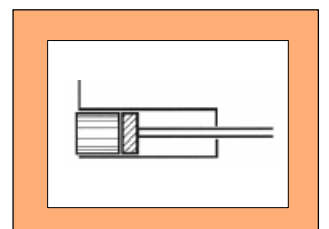
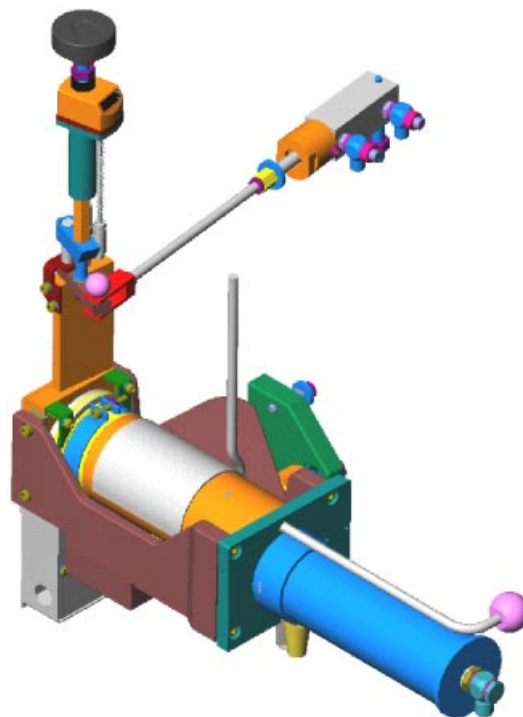


# INSTRUCTIONS FOR USE

## EDGE BANDING MACHINE

### GLUE STATION

### CARTRIDGE 1906 M



## Relevance in print

When buying the edge banding machine you decided in favour of a model with an individual composition. This operating instructions also contains additional devices, except special executions, that are offered by HOLZ-HER within the model range.

We ask for your understanding that there are mentioned additional devices which you did not choose.

The high standard of quality and security is guaranteed by a permanent development. Therefore there can possibly appear differences between this operating instructions and your unit. Also errors cannot be excluded totally. Therefore we ask for your understanding that from descriptions, indications and illustrations there cannot be derived legal claims.

## Order information

Please supply the following information:

Title of document  
Code number  
Date of issue  
Language

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This document was prepared by the Technical Editorial Department of REICH Special Machines GmbH.

## CHAPTERS

|          |  |       |
|----------|--|-------|
| <b>1</b> | <b>Technical data</b>                              |       |
| 1.1      | Characteristic Data .....                          | 1 - 1 |
| 1.2      | Weight .....                                       | 1 - 1 |
| 1.3      | Operation .....                                    | 1 - 1 |
| 1.4      | Scope of application .....                         | 1 - 1 |
| 1.5      | Intended use .....                                 | 1 - 2 |
| 1.6      | Unit dimensions .....                              | 1 - 3 |
| 1.6.1    | Version non-tracing nozzle .....                   | 1 - 3 |
| 1.6.2    | Version non-tracing nozzle (model range UNO) ..... | 1 - 4 |
| 1.6.3    | Version tracing nozzle .....                       | 1 - 5 |
| 1.7      | Working dimensions .....                           | 1 - 6 |
| 1.8      | Glue application .....                             | 1 - 6 |
| 1.9      | Connected power .....                              | 1 - 7 |
| 1.10     | Compressed air .....                               | 1 - 7 |
| 1.11     | Accessories .....                                  | 1 - 7 |
| 1.11.1   | Operating tools .....                              | 1 - 7 |
| 1.12     | Special accessories .....                          | 1 - 8 |
| <b>2</b> | <b>Safety</b>                                      |       |
| 2.1      | Protective devices .....                           | 2 - 1 |
| 2.2      | Residual risks .....                               | 2 - 2 |
| <b>3</b> | <b>Design and mode of operation</b>                |       |
| 3.1      | General description .....                          | 3 - 1 |
| 3.2      | Mode of operation .....                            | 3 - 1 |
| 3.3      | Design .....                                       | 3 - 2 |
| <b>4</b> | <b>Start up</b>                                    |       |
| 4.1      | Putting the glue station into service .....        | 4 - 1 |
| 4.1.1    | Switching on .....                                 | 4 - 1 |
| 4.2      | Collecting basin for melted glue .....             | 4 - 1 |

## CHAPTERS

|          |  |        |
|----------|--|--------|
| <b>5</b> | <b>Setting the glue station</b>  |        |
| 5.1      | General instructions .....   | 5 - 1  |
| 5.2      | Insertion of glue cartridges into glue shaft .....                                       | 5 - 2  |
| 5.3      | Setting of processing temperature .....  | 5 - 5  |
| 5.4      | Setting glue application to workpiece front edge .....                                   | 5 - 6  |
| 5.4.1    | Metering rod adjustment by hand with spindle to position indicator .....                 | 5 - 6  |
| 5.4.2    | Metering rod adjustment with pressure bridge connection .....                            | 5 - 7  |
| 5.4.3    | Version «Tracing nozzle» - Processing of glued-on edging .....                           | 5 - 8  |
| 5.5      | Setting of glue application to workpiece bottom edge - readjustment .....                | 5 - 9  |
| 5.6      | Setting of glue application .....  | 5 - 10 |
| 5.7      | Setting nozzle to workpiece infeed fence .....   | 5 - 11 |
| 5.8      | Nozzle pressure on workpiece .....   | 5 - 11 |
| 5.9      | Change of glue cartridge .....   | 5 - 12 |
| <b>6</b> | <b>Care and maintenance</b>  |        |
| 6.1      | General instructions .....   | 6 - 1  |
| 6.2      | Maintenance chart .....  | 6 - 3  |
| 6.3      | Cleaning of glue application area .....  | 6 - 5  |
| 6.3.1    | Removing glue residues .....   | 6 - 5  |
| 6.3.2    | Cleaning of bores for glue delivery and metering rod .....                               | 6 - 7  |
| 6.3.2.1  | Cleaning of bores for glue delivery .....  | 6 - 9  |
| 6.3.2.2  | Cleaning of metering rod - Version <i>non-tracing</i> nozzle with position indicator ... | 6 - 11 |
| 6.3.2.3  | Cleaning of metering rod - Version <i>tracing</i> nozzle with position indicator .....   | 6 - 15 |
| 6.3.2.4  | Cleaning of metering rod - Ver. <i>tracing</i> nozzle with pressure bridge connection .. | 6 - 19 |
| 6.4      | Resetting to new workpiece thicknesses - idle time .....                                 | 6 - 23 |
| 6.5      | Cleaning of the glue application system after processing PUR hot-melt glue .....         | 6 - 24 |
| <b>7</b> | <b>Troubleshooting and remedies</b> .....  | 7 - 1  |
| <b>8</b> | <b>Notes</b> .....   | 8 - 1  |

Explanation:

Correction bars for modifications with respect to the previous edition are shown in side bars or within tables or graphic frames.



## 1.5 Intended use

This glue station is intended only for melting hot-melt glue in the form of cartridges to be applied laterally to panels as part of a run through an edge banding machine, in order to press edging onto these surfaces.

Permissible working dimensions see Item 1.7.

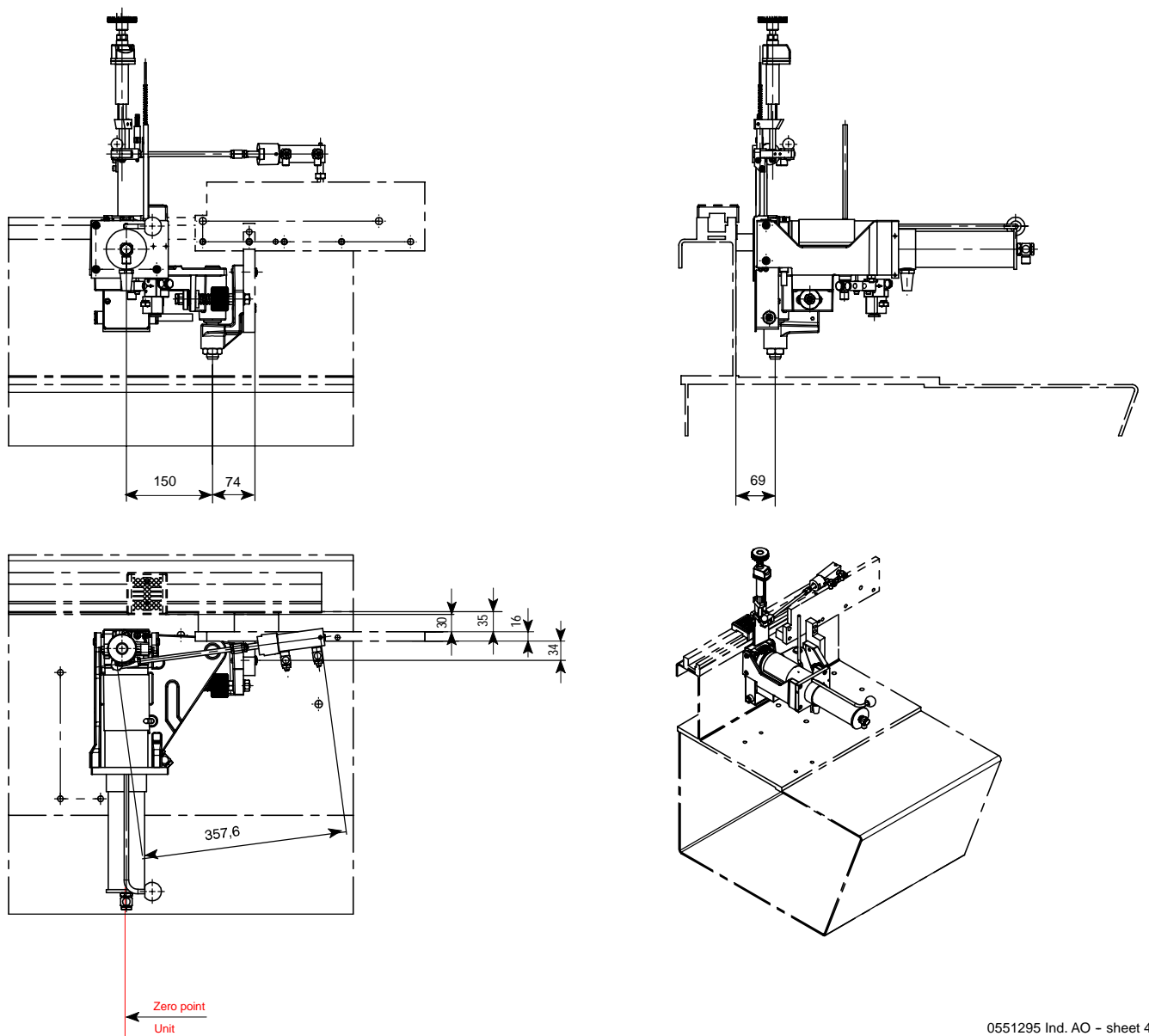
Any other or alternative use shall be considered use outside this scope of application.

The manufacturer shall not be liable for any resulting damage and any such use is at the sole risk of the user.

## 1.6 Unit dimensions

### 1.6.1 Version non-tracing nozzle

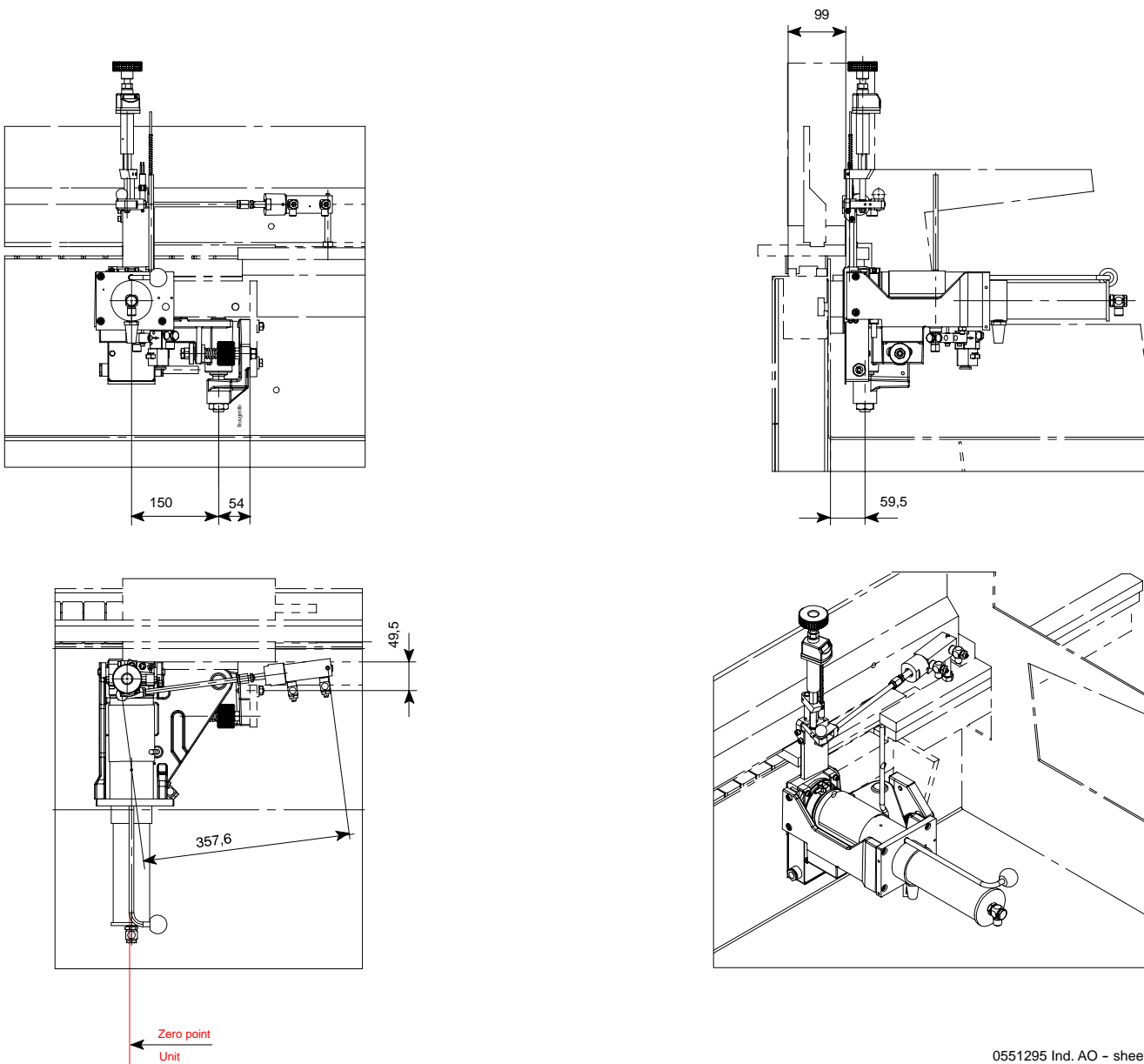
| Model  | 1906 M      |  |
|--------|-------------|--|
| Width  | 410 mm      |  |
| Height | 600 + 60 mm |  |
| Depth  | 490 mm      |  |



0551295 Ind. AO - sheet 4

### 1.6.2 Version non-tracing nozzle (model range UNO)

| Model  | 1906 M      |  |
|--------|-------------|--|
| Width  | 410 mm      |  |
| Height | 600 + 60 mm |  |
| Depth  | 490 mm      |  |

