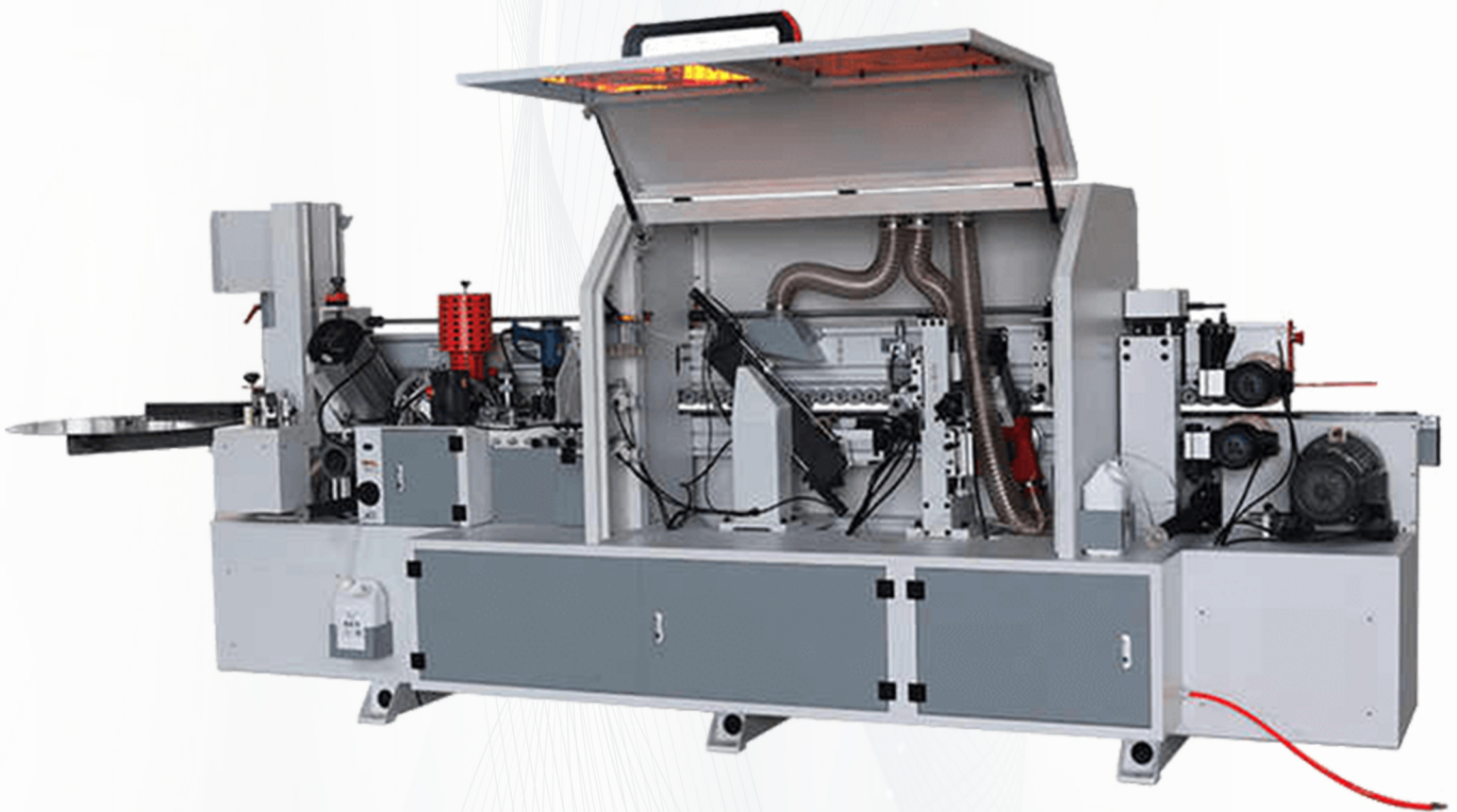


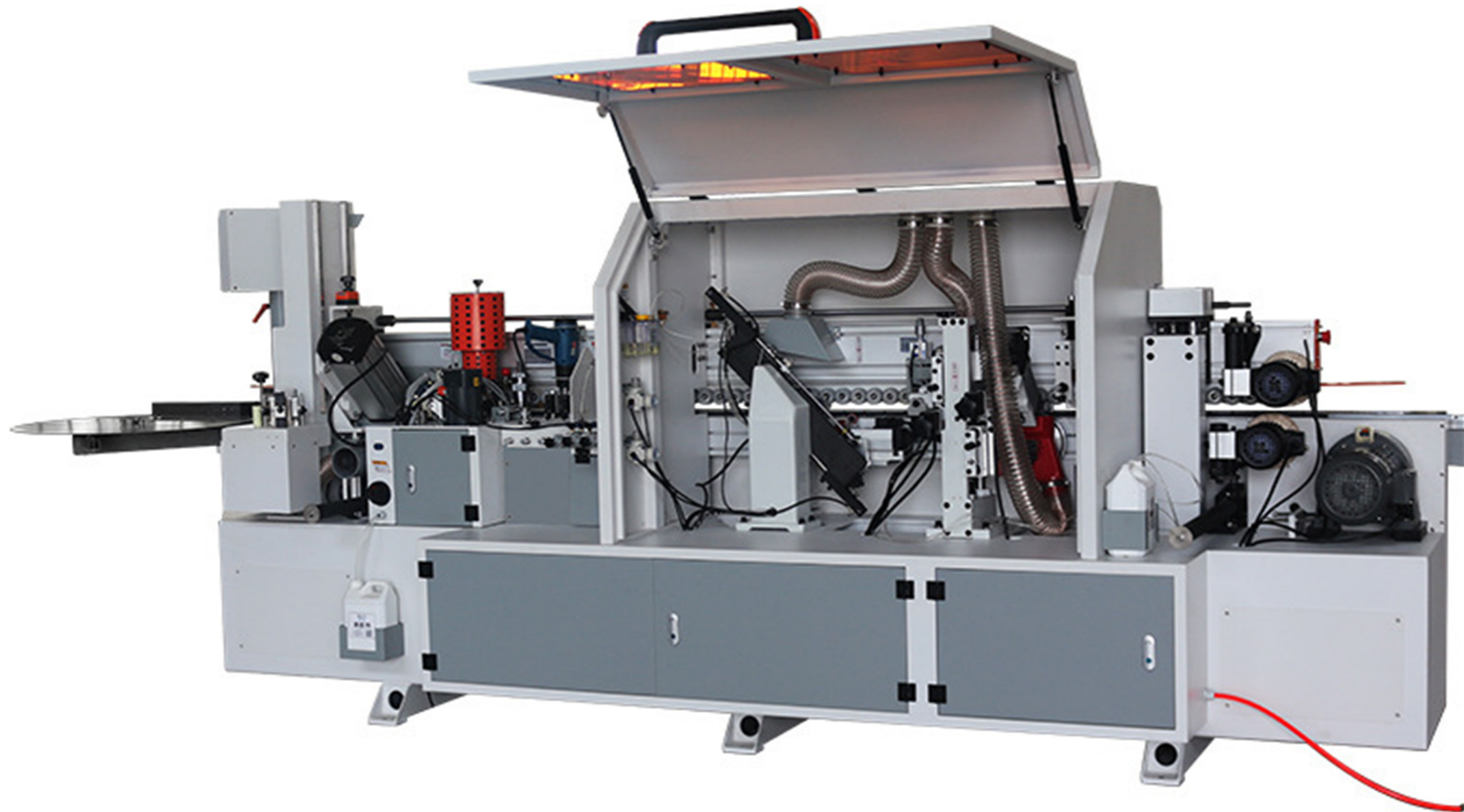
Machine - Auxiliary - Tool - Material

45 Degree Edge Banding Machine

Intelligent · Fully Automatic · Precise

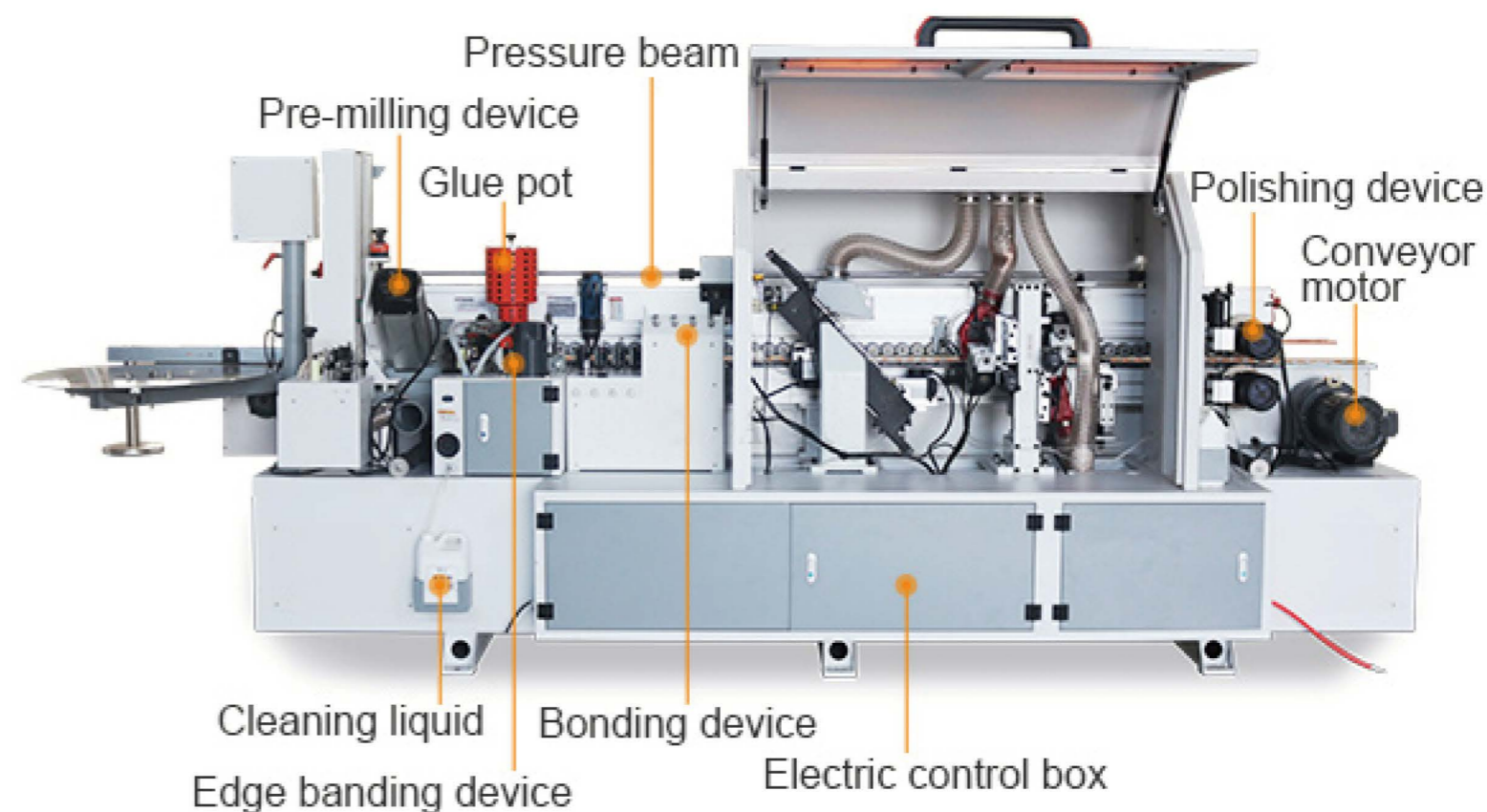


F350
Automatic edge banding machine



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1.1 Edge banding machine structure preview



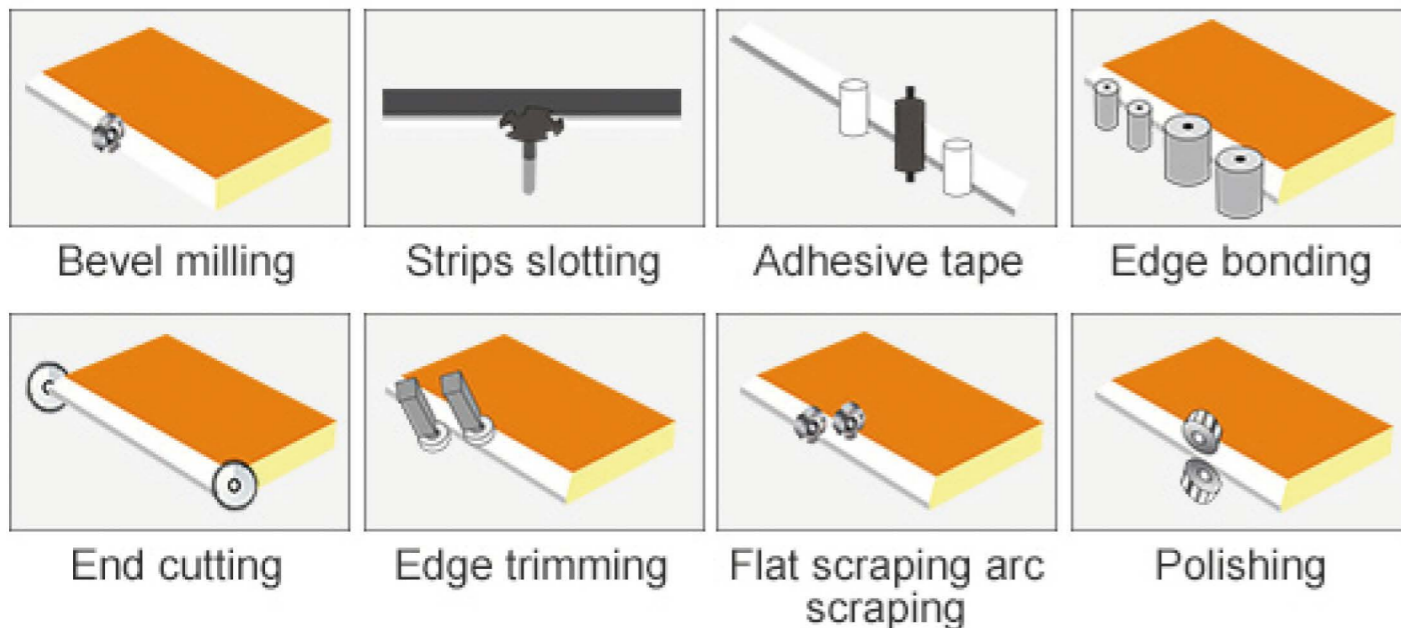
1. Product Overview

1.2 Product description

- **Function:** pre-milling, strip slotting, gluing, heating, bonding, end cutting, cleaning, trimming, scraping, polishing.
- **Features:** F350 automatic edge banding machine is focusing on process 45 degrees bevel with straight edge, also known as X shape or invisible handle.

1.3 Performance characteristics

- It can directly mill the straight board into a 45-degree bevel with straight edge.
- The milling motor can be raised and lowered with one-click, making blade replacement more convenient. Saw blades can be sharpened.
