

Bandit 3/2 Owner's Manual



LAGUNA

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Scope of This Manual

This manual outlines the basic procedures for the Laguna Tools Bandit 3/2 Edgebander.

For detailed instructions and videos, please go to www.lagunatools.com.

Customer Service

For technical support, please contact Laguna Tools Customer Service by calling 1-800-332-4094 or email customer_service@lagunatools.com. Please note the machine type in the subject line.

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DISCLAIMER

Laguna Tools is not responsible for errors or omissions. Specifications subject to change. Machines may be shown with optional accessories.

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1.0 General Information & Safety

1.1 Overview

SAVE THIS MANUAL. Keep this manual for the safety warnings, precautions, assembly, operating, inspection, and maintenance procedures. Read this Owner's Manual in its entirety prior to assembly or operation.

Please read and understand all warnings and operation instructions before using any tool or equipment. Always follow basic safety precautions to reduce the risk of personal injury. Improper operation, maintenance, or modification of tools or equipment could result in serious injury or property damage. Laguna Tools equipment is designed for specific and limited applications. This product should neither be modified nor used for any application other than those for which it was designed.

PERSONAL SAFETY IS THE RESPONSIBILITY OF THE OPERATOR.

1.2 Safety Signs and Call-Outs



DANGER

An imminently hazardous situation which, if not avoided, will result in death or serious injury.



WARNING

A potentially hazardous situation which, if not avoided, may result in death or serious injury.



CAUTION

A potentially hazardous situation which, if not avoided, could result in minor or moderate injury.

NOTE

A helpful tip from Laguna Tools staff.

1.3 Safety Warnings

1. Failure to comply with safety instructions may lead to personal injury and/or damage to the equipment. Do not operate the machine unless familiar with all safety instructions, warnings, and signs.
2. Do not operate the machine with the electrical cabinet door open—High Voltage Supply Inside.
3. The machine must be properly electrically grounded. The power supply must be connected with a permanently fixed electrical wire.
4. Keep children and non-operators away from the machine.
5. Operators must be familiar with the installation, operation, and service of the machine. Only proper operation can ensure the safe and smooth running of the machine.



WARNING

Automated machinery involves moving parts which pose a potential hazard to personnel. Be aware of machine movement at all times.



WARNING

Only allow qualified service personnel to do electrical installation or repair work, and always disconnect power before accessing or exposing electrical equipment to reduce risks.



CAUTION

Machine bits are sharp and pose a cutting hazard. Do not handle without gloves or while the machine is in operation.

1.4 Additional Safety Information

1. All motion parameters have been set up by Laguna Tools. If any modifications are required, please have a professional operator perform the changes.
2. Only qualified technicians should access lower cabinets of machine.
3. Safety Signs should be attached to places that are easy to spot.
4. Use the machine only in clean areas free from excessive moisture or flammable objects.
5. The machine must be level. Level the machine if the ground is uneven.
6. Keep the machine, electrical cabinet, and surrounding area clear of obstructions and free from excessive moisture.
7. Keep the machine, electrical cabinet, and cables away from excessive heat, flammable substances, and sharp objects.
8. Do not attempt to exceed the limits of the machine.
9. Disconnect power to all system components when not in use, when changing accessories, and before servicing. Remove the switch keys or lock-out the machine to prevent unauthorized use and child-proof the workshop.
10. Exercise care with machine controls and around keypad to avoid unintentional start-up.
11. Keep cutting tools clean and sharp.
12. Lubricate and change accessories when necessary.
13. Cables and cords should be inspected regularly.
14. Keep controls clean and dry.
15. Keep a copy of this manual for future reference.
16. Perform daily inspection of the machine for damaged, loose, or improperly adjusted parts or any condition that could affect safe operation. For your own safety, do not operate the machine with damaged parts.
17. Stay alert at all times while operating the machine.
18. Always wear safety glasses and hearing protection.
19. Know where the emergency stop switch is located.
20. Never operate machinery under the influence of drugs or alcohol, when tired, or when distracted.

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21. Do not wear clothing, apparel, or jewelry that can become entangled in moving parts. Always tie back or cover long hair. Wear non-slip footwear to reduce the risk of slipping and losing control or accidentally contacting cutting tool or moving parts.
22. Never stand on the machine. Serious injury may occur if the machine is tipped or if the cutting tool is unintentionally contacted.
23. Consult the Owner's Manual or Laguna Tools for recommended accessories. Using improper accessories will increase the risk of serious injury or damage.

2.0 Specifications & Dimensions

Specifications & Dimensions	
POWER REQUIREMENTS	220V, Single-Phase, 60 Hz
FULL-LOAD CURRENT RATING	19A
MINIMUM CIRCUIT SIZE	30A
CONNECTION TYPE	Cord & Plug
POWER CORD INCLUDED	Yes
POWER CORD GAUGE	12 AWG
PLUG INCLUDED	Yes
PLUG TYPE	L6-30
SWITCH TYPE	Control Panel w/ Magnetic Switch Protection
MACHINE FOOTPRINT	L x W x H: 111" x 44" x 50"
WORKING AREA	L x W: 120" x 48"
MACHINE WEIGHT	1200 lbs (pounds)
WORKTABLE LENGTH	79 inches
MINIMUM PANEL LENGTH	9 ¾ INCHS
MINIMUM PANEL WIDTH	4 ¾ INCH
PANEL THICKNESS	(MIN-MAX) 1-2 – 1 ¾ INCHES
SHIPPING DIMENSIONS	L x W x H: 84 x 29 x 52 inches
MUST SHIP UPRIGHT	YES
WORKTABLE LENGTH	78-3/4 inches
WORKTABLE WIDTH	10-1/2 inches
HOUSING	Aluminum

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FRAME	Steel
ROLLERS	Rubber
PAINT	Powder Coated
COUNTRY OF ORIGIN	Taiwan
WARRANTY	1 Year
APPROXIMATE ASSEMBLY AND SETUP TIME	2 Hours
SOUND RATING	80 dB
ISO 9001 FACTORY	Yes
SERIAL NUMBER LOCATION	Machine ID Label on Right Side
MIN. PANEL WIDTH	4-3/4 inches
MIN. PANEL LENGTH	9-1/2 inches
PANEL THICKNESS	(1/2" – 1 3/4)
TAPE THICKNESS	(.5mm – 3mm)
AIR REQUIREMENT	6 SCFM @ 100 PSI
PANEL FEED SPEED	16 FPM
GLUE POT CAPACITY	34 oz.
ROLLER WIDTH	3 3/4 inches
ROLLER DIAMETER	13/16 inches
MAX. HEIGHT OF ROLLERS	0.8 – 1.0 mm
EDGEBANDING COIL CAPACITY	31-1/2 inches
DUST COLLECTION PORTS (2)	4 inches
DUST COLLECTION REQUIREMENT (AT DUST PORT)	700 CFM
HEATING ELEMENT	1535W (t)

2.1 Feed Motor

Feed Motor	
TYPE	TEFC Capacitor-Start Induction
HORSEPOWER	¾ HP
VOLTAGE	220V
PHASE	Single-Phase
AMPS	3.6A
SPEED	1700 RPM
POWER TRANSFER	Gear Drive
BEARINGS	Shielded and Permanently Sealed

2.2 Glue Spindle Motor

Glue Spindle Motor	
TYPE	TEFEC Capacitor-Start Induction
HORSEPOWER	1/3 HP
VOLTAGE	220V
PHASE	Single-Phase
AMPS	1.7A
SPEED	1700 RPM
POWER TRANSFER	Gear Drive
BEARINGS	Shielded and Permanently Sealed

2.3 End Trim Motor

End Trim Motor	
TYPE	TEFC Capacitor-Start Induction
HORSEPOWER	1/4 HP
VOLTAGE	220V
PHASE	Single-Phase
AMPS	1.6A
SPEED	3400 RPM
POWER TRANSFER	Timing Belt
BEARINGS	Shielded and Permanently Sealed

2.4 Flush Trim Motor

Flush Trim Motor	
TYPE	TEFC Capacitor-Start Induction
HORSEPOWER	3/4 HP
VOLTAGE	220V
PHASE	Single-Phase
AMPS	3.5A
SPEED	3400 RPM
POWER TRANSFER	Flat Belt
BEARING	Shielded and Permanently Sealed
TYPE	TEFC Capacitor-Start Induction

2.5 Buffing Motor

Buffing Motor	
TYPE	TEFC Capacitor-Start Induction
HORSEPOWER	1/4 HP
VOLTAGE	220V
PHASE	Single-Phase
AMPS	1.6A
SPEED	3400 RPM
POWER TRANSFER	Direct Drive
BEARINGS	Shielded and Permanently Sealed

3.0 Machine Overview

3.1 Features

- Automatic belt feed with adjustable table rollers
- Edgebanding from 0.5 mm – 2 mm
- Panel thickness from $\frac{1}{2}$ - 1 $\frac{3}{4}$ inches
- 16 FPM feed speed
- Heated infeed fence for better glue dispersion
- Pneumatic edgebanding guillotine
- Double-bladed end-trimming saw
- Upper and lower trimming units with digital readout
- Upper and lower buffing units
- Adjustable infeed fence for different edgebanding thicknesses
- Extendable side bar to accommodate larger panels
- Digital control panel controls each element individually
- Teflon-coated glue pot with five (5) heating elements and motorized glue spreader
- 31 $\frac{1}{2}$ inch tape coil support
- Two (2) 4-inch dust ports
- Built-in air regulator and filter for pneumatic system

3.2 Components

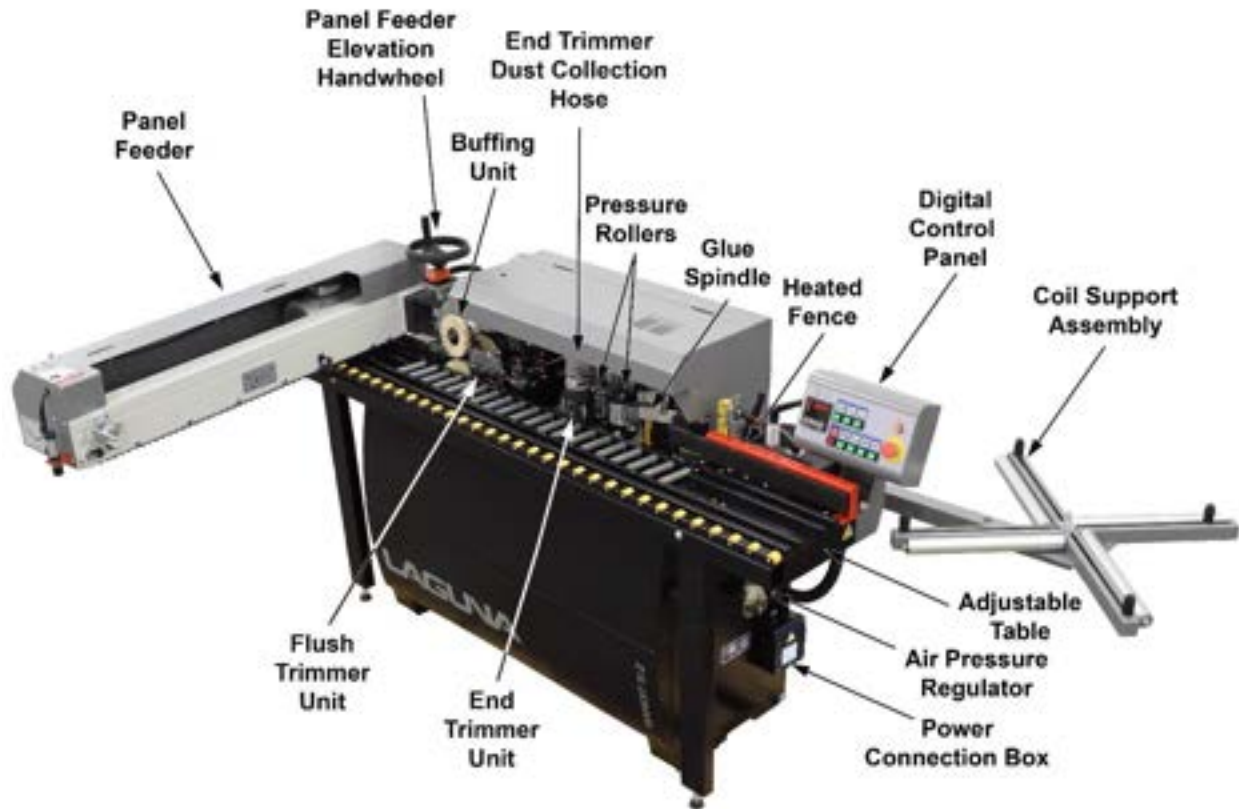


Figure 3-1: Bandit 3/2 Components (Front)

