEB50

Always keep the machine in a horizontal position while working with it and afterwards.

Please keep in mind that when you switch on the machine the Feed switch (A) has to be in position "0"



Scraper Plate (12) and Glue Pot Cover (16) will be "bonded to glue" after each operation. "Do not try" to "adjust" Scraper Control (13) or "remove" Cover (16) before machine is re-heated.



Should an edge jam, you always have to remove it into transport direction. Never pull back the edge, as otherwise the pressure and transport rollers can get dirty with glue and get sticky.

3. SPECIFICATION

Tape Width.....	22~45mm
Tape Thickness.....	0.5~3mm
Voltage.....	230V or 110V, 50/60Hz
Power.....	765W
Motor.....	15W
Heater.....	750W (= 150W x 5)
Feeding Speed.....	3.6 mts/min
Heating Temperature.....	180°C
Roller Activating Temperature.....	150°C
Pre-Heating Time.....	15 min
Glue Pot.....	150cc
Power Cord.....	5Meter
Weight.....	7.9Kg

4. STANDARD EQUIPMENT

Standard equipment includes:

- Portable Edge Bander PEB50
- Assembly fixture to convert PEB50 into a stationary unit
- 250gr. Bag of granulate glue for PEB50
- Hand bag for PBE50.

5. OPTIONAL ACCESSORIES

Virutex granulate glue for PEB50

Nonstick spray "Cantspray". (Minimizes adhesion of the glue on working elements).

Edge-Trimmer FR156N

CA56G Trimming head

AU93 Double edge trimmer (max. 1 mm).

RC21E Edge cutter (max. 1 mm).

RC221R Edge cutter (max. 2 mm).

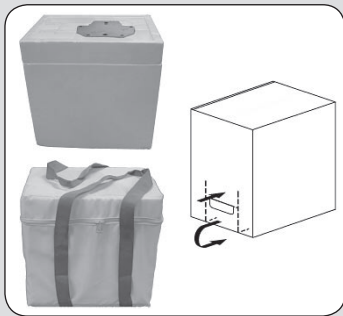
RC52P Edge cutter for round pieces (max. 2 mm).

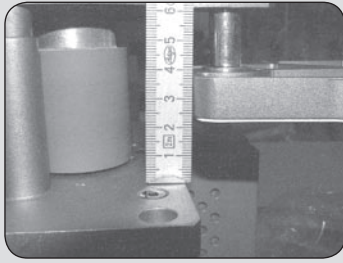
6. PACKAGING AND TRANSPORT

Extra strength Styrofoam packaging is designed to be a reusable storage casing.

A HAND BAG is enclosed for your conveniences. "Rip" open carton along dotted lines and remove bag. Do not dispose your carton, use it to contain Styrofoam casing.

"Be sure" Edgebander is cooled down before placing it into Styrofoam casing.





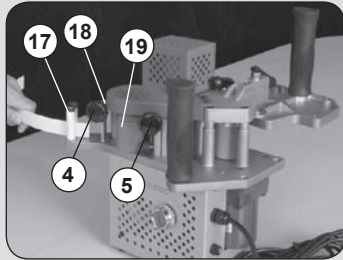
7. MACHINE ADJUSTMENTS

Adjusting the sliding plate.

Assemble Sliding Plate (2) into Support (11) Tighten clamping lever (1). (See Fig. 1).

Depending on the height of the work piece the sliding plate must be adjusted.

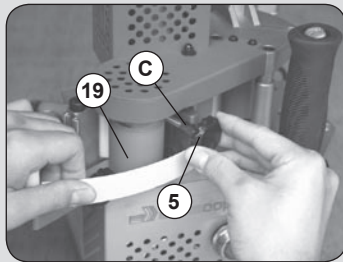
To do so open the clamping lever (1, Fig. 1), adjust the height of the sliding plate to the (workpiece thickness + 1,5 ~ 2 mm) with a measuring tape. Tighten lever (1) gently and make sure position is maintained before tighten it fully.



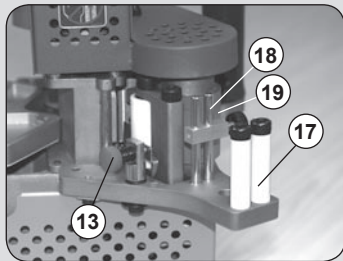
Adjusting the edge

Use edges 2 ~ 3 mm higher than workpiece thickness. Cut them to workpiece length + 5 ~ 6 cms.