- 9 bonding rollers, pressing and pasting the strips many times to ensure the bonding effect.
- The upper glue pot can use EVA or PUR glue. The inner wall of the glue pot is coated with Teflon, and has a glue discharge function for easy replacement of glue.
- 2 cleaning devices to spray anti-adhesion liquid automatically. Not easy to stick, clean and tidy.
- Two heating devices heat the thick strips to ensure the bonding effect.



2. Product Parameters

Voltage	380v 50hz 3phase	Edge band thickness	0.5-3mm
Total power	15KW	Edge band material	Veneer (customized) PVC
Air source air pressure	0.6-0.8Mpa	Plate thickness	14-25mm
Air storage tank volume	2L	External suction port diameter	Φ100, Φ150
Usetemperature of glue pot	110-210°C	Working speed	12m/min
Edge band width	14-40mm	Size	4500*1100*1640mm
Hot-melt glue	EVA, PUR	Weight	1330KG

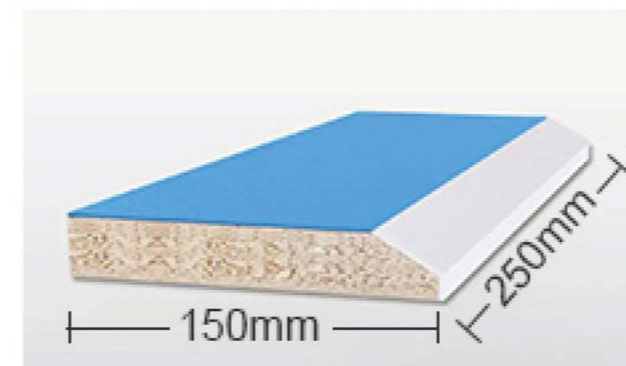
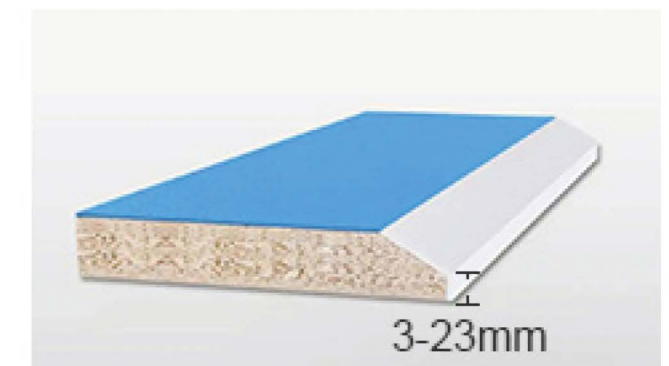