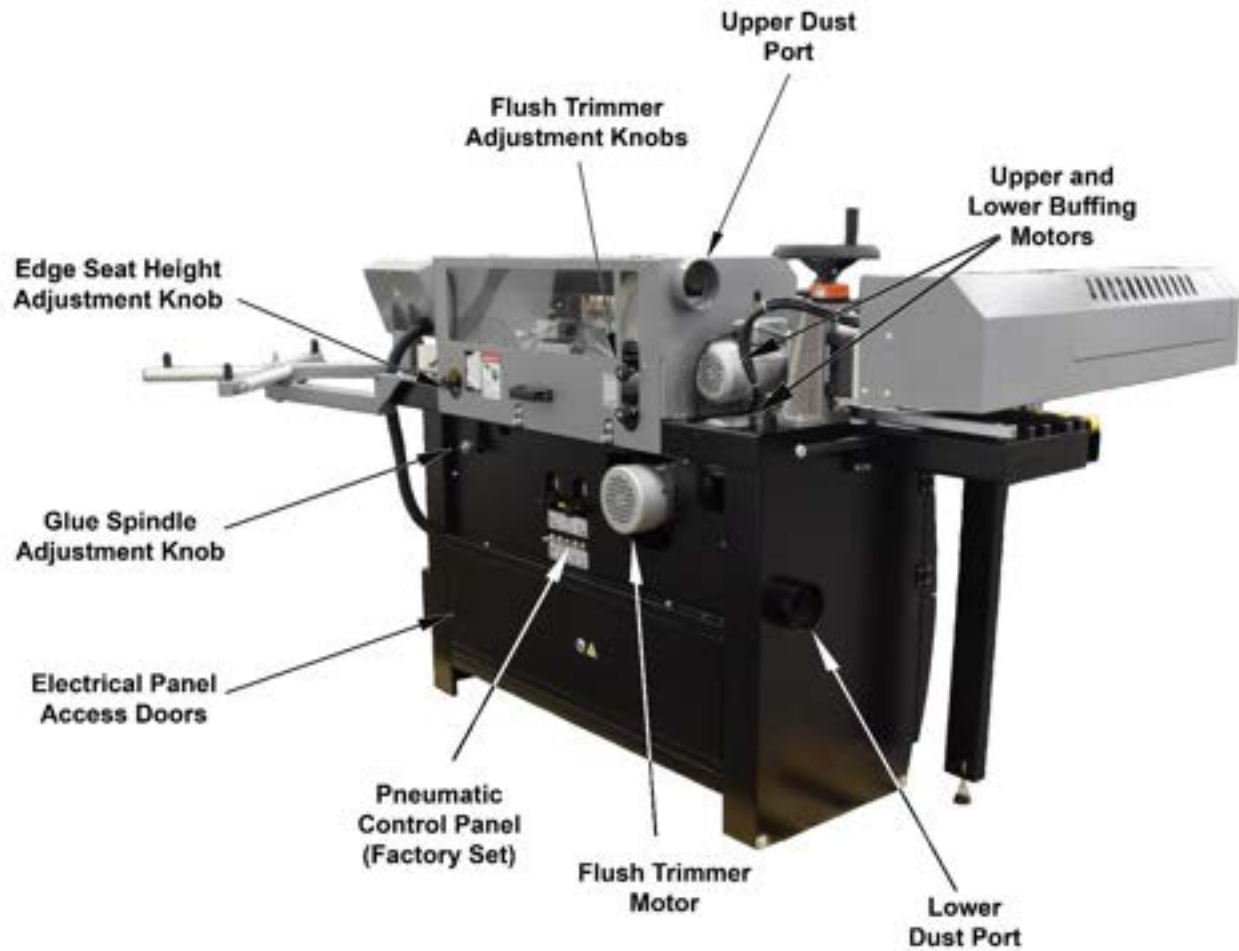


Figure 3-2: Bandit 3/2 Components (Rear)

3.2.1 Control Panel

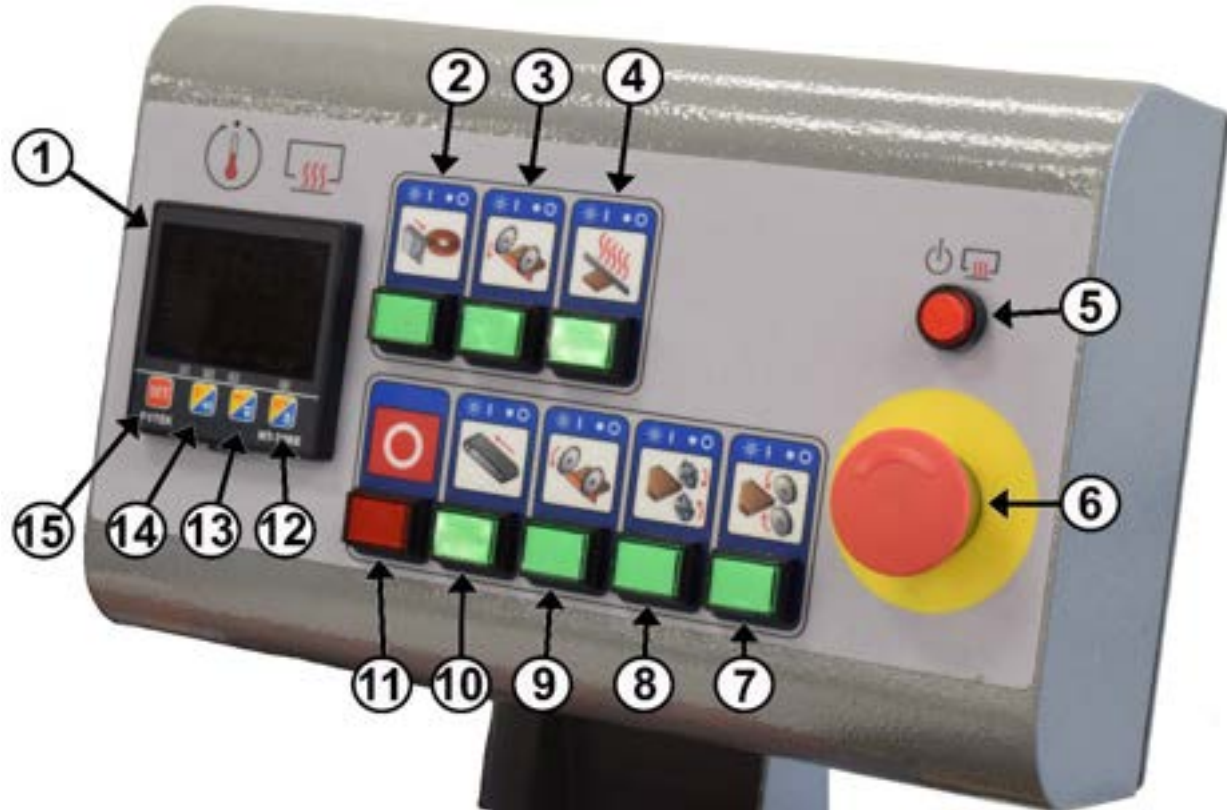


Figure 3-3: Control Panel

1. **Thermoregulator Display** – Displays actual and set temperatures of glue pot.
2. **Guillotine Sensor ON/OFF button** – Activates the sensor for guillotine pneumatic control.
3. **End Trimmer Sensor ON/OFF button** – Activates the sensor for end trimmer pneumatic control.
4. **Infeed Fence Heat ON/OFF button** – Controls the infeed fence heating element. Allow 12-14 minutes to reach the working temperature.
5. **Power Lamp** – Illuminates when the machine is in standby mode.
6. **Emergency Stop/Reset button** – Stops all machine functions except for the glue pot. Twist clockwise to reset.
7. **Buffing Unit ON/OFF button** – Controls the buffing motors.
8. **Flush Trimmer ON/OFF button** – Controls the flush trimmer motor.
9. **End Trimmer ON/OFF button** – Controls the end trimmer motor.

- 10. Panel Feeder ON/OFF button** – Controls the panel feeder conveyor belt.
- 11. Motor OFF button** – Turns OFF all motors and motor-driven functions (except for glue spindle motor).
- 12. Temperature UP key** – Incrementally raises temperature of the glue pot when pressed.
- 13. Temperature DOWN key** – Incrementally lowers temperature of the glue pot when pressed.
- 14. Thermoregulator Function key** – Only used for initial factory programming of thermoregulator. Not intended for end-user adjustment. Qualified service personnel only!
- 15. Temperature SET key** – Saves the temperature settings after user input from Temperature UP/DOWN key(s).

3.2.2 Coil Support

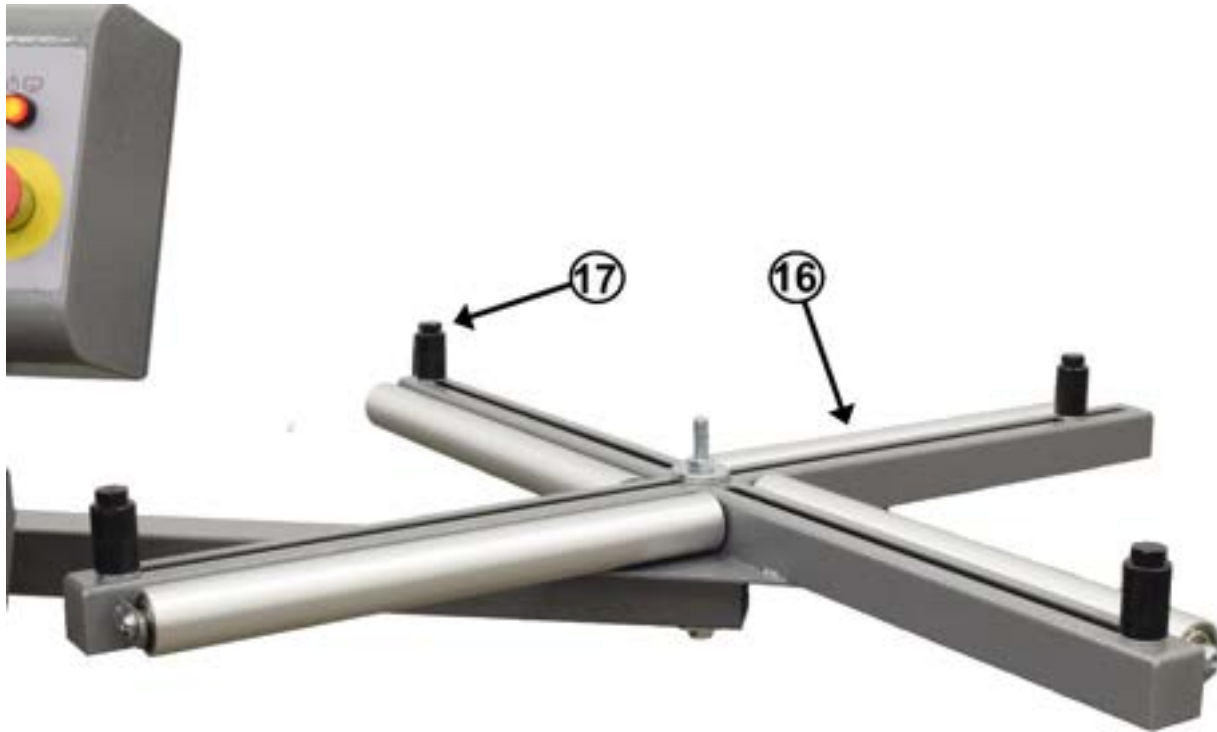


Figure 3-4: Coil Support

- 16. Coil Support Assembly** – Supports the edgebanding coil during operation.
- 17. Adjustable Guide Rollers (4)** – Holds the edgebanding coil in place during operation. Adjust as needed according to size of coil.