Adjustment at infeed, center and outfeed needs to be done according to the height of the tape selected. To do so insert a sampling tape through guides (17) and (18), open adjustment knob (4) set the holding-down clamp to edge height +0.5 mm and fasten again knob (4).



Remove sampling tape. Place the tape onto the support plate and under the holding-down clamp in the middle. Loosen the adjustment knob (5), place the tape under the brass sleeve ((C), +0.5 mm) and fasten again knob (5).



Setting the amount of glue

On/Off Switch with Yellow Indicator Light (3, Fig. 2) activates the Heater when turn on.

With the adjusting screw (13), you control the amount of glue applied to the tape. As soon as the machine has heated up and the granulate has become liquid turn the adjusting screw (13) to position "0" or "-" (clockwise).

Take a sampling tape (ca. 1 metre) to check the glue layer.

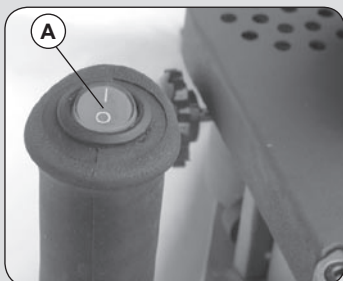
Lead the tape through the guides (17), (18) and through Feed roller (19) and Idle roller. Switch on "I" the feed switch (A) and after some seconds, push the tape inside until the transport roll carries it automatically. Now slowly open the glue adjustment screw (13) counterclockwise and repeat the checking until the tape is coated evenly.

When adjusting you have to keep in mind the paste roll needs 2-3 seconds to transport the glue up from the glue container.

Normally this setting has to be done only once.

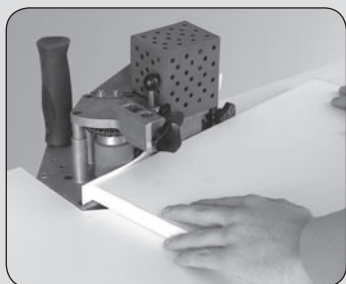
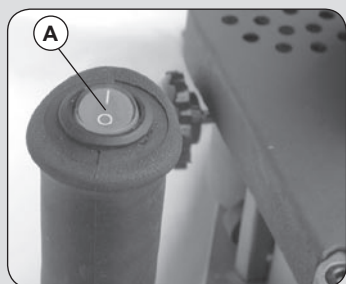
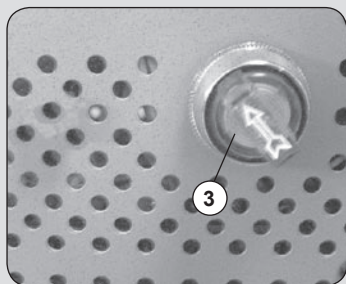
Do not set the adjusting screw (13) after the machine has cooled down.

With a filled glue reservoir the amount of glue can be used to cover around 35 m of edges that have a height of 23 mm or around 15 m of edges that have a height of 45 mm.



8. OPERATION

Observe safety regulations.
Direction of work - clockwise



Working mode

Switch on the main switch (3). The control lamp (A) lights up when the glue has reached a temperature of 150°C. Depending on the granular glue the machine has to warm up for 4 to 8 minutes to get 150°C. After this time has elapsed only short workpieces can be glued. For gluing larger or several workpieces it is imperative to wait until the granular material has become liquid (ca. 20 minutes). Open lid and check.

Place the sliding plate (2, Fig. 1 y 2) onto the work piece and place the pressure roll (15, Fig. 1 y 2) close to the workpiece without touching it. Hold the machine with the "right hand" and switch on "I" the Feed switch (A) on the left hand grip.

Lead the edge tape with your left hand through the guides (17 y 18 Fig. 2) up to the Feed roller (19, Fig. 2).

The tape is transported forward automatically now. Wait a moment till the tape reaches the pressure roll (15, Fig. 2) and press the pressure roll against the workpiece. The rotation movement of the pressure roll (15, Fig. 2) automatically moves the machine ahead with a speed of 3.6 – 4 m/min.

Pushing the machine forward will result in inconsistency speed. At the end of the tape make sure that the machine is led further uniformly in height and direction until the protruding tape is led out of the pressure roll (15, Fig. 2).