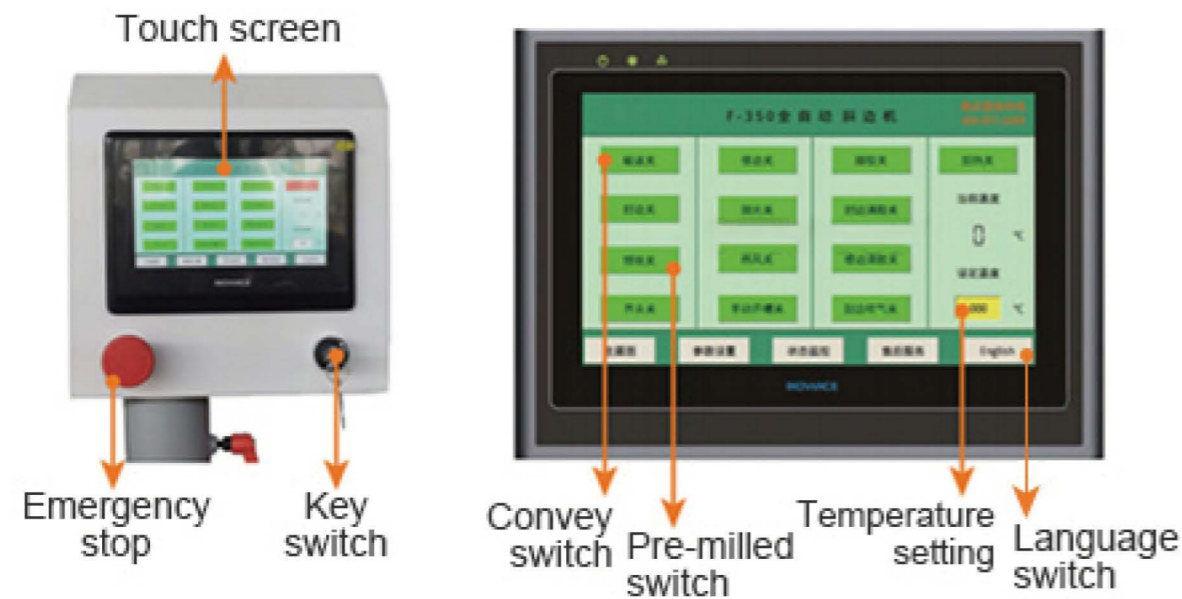
Plate size: ≥250*150mm



Straight edge height: 3-23mm

Name	Description	Name	Description
Slotted motor	DCA 350w 30000r/min	Polishing motor	380v 0.37kw 3-phase motor
Edge banding motor	380v 250w Variable-frequency motor	Trimming motor	380v 0.75kw
Pre-milled motor	380v 4kw	End cutting motor	380v 0.37kw
Conveyor motor	380v 1.5kw		

3.1 Touch control system



Turn on the key switch, the touch screen displays the main interface (as shown above)

- **Manual Slotting Switch:** When the strip is placed, click this button, the slotting motor will run, and the edge strip will be slotted.
- **Convey switch:** Turn on this switch, the conveying motor starts to run, and the plate starts to be conveyed.
- **Pre-milled switch:** Click this switch, the motor will run, and the plate will be milled.
- **End cut switch:** click this switch, board will be end-cut.
- **Trimming switch:** Turn on this switch to trim up and down the board.
- **Polishing switch:** Polishing the board
- **Hearing switch:** According to the actual effect of edge banding, decide whether to enable this function. Turning on the hot air can significantly improve the bonding firmness, but overheating may cause the strips to soften and expand due to overheating, affecting the actual effect.

- **Temperature of glue pot:** Set the temperature of the glue pot. When the temperature reaches the set value, the edge sealing motor can run and the equipment can be operated normally. When the temperature does not reach the set value, the edge sealing motor cannot run.
- **Cleaning glue pot:** Turn on this switch, the glue pot will automatically remove the waste glue. If PUR glue is used, it will not be used for more than 24 hours, please clean the glue pot in time.
- **Cleaning device:** There are two clearing devices to spray anti-adhesion liquid, one for edge banding and one for trimming, both of which can be controlled independently.
- **Language switch:** Switch between Chinese and English control interface. Other languages can be customized if needed.

3.2 Parameter settings



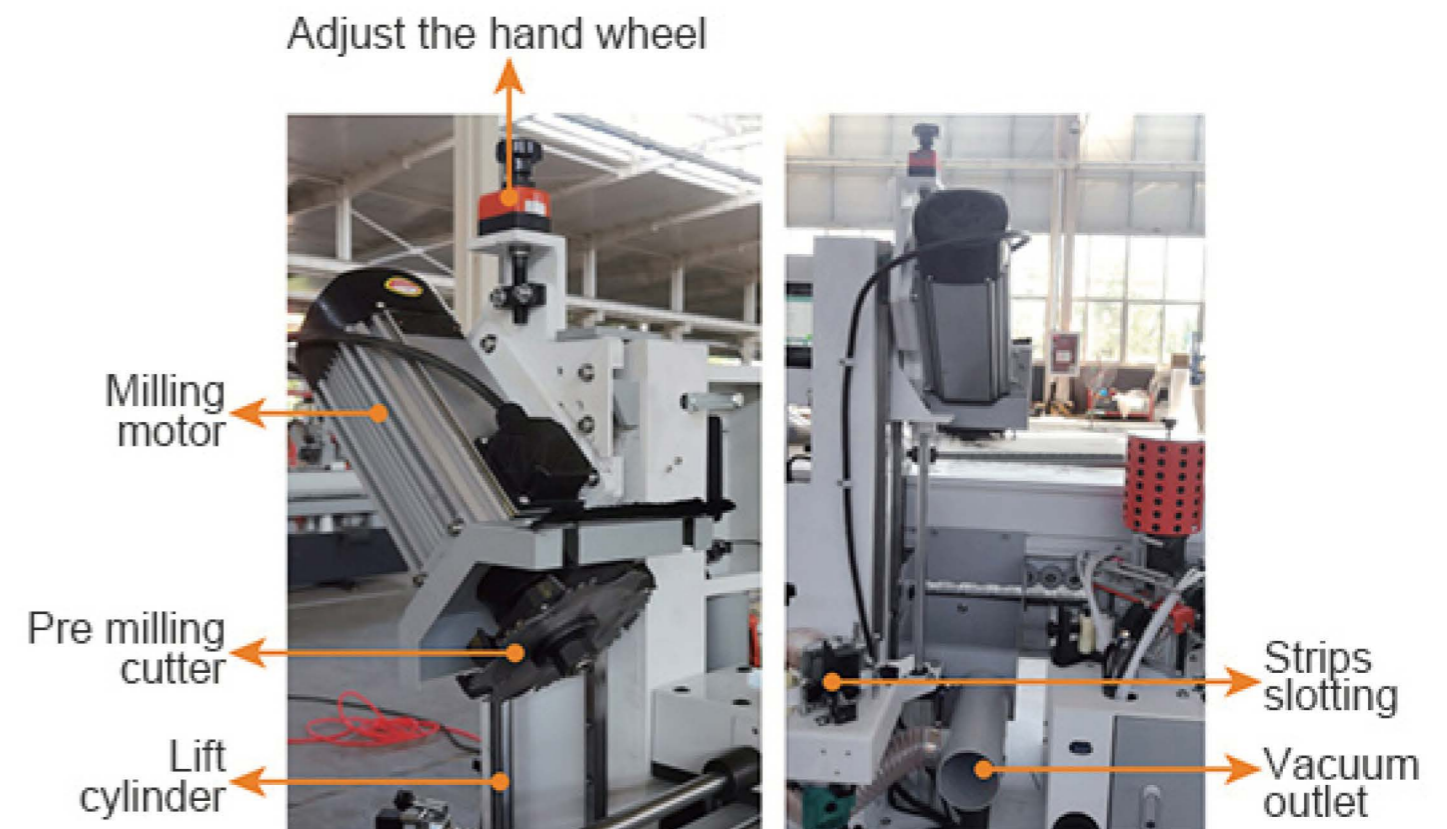
Click the parameter setting, the above interface will

- **Cylinder reset:** Click the button, the cylinder in the initial position can be reset
- **Replacing the pre-milling knife:** When replacing the pre-milling knife, turn on this switch, the cylinder will rise, and the motor cannot rotate at the same time, and the blade can be replaced at this time.
- **spray cleaning liquid time:** The spraying cleaning liquid at different positions can be turned on or off. This button is used to set the time of spraying liquid and intermittent time.
- **Fine-tuning of the s length:** The fine-tuning is divided into two parts: the fine-tuning of the beginning and the end.