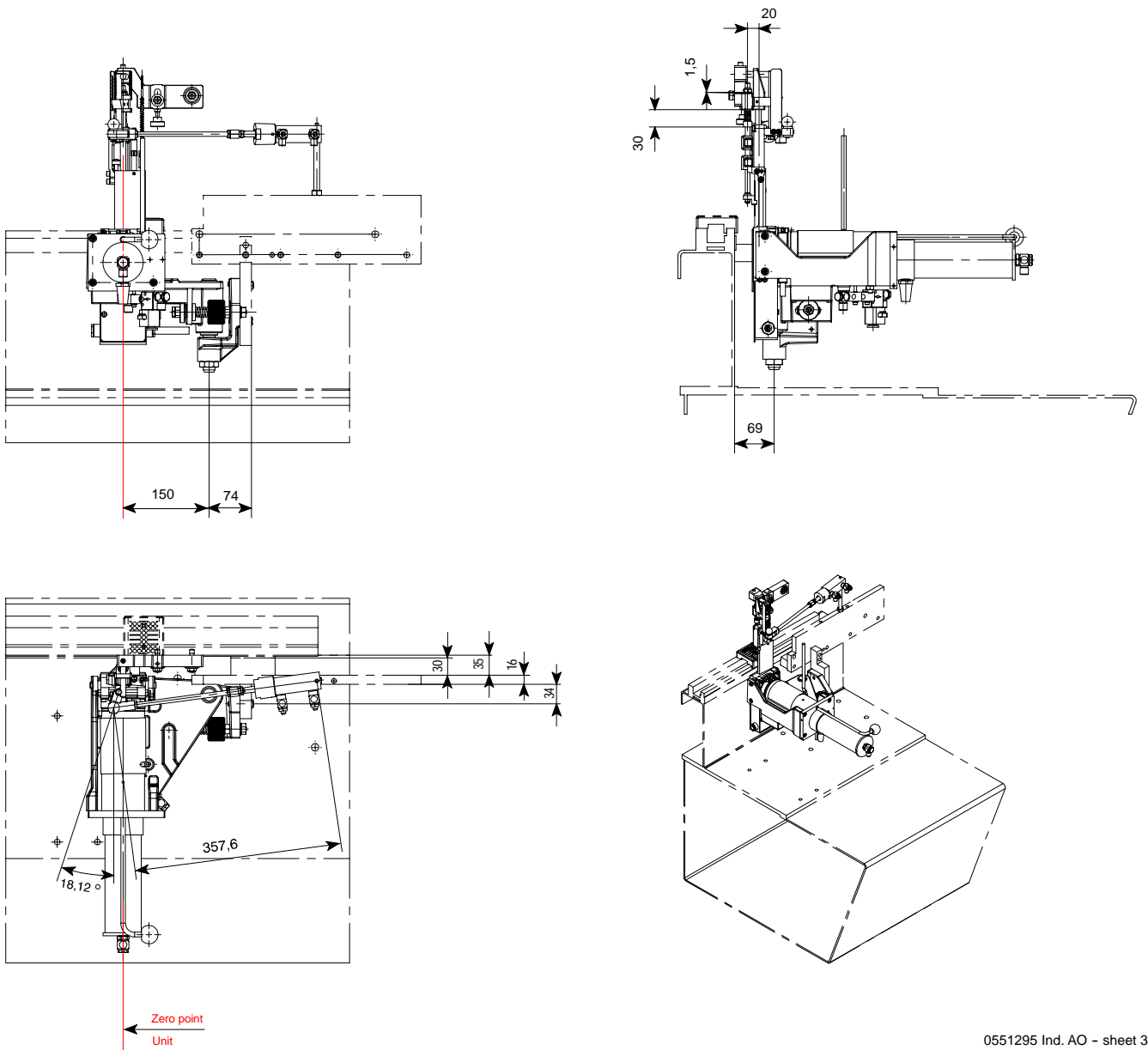


0551295 Ind. AO - sheet 5



1.6.3 Version tracing nozzle

|              |               |  |
|--------------|---------------|--|
| <b>Model</b> | <b>1906 M</b> |  |
| Width        | 410 mm        |  |
| Height       | 540 + 60 mm   |  |
| Depth        | 490 mm        |  |

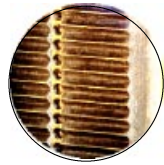


0551295 Ind. AO - sheet 3

## 1.7 Working dimensions

| Model                        | 1906 M   |  |
|------------------------------|--|--|
| Workpiece thickness          | 6 - 60 mm<br>depending on feed speed, glue type and glue viscosity                                   |  |
| Standard value of feed speed | <ul style="list-style-type: none"> <li>- 16 m/min</li> <li>- 11 m/min</li> <li>- 08 m/min</li> </ul> |  |
| Workpiece length             | min.   | 140 mm   |
|                              | max.   | For 60 mm workpiece thickness 4000 mm approx. For thinner workpieces correspondingly longer. |

## 1.8 Glue application

| Model   | 1906 M   | Comment   |
|---|--|---|
| Glue application                                      | Hot/cold process, glue application left-hand by sword nozzle with electro-pneumatic control. | Sword nozzle: <ul style="list-style-type: none"> <li>- Wiper 120° for processing of thin edges (serie).</li> <li>- Wiper 90° for processing of solid edges (optional).</li> </ul>  |
| Glue type   | Hot-melt glue cartridge<br>Ø 63 x 80 mm long   |   |
| Cartridge magazine - Filling capacity (manual refill) | 1 cartridge = approx. 0,3 kg   |   |
| Heating-up time                                       | ≅ 5 min  |   |
| Working temperature for EVA glue                      | 160 - 240° C<br>depending on glue type   |   |
| Temperature control                                   | by means of PLC control or contactor control at model range UNO                              |   |

## 1.9 Connected power

| Model           | 1906 M       |  |
|-----------------|--------------|--|
| 400 V 50 Hz + N | 1,9 kW 3,5 A |  |
| 230 V 50/60 Hz  | 1,9 kW 6,1 A |  |
| 200 V 50 Hz     | 1,9 kW 6,8 A |  |
| Control voltage | 24 V DC      |  |

## 1.10 Compressed air


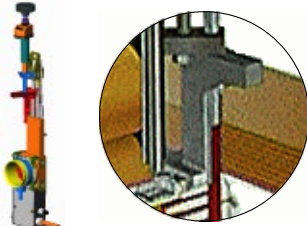
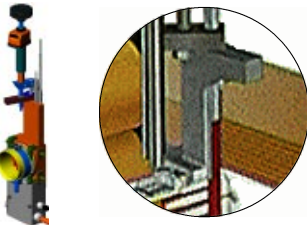
| Model              | 1906 M                                 |  |
|--------------------|--|--|
| Operating pressure | max. 6 bar<br>(6 x 10 <sup>5</sup> Pa) |  |
| Air consumption    | 50 L/min                               |  |

## 1.11 Accessories

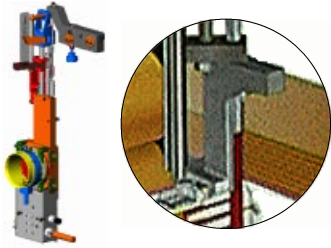
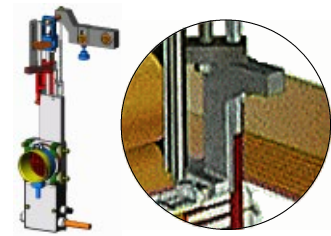
### 1.11.1 Operating tools

|  | 1906 M         | Application   |
|--|----------------|---|
| Hex.-socket offset screw key             | A/F 4 ISO 2936 | Removal and re-installation of metering rod strap   |
| Offset screw driver with hexagonal pivot | A/F 8 DIN 6911 | Setting glue application to lower edge of workpiece |
| Single ended spanner                     | A/F 30 DIN 894 | Setting glue application to lower edge of workpiece |
| Nozzle scraper                           | X              | Cleaning nozzle of glue remains                     |
| Wire brush                               | X              | Cleaning nozzle of glue remains                     |
| Nozzle bore broach                       | X              | Cleaning out glue delivery bores at nozzle          |

## 1.12 Special accessories

|   | 1906 M              | Application  |
|---|---------------------|--|
| Add-on unit for processing PUR glue<br>  | Article No. 1614789 | When processing PUR hot-melt glue, an additional pressure reducer is needed to reduce the glue application rate. |
| Tracing nozzle cpl.<br>Wiper 90°<br>- manual adjustment<br>- without pressure bridge connection<br>Model range SPRINT<br>          | Article No. 5002956 | More glue applied to the workpiece edge when gluing solid edging.  |
| Nozzle cpl.<br>Wiper 90°<br>- manual adjustment<br>- without pressure bridge connection<br>Model range SPRINT/TRIATHLON/ACCORD<br> | Article No. 5002957 |  |

Continuation

|  | 1906 M                     | Application  |
|--|----------------------------|--|
| <p>Tracing nozzle cpl.<br/>Wiper 90°<br/>- with pressure bridge connection<br/>Model range SPRINT</p>                      | <p>Article No. 5002959</p> |  |
|   |                            | <p>More glue applied to the workpiece edge when gluing solid edging.</p> |
| <p>Tracing nozzle cpl.<br/>Wiper 90°<br/>- without pusher<br/>- with pressure bridge connection<br/>Model range SPRINT</p> | <p>Article No. 5003980</p> |  |
|   |                            | <p>More glue applied to the workpiece edge when gluing solid edging.</p> |



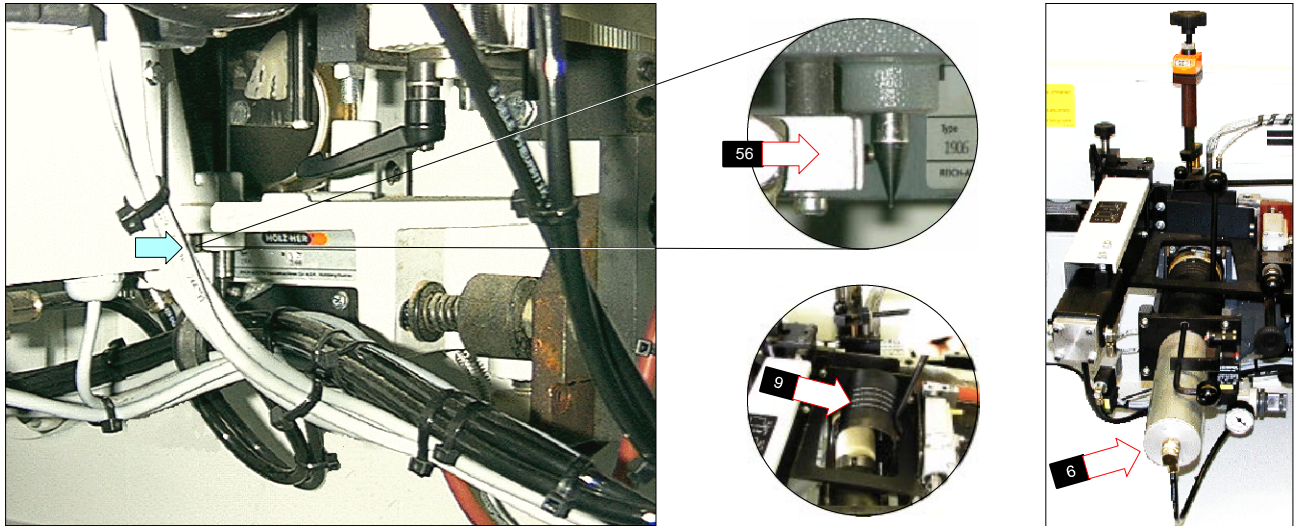
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See also operating manual for the basic machine, chapter "safety".

## 2.1 Protective devices

### ● Pressure relief for glue cartridge pressure cylinder (6)

When the cover (9) for the glue cartridge shaft is removed, the air supply to the pressure cylinder (6) for the glue cartridges is interrupted by an air valve 0.3 (56).



### ● Machine shut-down after 6 minutes (not at model range UNO)

- Once the operating temperature has been reached, the timer starts and switches the machine off if no workpiece has been fed in.
- After a machining pause longer than the set time interval, with a consequential non-activation of the corresponding PLC line point, the machine will switch off.



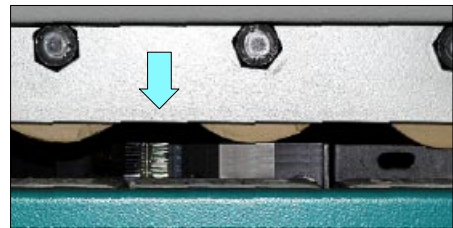
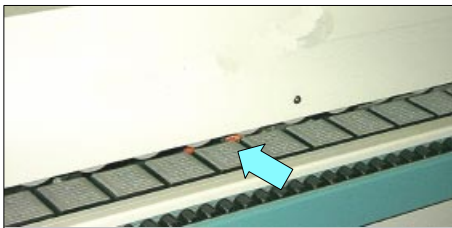
## 2.2 Residual risks

- Our machines harbour residual risks that are unavoidable despite the care taken in their design and manufacture, and that are inherent to operation of the machine.

**⚠ DANGER**

### Residual risks are:

- Uncovered area between transport chain and raised pressure bridge at the basic machine. This would allow access to the glue application roller.  
Danger of burns!



- Hot-melt glues produce vapours, even at recommended processing temperatures. This may lead to unpleasant odours being generated and to an irritation of the breathing and sensory organs. Should the stated processing temperatures be considerably exceeded over a long period of time, dangerous decomposition products may also develop.  
For this reason it is important that the vapours produced should be evacuated by suitable means, such as an extraction unit fit for the purpose.

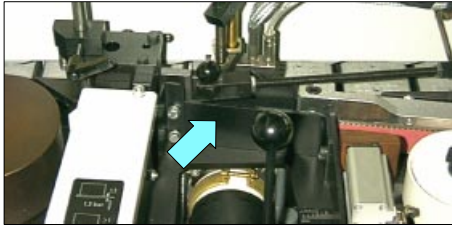
When processing PUR hot-melt glues, even when keeping to the recommended processing temperature, vapours may be produced that may possibly contain minimal quantities of residual isocyanic monomers, for which reason good extraction facilities and proper ventilation are essential.

Read and observe the safety and processing instructions issued by the glue manufacturer.

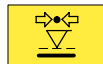




- There is a burn hazard when working in the area of the hot glue station.



- Exceeding the limiting pressure for pneumatic hoses.



- The manufacturer of this machine shall not be liable for risks arising from the use of other agents (such as lubricants or cleaners) or from hooking up the machine to machines or products made by other manufacturers. ◀



## Safety

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## 3.1 General description

- This machine/unit is based on years of practical experience and incorporates the results of extensive studies in research and development.

## 3.2 Mode of operation

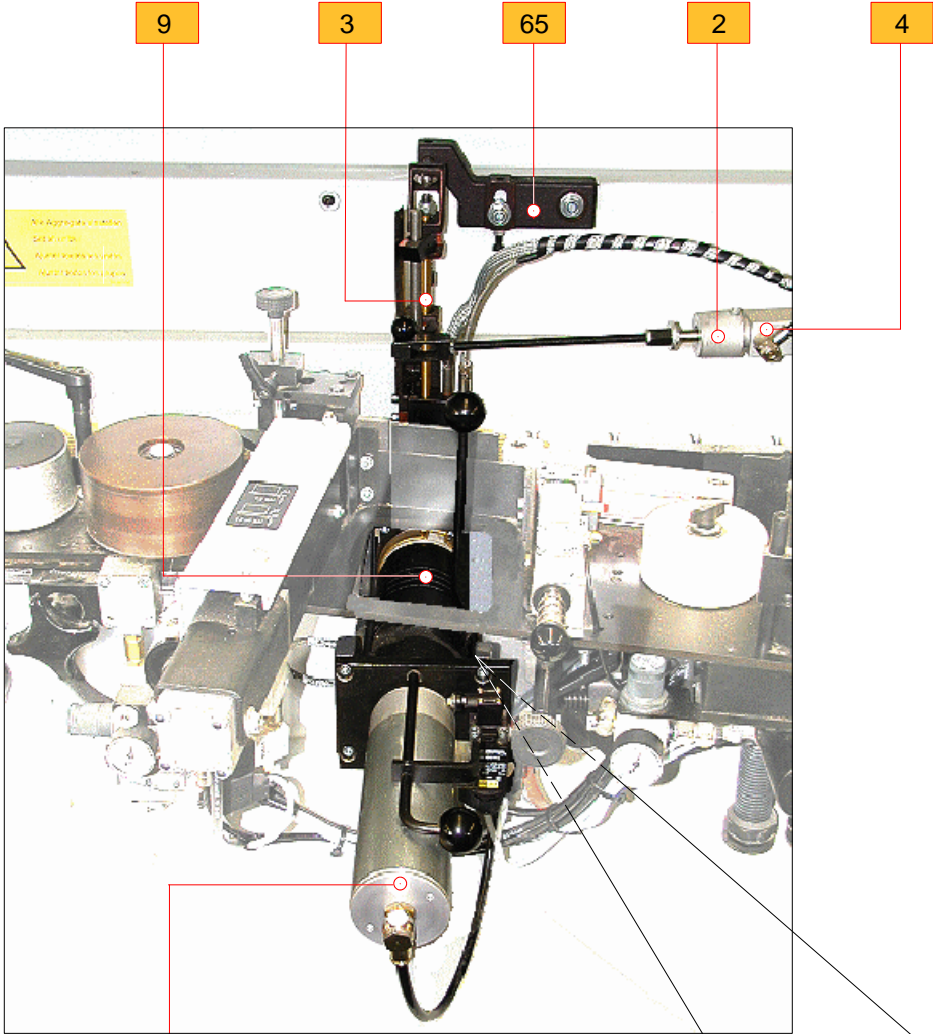
- The workpiece is placed onto a continuously driven transport chain with precision-guided coated plastic links; pressed and positively held onto it by means of either idling rubber-coated pressure rollers or spring-loaded roller levers with a revolving endless composite belt, from where it is then passed along the application nozzle of the glue station.

In a hot/cold process, the workpiece edge is coated with hot-melt glue by means of an electro-pneumatically controlled application nozzle, then the edging is glued to this surface by contact pressure. Only as much hot melt glue is melted as is needed for the present banding process.

Loading of the melt unit is by glue compound in the shape of cartridges.  
The glue cartridges are manually refilled for the melt unit.