3.2.3 Guillotine

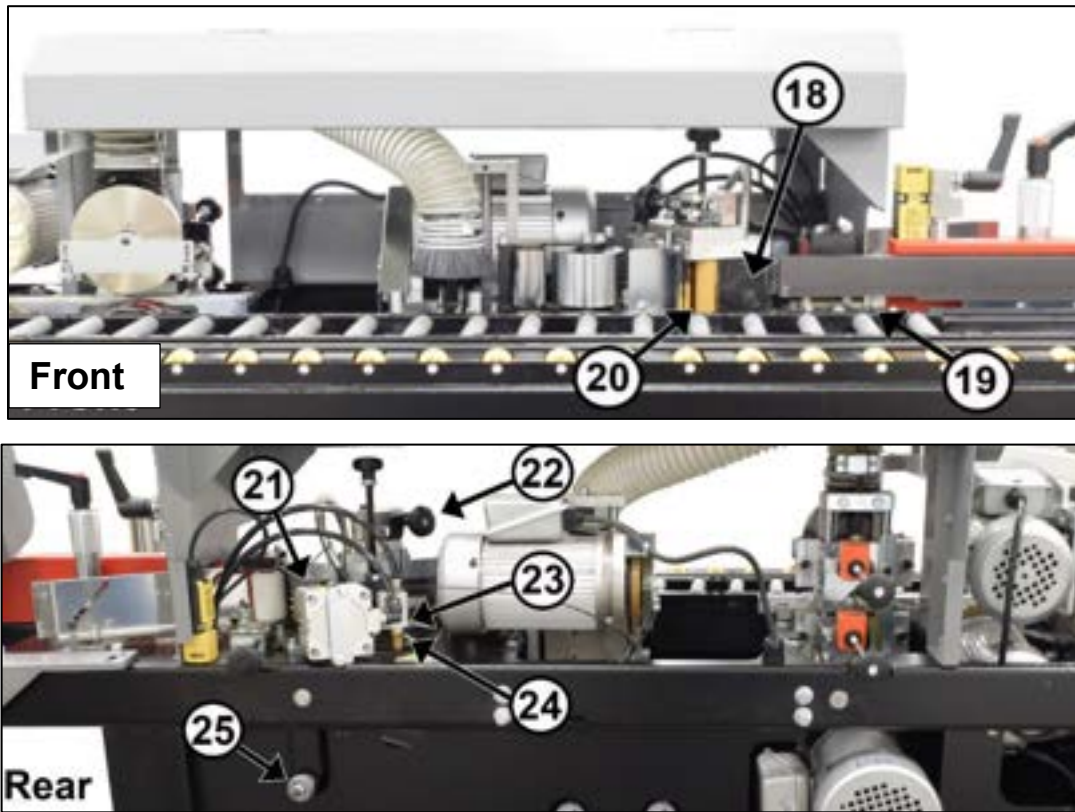


Figure 3-5: Guillotine and Glue System

18. Guillotine Limit Switch – When the trailing end of the workpiece passes over and releases the switch, the switch activates pneumatic guillotine to sever edgeband.

19. Pneumatic Guillotine – Severs the trailing end of the glued edgeband.

3.2.4 Glue System

20. Glue Flow Adjustment Knob – Rotate counterclockwise to increase the glue flow; rotate clockwise to decrease the glue flow.

21. Glue Spindle – Applies the melted glue to the workpiece edge.

22. Guide Plate – Maintains proper distance between the workpiece and the glue spindle to control the amount of glue that is applied.

23. Glue Spindle Adjustment Knob – Rotate counterclockwise to move the spindle all the way forward into the working position.

24. Glue Pot Lid – Remove to inspect the glue pot or to add glue. Leave closed during operations.

25. Glue Pot – Stores and heats glue for bonding edgeband to the workpiece.

3.2.5 Pressure Rollers

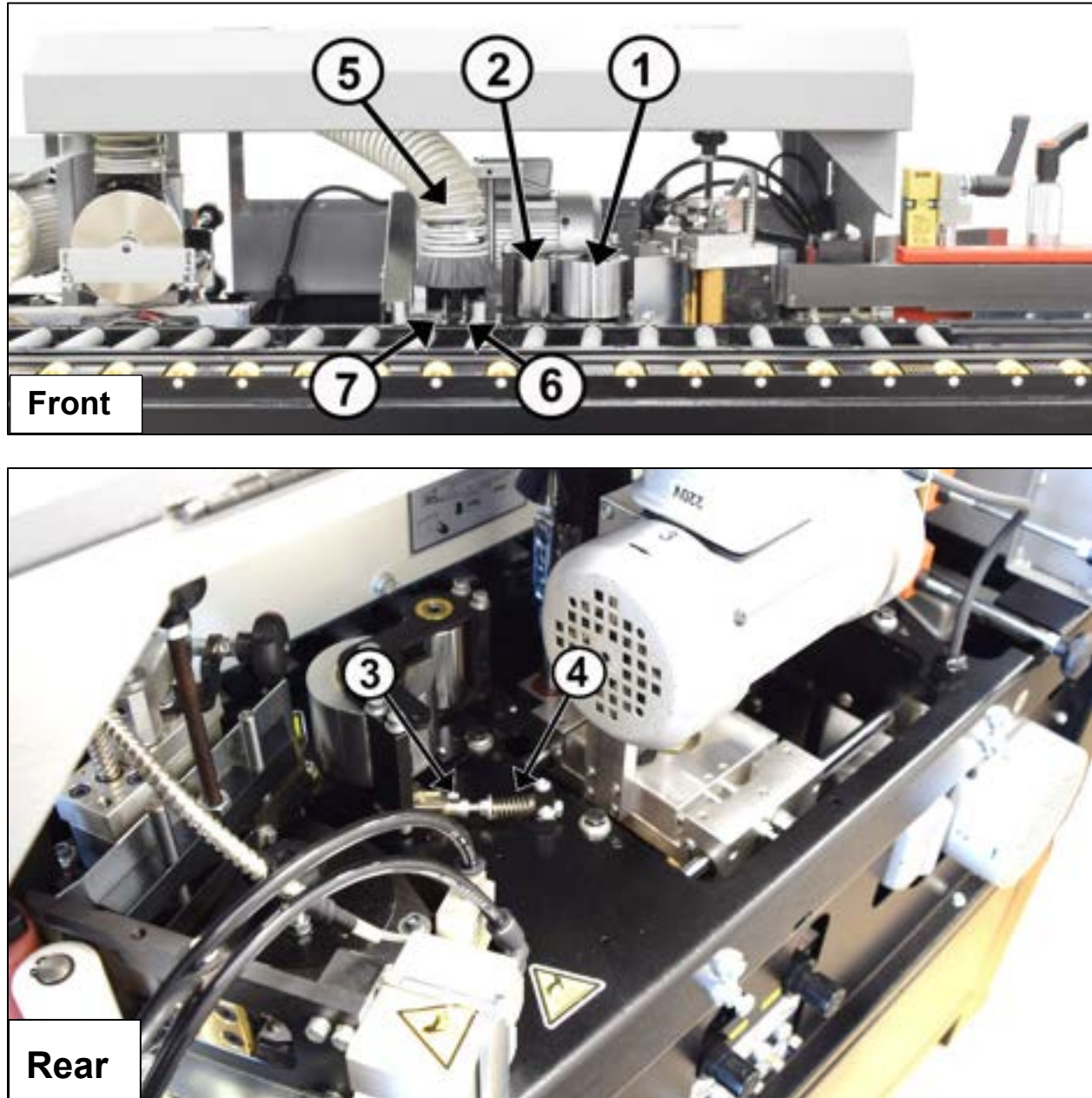


Figure 3-6: Pressure Rollers and End Trimmer Components

1. **Stationary Pressure Roller** – Presses the edgeband against the workpiece after the glue is applied. The position is not adjustable.
2. **Adjustable Pressure Roller** – Presses the edgeband against the workpiece after the glue is applied. The position can be adjusted to increase or decrease pressure as necessary.
3. **Adjustable Pressure Roller Jam Nut** – Loosen to rotate the adjustable pressure roller bolt. Tighten to secure the setting.

4. **Adjustable Pressure Roller Blot** – Loosen to increase the pressure of adjustable pressure roller against edgeband and workpiece. Tighten to decrease pressure.

3.2.6 End Trimmer

5. **End Trimmer Dust Collection Hose** – Removes the sawdust and debris caused by the end trimming operation.
6. **End Trimmer Blades (Right and Left)** – Rotate at approximately 9000 RPM and follow the workpiece to the trim leading and the trailing ends of glued edgeband.
 - The right end trimmer blade trims the leading end of the edgeband.
 - The left end trimmer blade trims the trailing end of edgeband.
7. **End Trimmer Tracer** – Guides the end trimmer blades.