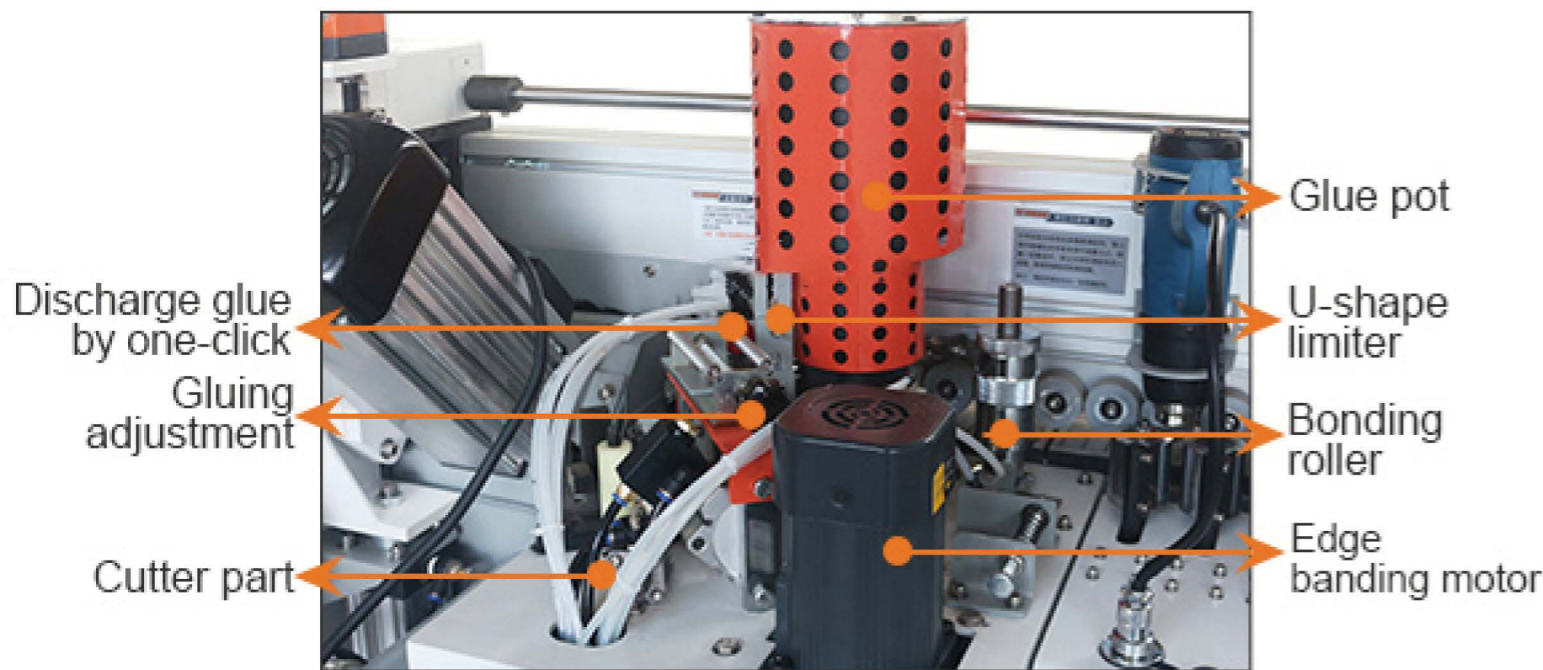
The rest of the values in this interface have been set before leaving the factory. If you want to change the settings, please contact professional after-sales personnel to adjust them, and you cannot change them without permission.

3.3 Pre-milling part

1. The pre-milling assembly mills a 45-degree bevel with straight edge shape for the normal sheet in advance, saving time and being fast and accurate.
2. According to the height of the straight edge of the insulating board, adjust the upper adjustment handwheel to adjust the height of the milling cutter. The minimum height of the straight edge of the plate is 5mm, and the maximum thickness of the plate is 25mm.
3. According to the actual situation of the plate, adjust the front and rear positions of the pre-milling spindle to adjust the position of the plate milling type. Note: If there are too many types of plate milling, pay attention to adjusting the front and rear positions of the edge banding assembly to achieve the effect of high heel sticking.
4. To replace the pre-milling tool, lift the milling motor, and the motor is raised to a higher level, it is more convenient and quick to replace the milling cutter.



3.4 edge banding part

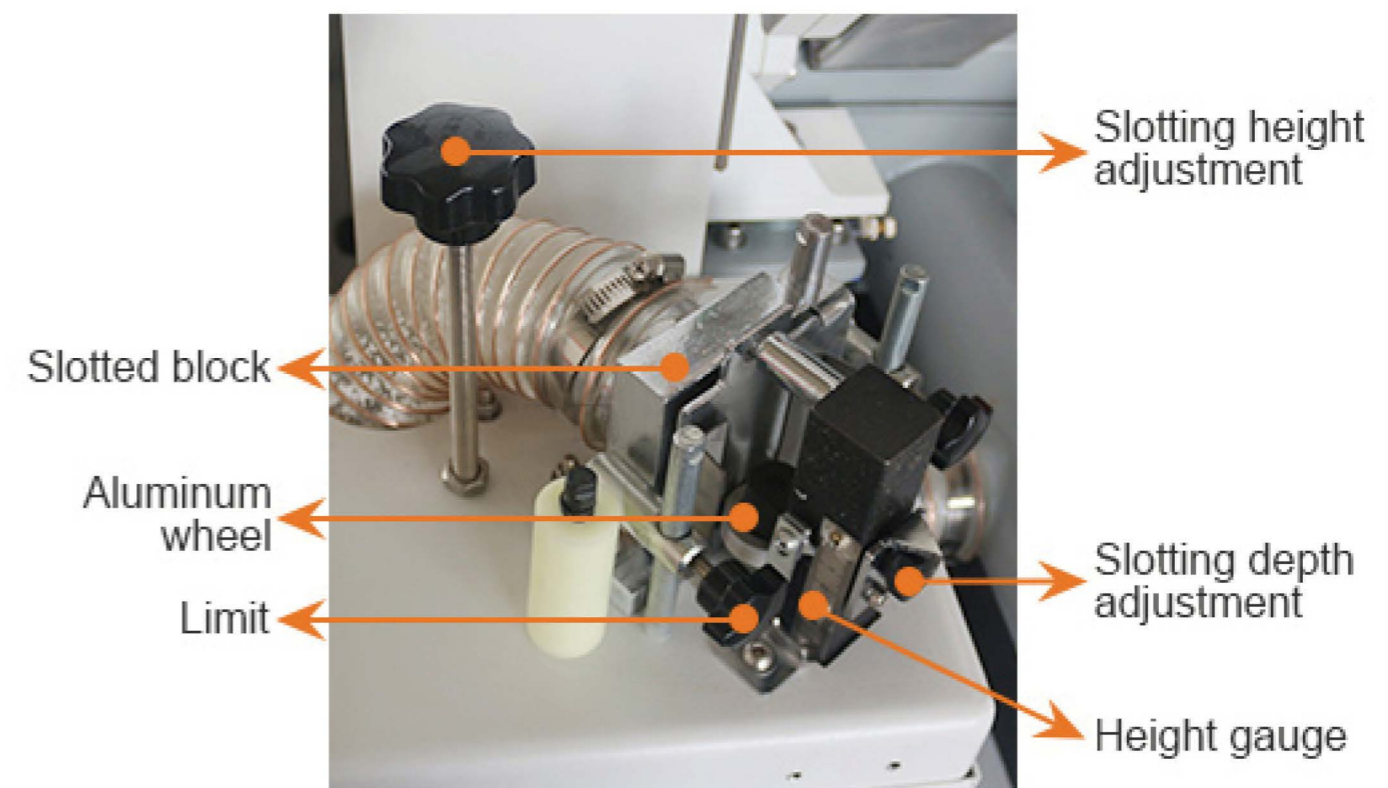


1. Adjust the height of the stopper, U-shaped limiter and bonding roller according to the height of the strips. The limiter is as high as the strips. The height of the bonding roller is about 0.5-1mm higher than the strips.
 2. When the thickness of the board changes, the groove of the strips should be adjusted first. Adjust the height of the slotting knife by adjusting the screw rod to realize the adjustment of the slotting height of the strips (according to the height of the straight edge on the board), and the slotting height (3-23mm) can be directly reflected on the height gauge.
 3. The heat gun reheats the strips to soften them, which can better fit the board and make the bonding more firm.
 4. Adjust the handwheel according to the different thickness of the strips, so that the gluing effect of the strips is better.
- Note: Be sure to adjust the gap between the batten plate and the gluing shaft. If the gap is too small, too much glue is applied on the upper and lower sides of the strips, and the batten plate is easy to stick to glue. If the gap is too large, the glue on the edge banding will be uneven, which will affect the fitting effect.

5. This machine adopts the design of floating lamination wheel, which makes the lamination firmer and more reliable. Through the adjustment structure of the fitting wheel, the position adjustment and floating of the bonding rollers can be realized conveniently and quickly.