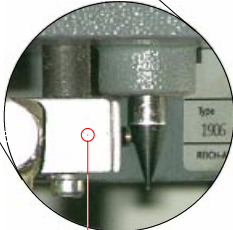
### 3.3 Design

- 1 Console
- 2 Adjusting nut - Setting of glue flow
- 3 Metering rod
- 4 Cylinder, glue
- 5 Glue cartridge shaft
- 6 Cylinder - Glue cartridge press-on
- 7 Press-on piston
- 9 Cover, glue cartridge shaft
- 12 Handle to set metering rod to workpiece top edge  
(version without pressure bridge connection)
- 14 Position indicator  
(version without pressure bridge connection)
- 26 Knurled nut to adjust nozzle pressure on workpiece
- 27 Knurled nut to set working position Yes/No
- 29 Nozzle for glue application
- 56 Breather valve (0.3) - Safety
- 60 Glue cartridge
- 61 Tracing nozzle for glue application  
(version)
- 65 Pressure bridge connection to set metering rod to workpiece top edge
- 90 Add-on unit for processing PUR glue

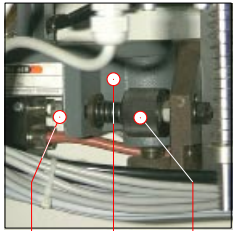


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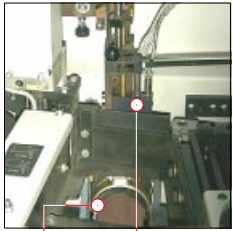
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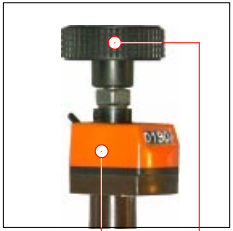
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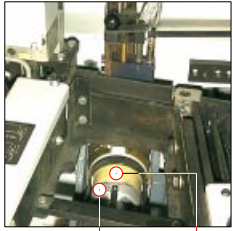
27 1 26



5 29



14 12



7 60



61

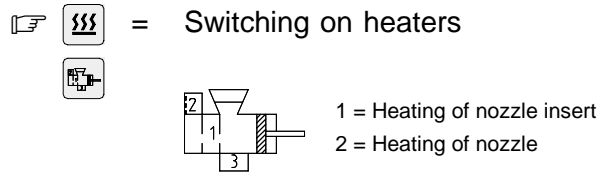


## Design and mode of operation

- Void page -

## 4.1 Putting the glue station into service

### 4.1.1 Switching on



- For program start see operating manual basic machine in the chapter "Control".

## 4.2 Collecting basin for melted glue

### Model range SPRINT

- Place collecting basin (50) in recess of frame.



en

50

### DANGER



#### **Danger of burns via hot glue.**

During the cleaning process, glue from the nozzle bores will flow into the collecting basin.

Wear heat protection gloves. ◀



Model range UNO

- Place a collecting basin (50) under the nozzle.



50

**⚠ DANGER****Danger of burns via hot glue.**

During the cleaning process, glue from the nozzle bores will flow into the collecting basin.

Wear heat protection gloves. ◀



## 5.1 General instructions

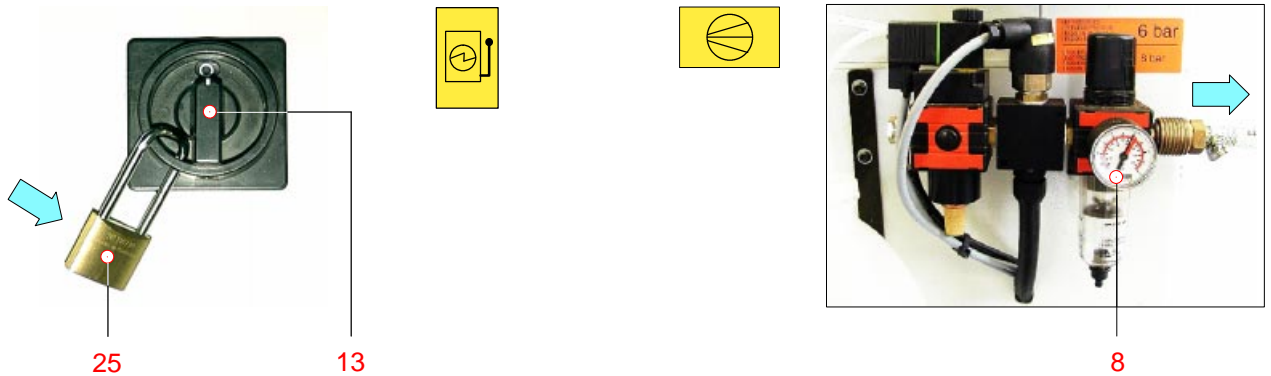
### **⚠ DANGER**

**Removal of safety hoods or safety switches is not permissible!**

This could cause very serious injuries. Protection hoods and safety switches have been provided for your own safety!

The voltage must be switched off before work is started on the machine. Turn off the main switch (13) - setting «O» - and secure it with a padlock (25).

Depressurise the pneumatic supply system (8)! ◀

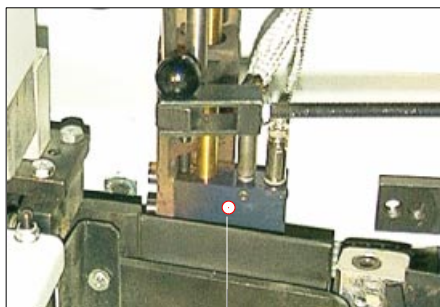


### **⚠ DANGER**

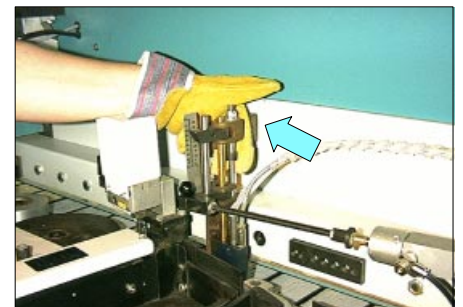


**Danger of burns!**

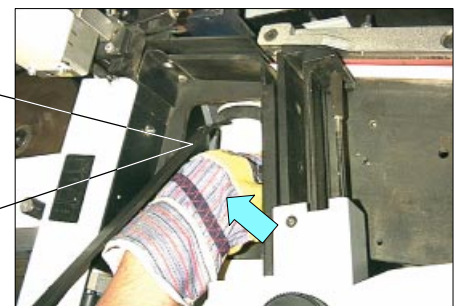
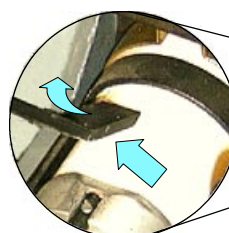
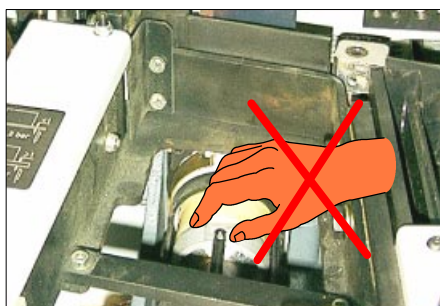
Always wear heat protection gloves when working at the hot nozzle (29).



29



When changing the glue cartridge never put your hands in the cartridge feeder. Use a tool (e.g. nozzle scraper) and wear heat protection gloves. ◀

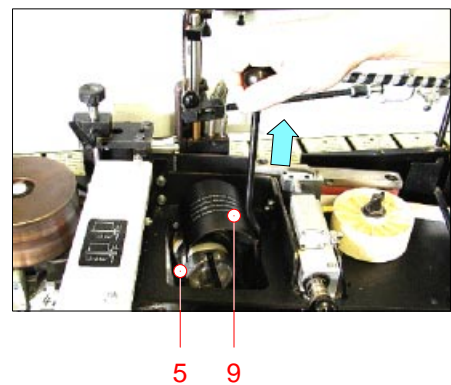
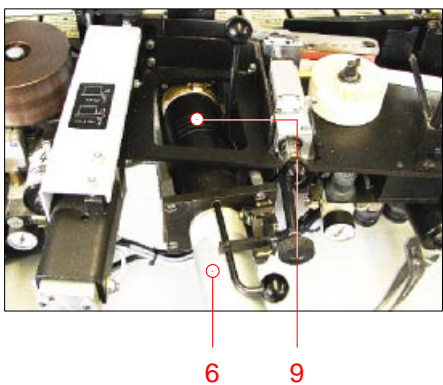


## 5.2 Insertion of glue cartridges into glue shaft

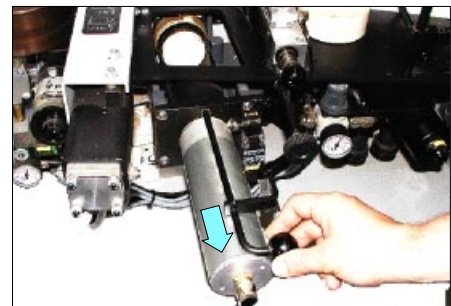
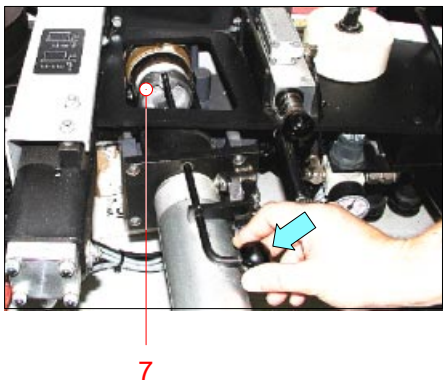
**CAUTION**

Always observe manufacturers' processing advice and recommendations!  
REICH Special Machines assume no responsibility in respect of the glue supplied with the new machine as regards optimum glueing properties for any specific edging material. ◀

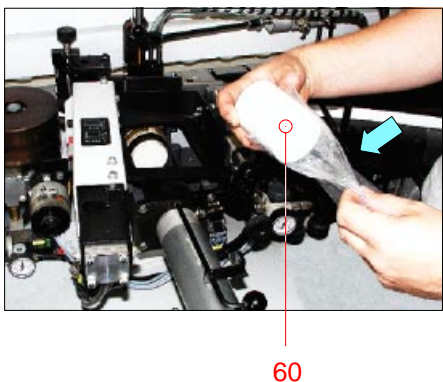
- Lift cover (9) of glue shaft (5).  
The pressure to the pressure cylinder (6) for the glue cartridge is automatically relieved.



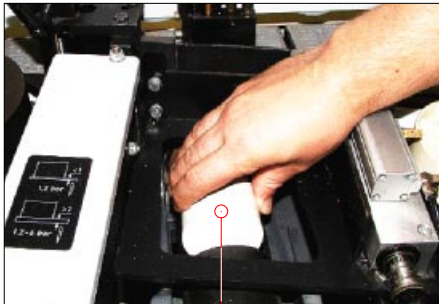
- Retract the pressure piston (7) for the glue cartridge by means of the ball end.



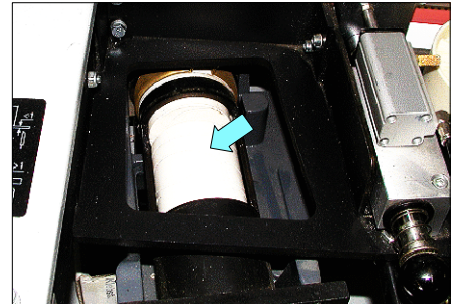
- Select the glue cartridge type (60) appropriate to the application.  
Do not remove the protective cover until the cartridge is ready for insertion into the glue shaft.



- Insert glue cartridge (60) into the shaft.  
(Capacity 1 cartridge = approx. 0,3 kg)



60



### ⚠ CAUTION

When re-loading glue cartridges (60), no dirt or off-cut particles must be allowed to fall into the glue stack.

Otherwise the bores in the heating area may become blocked.

Carefully insert clean glue cartridges (60) with the flat surface facing the pressure piston of the pressure cylinder. ◀



60

Surface drawn

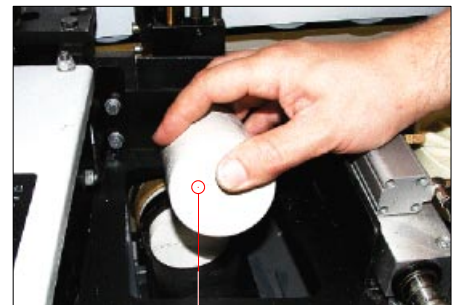


wrong side

Surface flat

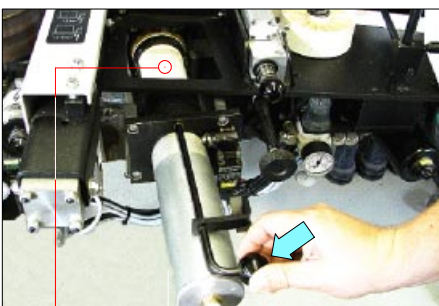


correct side

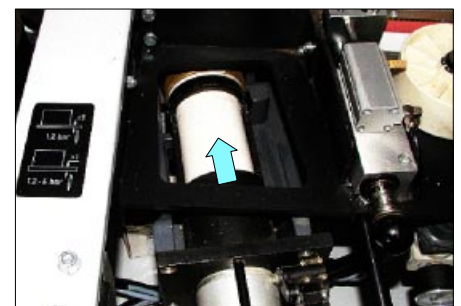


60

- Advance the pressure piston for the glue cartridge (60) by means of the ball end.

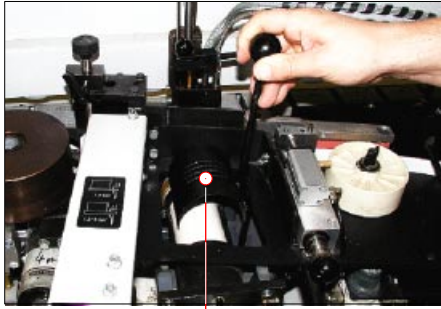


60



- Insert cover (9) of glue shaft.

Make sure that there is no gap or leak around the cover, to ensure that the compressed air can activate the pressure cylinder by way of the compressed air valve (0.3).



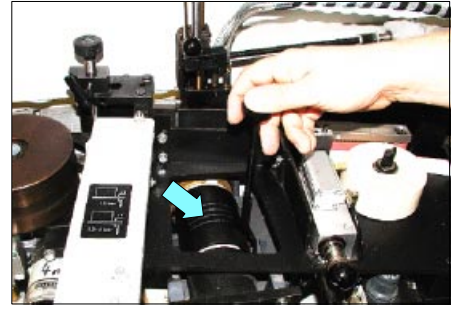
9



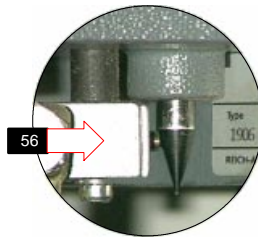
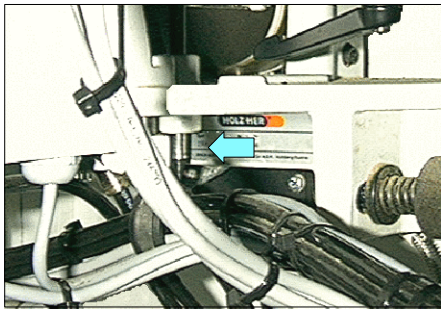
Gap around cover



No-gap cover

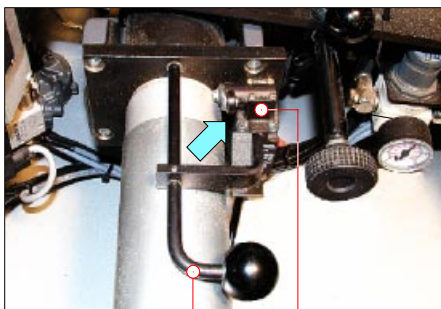


The cover must be applied so that no gap occurs, to ensure the activation of the pressure cylinder by way of the compressed air valve (0.3) (56).



56

- The fully-automated control system permits continuous operation with an exactly metered and aligned glue application. When the hot-melt glue cartridge is exhausted, a lever (46) presses on the control switch (47) and the PLC shows a fault message on the display of the operating panel. At the same time, the white indicator light (122) for workpiece release remains extinguished. The red light shines at the model range UNO at the heating symbol. There is a glue reservoir for the panel in the machine.



46

47

**Fault message:**  
REFILL HEATING SYSTEM

Acknowledge fault message after refill by pressing delete key (104). (orange key)

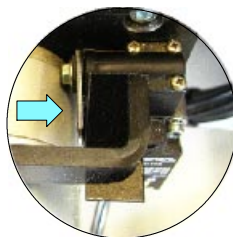


Illustration:  
PLC control

122



Illustration:  
Model range UNO

107

### 5.3 Setting of processing temperature

#### **⚠ DANGER**

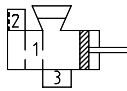
#### **Exceeding processing temperature!**

If the indicated glue processing temperature is exceeded over a prolonged period, there is the danger of noxious decomposition products being developed.