3.2.7 Flush Trimmer

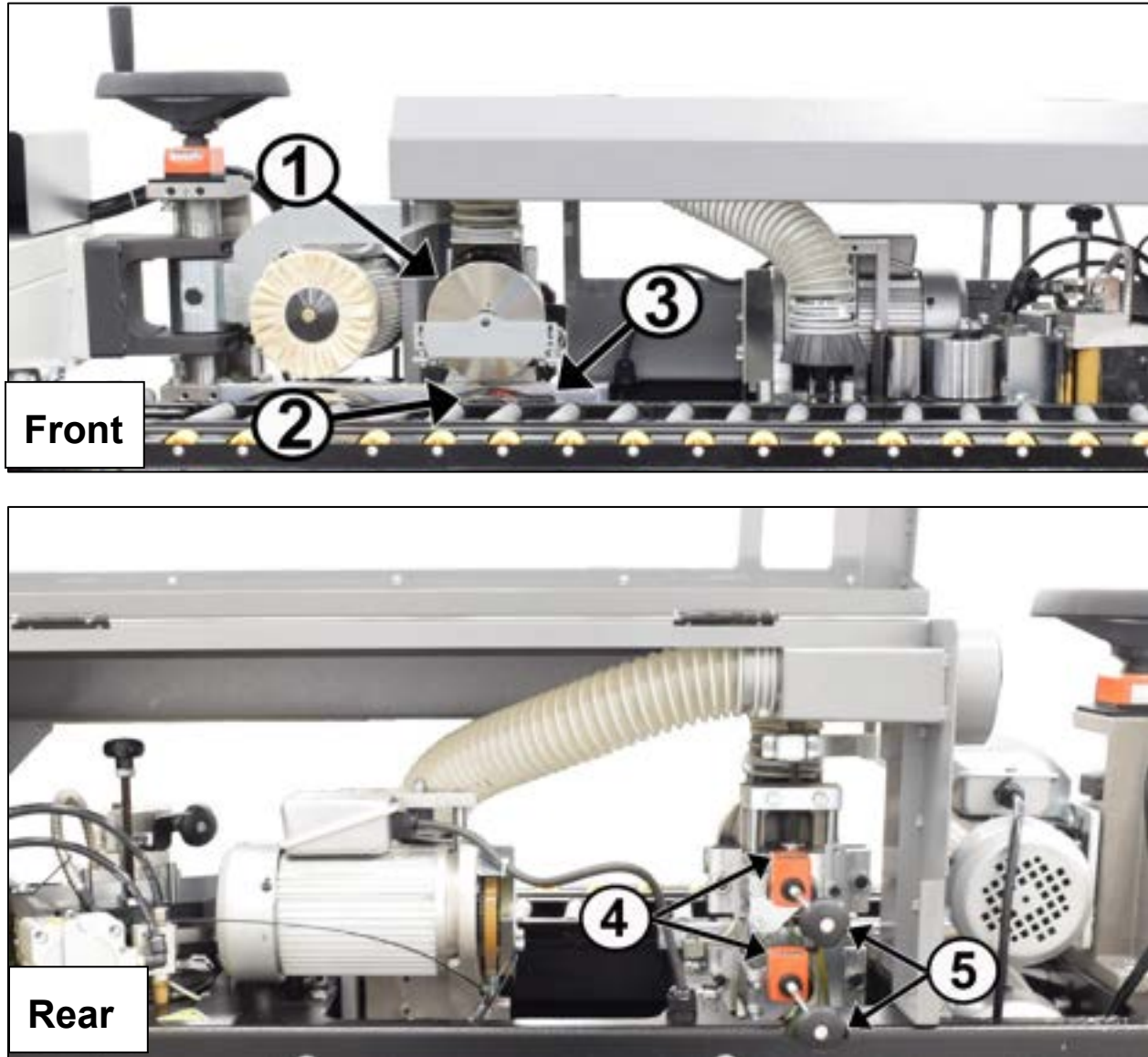


Figure 3-7: Flush Trimming System Components

1. **Adjustable Flush Trimmer Tracer** – Guides the upper flush trimmer cutter. Height adjusts simultaneously with panel feeder elevation adjustment.
2. **Flush Trimmer Axial Adjustment Knobs (Upper and Lower)** – Rotates counterclockwise to move flush trimmer cutters closer to the workpiece edge; rotates clockwise to move the cutters farther away.

NOTE

For best results, always adjust the upper and lower flush trimmer cutters equally.

3.2.8 Buffing Unit

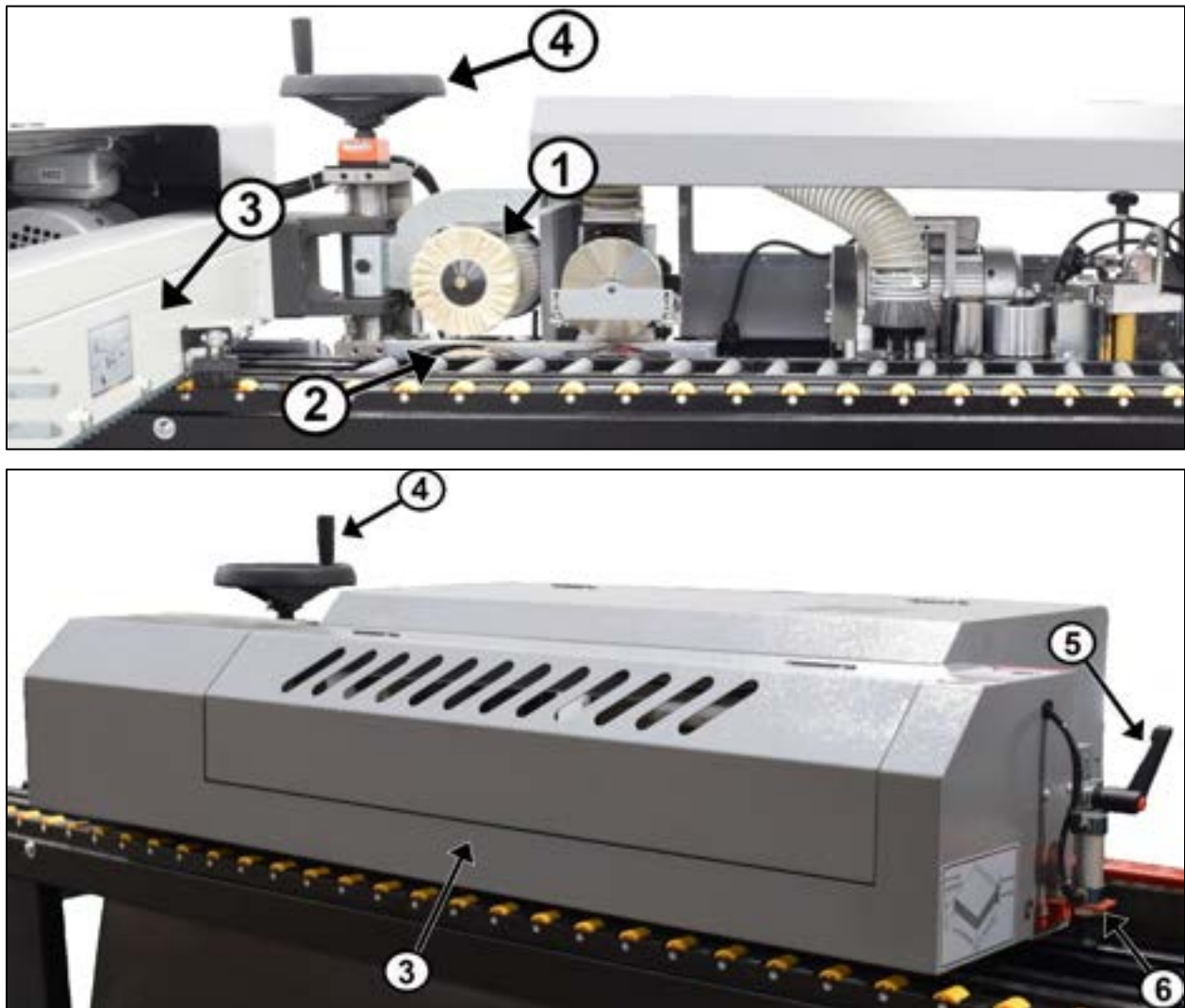


Figure 3-8: Buffing System and Panel Feeder

1. **Adjustable Buffing Wheel** – Rotates at approximately 3000 RPM and polishes upper surface of glued and trimmed edgeband. Height adjusts simultaneously with panel feeder elevation adjustment.
2. **Stationary Buffing Wheel** – Rotates at approximately 3000 RPM and polishes the lower surface of glued and trimmed edgeband. Height is not adjustable.

3.2.9 Panel Feeder

3. **Panel Feeder** – Uses the conveyor belt to advance the workpiece from the infeed end of table to outfeed end of table during edgebanding operation. Height is adjustable according to workpiece thickness.
4. **Panel Feeder Elevation Handwheel** – Raises and lowers the panel feeder according to the workpiece thickness. Rotate clockwise to raise the panel feeder; rotate counterclockwise to lower the panel feeder to lower it. The handwheel base features a readout that displays height in millimeters.
5. **Panel Feeder** – Locks the panel feeder in position during the edgebanding operations.
6. **Pneumatic Panel Stop** – Automatically lowers during operation to prevent multiple workpieces from entering the panel feeder at same time. Automatically raises when the workpiece exits the panel feeder, to allow for the next operation.

3.2.10 Edge Banding Feeder

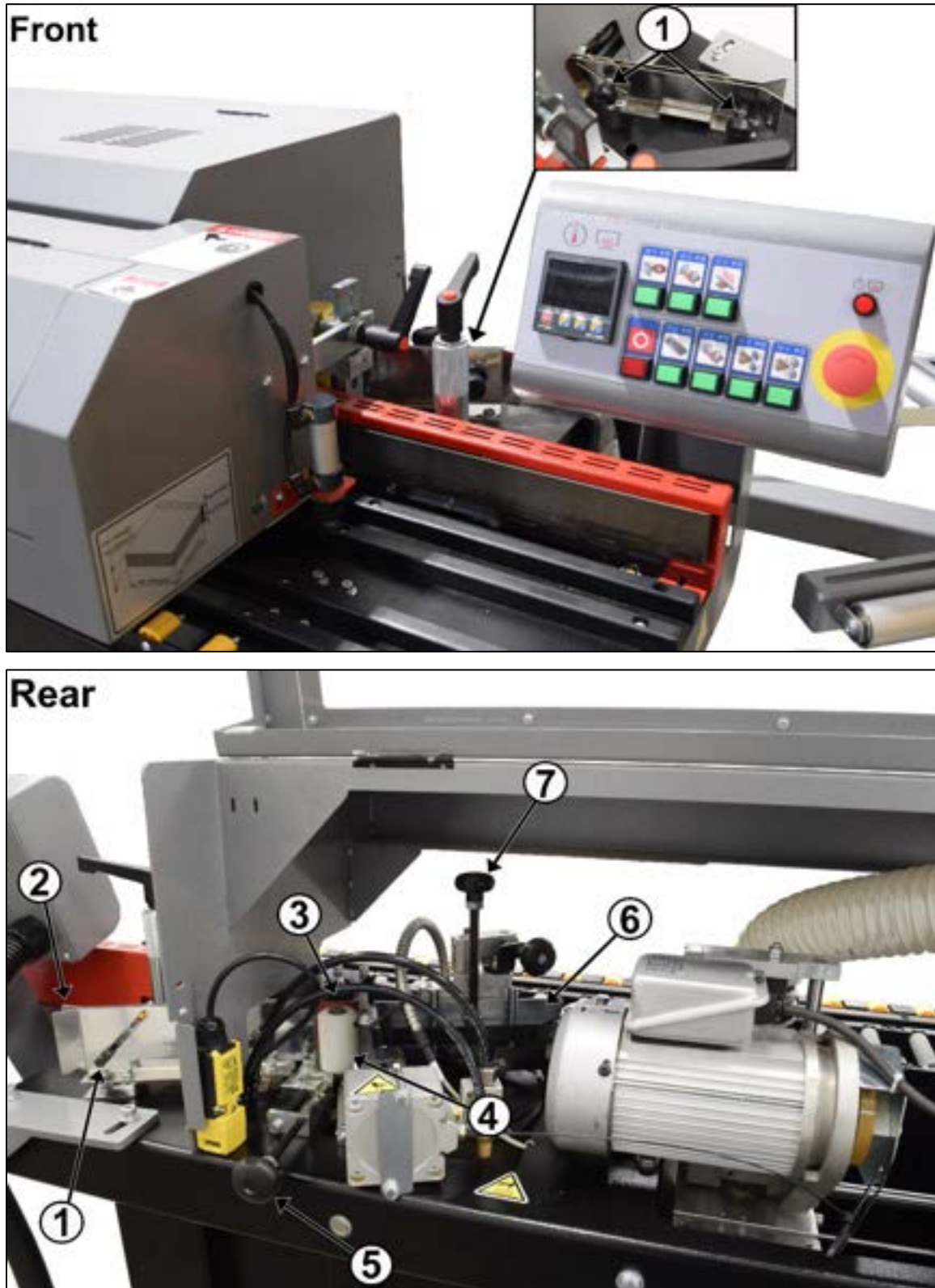


Figure 3-9: Edgebanding Feeder

1. **Edge banding Height Knobs (2)** – Secures the edge banding vertically within the edge banding intake guides. Loosen to adjust according to the edge banding width; tighten to secure the setting.

NOTE

Leave approximately 0.2mm vertical play when setting knobs.

2. **Edgebanding Intake Guides (2)** – Guides the edgebanding as it feeds into the machine.
3. **Rubber Drive Roller** – Advances the edgebanding until it is severed by the guillotine.
4. **Nylon Roller** – Forces the edgebanding against the rubber drive roller, providing necessary friction to advance the edgeband.
5. **Nylon Roller Release knob** – Pull the knob to the right to release the nylon roller pressure when removing or loading the edgeband. Release the knob to apply pressure after the edgebanding is properly loaded.
6. **Edgebanding Seat Adjustment knob** – Rotate clockwise to raise upper section of edgebanding seat; rotate counterclockwise to lower upper section. Adjust as necessary according to edgebanding width.