3.5 Slotting part

Used to open the bending groove for the strips



1. When the slotting depth of the strip changes, the distance between the aluminum wheel and the slotting knife is adjusted through the slotting depth adjustment handwheel, so that the slotting depth of the strip changes. The operation is simple and convenient.
2. Adjust the screw to adjust the height of the slotting knife to realize the adjustment of the slotting height of the strip (according to the height change of the straight edge on the plate), the slotting height (3-23mm) can be directly reflected on the height gauge.

3. Product Structure

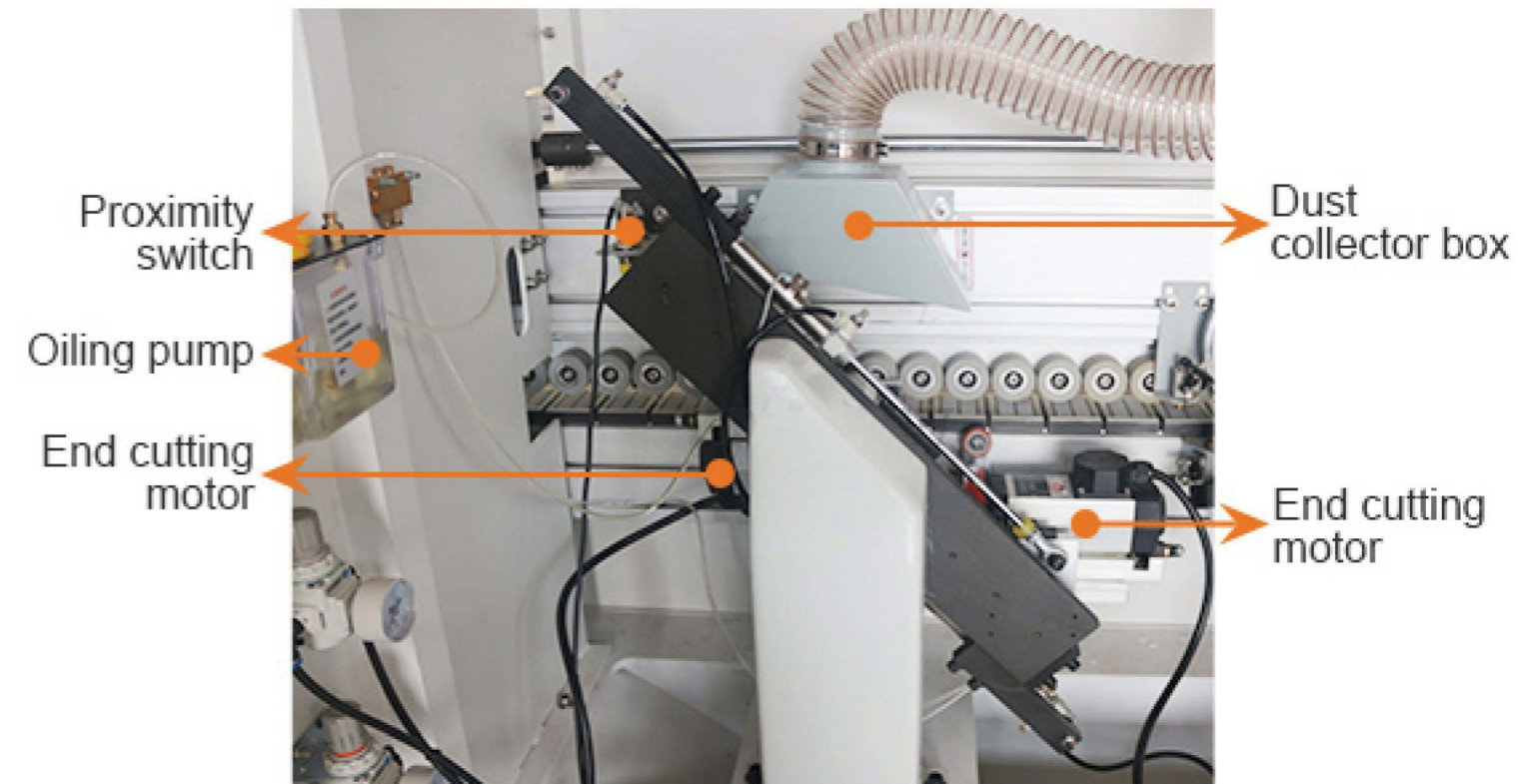
3.6 Bonding part

1. The floating design is adopted for both straight pressing and inclined pressing, which makes the edge banding more firm and strong.
2. Adjust the front and rear positions of the floating wheel by adjusting the screw.
3. The pressure wheel is equipped with a glue removing device, which greatly reduces the possibility of glue on the front side of the strip, making the edge banding effect more beautiful.
4. Please note that the position of the direct-facing pressing structure has been adjusted before leaving the factory. Please do not adjust their positions at will during use.