Always use the glue at the temperature recommended by the manufacturer!

When processing PUR hot-melt glues, even when keeping to the recommended processing temperature, vapours may be produced that may possibly contain minimal quantities of residual isocyanic monomers, for which reason good extraction facilities and proper ventilation are essential. Take measures to duct away any vapours (extractor). ◀

  = Switching on heaters



1 = Heating of nozzle insert  
2 = Heating of nozzle

The nominal values for heating of nozzle insert «1» and heating of nozzle «2» can be changed.

- See operating manual basic machine in the chapter "Control".

Observe the processing temperature by the manufacturer.

#### **NOTICE**

For one best possible flow of glue, the nominal temperature for heating of nozzle «2» should be set higher by 5-10 ° C than the nominal value for the heating of nozzle insert «1». ◀

#### **⚠ CAUTION**

The modified values remain stored even after using the OFF button at the control panel or the EMERGENCY-OFF device.

If the machine is switched off at the main switch before saving the current programs, the modified values will *not* be stored.

## 5.4 Setting glue application to workpiece front edge

**CAUTION**

Only adjust metering stick (3), either manually or by pressure bridge connection, when the unit is hot.

Otherwise there is a risk of damage to the glue application system.

Before re-setting the metering rod, wait until the glue has reached its processing temperature.

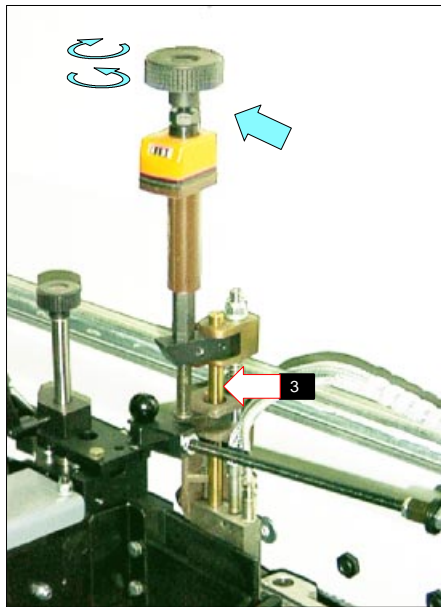


Illustration:  
Metering rod (3) with manual adjustment spindle  
Setting to workpiece thickness

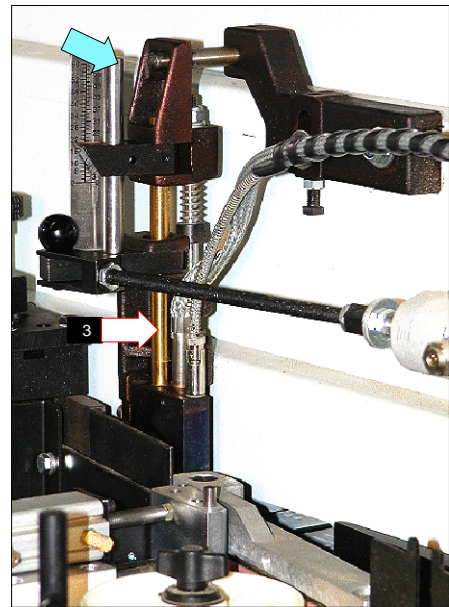
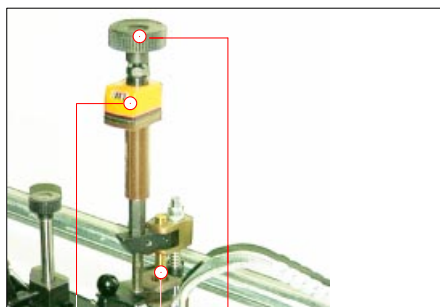


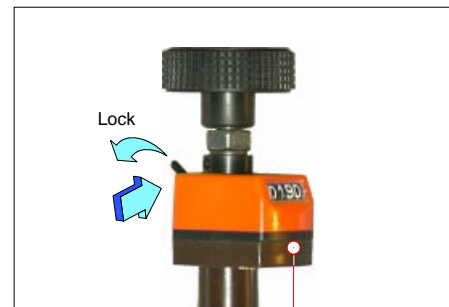
Illustration:  
Nozzle metering rod (3) with pressure bridge connection  
Adjustment of metering rod by setting pressure bridge  
to workpiece thickness.

## 5.4.1 Metering rod adjustment by hand with spindle to position indicator

- Set metering rod (3) with handle (8) to workpiece thickness according to position indicator (14). Lock the dimension set by means of rocker lever at position indicator (14).



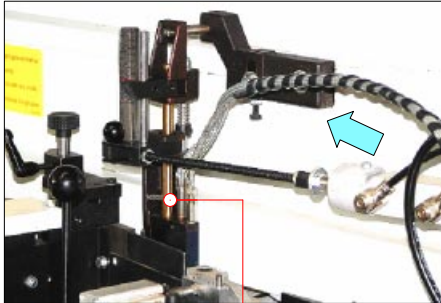
14 3 8



14

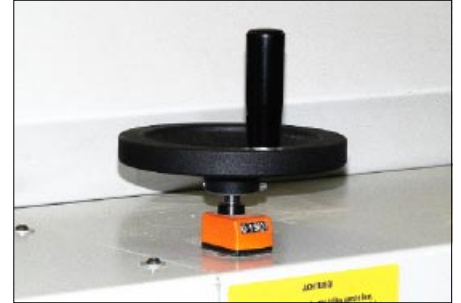
## 5.4.2 Metering rod adjustment with pressure bridge connection

- Set the metering stick (3) to the workpiece thickness by means of the manual adjustment facility (A) of the pressure bridge.



3

Illustration:  
Nozzle metering rod (3) with bridge connection

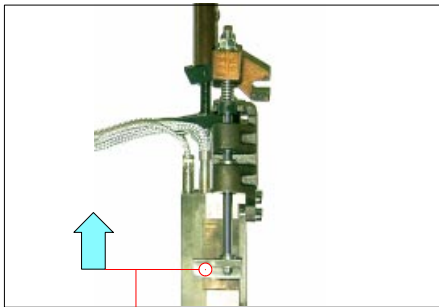


A

## 5.4.3 Version «Tracing nozzle» - Processing of glued-on edging

**⚠ CAUTION**

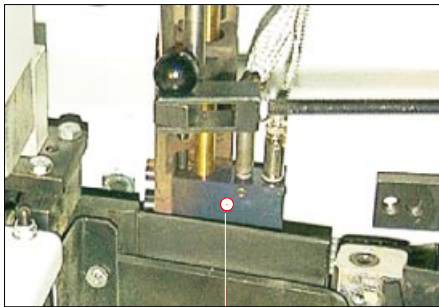
When processing workpieces with glued-on edging and using the version «Tracing nozzle» the tracer shoe (66) must be raised.  
Non-observation implies the risk of damage to the glue application system.  
Raising tracer shoe. ◀



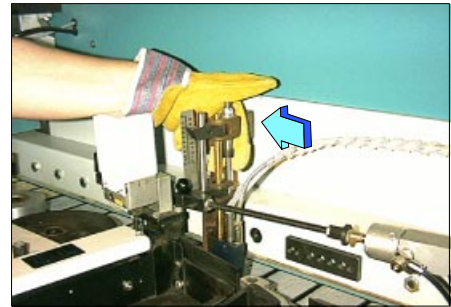
66

**⚠ DANGER**

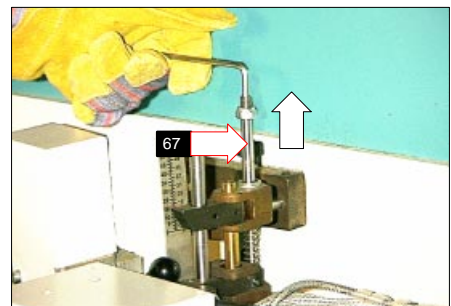
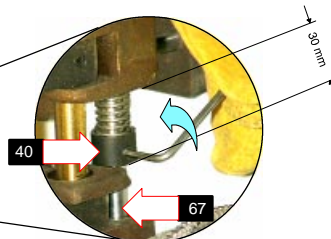
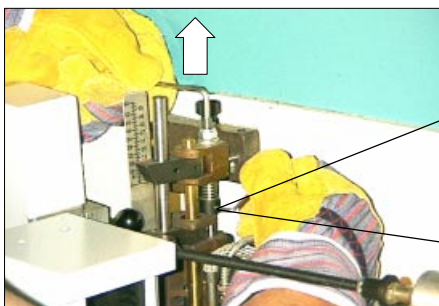
**Danger of burns!**  
Always wear heat protection gloves when working at the hot nozzle (29).



29



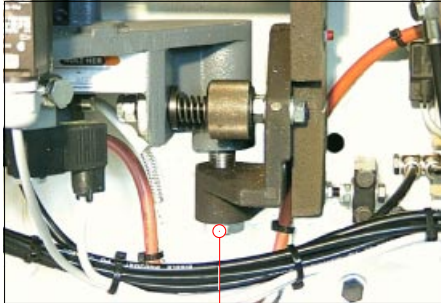
- Release belleville spring washer (40) on tracer shaft (67) below the pressure spring, raise the tracer shoe and once more tighten the belleville spring washer (40).



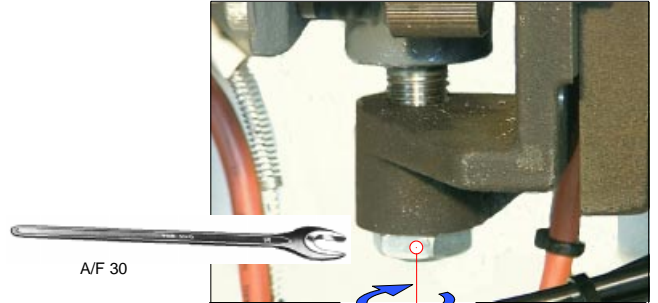


## 5.5 Setting of glue application to workpiece bottom edge - readjustment

- Loosen hex. nut (22).



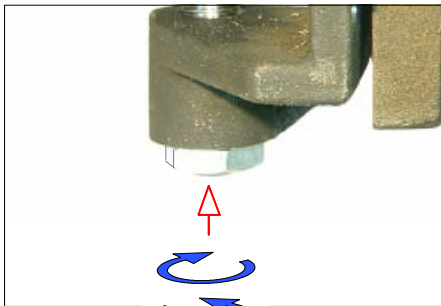
22



A/F 30

22

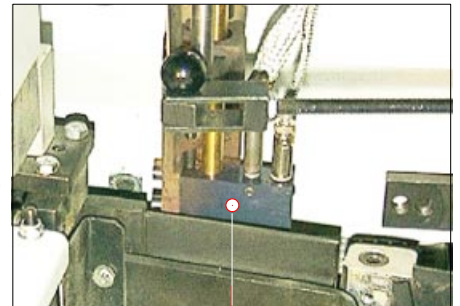
- Adjust with offset screw driver.



A/F 8

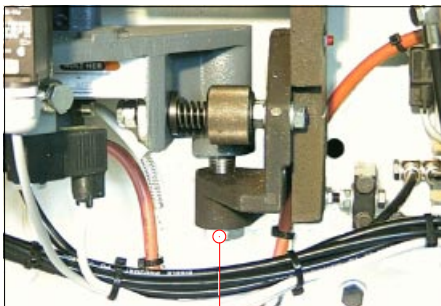
Turning clockwise= moves nozzle (29) **downwards**

Turning anti-clockwise = moves nozzle (29) **upwards**

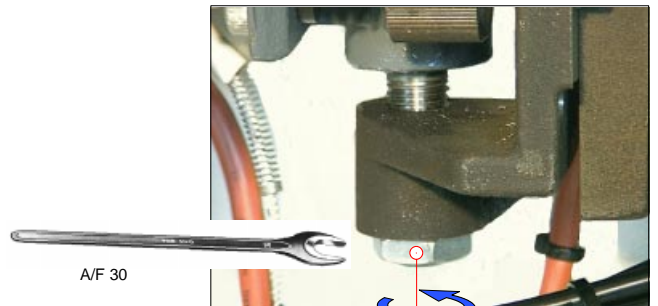


29

- Tighten hex. nut (22).



22

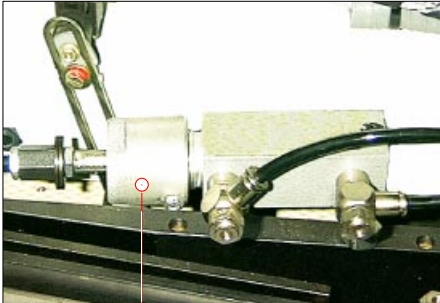


A/F 30

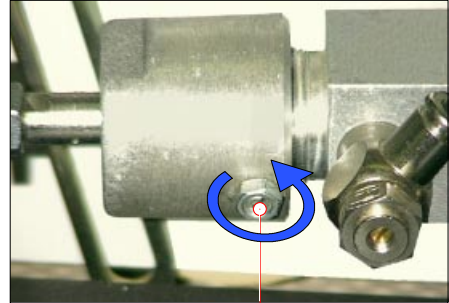
22

## 5.6 Setting of glue application

- Loosen clamping screw (44) at setting nut (2).

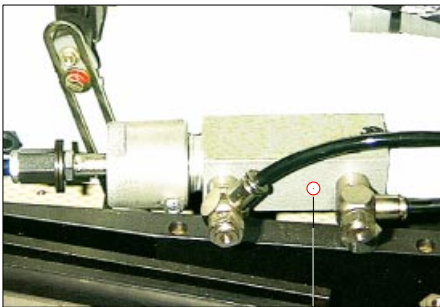


2



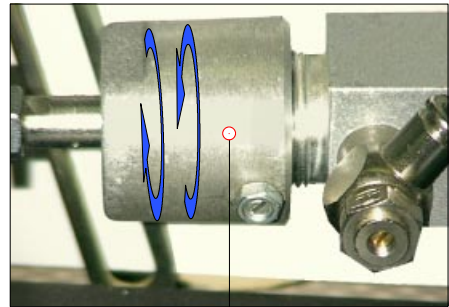
44

- Turn setting nut (2) at glue cylinder (4).



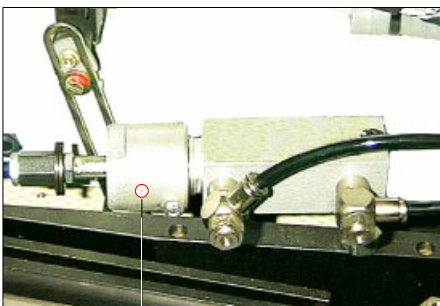
4

Turning clockwise= **increased**  
 glue application  
 Turning anti-clockwise = **decreased**  
 glue application

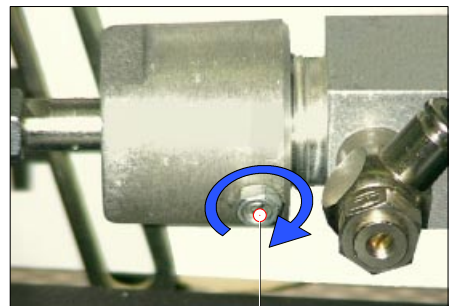


2

- Tighten clamping screw (44) at setting nut (2) and fix by a hex. nut.



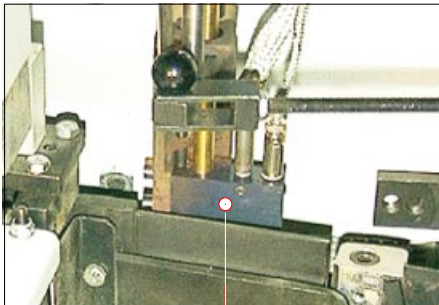
2



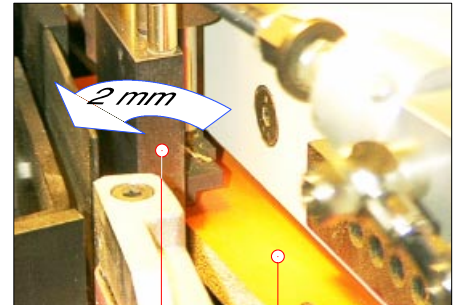
44

## 5.7 Setting nozzle (29) to workpiece infeed fence

- The nozzle (29) must spring back by approx. 2 mm as the workpiece is fed through (A).



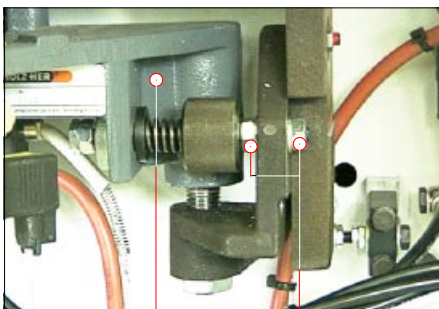
29



29

A

- Adjustment:
  - Loosen hex. nuts (24).
  - Turn console (1) by 2 mm approx.
  - Fixed by hex. nuts (24).