NOTE

Leave approximately 1/32-inch vertical play when adjusting the upper section height.

7. **Edgebanding Seat** – Vertically supports the edgebanding prior to contacting the glued edge of the workpiece. Use the Edgebanding Seat Adjustment knob (AU) to adjust the seat according to the edgebanding width.

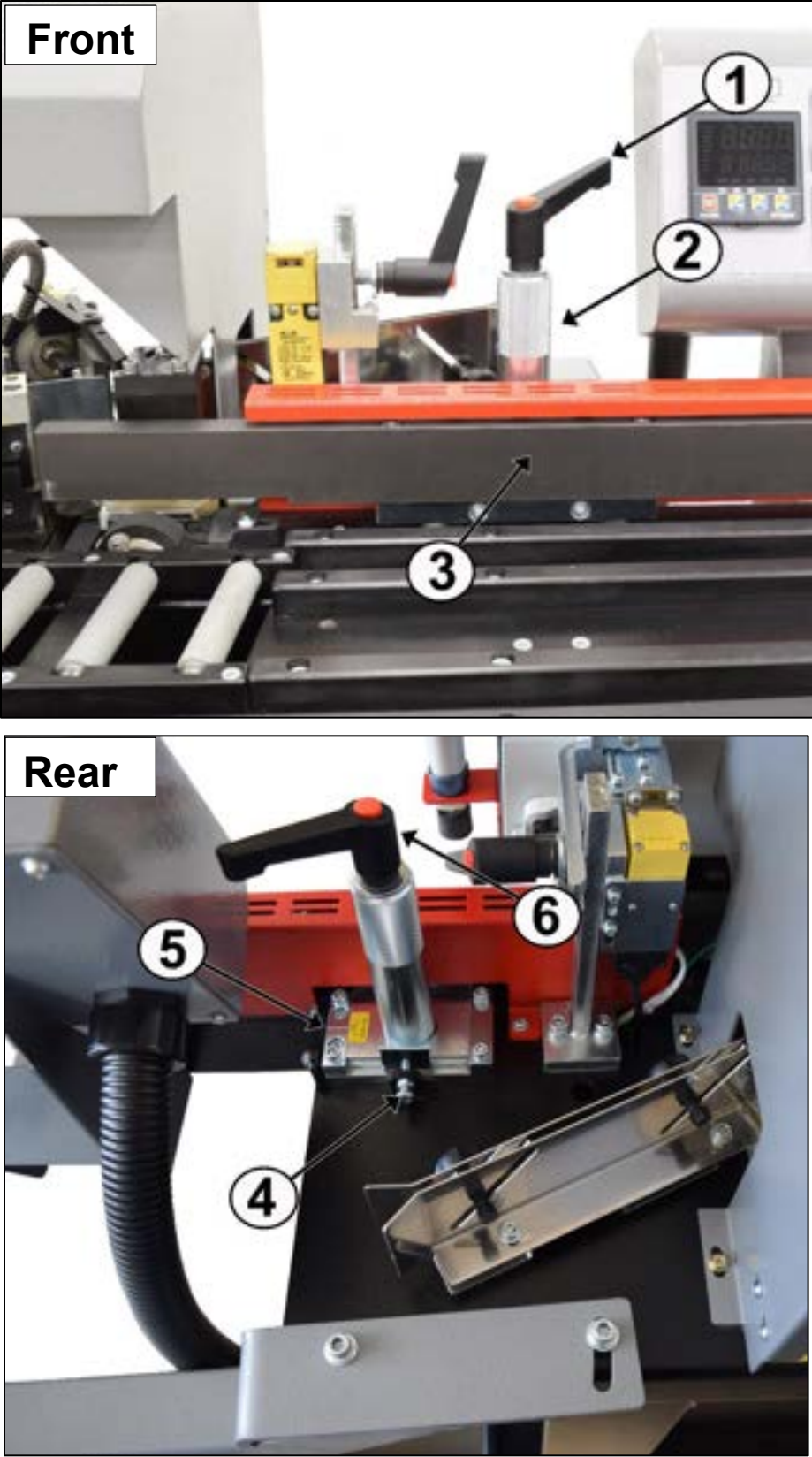


Figure 3-10: Infeed Fence

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1. **Fence Adjustment Lock Lever** – Tighten to secure the fence position; loosen to allow the fence adjustment.
2. **Fence Adjustment Knurled Cylinder** – Rotate to adjust the fence position according to edgebanding thickness. Rotate counterclockwise for greater edgebanding thickness; rotate clockwise for less edgebanding thickness.
3. **Heated Infeed Fence** – Guides workpiece during operation while also heating workpiece edge for better glue adhesion.
4. **Fence Stop** – Allows for quickly and easily setting the infeed fence position without having to use the scale.
5. **Fence Adjustment Scale** – Indicates position of the fence relative to the edgebanding thickness in millimeter increments.

6. **Master Power ON/OFF switch**
– Turns incoming power ON and OFF.
7. **Main Pressure Regulator** –
Adjusts incoming air pressure.
Pressure should be set to 100 PSI. Lift knob up and rotate clockwise to increase PSI/counterclockwise to decrease PSI, then push knob down to secure setting.
8. **Wiring Box** – Location to permanently connect (hardwire) the machine to the power supply.



Figure 3–1: Power and Air Fence

[illegible]

4.0 Receiving the Machine

Following delivery and before the driver and riggers have left, inspect the packing, invoice, and shipping documents. Next, ensure there is no visible damage to the packaging or the machine. All damage must be noted on the delivery documents and signed by the receiver and the delivery driver. Contact Laguna Tools Customer Service as soon as possible in case of damage. It is advisable to photograph and document any shipping damage. The original packaging is required to return damaged equipment to Laguna Tools.

NOTE

Sawdust may be found in the machine upon arrival. This is because the machine has been tested prior to shipment from the factory and/or Laguna Tools. Laguna Tools tests all machines prior to shipping, but some adjustments may have to be undertaken by the customer. These adjustments are covered in the various sections of this manual.

Most large machinery will be delivered on a tractor trailer 48 to 53 feet long. Please notify a Sales Representative with any Delivery Restrictions. The customer is required to have a forklift (6000 lbs. or larger is recommended) with 72-inch tines or tine extensions.

[illegible]

5.0 Machine Placement

When unpacking the Bandit 3/2 Edgebander, separate all enclosed items from the packing materials and inspect each for damage. Save the packaging materials until all issues concerning missing or damaged items have been resolved.

5.1 Placement

Select the area where the Bandit 3/2 Edgebander will be operated. The physical environment where the Bandit 3/2 Edgebander is located is important to safe assembly and operation. Before removing the Bandit 3/2 Edgebander from its packaging, consider the weight load, electrical installation requirements, lighting, dust collection, and space allocation available for the machine and accompanying materials.

Guidelines for properly placing the machine follow:

1. There should be sufficient area around the machine to facilitate easy access to the workpiece, perform maintenance, and provide safe egress in the event of an emergency.
2. Select a solid level floor rated to hold the weight of the Bandit 3/2 Edgebander (1200 pounds) and workpieces under both static and dynamic loads. Laguna Tools recommends concrete flooring. Consult a licensed and experienced professional if in doubt.
3. Locate the Bandit 3/2 Edgebander close to a power source and dust collection.
4. Allow an area for the storage of workpiece materials, finished products, and tools.
5. Leave ample space around the Bandit 3/2 Edgebander for the operator to handle both the equipment and the materials being cut.
6. Leave enough space around the Bandit 3/2 Edgebander to open or remove doors/covers as required by the maintenance section described in the Owner's Manual.

5.2 Dust Collection

1. Fit a 4-inch dust hose over each dust port and secure in place with hose clamps.
2. Tug on the hoses to verify each end is secure.

NOTE

A tight fit is necessary for proper performance.

5.3 Electrical Requirements

The Bandit 3/2 Edgebander requires permanent, direct power installed by a qualified electrician familiar with industrial best practices. Ensure that all power cords are protected from traffic, moisture, chemicals, or other hazards. **For safety, always have a qualified electrician assess grounding and any further electrical needs.**

5.4 Compressed Air Requirements

This machine requires compressed air at 6 SCFM @ 100 PSI

5.5 Lighting

Ensure that the lighting your machine is placed under is sufficient to safely perform regular operation and maintenance. Any glares, shadows, or strobe lighting which may distract or prevent the operator from safely operating the machinery should be removed from the working area.

6.0 Unloading & Unpacking the Machine

NOTE

All shipping related claims for loss or damaged goods must be made to Laguna Tools within 24 hours of delivery.

Contact Laguna Tools customer service department to make claims for any damaged items/parts.

The original packaging is required to return damaged goods within the warranty period.

The machine should be delivered on a trailer by one or a combination of these methods.

1. In a crate
2. In a box
3. Heat shrunk in plastic

Sitting on a pallet BEFORE unpacking your new machine, inspect the packaging, invoice, and the shipping documents supplied by the driver. When unloading the machine, verify there is no signs of damage to the parts or machine you have received.

See the components section to cross reference the parts you should receive.



WARNING

The customer is required to have a forklift (6000 lbs. or larger is recommended) with 72-inch forks or fork extensions.



WARNING

Unload the machine with care. DO NOT pinch, crush, or damage any components that are on/around the machine.

WARNING

This machine is heavy. Seek assistance from an experienced professional if you have any doubt about the following unboxing or set up procedures.

DO NOT attempt any procedure that you feel is unsafe or you believe you do not have the physical capability of achieving.

CAUTION

When determining location, verify there is sufficient room around the machine.. If you cannot fully open all the doors around the machine, it cannot be installed or serviced in the future if necessary.

Tools needed:

- Crowbar or prybar
- Forklift or pallet jack
- Drill with Phillips head bit
- Tin snips

BEFORE moving the machine to the desired location, verify that there is sufficient room around the dust collector to facilitate easy access to the workpiece, perform maintenance, and provide a safe exit in the event of an emergency.

1. Use a forklift (6000 lbs. or larger is recommended) with 72-inch forks or fork extensions to unload the machine from the trailer.
2. Move the machine to a desired location.
3. Use tin snips to cut and remove any straps.
4. Use a drill with Phillips head bit to remove any screws that are securing the machine to the pallet/crate.
5. If necessary, use the prybar to remove any surrounding wood.
6. Use the forklift to lift the machine and remove the pallet/crate.
7. Lower the machine gently on the floor.

Ensure that all parts/components are present and in good condition.

7.0 Setup & Assembly

The machine must be fully assembled before it can be operated. Before beginning the assembly process, collect all required items. To ensure the assembly process goes smoothly, first clean any parts that are covered or coated in heavy-duty rust preventative (if applicable).

Assembling the Bandit 3 requires repositioning to the control panel, installing the coil support assembly, installing the panel feeder elevation handwheel, and aligning the table extension with the table.

7.1 To Assemble the Machine

1. Use a 6mm Allen key to remove the (2) pre-installed cap screws, lock washers, and flat washers that secure control panel in shipping position.
2. Mount control panel upright with fasteners removed during Step 1.



Figure 7-1: Cap Screws Securing the Control Panel

3. Use a 5mm Allen key to remove the (2) lock nuts on the side of the panel feeder elevation handwheel.
4. Install the handwheel on panel feeder elevation shaft and secure with fasteners removed in the previous step.



Figure 7-2: Handwheel Installed

5. Remove (2) pre-installed M10- 1.5 hex nuts and (2) 10mm fender washers from coil support stud.

NOTE

Leave (1) M10-1.5 hex nut and (1) 10mm fender washer installed.

6. Thread the stud up through bottom of coil support arm.
7. Install one (1) M10-1.5 hex nut and (1) 10mm fender washer on coil support stud and tighten hex nut against top of coil support arm then tighten hex nut against support arm.
8. Install coil support assembly on stud and secure with remaining M10-1.5 lock nut and 10mm fender washer.