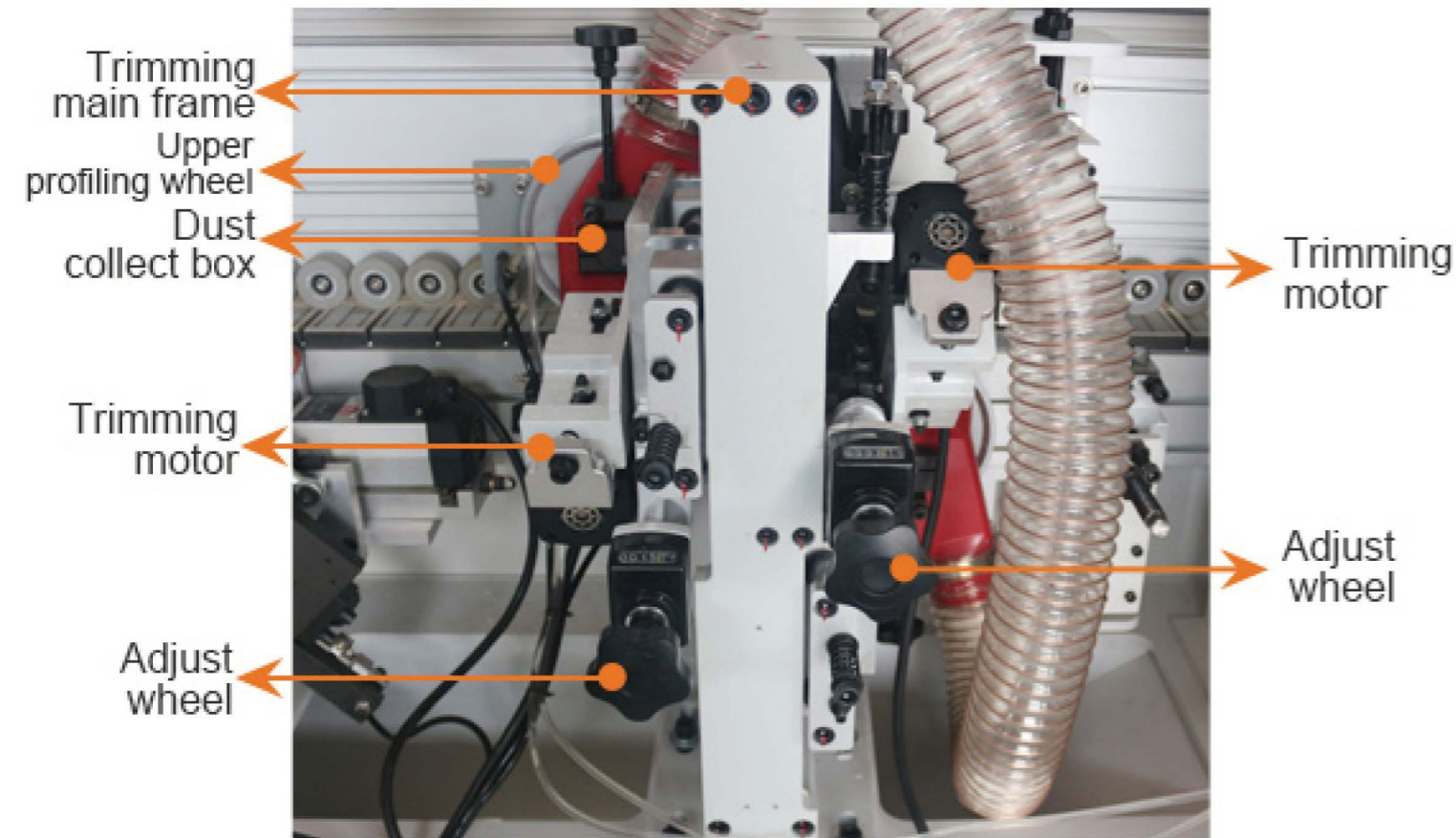
3. Product Structure

3.7 End cutting device



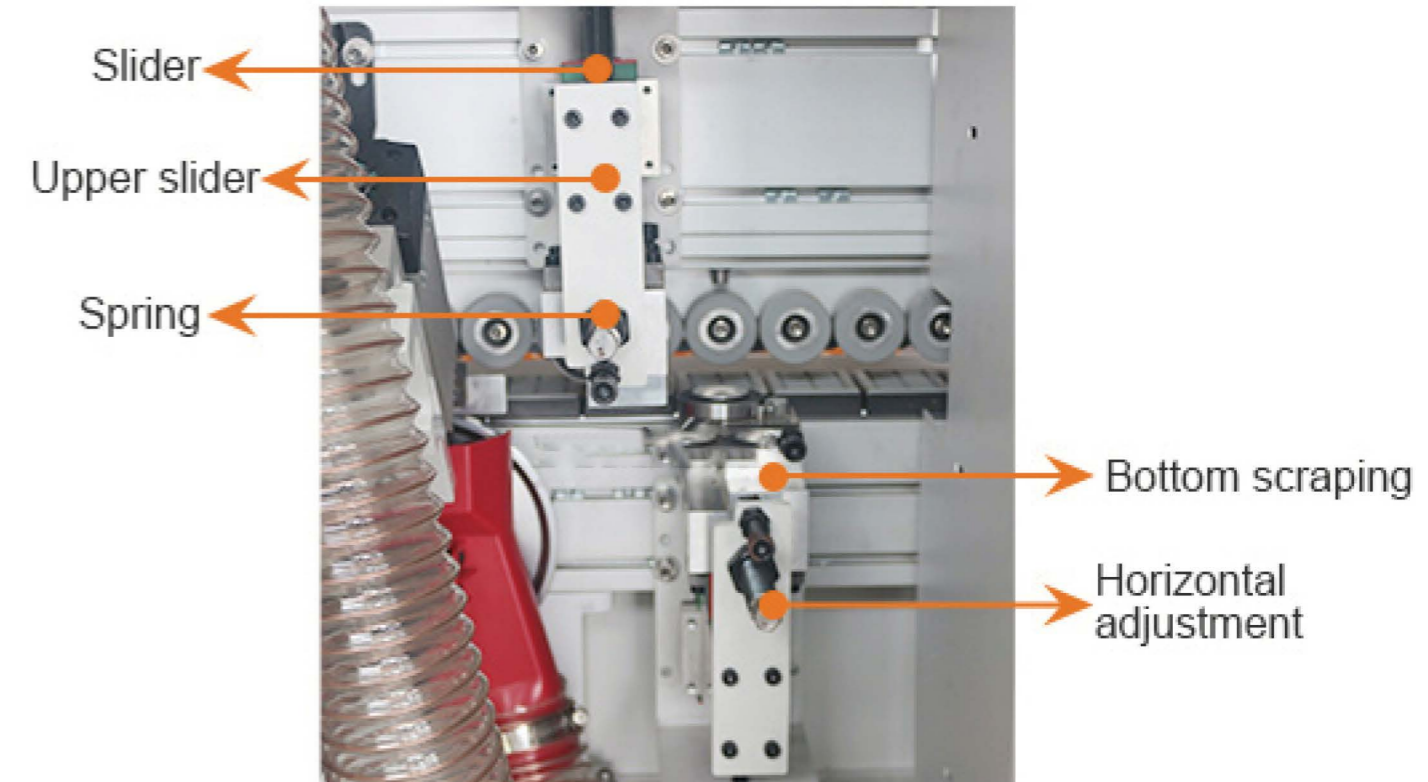
1. Adjust the screw to adjust the position of the motor to achieve the purpose of adjusting the margin of the strip
2. When the cylinder receives the signal, it will drive the motor to work and complete the process of end cutting.
3. The oil injection pump regularly lubricates the slider to ensure smooth operation of the slider.

3.8 Trimming part



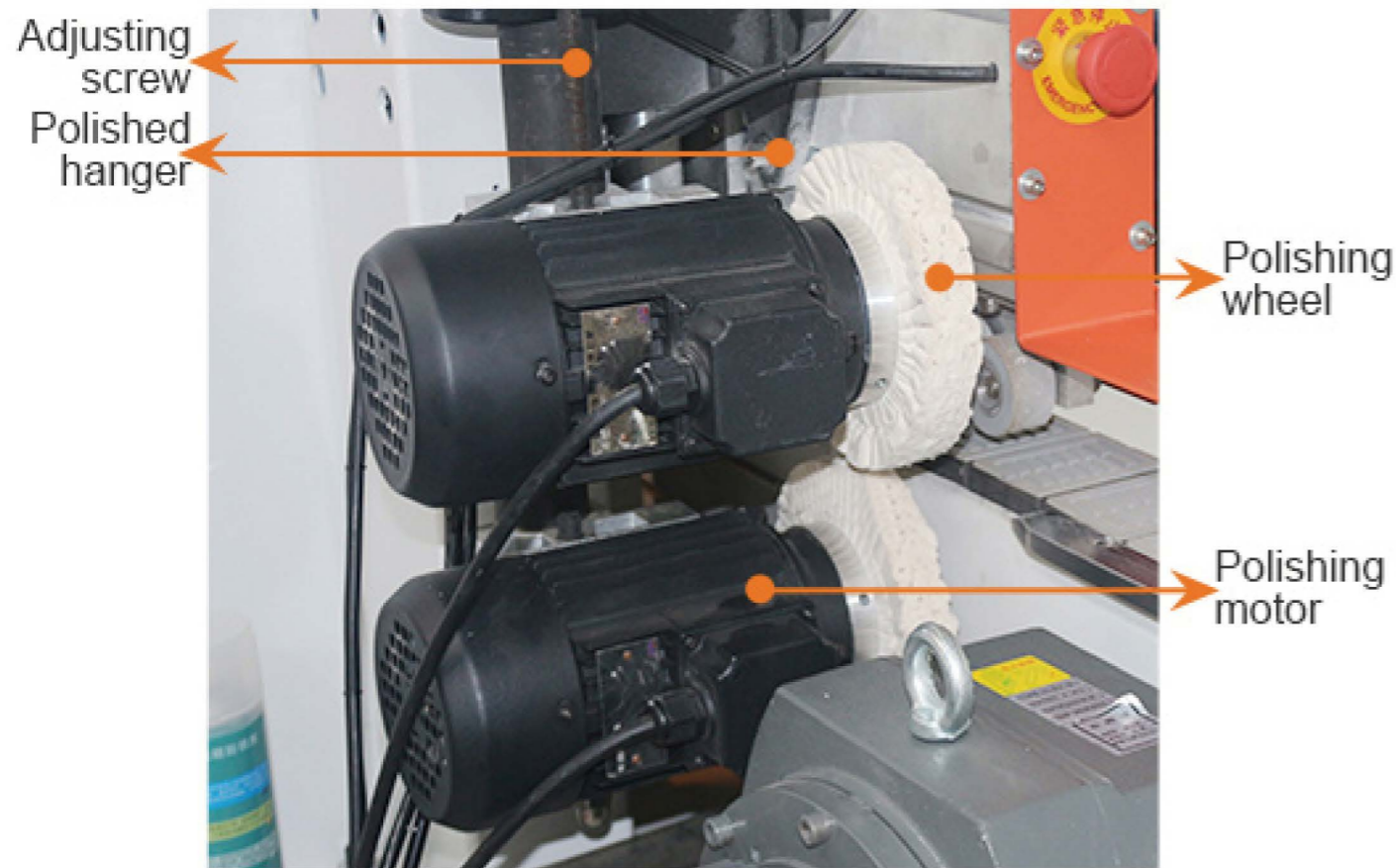
1. The main frame of trimming is made of thickened aluminum profile, which is light, strong and durable.
2. The overall edge trimming can float up and down, back and forth, so that the effect of profiling trimming effect is better.
3. The upper and lower trimming motors are equipped with a dust collection box, which has a better dust collection effect.
4. It is more intuitive and clear to adjust the relative position of the upper and lower profiling wheels for adjusting the hand wheel plus position display.
5. When the relative size of the bevel and straight height changes, the relative position of the upper and lower profiling wheels needs to be adjusted.