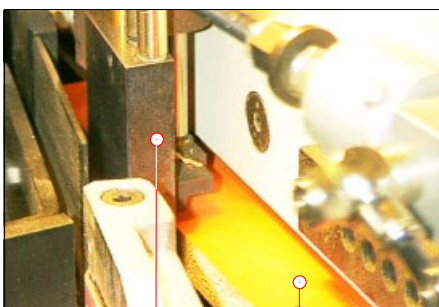


1

24

## 5.8 Nozzle (29) pressure on workpiece

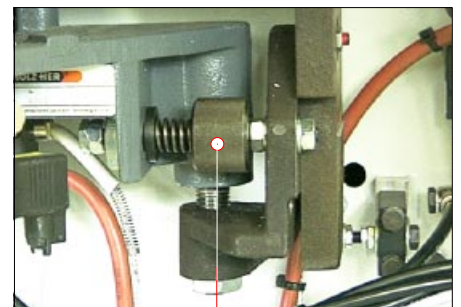
- Pressure on workpiece (A) about 70 N.  
When processing other glue types, such as thin PU glues, it is necessary to readjust the pressure force.  
Adjustment: Loosen or tighten the knurled nut (26) on threaded rod.



29

A

Knurled nut (26):  
 Turning clockwise = pressure force **more**  
 ○ prestressed spring  
 Turning anti-clockwise = pressure force **less**  
 ○ released spring

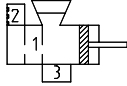


26

5.9 Change of glue cartridge

- Select heaters with key at operating panel.

  = Switching on heaters

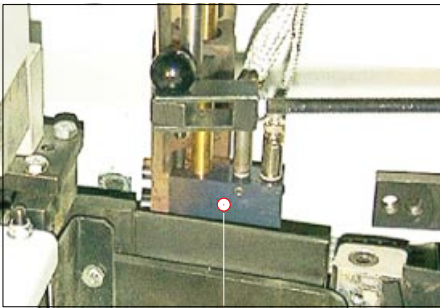


1 = Heating of nozzle insert  
2 = Heating of nozzle

**⚠ DANGER**

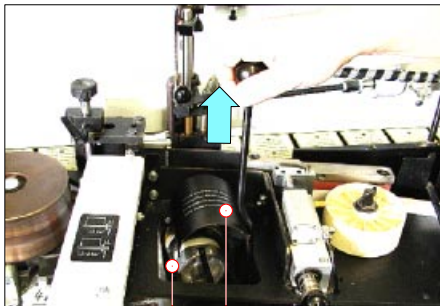


**Danger of burns!**  
Always wear heat protection gloves when working at the hot nozzle (29).

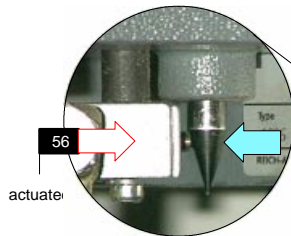


29

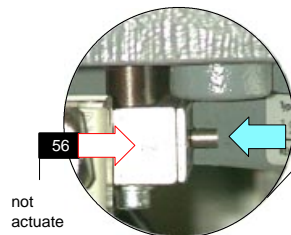
- Remove cover (9) for glue shaft.  
Compressed air supply to the pressure cylinder for the glue cartridges is interrupted because of non-activation of air valve (56).



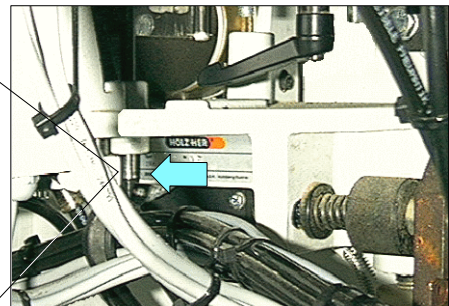
5 9



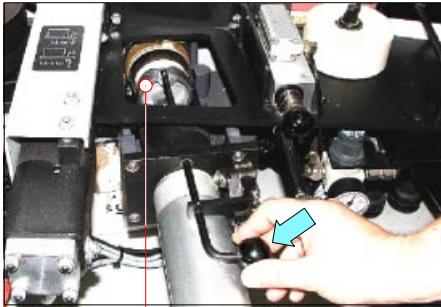
actuate



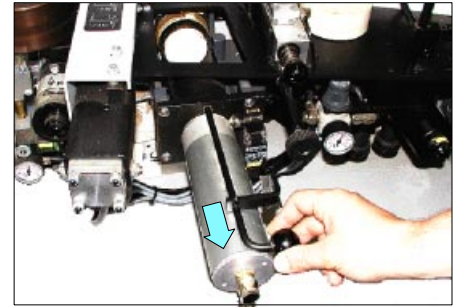
not actuate



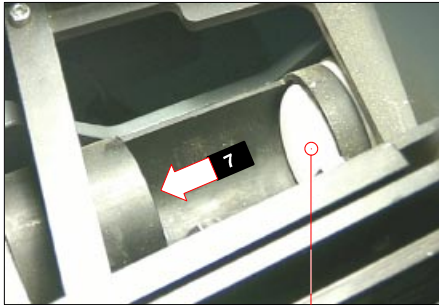
- Retract the pressure piston (7) for the glue cartridge by means of the ball end.



7

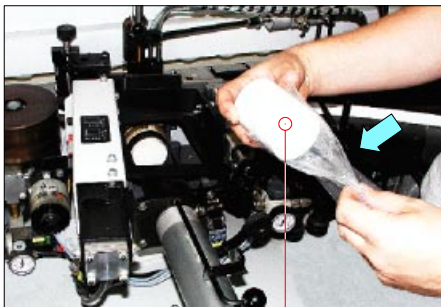


- Pressure piston (7) of pressure cylinder for glue cartridge (60) retracted.



60

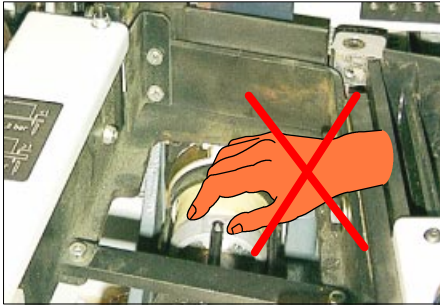
- Select the glue cartridge type (60) appropriate to the application.  
Do not remove the protective cover until the cartridge is ready for insertion into the glue shaft.



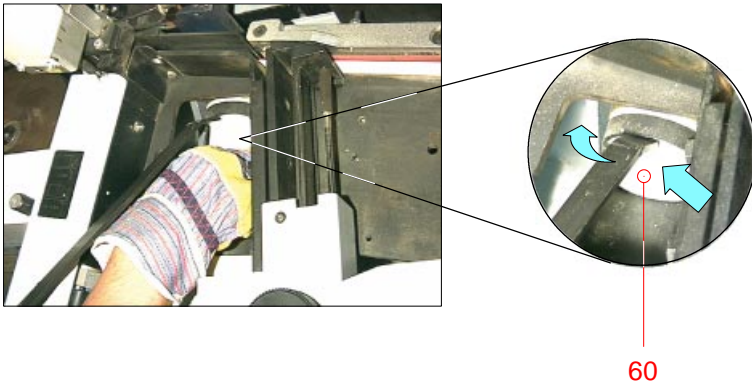
60

**⚠ DANGER****Danger of burns!**

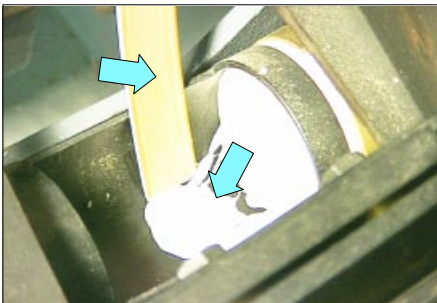
When changing the glue cartridge never put your hands in the cartridge feeder. Use a tool (e.g. nozzle scraper) and wear heat protection gloves. ◀



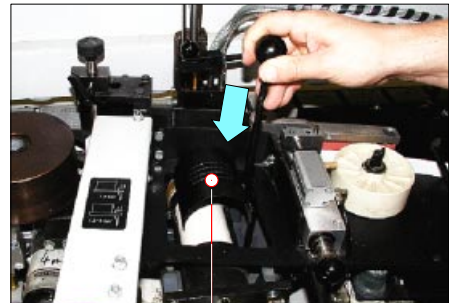
- Remove glue cartridge remainder (60) from feeder well, using a tool (e. g. nozzle scraper).



- Remove glue threads from the glue stack with a suitable tool (such as a piece of edging). Insert new glue cartridge (see chapter 5.2) and replace cover (9).



see chapter 5.2

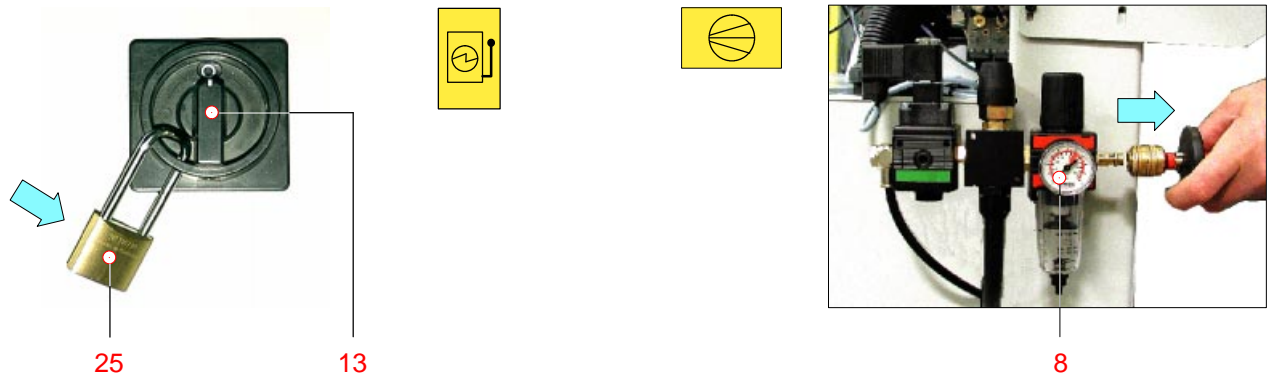


9

## 6.1 General instructions

### **⚠ DANGER**

Refer to the chapter «Safety» during maintenance and inspection work.  
The voltage must be switched off before work is started on the machine. Turn off the main switch (13) - setting «O» - and secure it with a padlock (25).  
Depressurise the pneumatic supply system (8)!



- Clean the machine/unit daily.  
Remove wood chips with a suitable brush or with a saw dust approved extractor system.  
Remove any wood left inside, particularly in the area of the motor, spindles and guideways.

### **⚠ DANGER**



**This will endanger your health!**

Because of the fine dust produced, the machine should never be cleaned with compressed air.

Use extraction system released for wood dust. ◀

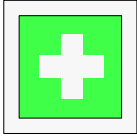
- Lightly grease all moving parts, such as sliding surfaces, adjusting spindles and guideways, whenever required.



**Pollution of the environment.**

Waste material of all kinds should be disposed of in an environmentally friendly way and in compliance with local recycling and disposal procedures. ◀

Continuation

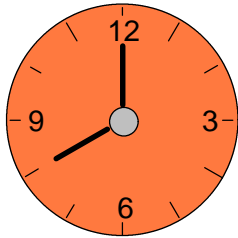


### Emergency measures

- If molten glue should come into contact with the skin, rinse affected area immediately under cool running water (not iced water) for 10 to 15 minutes, until the pain subsides.
- Never try to prise glue off the skin.
- Burns should be treated by a medical practitioner as soon as possible.

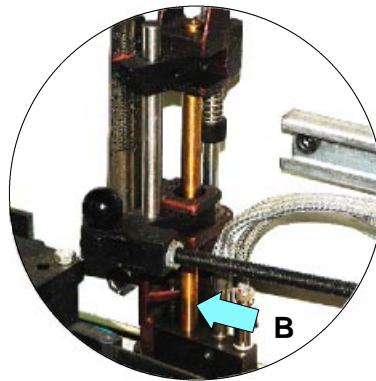
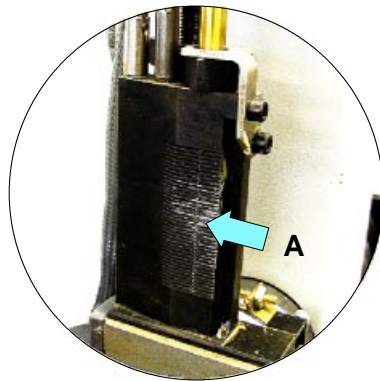


6.2 Maintenance chart



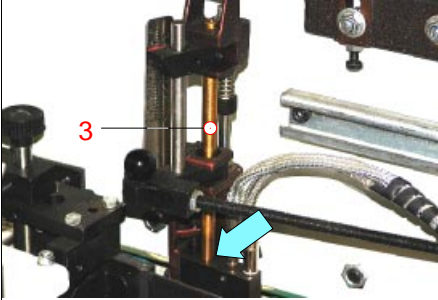
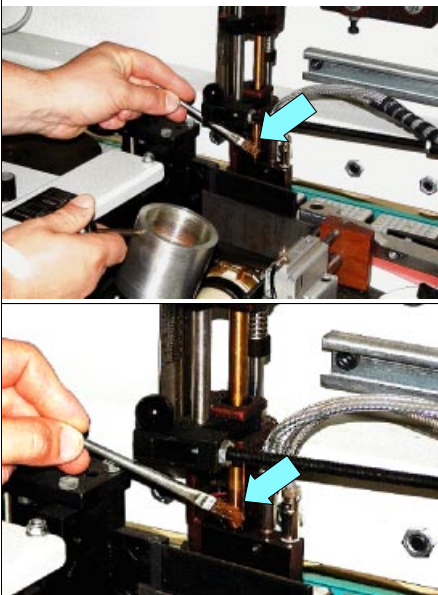
In single-shift operation the operating hours correspond to a certain lubrication rhythm:

- 2000 hrs. ----- Every year
- 1000 hrs. ----- Every six months
- 160 hrs. ----- Every month
- 40 hrs. ----- Every week
- 8 hrs. ----- Every day



| Item | Maintenance point     | Interval | Maintenance work  | Remarks                             |
|------|-----------------------|----------|---|-------------------------------------|
| A    | Glue application area | 8 hrs.   | Visual inspection.<br>Remove residual glue incrustations and dirt with nozzle scraper (63) and wire brush (64). | Proceed as indicated in chapter 6.3 |
|      |                       |          | <p>63</p> <p>64</p>   |                                     |

Continuation

| Item | Maintenance point      | Interval | Maintenance work  | Remarks   |
|------|------------------------|----------|---|---|
| B    | Oiling metering stick. | 8 hrs.   | Thinly apply a coat of light engine oil, such as SAE 10 W 30 , to metering stick (3). |   |
|      |                        |          |     | <p>Set metering stick to approximately 40 to 50 mm glue application height, either manually, motor-assisted or through the bridge, depending on model.</p> <p>See chapter 5.4.</p> <p><b>Caution!</b><br/>Wait for the glue to reach processing temperature before changing the metering stick setting.</p> |
|      |                        |          |    | <p><b>Caution!</b><br/>Do not contaminate the glue application area with engine oil. Otherwise there may be a risk of danger from the edging stop.</p> <p>Only apply a <u>thin</u> film of engine oil to the metering stick.</p>  |

### 6.3 Cleaning of glue application area

**⚠ DANGER**



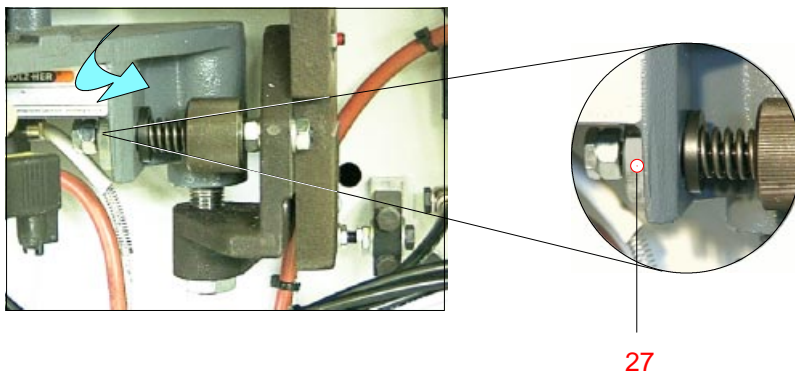
**Danger of burns!**

Be very careful when working with melted glue. Even solidified glue can still be very hot.

Always wear protective clothing covering all body parts at risk. ◀

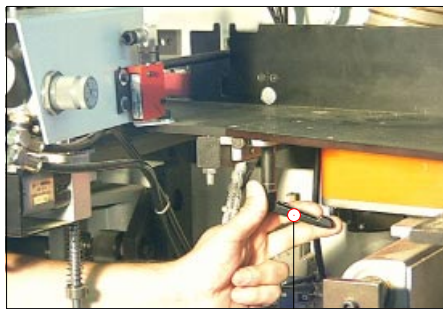
#### 6.3.1 Removing glue residues

- Press back glue station against spring pressure and set knurled nut (27) against support wall.