Figure 7-3: Coil Support Assembly

9. Remove slide nut from each of four (4) guide roller assemblies.



Figure 7-4: Guide Roller and Slide Nut

10. Place the side nut under slot in coil support assembly, then thread guide roller with washers into nut from above and tighten. Repeat with the remaining three (3) guide roller assemblies in each of the remaining slots.



Figure 7-5: Location of Panel Feeder Lock Lever

11. Pull out the extension table as far as it goes.
12. Place straightedge over infeed (right) end of main table and extension table. Make sure straightedge touches the top of extension table roller above leg.
 - If straightedge makes solid contact across the entire infeed end of the main table and top of extension table roller, no adjustment is necessary. Proceed to Step 14.
 - If straightedge **does not** make solid contact across the entire infeed end of main table and top of extension table roller, extension table is not aligned with main table and must be adjusted.



Figure 7-6: Extension Table Extended

If this machine comes with 4 adjustable leveling feet, save them for future use. The leveling feet can be used with a mobility kit (not included) if one is purchased. The machine is meant to be placed on the ground and shims should be used if on unlevel ground.

13. Use a 19mm wrench to loosen the jam nut at bottom of extension table leg.
 - a. Rotate adjustable foot nut until extension table is aligned with main table, then tighten jam nut against bottom of leg to secure setting.
14. Repeat Steps 16-17 for outfeed (left) end of table.



Figure 7-7: Extension Table Alignment Components

7.2 Cleanup

The heated infeed fence is coated with a heavy-duty rust preventative that prevents corrosion during shipment and storage. This rust preventative works extremely well, but it will take a little time to clean.

Be patient and do a thorough job cleaning. The infeed fence gets extremely hot during operations and could create harmful fumes if any residue is left on the fence.

There are many ways to remove this rust preventative, but the following steps work well in a wide variety of situations. Always follow the manufacturer's instructions with any cleaning product you use and make sure you work in a well-ventilated area to minimize exposure to toxic fumes.

Before cleaning, gather the following:

- Disposable rags
- Cleaner/degreaser
- Safety glasses and disposable gloves
- Plastic paint scraper (optional)

Basic steps for removing rust preventative:

1. Put on safety glasses.
2. Coat rust preventative with a liberal amount of cleaner/degreaser, then let it soak for 5-10 minutes.

3. Wipe off surfaces. If your cleaner/degreaser is effective, rust preventative will wipe off easily. If you have a plastic paint scraper, scrape off as much as you can first, then wipe off the rest with rag.
4. Repeat Steps 2-3 as necessary until all rust preventative and cleaner/degreaser are completely removed.

7.3 Dust Collection

To connect dust collection hoses:

1. Fit a 4-inch dust hose over each dust port. Secure in place with hose clamps.
2. Tug hoses to make sure they do not come off.

NOTE

A tight fit is necessary for proper performance.

7.4 Safety Test Run

Once assembly is complete, test run the machine to ensure it is properly connected to power and all safety components are functioning correctly.

If you find an unusual problem during the test run, immediately stop the machine, disconnect it from power, and fix the problem before operating the machine again. Refer to the Troubleshooting table in the Troubleshooting section of this manual.

The test run consists of verifying the following:

- Glue pot powers up and reaches working temperature of 356°F (180° C)
- Heated infeed fence powers-up
- Guillotine and edge trimmer sensors power-up
- Each motor powers-up and runs correctly
- Emergency Stop button works correctly
- Safety limit switches work correctly

To test run the machine:

1. Read and follow safety instructions at the beginning of manual, take all required safety precautions, and make sure all pervious setup/assembly steps in this manual have been followed and completed.
2. Ensure panel feeder is closed and locked, and rear access cover is closed. If either of these items is not properly closed, the machine will not function.
3. Clear all setup tools and loose items away from the machine.
4. Turn the master power switch OFF and press the Emergency Stop button in.
5. Connect machine to power by inserting power cord plug into a matching receptacle, then connect machine to an air supply and adjust air regulator to 100 PSI.
6. Twist the Emergency Stop button clockwise until it springs. This resets the switch so the machine can start.
7. Turn the master power switch ON. The thermoregulator display on the control panel should illuminate.
8. Watch the thermoregulator display and listen for glue spindle motor to start. When the upper number reaches 180°C, glue spindle motor should turn ON.



Figure 7-8: Thermoregulator Display and Stop Button

NOTE

Spindle motor won't turn ON if the Emergency Stop button is in.

9. Press guillotine sensor ON/OFF button; button should illuminate, indicating sensor is activated. Press button again; button should darken, indicating sensor is no longer activated.



Figure 7-9: Panel Feeder, End Trimmer, Flush Trimmer and Buffing Unit ON/OFF

10. Perform same activation test for end trimmer sensor.
11. Press infeed fence ON/OFF button; button should illuminate, indicating fence is heating up. Press button again; button should darken, indicating fence is no longer heating and has begun to cool down.
12. Press panel feeder ON/OFF button. The button should illuminate. Panel feeder motor should start up and run smoothly without any unusual problems or noises.
13. Perform same motor test for end-trimmer, flush trimmer, and buffing unit motors.
14. Turn all upper and lower green ON/OFF buttons ON.



Figure 7-10: Thermoregulator

15. Press the OFF button. All upper green ON/OFF buttons should remain illuminated. All lower green ON/OFF buttons should darken and the following motors should turn OFF.

- Panel feeder
- End trimmer
- Flush trimmer
- Buffing unit

16. Press all lower green ON/OFF buttons again. They should illuminate and their respective motors should turn ON.

17. Press the Emergency Stop button. All upper and lower green ON/OFF buttons should darken, and their respective components and motors should turn OFF.



Figure 7-11: Guillotine Sensor, End Trimmer Sensor, Infeed Fence ON/OFF

NOTE

The only machine functions that should still be in operation are glue pot heating element and thermoregulator display.

18. WITHOUT resetting the Emergency Stop button, press each green ON/OFF button one at a time.

- If no green ON/OFF buttons illuminate and no sensors activate or motors turn ON, the Emergency Stop button safety feature is working correctly. Proceed to Step 19.

- If any green ON/OFF buttons illuminate and any sensors activate or motors turn ON, immediately turn master power switch OFF and disconnect machine from power. The Emergency Stop button safety feature is not working correctly. This safety feature must work correctly before proceeding with regular operations. Contact Customer Service if needed.



Figure 7-12: Panel Feeder, End Trimmer, Flush Trimmer and Buffing Unit ON/OFF

19. Twist and pull the Emergency Stop button clockwise to reset it.
20. Open the rear access cover, then press each green ON/OFF button one at a time.
 - If no green ON/OFF buttons illuminate and no sensors activate or motors turn ON, the rear access cover safety limit switch is working correctly. Proceed to Step 21.
 - If any green ON/OFF buttons illuminate and any sensors activate or motors turn ON, immediately turn master power switch OFF and disconnect machine from power. The rear access cover safety limit switch is not working correctly. This safety feature must work correctly before proceeding with regular operations. Contact Customer Service if needed.
21. Open panel feeder, then press each green ON/OFF button one at a time.
 - If no green ON/OFF buttons illuminate and no sensors activate and no motors turn ON, the feeder panel safety limit switch is working correctly. The Test Run is complete.

If any green ON/OFF buttons illuminate and any sensors activate or motors turn ON, immediately turn master power switch OFF and disconnect machine from power. The feeder panel safety limit switch is not working correctly. This safety feature must work correctly before proceeding with regular operations. Contact Customer Service if needed

7.5 Overview

The purpose of this overview is to provide the novice machine operator with a basic understanding of how the machine is used during operation, so the machine controls/components discussed later in this manual are easier to understand.

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Due to the generic nature of this overview, it is not intended to be an instructional guide. To learn more about specific operations, read this entire manual, seek additional training from experienced machine operators, and do additional research outside of this manual by reading how-to books, trade magazines, or websites.

WARNING

To reduce your risk of serious injury, read this entire manual before using machine.

WARNING

To reduce risk of eye injury from flying chips or lung damage from breathing dust, always wear safety glasses and a respirator when operating this machine.

NOTE

If you are not experienced with this type of machine, Laguna Tools strongly recommend that you seek additional training outside of this manual. Read books/magazines or get formal training before beginning any projects. Regardless of the content in this section, Laguna will not be held liable for accidents caused by lack of training.

To complete a typical operation, the operator does the following:

1. Put on safety glasses and a respirator.
2. Checks to verify there is enough glue in the glue pot.
3. Examines workpiece to verify it is suitable for edgebanding.
4. Sets panel feeder height according to workpiece thickness.

5. Adjusts positions of infeed fence, glue spindle guide plate, glue flow, and flush trimmers according to edgebanding thickness.
6. Installs correct size of edgebanding coil for workpiece thickness.
7. Connects machine to air and power, verifies air pressure is set to 100 PSI and waits for the glue pot to reach at least 180°C.
8. Activates guillotine and end-trimmer sensors and turns infeed fence ON. Waits for the infeed fence to heat up.
9. Sets glue temperature according to glue manufacturer's instructions, then waits for glue pot to reach that temperature.
10. Turns ON panel feeder, end trimmer, flush trimmer, and buffing unit.
11. Places workpiece against heated infeed fence, and slides it under panel feeder, allowing panel feeder to take control of workpiece.
12. Receives edgeband workpiece at outfeed end of machine.
13. When finished, stops machine, turns it OFF, and disconnects it from power.

7.6 Setting Glue Pot Temperature

The glue pot ON/OFF is controlled by the master power switch. The glue pot temperature can be adjusted, according to the glue manufacturer's recommendation, by using the buttons on the digital display.

The glue pot will reach working temperature when the actual temperature is within 10° of the set temperature, at which point the glue spindle will begin to spin.

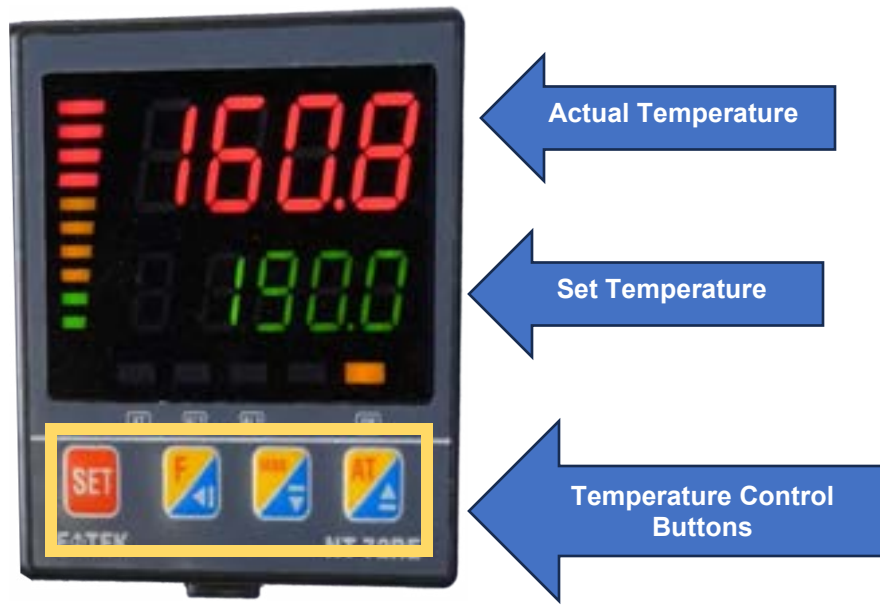


Figure 7-13: Temperature Display and Controls

To set glue pot temperature:

1. Turn the master power switch ON.
2. Press the Set button on the control panel. The lower (green) digit will begin to flash.
3. Press the left arrow button to cycle left until the appropriate digit is flashing, then press the up or down button to adjust to desired setting.
4. When finished, press the Set button to return to normal operating mode.