3.9 Scraping part

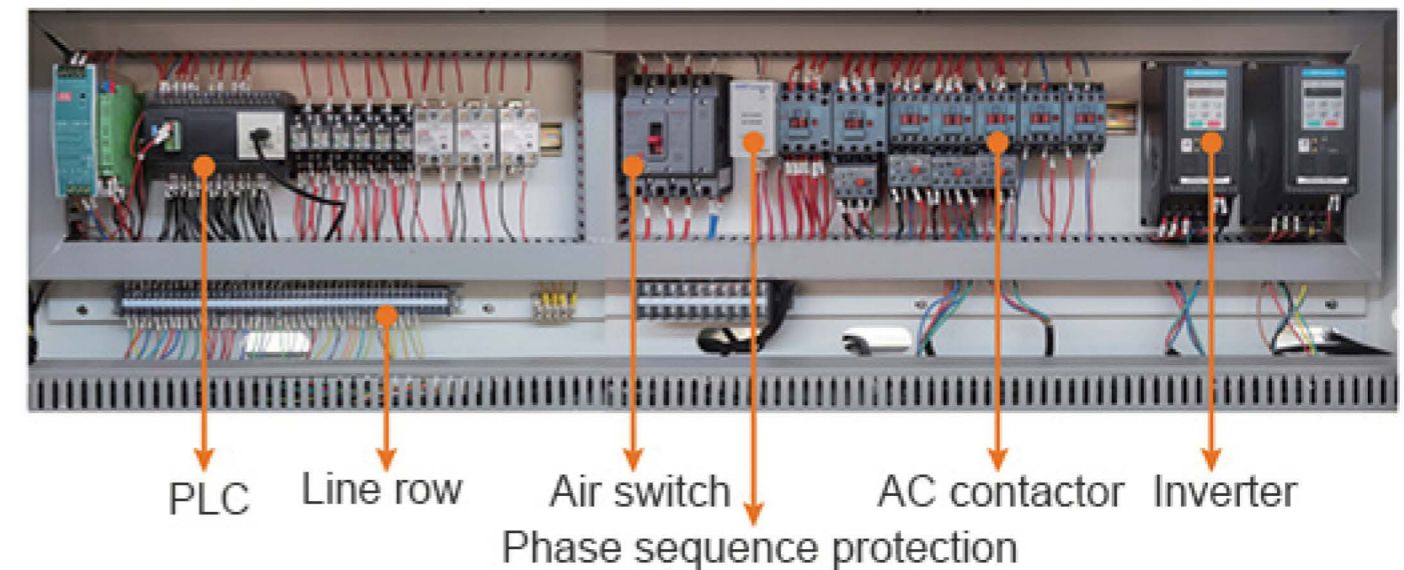


1. The machine has an upper scraping part, and the scraping edge adopts a flat scraper.
2. The vertical adjustment screw can realize the change of the upper and lower positions of the scraper, and the horizontal adjustment screw can realize the change of the front and rear position of the scraper.
3. When the thickness of the plate or the size of the straight edge changes, it is necessary to adjust the corresponding position of the scraping knife to achieve a better scraping effect.
4. The front, back, up and down positions of the scraping knife can float with the plate, making the scraping more beautiful and more consistent with the shape of the plate.

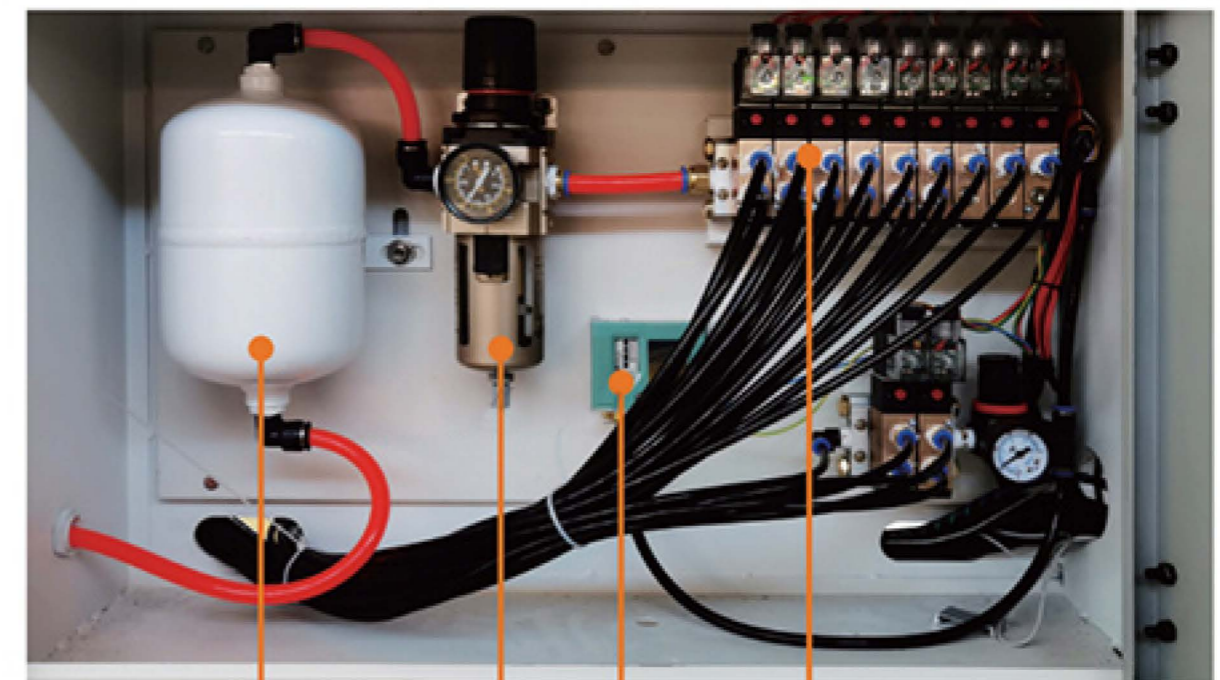
3.10 Polishing part



1. The polishing part is respectively fixed on the upper and lower pressure beams through the upper and lower sets of hangers. The lifting of the pressure beam drives the upper polishing structure to move up and down, so as to adapt to plates of different thicknesses. The operation is simple and fast.
2. By adjusting the screw, fine-tune the upper and lower positions of the polishing wheel. When the polishing wheel is severely worn, the position of the motor can be fine-tuned by adjusting the screw to increase the service life of the polishing wheel.
3. The polishing motor is easy to install and easy to replace the polishing wheel.