REMARK:

To get used to the correct work procedure we recommend gluing some short workpieces to find out the correct handling. You will be surprised how easily and precisely the machine can be handled. You should constantly monitor the glue supply and refill it at an early stage. It will still take approximate 1 minute for additional glue to melt after the initial heat up.

Stationary use

Your PEB50 Edgebander can be converted into a stationary unit on a work table with the "Fix Bracket" enclosed (Fig. 5 y 6).

Work table thickness must be 19 mm (Fig. 6).

Cut a window on work table using "Fix Bracket" as template (Fig. 4). Mount "Fix Bracket" to bottom of work table (Fig. 5) with the Wood Screws (10 pieces enclosed).

Remove Sliding Plate (2, Fig. 1 y 2) and mount the Edgebander to Fix Bracket (Fig. 6) with the M6 Screws enclosed.

A "Support Pad" is required. (Approximate 3 mm in thickness) (Fig. 6).

By raising work piece 3 mm above table surface and allow "Bottom-Trim" clearing space, (excess tape to be trimmed on bottom).

Glue Selection

Recommended Glue: Virutex especially developed granulate for PEB50,



PEB50

Aplacadora de cantos de cola caliente con control de temperatura

Hot melt manual edgebander with temperature control

ESPAÑOL

Esta máquina está equipada con un control de temperatura digital. De esta forma es posible regular la temperatura de la cola ininterrumpidamente desde 120°C hasta 200°C. Accione primeramente el interruptor principal de la máquina. La pantalla inferior (roja) «SV» muestra la temperatura programada. La pantalla superior (verde) «PV» muestra la temperatura real de la cola dentro del depósito. Para cambiar la temperatura de la cola presionar el botón «FUNC» (B). La pantalla roja parpadeará. Al presionar de nuevo este botón es posible cambiar la temperatura por medio de los botones (C) al nivel deseado. Para finalizar presionar el botón «MODE» (A)



A

B

C



ATENCIÓN

Siga siempre las indicaciones del fabricante de la cola.

ENGLISH

This machine is equipped with a digital temperature display. Here the temperature of the glue can be set infinitely variable from 120° - 200°C. First switch on the main switch of the machine. The lower display (red) «SV» shows the currently set value. The upper display (green) «PV» shows the current temperature of the hotmelt adhesive in the glue pot. To change the temperature of the glue press the «FUNC» (B) button. The red display starts flashing. If you press this button again you can use the buttons (C) to change the temperature at the desired level. For confirmation press the «MODE» (A) button.



ATTENTION

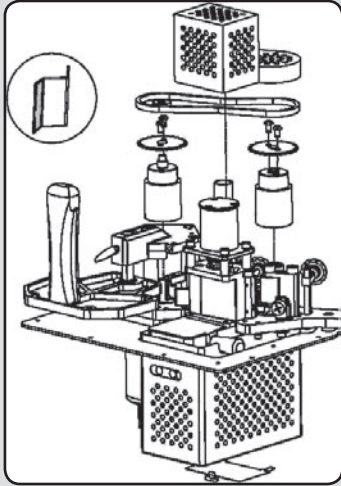
Always observe the specifications of the glue manufacturer.

9. MAINTENANCE & CLEANING



Excess glue needs to be removed according to demands.

Make sure machine is "disconnected from power source" and "Wait for machine to cool down" before any maintenance.



Edging Surface (1): Remove excess glue with cloth & solvent.
Press Roller (2): When coarsely soiled remove Roller and clean it with cloth & solvent.

Fence (3): Remove excess glue with cloth & solvent.

Removable Lid (4): Lid is located on bottom of Housing. Excess glue accumulated can be removed easily.

Pressing Plate (5): Remove Cover (6) and clean pressing plate with cloth & solvent when needed.

Glue reservoir: Excess glue around Heating Unit does not need to be cleaned. It will be re-melted on next operation.

We recommend spraying Virutex "CANTSPRAY" over tape guides and gluing rollers before starting to edge. It reduces considerably the adhesion of the glue on working elements and is easily cleaning.

10. NOISE LEVEL AND VIBRATIONS

These levels have been measured according to the European Standard EN50144.

Noise level at work area can exceed 85 dB (A). In that case operators should protect themselves against damage to hearing.

11. WARRANTY

All VIRUTEX machines are guaranteed for 12 months from the date of purchase, excluding any damage which is a result of incorrect use or of natural and tear on the machine. All repairs should be carried out by the official VIRUTEX technical assistance service.

VIRUTEX reserves the right to modify its products without prior notice.