7.7 Standby Mode

Standby mode is activated when the machine has been sitting idle, with the master power switch ON for 30 minutes after initial power-up. If any motor has been powered ON, then OFF, standby mode is activated after sitting idle for 20 minutes.

When the machine enters standby mode, the power lamp will be illuminated and the glue pot temperature will decrease by 40° C. To remove the machine from standby mode, simply press any motor ON button. The power lamp will turn off and the glue temperature will increase until it reaches the set working temperature. The glue spindle will not operate until the working temperature has been reached.

7.8 Checking/Adding Glue

WARNING

This procedure requires the user to work with parts that are very hot. To reduce the risk of burns, use extreme caution and wear leather gloves or heat resistant gloves while performing this procedure.

The BANDIT 3 uses a glue pot system that melts glue pellets and dispenses the melted glue using a spindle.

We recommend only using EVA (Ethylene Vinyl Acetate) glue pellets in this machine. EVA adhesive can be re-melted which makes it easy to refill and/or clean the glue pot. EVA works well as a multi-purpose glue melt for most edgebanding operations.

Avoid using PUR (Polyurethane) adhesive in this machine. PUR adhesive hardens when cured and cannot be re-melted, which makes cleaning the glue pot much more difficult.

Always follow the glue manufacturer's recommendation for setting the proper glue pot working temperature 356°F (180°C).

NOTE

This procedure is best performed after glue pot has reached working temperature.

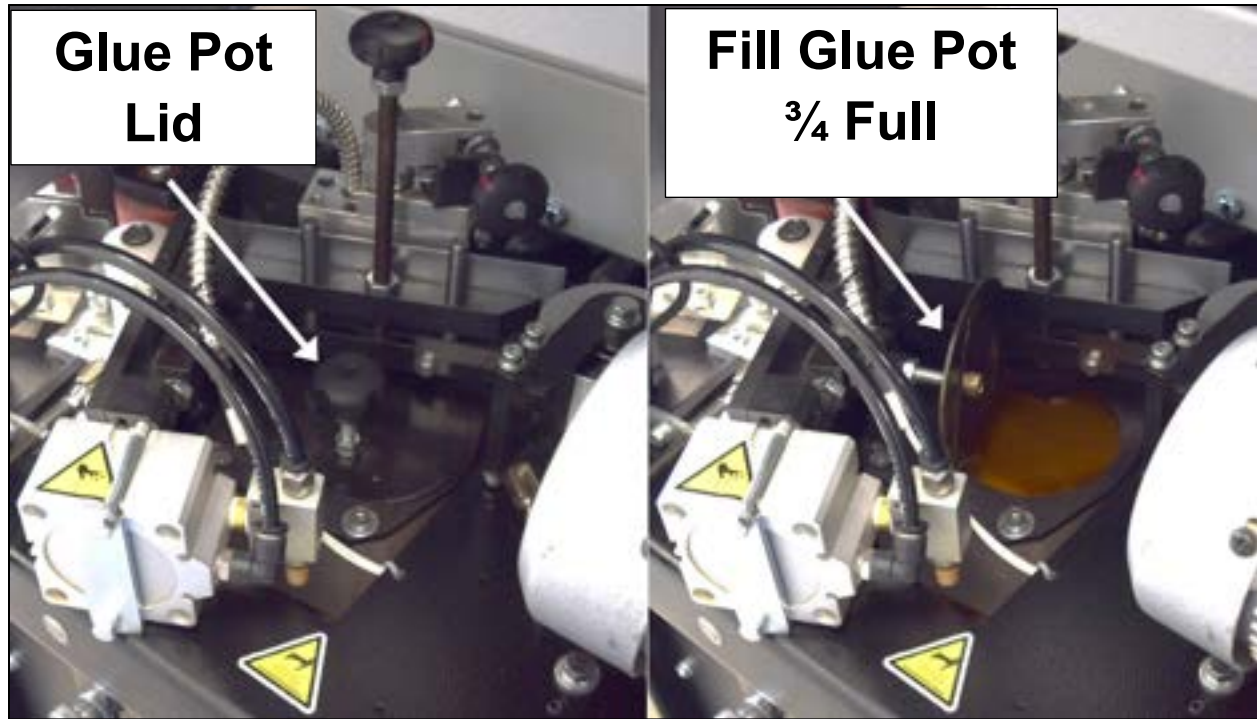


Figure 7-14: Checking Glue Level

Always check the glue level before starting the edgebander and periodically during operations.

The glue pot is full when the melted glue reaches $\frac{3}{4}$ inch (2 cm) below the top of the pot. **Do not** overfill the glue pot.

NOTE

For instructions on removing and changing glue, refer to Removing/Changing Glue in the Maintenance section.

⚠ CAUTION

This procedure requires the user to work with parts that are very hot. To reduce risk of burns, use extreme caution and wear leather gloves or heat resistant gloves while performing this procedure.

To check/add glue:

1. Press the Emergency Stop/Reset button.
2. Open rear access cover and remove glue pot lid. Determine if pot needs glue pellets.
3. Carefully add glue pellets until glue reaches $\frac{3}{4}$ inch (2 cm) below top of glue pot, then close glue pot lid and close rear access cover.

NOTE

Add small amounts of glue pellets frequently for better melting consistency.

7.9 Setting Panel Feeder Height

The panel feeder must be set to match the workpiece thickness. The height adjusts with a handwheel and locks in place with a lock lever. Below the panel feeder elevation handwheel, is a numerical display that shows the height of the panel feeder in millimeters.

To set panel feeder height:

1. Measure workpiece thickness in millimeters.
2. Loosen panel feeder lock lever.



Figure 7-15: Panel Feeder Lock Lever

IF PANEL FEEDER LOCK LEVER IS NOT LOOSENED, PANEL FEEDER HEIGHT WILL BE CROOKED WHEN ROTATING HANDWHEEL.

3. Rotate panel feeder elevation handwheel until numerical display on base of handwheel matches measurement from workpiece thickness.
4. Rotate the handwheel clockwise to raise panel feeder, rotate handwheel counterclockwise to lower panel feeder.



Figure 7–16: Handwheel

NOTE

When adjusting panel feeder down, lower 3-4 digits past desired position and then raise back up to desired position to eliminate backlash in the worm gear.

5. Retighten panel feeder lock lever to secure panel feeder.

7.10 Setting Infeed Fence Position

The infeed fence position is set according to the edgebanding thickness.

There are two (2) methods for setting the infeed fence position:

1. Using the infeed fence scale
2. Using the infeed fence stop.

The recommended set up is utilizing the infeed fence stop.

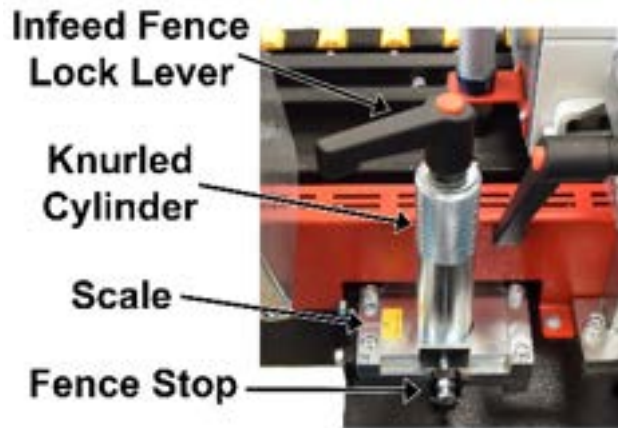


Figure 7-17: Infeed Fence

7.10.1 Using Infeed Fence Scale

The numbers on the infeed scale correspond to the edgebanding thickness (in millimeters). When using the infeed scale, simply adjust the fence until the scale indicates the correct edgebanding thickness.

To set infeed fence position using scale:

1. Carefully measure thickness of edgebanding to be used.
2. Loosen infeed fence adjustment lock lever, rotate knurled cylinder until number indicating thickness of edgebanding aligns with mark on scale, then retighten lock lever.

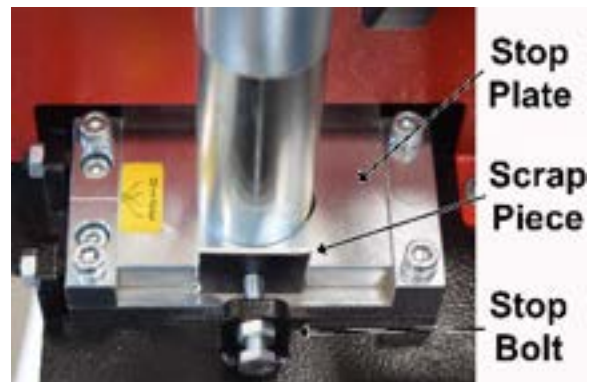


Figure 7-18: Infeed Fence Position

7.10.2 Using Infeed Fence Stop

The infeed fence stop allows you to set the infeed fence position quickly and easily without having to use the scale. It is particularly useful when switching back and forth between different edgebanding thicknesses or when the thickness of the edgebanding cannot be expressed in whole millimeters.

With this method, you place a scrap piece of the edgebanding you intend to use between the stop bolt and stop plate, then adjust the fence until the stop plate presses firmly against the scrap piece.

NOTE

For best results, the infeed fence stop should be periodically checked for accuracy and, if necessary, calibrated.

To set infeed fence position using stop:

1. Cut a 1-3 inches long section from edgebanding you intend to use.
2. Loosen infeed fence adjustment lock lever, then rotate knurled cylinder to create a gap between stop plate and stop bolt.
3. Place scrap piece from Step 1 between stop bolt and stop plate.
4. Rotate knurled cylinder until stop plate presses firmly against scrap piece, then tighten infeed fence lock lever to secure setting.

7.11 Checking/Adjusting Guide Plate

The guide plate keeps the workpiece the proper distance from the glue spindle to help control the amount of glue that is applied.

The glue spindle draws melted glue up from the glue pot and applies it to the workpiece edge just before the edgebanding is applied.

Items needed:

- One (1) Workpiece at least 36 inches long. This workpiece must be a machined surface without any deviations along its length. The measurement for this procedure is $\frac{1}{2}$ of a millimeter. Wood or other manufactured materials will have variances too great to achieve an accurate measurement. A precision level with a machined side may be acceptable as a workpiece.
- One (1) Hex Wrench 3 mm
- One (1) pair of leather gloves or heat-resistant gloves

CAUTION

This procedure must be done while the machine is connected to power and air and while the glue pot is very hot. Use extreme caution while making this adjustment to avoid burns or getting caught in moving parts.

To check/adjust guide plate:

1. Press the Emergency Stop/Reset button.
2. Verify that glue pot has sufficient amount of glue and is at working temperature.
3. Set infeed fence to desired position.
4. Move spindle all the way forward by turning glue spindle adjustment knob (Figure 7-6) counterclockwise until it stops.
5. Open the panel feeder, then place straight edge of workpiece against infeed fence.
6. While maintaining inward pressure and keeping the workpiece flat against infeed fence, slide workpiece across the guide plate and over the glue spindle.

- If the workpiece edge is approximately 0.5 mm away from the glue spindle, no adjustments are necessary. Close panel feeder.
- If the workpiece is more than 0.5 mm away or touches the glue spindle, the guide plate is not properly adjusted. Proceed to Step 7.