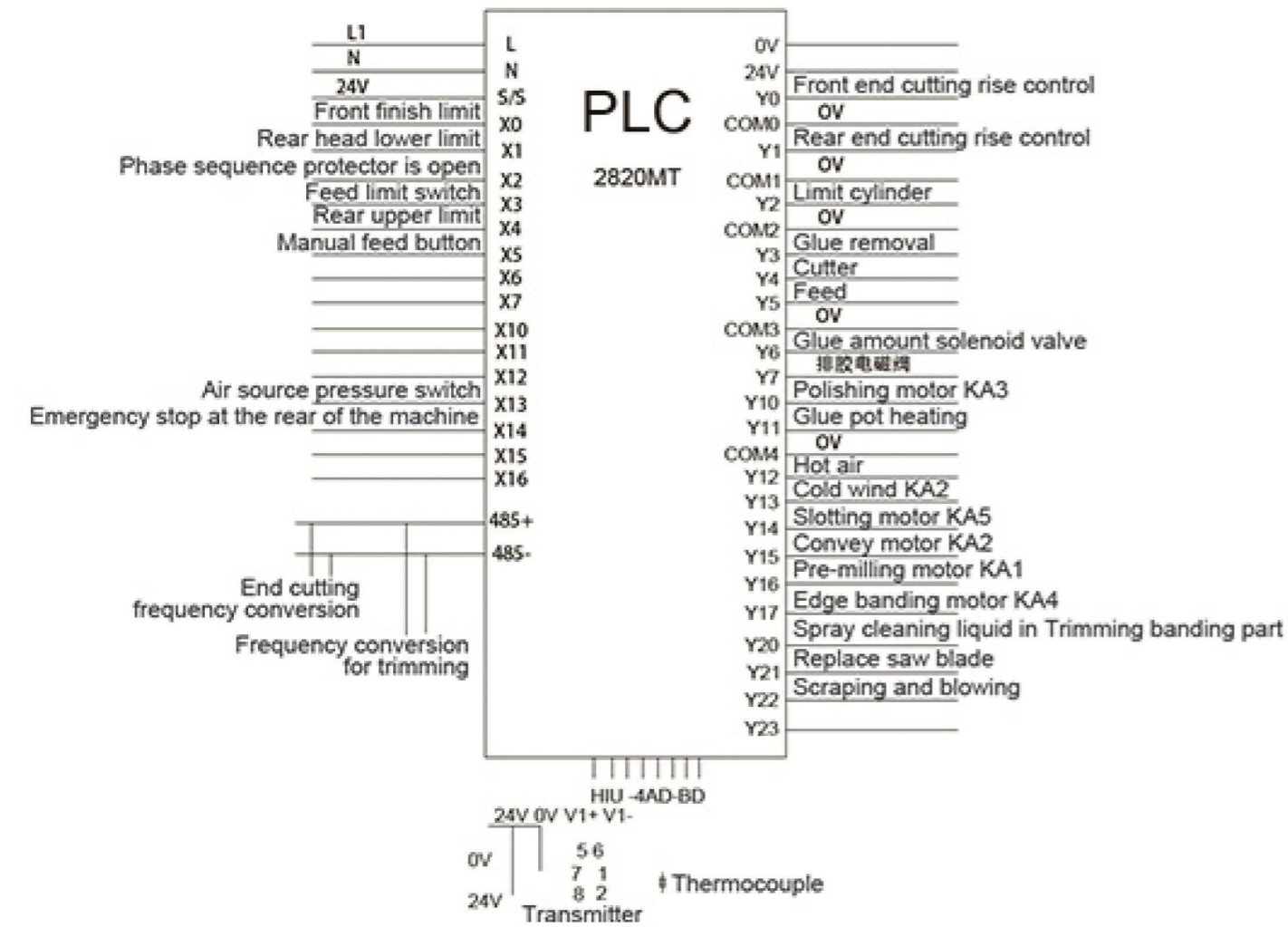
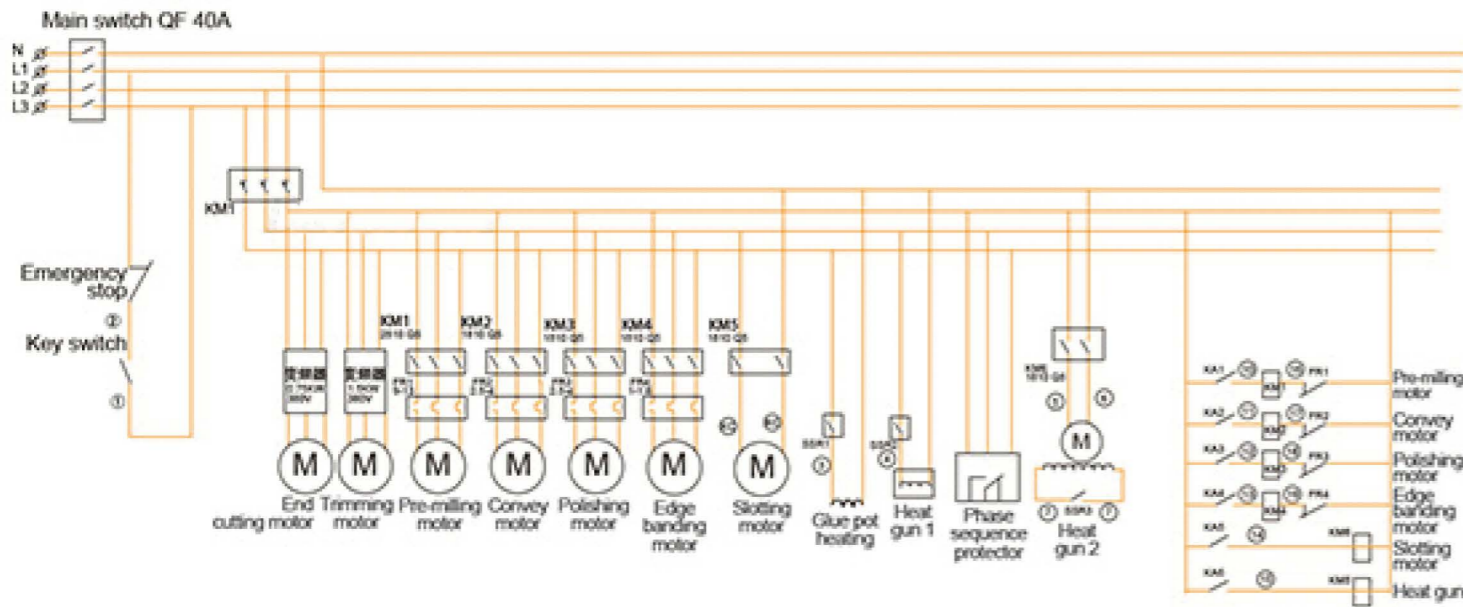
PLC Line row Air switch AC contactor Inverter
Phase sequence protection



Gas tank Oil-water separator Pressure sensor Electromagnetic valve

Wiring tips: Match the three live wires and one neutral wire of the main power line to the corresponding positions of the incoming wires. Turn on the device for trial operation, if the touch screen displays a "phase sequence error" prompt, you need to replace the positions of two of the live wires.

3.11 Circuit diagram



4.1 Installation Precautions

4.1.1 Instructions

- Before starting the machine, please check and clean up the sundries on the machine.
- When starting up, please remind the surrounding staff to pay attention to safety.
- Please check the remaining amount of hot melt adhesive in the glue pot before use.
- When any abnormal situation occurs during processing, please immediately press the emergency stop switch.
- Please perform maintenance and repair with the power off.
- It is forbidden for non-professionals to open the control box and electric control cabinet in the charged state.
- Regularly check the safety protection device, and repair and solve it immediately if any fault is found.

4.1.2 Precautions

- Strictly modify the machine structure without written permission.
- Please buy original parts.
- As the equipment is constantly updated and improved, when the product does not match the manual, please refer to the actual product.

4.1.3 Machine installation

1. 380v three-phase five-wire (three live wires, one neutral wire, one ground wire)Copper wire over.
2. 6 Square centimeters.
3. Air source pressure 0.6-0.8Mpa.
4. The installation site should meet the space occupied by the normal work of the machine.
5. The installation ground must be firm.

Note: The equipment continues to be grounded. If any accident occurs due to the grounding line, the company will not be responsible.

4.1.4 Installation steps

1. Fix the machine: use a forklift to place the machine in a suitable position, adjust the anchor bolts to make the machine level, and then fix the machine.
2. Connect the power supply: Put the main power cord through the hole on the side of the machine, and connect the five wires to the corresponding positions of the line row (remember, the neutral wire cannot be connected incorrectly). Note that the positions of the connection terminals of each distribution block cannot be mistaken, otherwise irreparable losses will be caused.
3. Connect the air source, there must be no impurities when connecting the air source, and check whether there is any air leakage in the air pipe joint.
4. Connect the vacuum equipment, connect the vacuum tube to the machine, and fasten the connection.
5. According to the thickness of the plate and the thickness and width of the strip, adjust the corresponding parts.

4.2 Device Activation Instructions

Technical support

不激活一小时后停机

00000

填写激活码

00000

请将此初始码告知二维码售后人员

Activation code entry

Device initialization code

Technical support

Device Information

Warranty information

Time display Technical support

0000 年 00 月 00 日

00 : 00 校准

产品编码: []

产品序列号: 0000 激活码 00000

激活剩余时间: 0 小时

质保到期时间: 0000 年 00 月 00 日

为保证封边质量及机器寿命，
请使用原厂封边胶，清洗剂及原厂配件

主页面 参数设置 状态监控 English

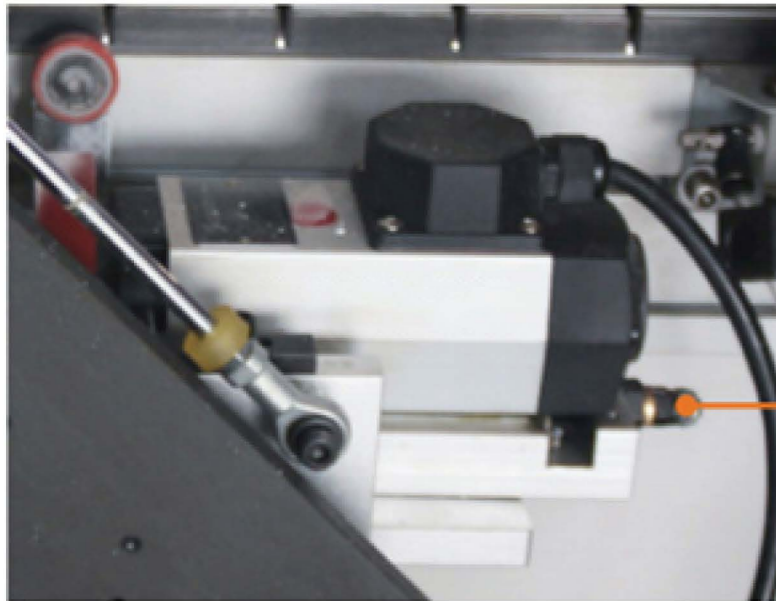
Please use the specified hot melt adhesive together!
Use matching special cleaning liquid!

5.1 Common faults and troubleshooting methods



Strip Limit post Cutter Glue adjustment

- Adjust the amount of glue through the handwheel until you are satisfied
- The replacement strip needs to be slotted in advance, just click "Manual slotting" on the touch screen.



Motor adjustment screw

- When the flush margin is not appropriate, manually adjust the motor adjustment screw to adjust the front and rear positions of the motor.

5.2 Lubrication and maintenance

- The gearbox needs to be cleaned and lubricated once every two weeks (8 hours a day).
- The transmission chain is cleaned and lubricated once every two weeks (8 hours a day).
- Clean the whole machine once a day (after the hot melt adhesive cools down).
- The screw rod is lubricated regularly.



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