27

- More free space becomes available if the edging feed unit is retracted. Loosen clamping lever (62).



62

- Place a collecting basin (50) under the nozzle.



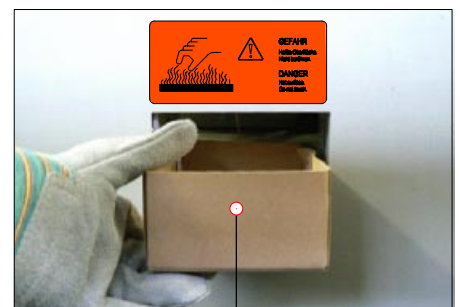
Model range UNO

50

**⚠ DANGER**



**Danger of burns via hot glue!**  
Wear heat protection gloves.

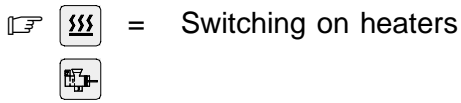


Model range SPRINT

50

Continuation

- Select heaters at operating field with the button and heat up to processing temperature of the glue.



- Expel remaining glue through the nozzle bores.

#### Model range SPRINT

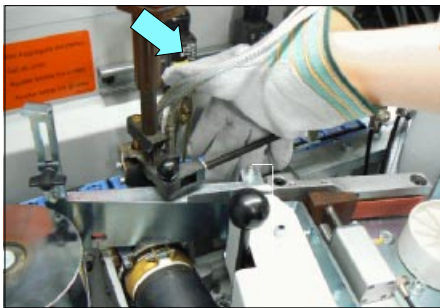
Release rinsing process—see operating manual basic machine in the chapter "Control".

#### Model range UNO

Switch (104) in position «0» for edging feed unit at operating panel.



Operate the control switch 1806 S9 if the control is on.



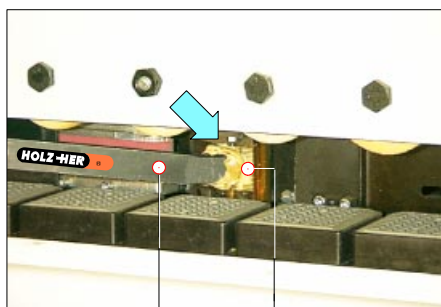
1806 S9

**⚠ DANGER**



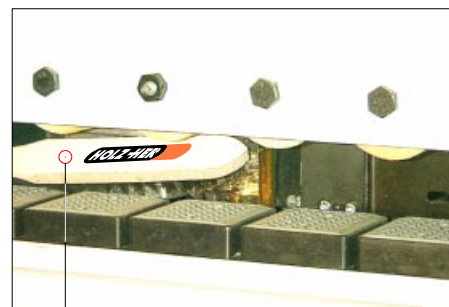
**Danger of burns via hot processing area of the nozzle.  
Wear heat protection gloves.**

- Clean glue remains from nozzle (29) with nozzle scraper (63) and wire brush (64).  
(Supplied as accessories)



63

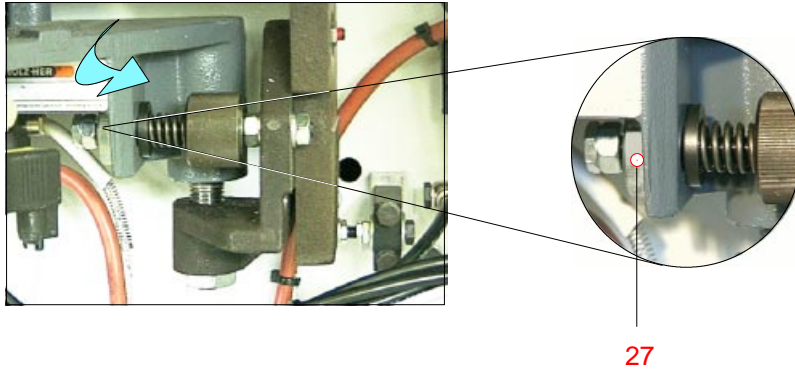
29



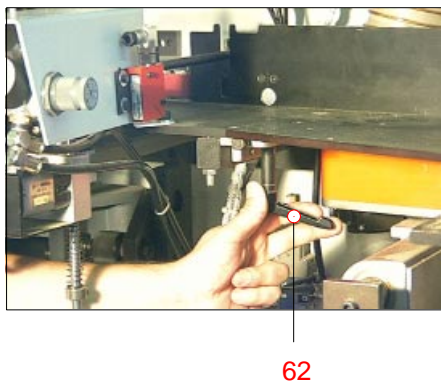
64

### 6.3.2 Cleaning of bores for glue delivery and metering rod

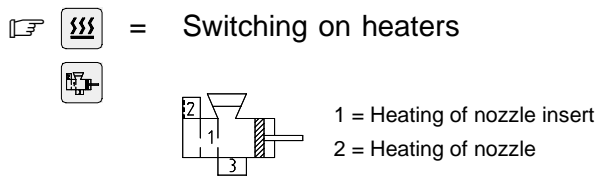
- Press back glue station against spring pressure and set knurled nut (27) against support wall.



- More free space becomes available if the edging feed unit is retracted. Loosen clamping lever (62).



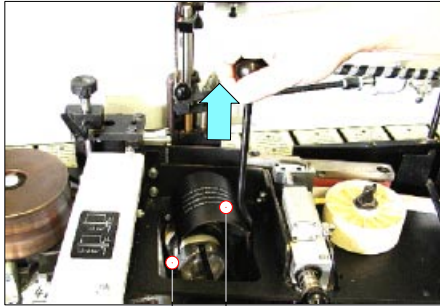
- Select heaters at operating field with the button and heat up to processing temperature of the glue.



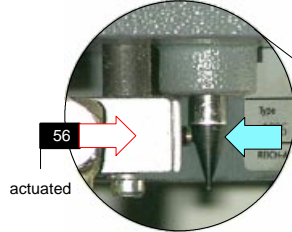
- Temperature reached; green light on

- Remove cover (9) for glue shaft (5).

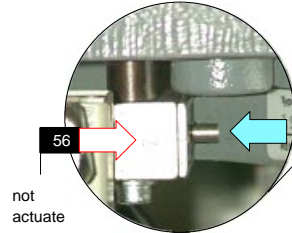
Compressed air supply to the pressure cylinder for the glue cartridges is interrupted because of non-activation of air valve (56).



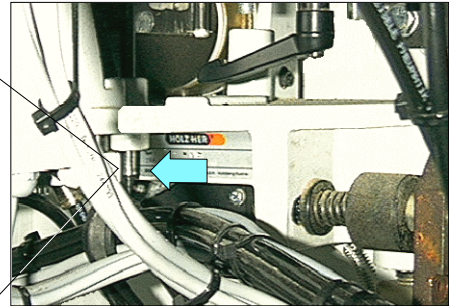
5 9



actuated



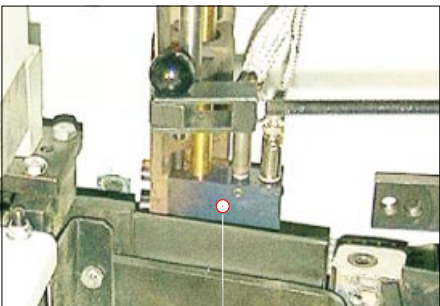
not  
actuate



### **⚠ DANGER**



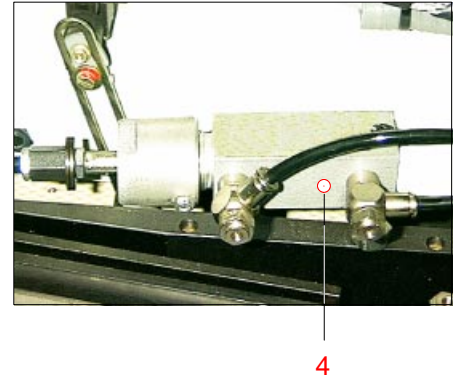
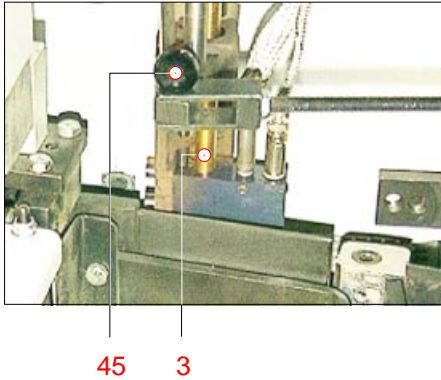
**Danger of burns!**  
Always wear heat protection gloves when working at the hot nozzle (29). ◀



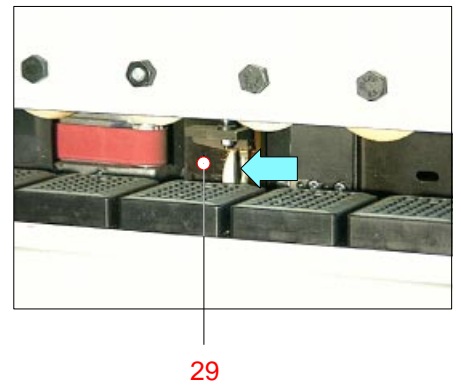
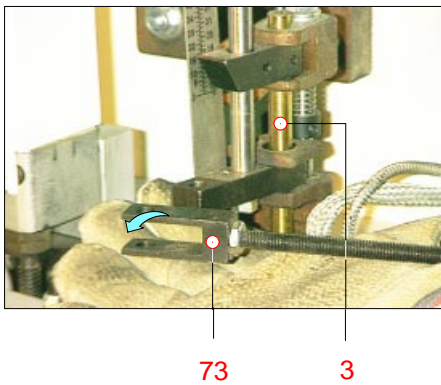
29

### 6.3.2.1 Cleaning of bores for glue delivery

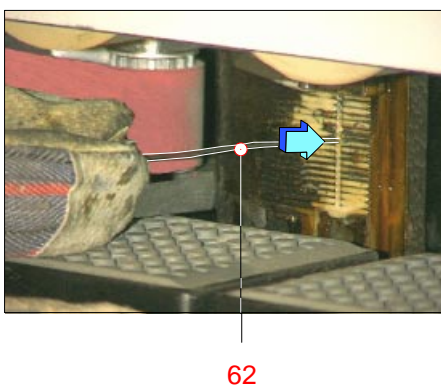
- Separate metering rod (3) from cylinder (4) by means of ball head knob (45).



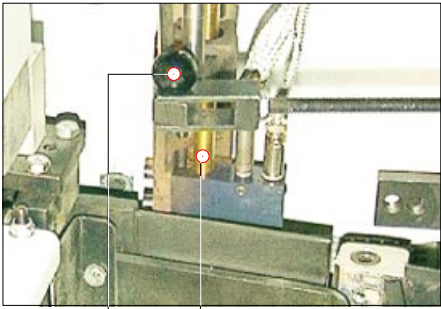
- Move fork joint (73) out of the way and turn metering rod (3) by hand until the bores for glue delivery at the nozzle (29) are open.



- Carefully clean out the glue delivery bores by means of broach (62), as supplied with the accessories.

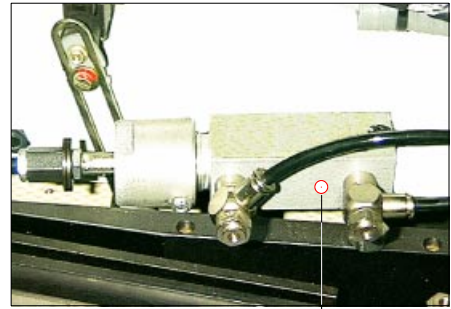


- Connect metering rod (3) to cylinder (4) by means of ball head knob (45).



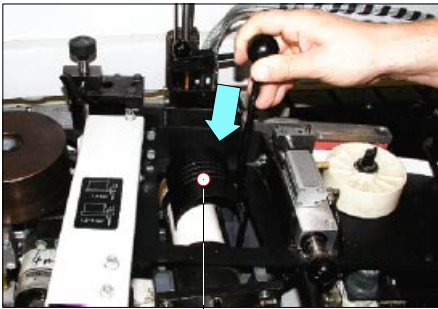
45

3



4

- Insert cover (9) for glue cartridge.

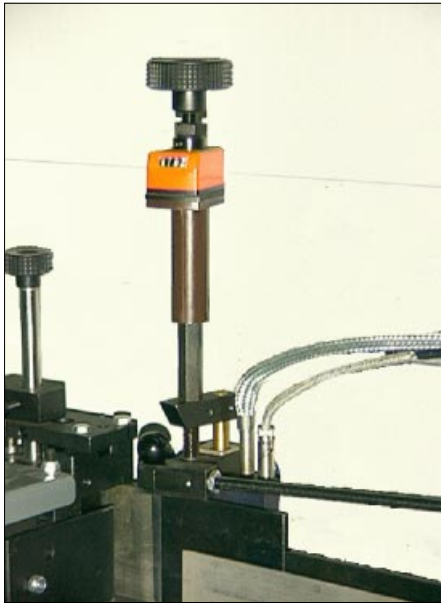


9

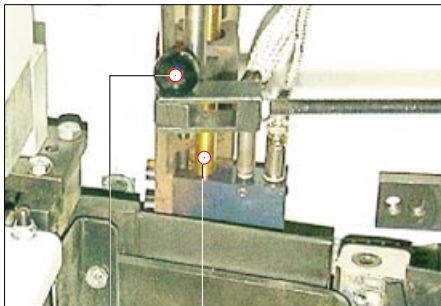


### 6.3.2.2 Cleaning of metering rod - Version *non-tracing* nozzle with position indicator

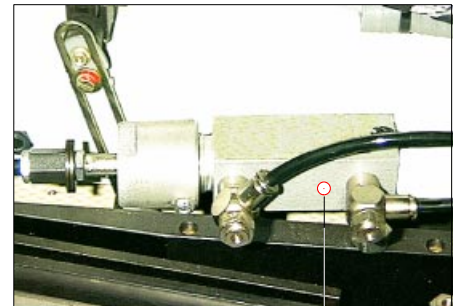
- Version non-tracing nozzle with position indicator.



- Separate metering rod (3) from cylinder (4) by means of ball head knob (45).

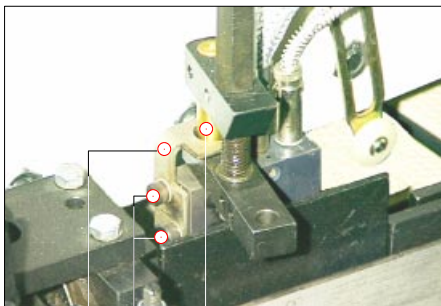


45 3

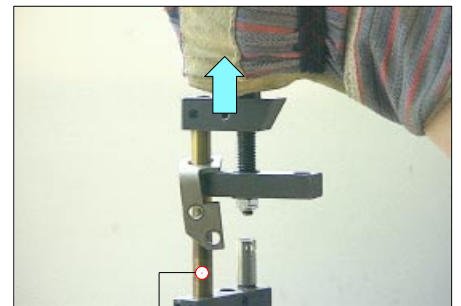


4

- Unscrew bolts (31) at strap (30) and pull metering rod (3) out of the nozzle.



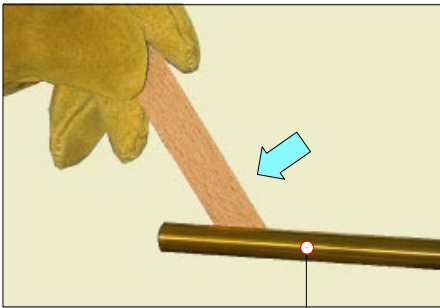
30 31 3



3

Continuation

- Clean the glue channel of metering rod (3) whilst the glue is still warm. For example, the slot by means of a piece of veneer edging and the bore with a screw driver.

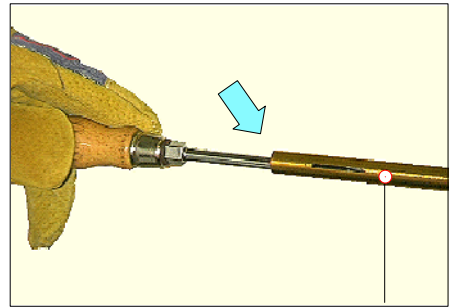


3

**⚠ DANGER**

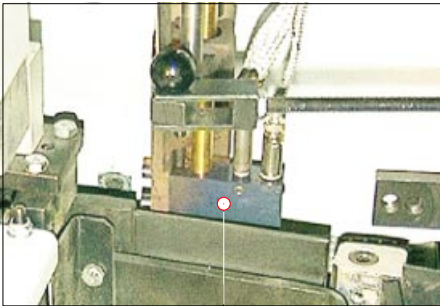


**Danger of burns!**  
Always wear heat protection gloves when working at the metering rod.



3

- Heat up nozzle (29).

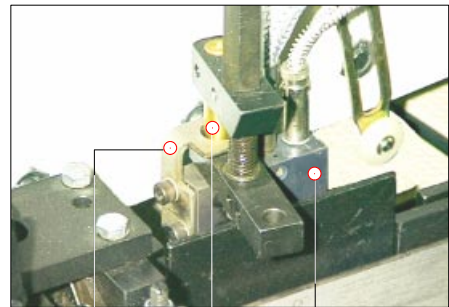


29

= Switching on heaters  
 = Temperature reached; green light on

Temperature reached; green light on .

- Insert metering rod (3) into nozzle (29) and attach strap (30).

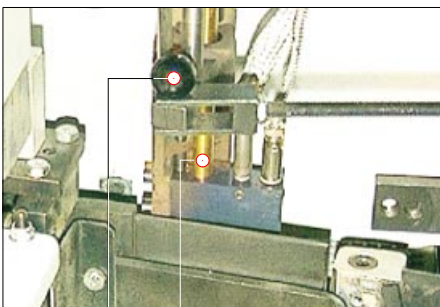


30

3

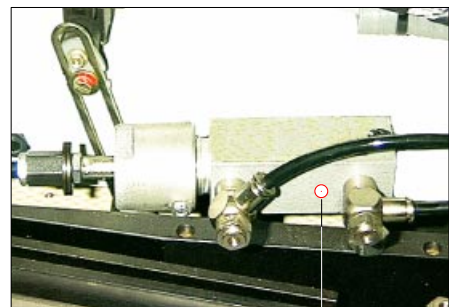
29

- Connect metering rod (3) to cylinder (4) by means of ball head knob (45).



45

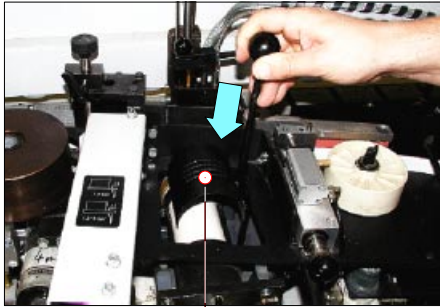
3



4

Continuation

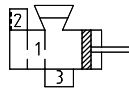
- Insert cover (9) for glue cartridges.




9

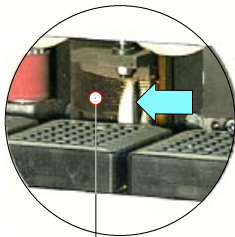
- Select heaters at operating field (109) with the button and heat up to 150° C.

 = Switching on heaters



1 = Heating of nozzle insert  
2 = Heating of nozzle

- Temperature reached; green light on .
- Check that glue is delivered through all bores of nozzle (29).



29

### Model range SPRINT

Release flushing process—see operating manual basic machine in the chapter "Control".

Model range UNO

Switch (104) in position «0» for edging feed unit at operating panel.



Operate the control switch 1806 S9 if the control is on.



1806 S9

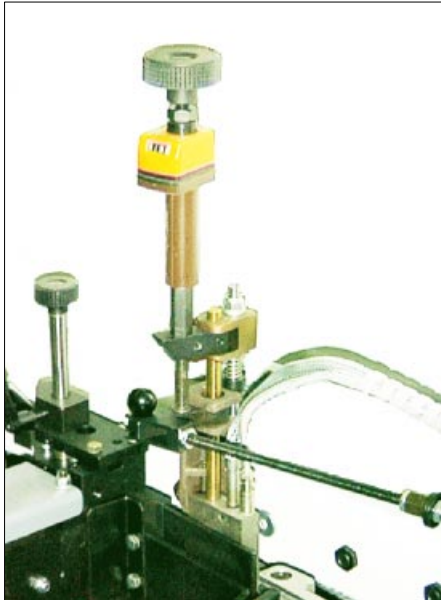
**⚠ DANGER**



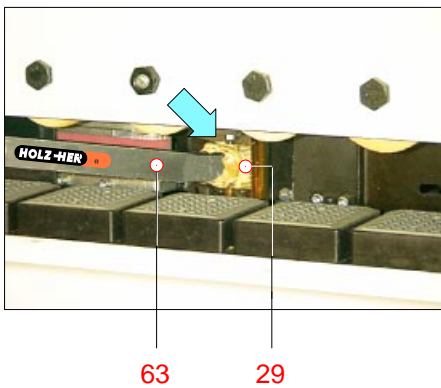
**Danger of burns via hot processing area of the nozzle.  
Wear heat protection gloves.**

6.3.2.3 Cleaning of metering rod - Version *tracing* nozzle with position indicator

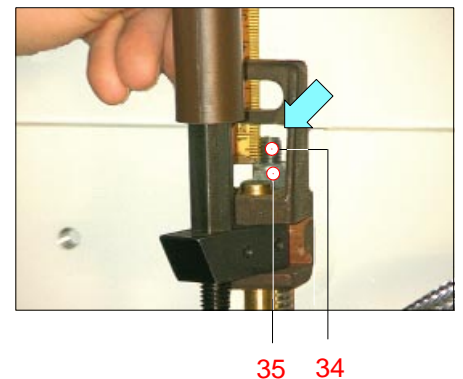
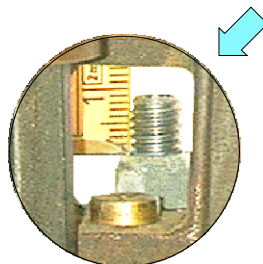
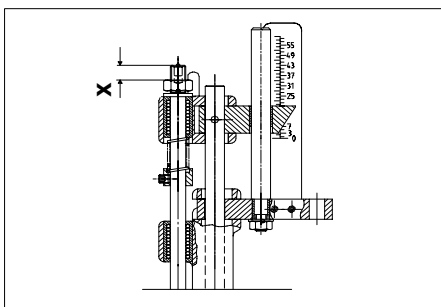
- Version *tracing* nozzle with position indicator.



- Scrape off glue remains at nozzle (29) with nozzle scraper (63), supplied with accessories.

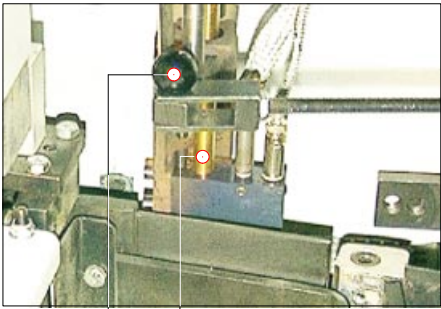


- Measure and make a note of dimension X between the end of tracer shaft (34) and nut (35). (For re-assembly reset dimension X again to this value)

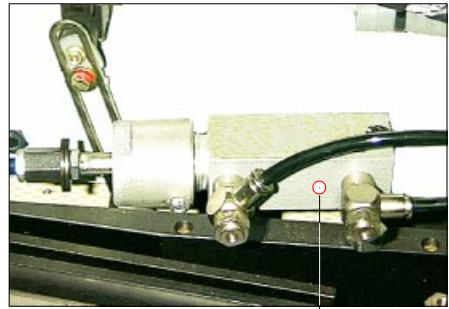


Continuation

- Separate metering rod (3) from cylinder (4) by means of ball head knob (45).

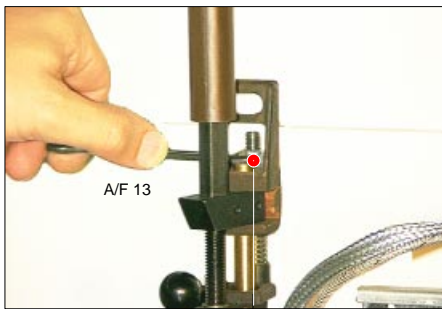


45 3



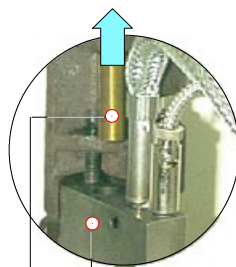
4

- Loosen hex. nut (35) and pull metering rod (3), with height adjustment (positional indicator), out of the nozzle.

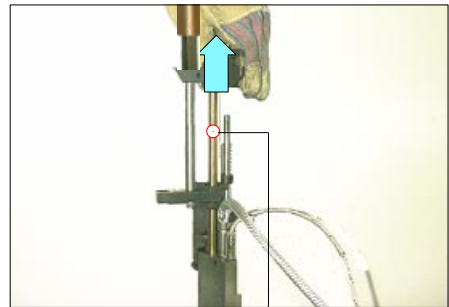


A/F 13

35

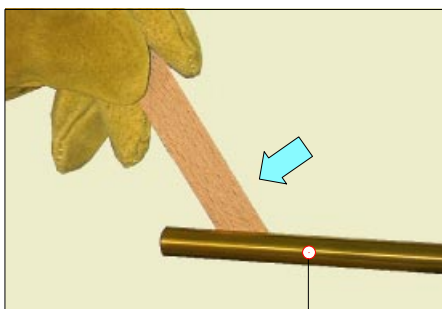


3 29



3

- Clean the glue channel of metering rod (3) whilst the glue is still warm. For example, the slot by means of a piece of veneer edging and the bore with a screw driver.

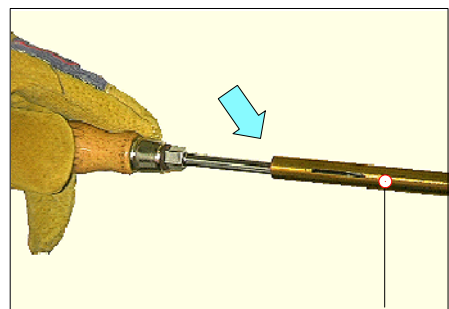


3

**⚠ DANGER**

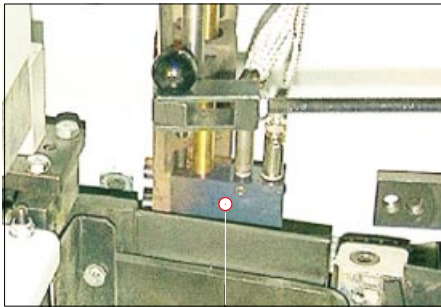


**Danger of burns!**  
Always wear heat protection gloves when working at the metering rod.



3


- Heat up nozzle (29).



29

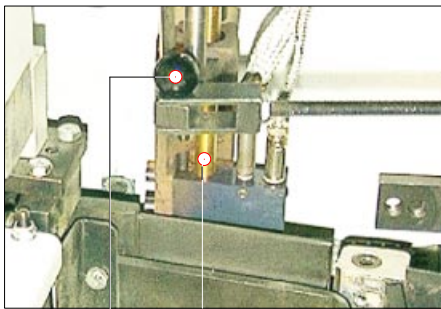
  = Switching on heaters



Temperature reached; green light on .

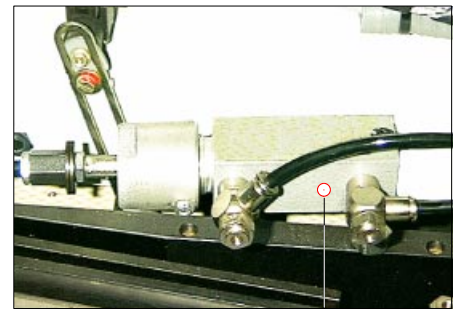
- Re-assembly in reverse order.

- Connect metering rod (3) to cylinder (4) by means of ball head knob (45).



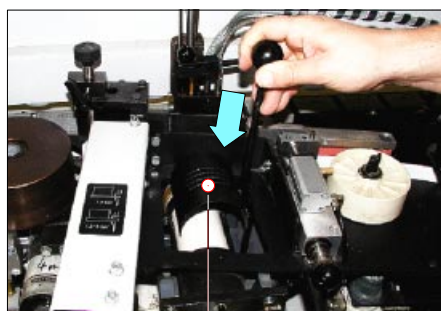
45

3



4

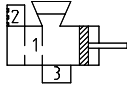
- Insert cover (9) for glue cartridge.




9

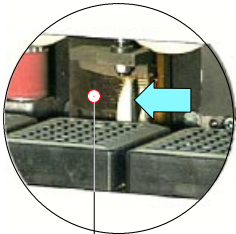
- Select heaters at operating field (109) with the button and heat up to 150° C.

  = Switching on heaters



1 = Heating of nozzle insert  
2 = Heating of nozzle

- Temperature reached; green light on .
- Check that glue is delivered through all bores of nozzle (29).



29

#### Model range SPRINT

Release rinsing process—see operating manual basic machine in the chapter "Control".

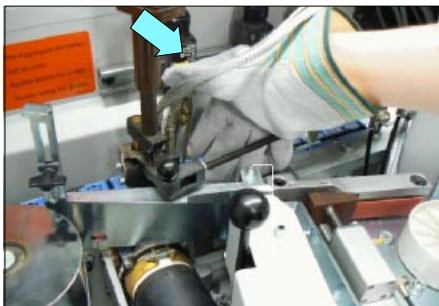
#### Model range UNO

Switch (104) in position «0» for edging feed unit at operating panel.



104

Operate the control switch 1806 S9 if the control is on.



1806 S9

 DANGER

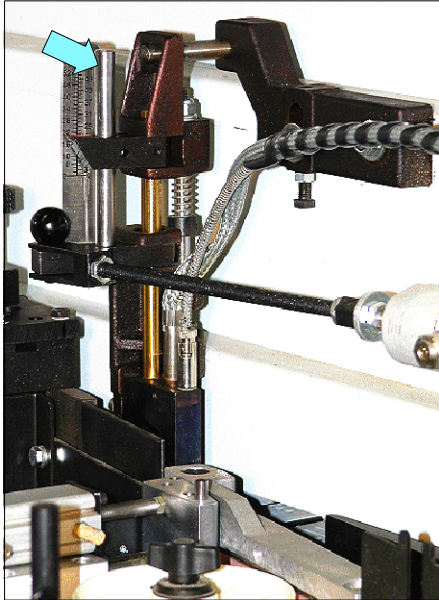


Danger of burns via hot processing area of the nozzle.  
Wear heat protection gloves.

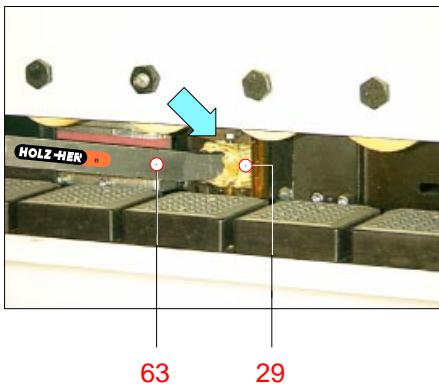


6.3.2.4 Cleaning of metering rod - Version *tracing* nozzle with bridge connection

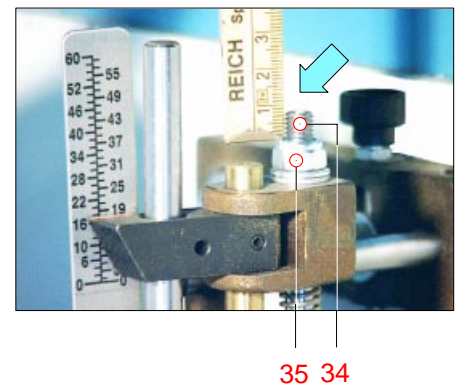
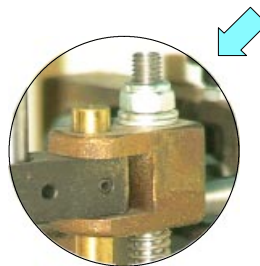
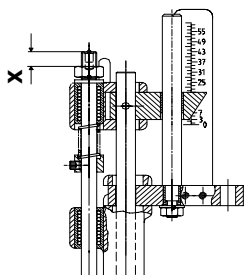
- Version *tracing* nozzle with bridge connection.



- Scrape off glue remains at nozzle (29) with nozzle scraper (63), supplied with accessories.

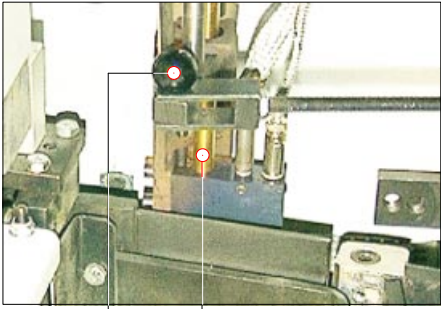


- Measure and make a note of dimension X between the end of tracer shaft (34) and nut (35).  
(For re-assembly reset dimension X again to this value)

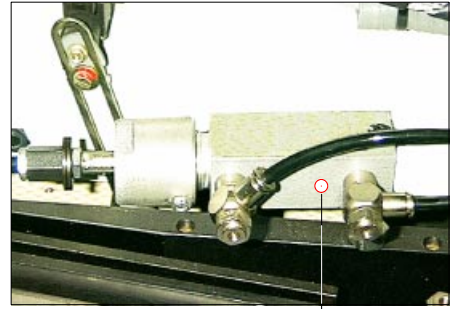


Continuation

- Separate metering rod (3) from cylinder (4) by means of ball head knob (45).

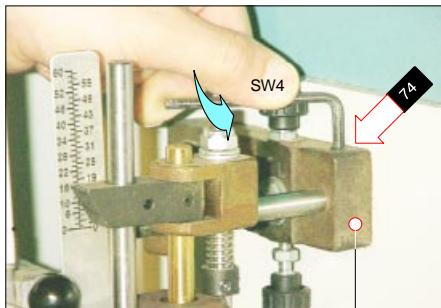


45 3

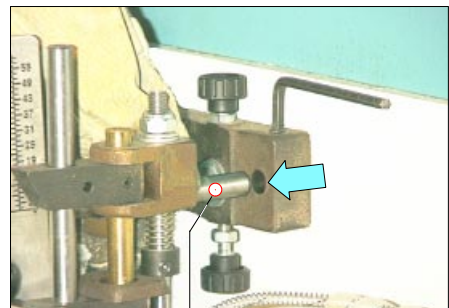


4

- Disconnecting bridge connection (75):  
Loosen threaded pin (74) and pull out cylindrical pin (76).

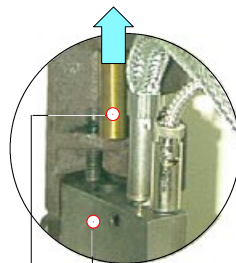
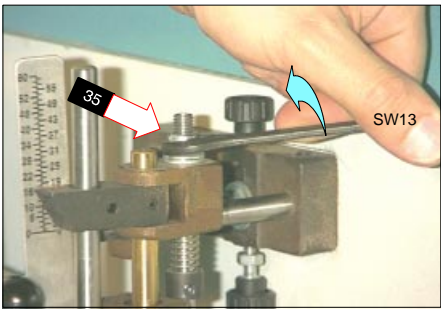


75

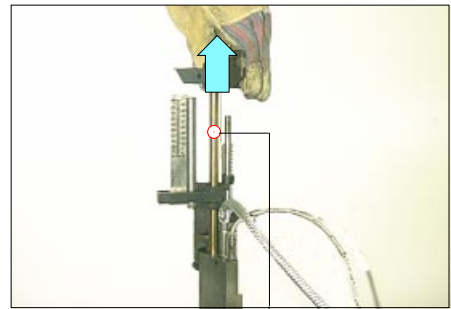


76

- Loosen nut (35) and pull metering rod (3) out of nozzle.

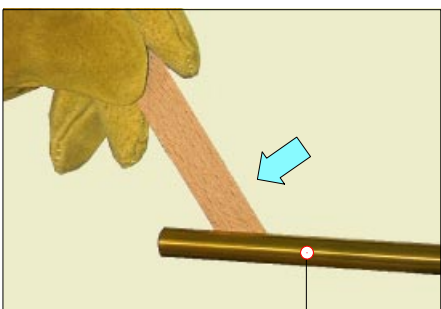


3 29



3

- Clean the glue channel of metering rod (3) whilst the glue is still warm.  
For example, the slot by means of a piece of veneer edging and the bore with a screw driver.

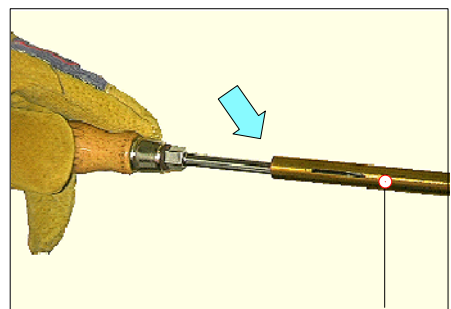


3

**⚠ DANGER**



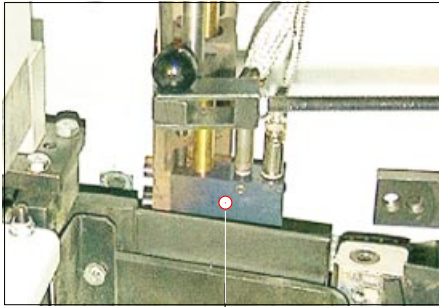
**Danger of burns!**  
Always wear heat protection gloves when working at the metering rod.



3

Continuation


- Heat up nozzle (29).



29

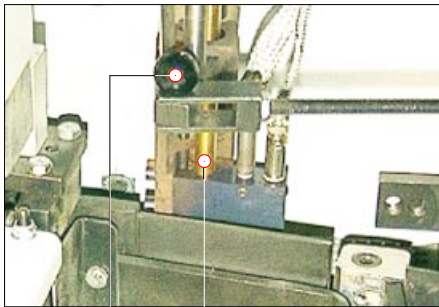
  = Switching on heaters



Temperature reached; green light on .

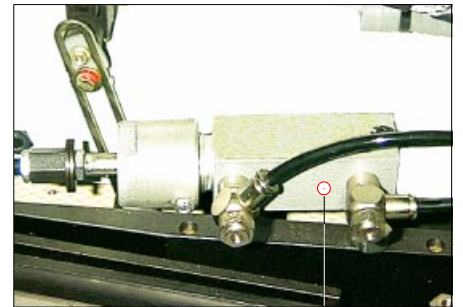
- Re-assembly in reverse order.

- Connect metering rod (3) to cylinder (4) by means of ball head knob (45).



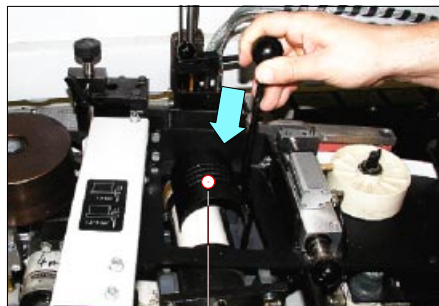
45

3



4

- Insert cover (9) for glue cartridge.

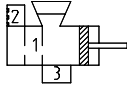


9


Continuation

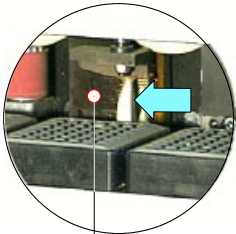
- Select heaters at operating field (109) with the button and heat up to 150° C.

  = Switching on heaters



1 = Heating of nozzle insert  
2 = Heating of nozzle

- Temperature reached; green light on .
- Check that glue is delivered through all bores of nozzle (29).



29

#### Model range SPRINT

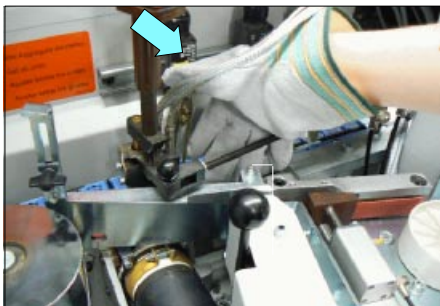
Release rinsing process—see operating manual basic machine in the chapter "Control".

#### Model range UNO

Switch (104) in position «0» for edging feed unit at operating panel.



Operate the control switch 1806 S9 if the control is on.



1806 S9

 DANGER

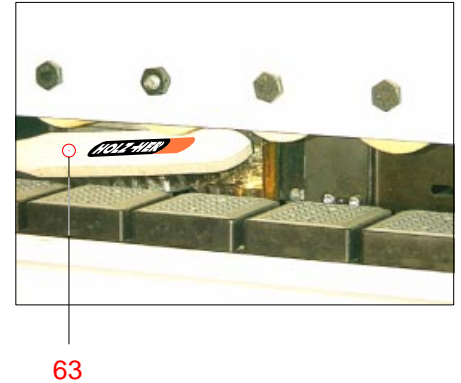
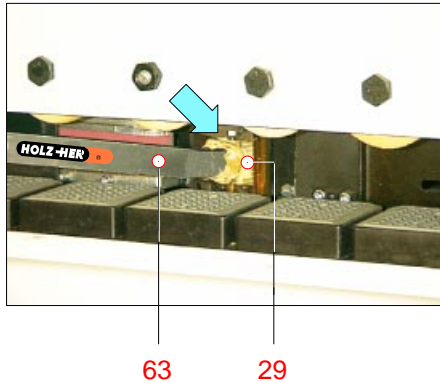


**Danger of burns via hot processing area of the nozzle.**  
Wear heat protection gloves.

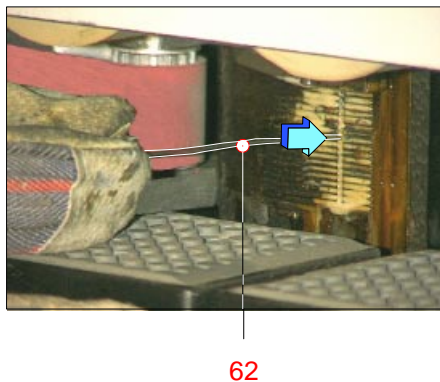
## 6.4 Resetting to new workpiece thicknesses - idle time

- If, after some time, settings are changed to a greater workpiece thickness, it may become necessary to clean the nozzle wiper (29) as well as the bores for glue delivery.

Remove glue remains from nozzle with nozzle scraper (63) and wire brush (64). (--> 6.3.1)



Carefully clean the glue delivery bores with broach (62). (--> 6.3.2.1)



### Version Tracing nozzle with or without pressure bridge connection

In the case of models of these variants, before any change-over from high to low workpiece thickness, the pressure bridge must first be moved completely to the top and/or the nozzle opened to the maximum workpiece thickness before the cleaning process. This ensures that there will be no glue in the sword nozzle when once again changing from a thin workpiece to a thick one. Cleaning process as aforesaid.

### NOTICE

**Idle times should be avoided.**

**When the machine is idle for more than 6 minutes, the nozzle bores may become clogged.**

(Machine shut-down after 6 minutes - not at model range UNO)

**After finishing work, switch off machine immediately.**

(Short heating-up time) ◀

### 6.5 Cleaning of the glue application system after processing PUR hot-melt glue

- To clean the glue application system when alternately processing reactive PUR hot-melt glue and/or other non-reactive hot-melt glue types (such as EVA-based glue), the corresponding glue manufacturer can provide cleaning cartridges.
- Use of these cleaning products prevents both blockages and reactive contamination of the glue application system, and ensures that the nozzle bores remain open.

#### NOTICE

**Cleaning of the glue application system after long periods of disuse.**

**When using hot-melt PUR glue, the glue application system must be completely cleaned and the nozzle bores for the glue application must be kept open when changing the glue type or when the system is idle, such as overnight or over the weekend.**

**Use cleaning products in cartridge form as recommended by the glue manufacturer and observe their processing and safety instructions.**



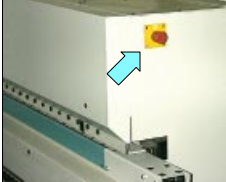













(--> 6.3)









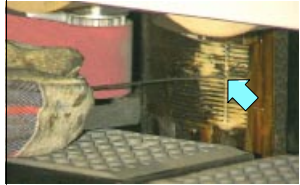


**⚠ DANGER**

Repairs to electrical equipment must not be performed except by an electrician, or by trained personnel under the direction and supervision of an electrician, in accordance with electrical engineering rules.

● This table is intended for rectification of simple problems.

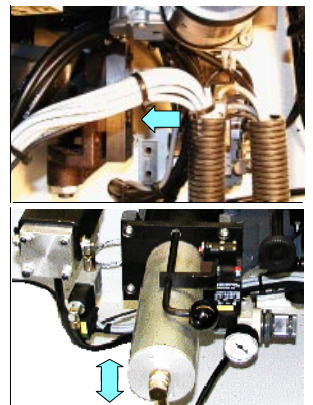
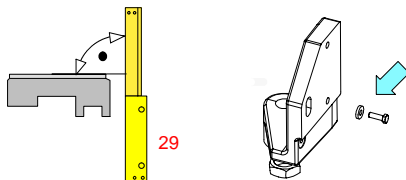
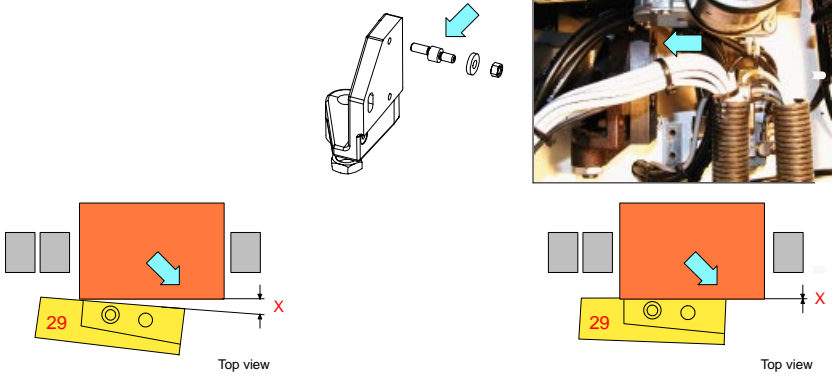
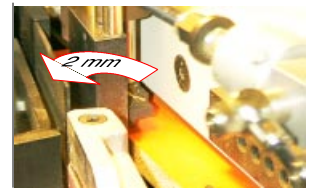
| No.   | Fault   | Possible cause  | Remedy  |
|---|---|---|---|
| 1   | Nozzle does not heat up   | <b>Basic machine</b><br>a) Main switch not switched on.   | a) Switch on main switch - Position "I" -.  |
|   |   |    |    |
|   |   | b) Emergency-Off button pressed.  | b) Pull out pushbutton to disengage it.   |
|   |   |    |   |
| c) No compressed air or pressure too low.   | c) Set working pressure from 6 bars to gauge reading on servicing unit (8).   |   |   |
|    |   |   |   |
| d) Heaters at operating panel not selected on.  | d) Select the heaters at operating panel.   |   |   |
|    |    |   |   |



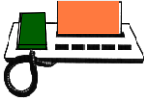
Continuation

| No.   | Fault   | Possible cause   | Remedy   |  |
|---|---|--|--|--|
| 2   | Nozzle does not reach processing temperature  | Nominal value of the heaters incorrectly set.  | Set nominal value of the heaters to the processing temperature recommended by the manufacturer.<br>(see chapter 5.3)   |  |
| 3   | No glue applied or only in part   | a) Glue cartridge used up.   | a) Refill glue cartridge.<br>(see chapter 5.2)   |  |
|   |   |    |                                      |  |
|   |   | b) <u>Manual adjustment from metering rod</u><br>Workpiece thickness incorrectly set | b) <u>Manual adjustment from metering rod</u><br>Set workpiece thickness to position indicator.<br>(see chapter 5.4.1) |  |
|   |   |   |                                   |  |
|   |   | c) Bores of nozzle clogged.  | c) Carefully clean nozzle bores with broach.<br>(see chapter 6.3.2.1)  |  |
|  |  |  |  |  |
| d) Top of metering stick glue incrustrated.   | d) Clean.<br>(see chapter 6.3.2.2/6.3.2.3/6.3.2.4)                                    |  |  |  |
|  |  |  |  |  |



| No. | Fault                   | Possible cause   | Remedy   |
|-----|-------------------------|--|--|
| 4   | Uneven glue application | a) Workpiece not at right angles.  | a) Check that workpiece is at right angles.  |
|     |                         | b) Nozzle not in contact with workpiece.   | b) Nozzle must spring back by approx. 2 mm as the workpiece runs through.<br><small>(see chapter 5.8)</small>  |
|     |                         | c) Parallelism divergence (x) between nozzle wiper surface (29) and the right-angled workpiece edge. | c) Loosen hex. nut 13 A/F and set eccentric adjuster with 3 A/F angle spanner until parallelism (x) is reached. Then set glue application to workpiece lower edge – re-adjust<br><small>(s. chapter 5.6)</small> |
|     |                         | d) Nozzle (29) not at right angle to feed chain.   | d) Loosen fixing screw and move glue station at the glue cylinder up or down.  |



| No. | Fault                 | Possible cause  | Remedy   |
|-----|-----------------------|---|--|
| 5   | Glue joint too heavy  | Processing temperature of the glue too low.   | Set selectors to recommended processing temperature.<br>(see chapter 5.3)  |
|     |                       |   |    |
| 6   | Edging does not stick | a) Dust on edging and/or workpieces.<br>b) Too thin glue application.<br>c) Workpieces and/or workshop too cold.<br>d) Workpieces and/or edging too moist.<br>e) Unsuitable glue.<br>f) Teak edging stored for a long time.<br>g) Glue-on pressure too low. | a) Use workpieces and edging free of dust.<br>b) Check glue application setting.<br>(see chapter 5.6)<br>c) Bring workpieces and workshop to 18–20°C at least.<br>d) Material moisture < 10%<br>e) Use a glue type suited to the edging processed. Observe manufacturer's recommendations.<br>f) Apply edging immediately after cutting.<br>g) Check pressure roller setting at pressure unit. |
| 7   | Other faults          |   |  Manual Error Messages PLC<br> SERVICE   |