Figure 7-19: Glue Spindle Adjustment Knob

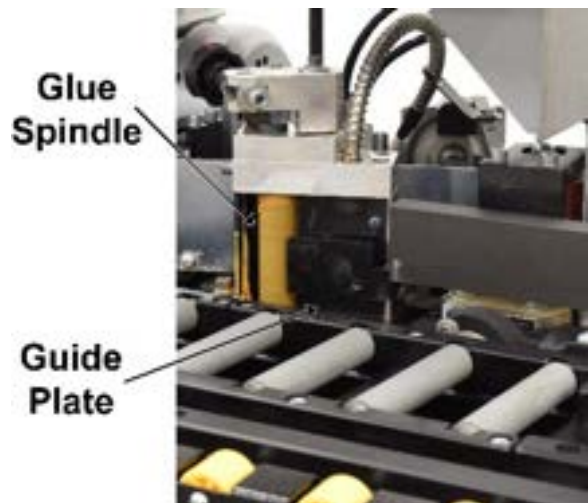


Figure 7-20: Guide Plate Position

CAUTION

Guide plate and spindle are very hot. To reduce risk of burns, wear leather gloves or heat resistant gloves and use extreme caution while performing the next step.

7. Use the **glue spindle adjustment knob** located in face of guide plate to adjust depth.

- Turn the knob clockwise to move the workpiece away from the glue spindle.
- Turn the knob counterclockwise to move the workpiece closer to the glue spindle.

8. Repeat Steps 6-7 until the workpiece is about 0.5 mm away from glue spindle.

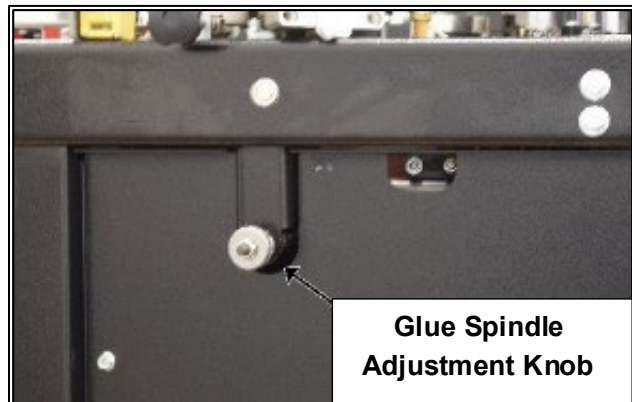


Figure 7-21: Glue Spindle Adjustment Knob

NOTE

When guide plate is properly adjusted, workpiece will pull glue off without touching spindle.

9. Close panel feeder.

7.12 Adjusting Glue Flow

Excess glue can cause build-up on flush trimmer blades and buffing wheels. Adjusting the glue flow so that the residual amount is minimal will increase the life of the finishing blade and wheels, as well as reduce clean-up of the finished product.

To adjust glue flow:

1. Press the Emergency Stop/Reset button.
2. Open rear access cover.
3. Rotate glue flow adjustment knob counterclockwise to increase glue flow; rotate clockwise to decrease glue flow.

NOTE

Adjust only 1/4 of a full turn at a time. 1/4 knob turns make a significant difference.

7.13 Adjusting Flush Trimmer

The flush trimmer trims excess height off of the upper and lower edges of newly applied edgebanding, making it flush with the top and bottom of the workpiece.

The flush trimmer consists of two (2) cutterheads (one upper and one lower) that must each be separately adjusted toward or away from the workpiece, according to the edgebanding thickness.

Always adjust upper and lower cutterheads equally.

To adjust flush trimmer:

1. Disconnect machine from power and air.
2. Carefully measure thickness (in millimeters) of edgebanding you intend to use.
3. Rotate each flush trimmer adjustment knob until the number displayed in readout equals the thickness of edgebanding. (Example: .5mm would read **0005** on the numerical display)

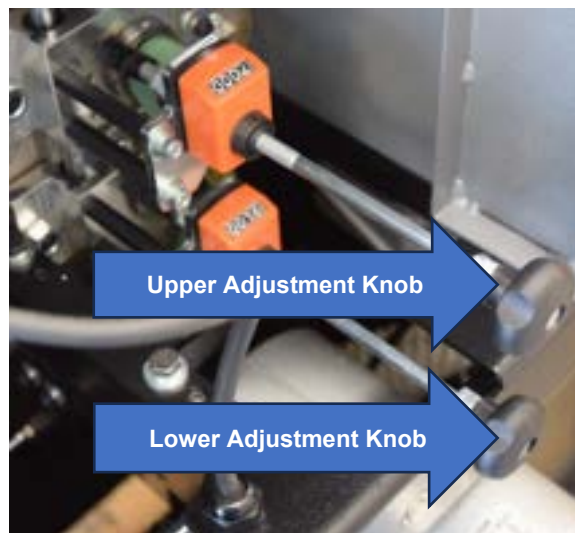


Figure 7-22: Flush Trimmer Adjustment

NOTE

Rotate knobs counterclockwise to move flush trimmers closer to workpiece; rotate knobs clockwise to move them farther away. When adjusting down, lower past desired position by 3-4 digits and then raise back up to desired position to eliminate backlash in the worm gear.

7.14 Installing Edgebanding Coil

The edgebanding coil (not included) is a coiled strip of wood or plastic veneer that is automatically fed into the edgebander and glued to the workpiece edge during the edgebanding process. The BANDIT 3 uses edgebanding tape from .5mm – 3mm inches wide.

For the best results, the edgebanding tape width must be slightly greater than the workpiece thickness. The excess edgebanding tape is automatically trimmed flush with the workpiece during operations.

The edgebanding tape thickness affects machine setup. Before installing the edgebanding coil, the following components should be checked and, if necessary, adjusted depending on the edgebanding tape thickness:

- Heated infeed fences position
- Guide plate position
- Upper and lower flush trimmer positions

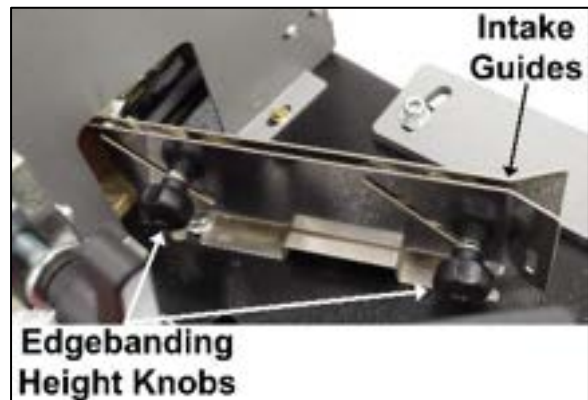


Figure 7-23: Edgebanding Height Knobs and Intake Guides

To install edgebanding coil:

1. Disconnect machine from power and air.
2. Loosen edgebanding height knobs on intake guides, raise knobs to allow room for edgebanding tape, then tighten to secure.
3. Loosen guide rollers on coil support and move them out to allow room for edgebanding coil.
4. Center edgebanding coil on coil support. Move guide rollers so they just touch coil, then tighten to secure.

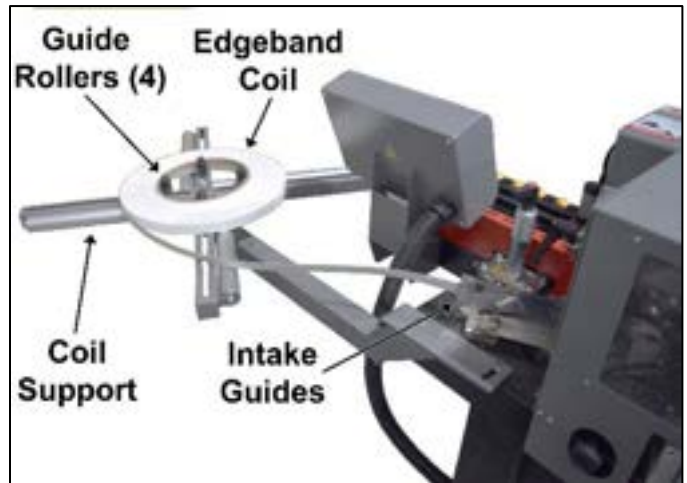


Figure 7-24: Edgebanding Coil on Coil Support

NOTE

Ensure coil can rotate freely. If coil cannot rotate freely, re-adjust guide rollers until it can.

5. Insert the end of edgebanding tape into intake guides.
6. Rotate edgebanding seat adjustment knob clockwise to raise upper portion of seat and allow room for edgebanding tape.
7. Move nylon roller release knob to the right and manually advance edgebanding tape all the way forward, past nylon roller, to end of the edgebanding seat.

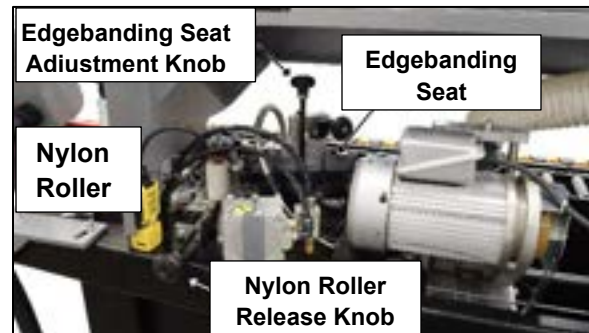


Figure 7-25: Edgebanding Tape Advanced to Forward End

NOTE

Nylon roller release knob is spring-loaded. Hold it in released position (to the right) while you manually move edgebanding tape past the roller.

8. Rotate edgebanding seat adjustment knob counterclockwise to lower upper portion of seat until edgebanding tape has just enough room to move freely back and forth. Leave approximately 1/32 -inch vertical play.

9. Loosen edgebanding height knobs from Step 2, adjust knobs until edgebanding tape has just enough room to move freely back and forth, then tighten to secure. Leave approximately 1/32-inch vertical play.

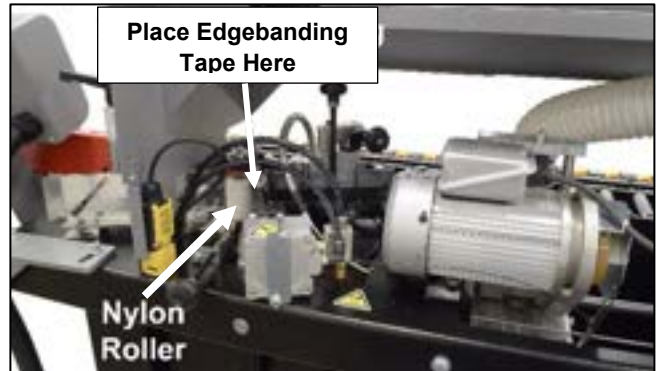


Figure 7-26: Starting Position for Edgebanding Tape

10. Move nylon roller release knob to the right, then manually move edgebanding tape back, until its end is just in front of nylon roller.

The edgebanding tape is now properly set up in the starting position for operations.

8.0 Operating the Machine

8.1 Preliminary checks

BEFORE operation, verify that the operator:

1. Reads and follows all safety and initial setup instructions described earlier in this manual.
2. Runs a safety test run to ensure all components are safely working.
3. Inspect workpiece to make sure it is suitable for edgebanding.
4. Properly adjust panel feeder elevation, infeed fence position, and flush trimmer.
5. Properly install edgebanding coil.
6. Press the Emergency Stop button, turn the master power switch ON.

Once all of the initial setup is complete, performing the edgebanding operation is a relatively simple and quick procedure.

Any workpiece you intend to edge band with the BANDIT 3 must have at least one straight and square edge that is at least 9 ½ inches long.

It is always best to start with a test piece of the same material and dimensions as your intended workpiece, in order to verify all of your settings are correct.

NOTE

Spindle motor won't turn ON if emergency stop button is pressed.

For long workpieces that extend beyond the length of the table, it may be helpful to set up roller stands at each end of the table to add additional workpiece support during operations.

NOTE

In Steps 5-9, the Emergency Stop button must be released before spindle motor will turn.

8.2 Machine Operation

Rotate and pull the Emergency Stop button to reset it, then press lower green ON/OFF buttons to start the machine.

7. Use the **Temperature UP/DOWN** keys to set glue pot temperature according to the glue manufacturer's instructions. Wait for glue pot to reach at least 356°F (180°C), then glue spindle motor will start.
8. Press the upper green **ON/OFF** buttons to activate pneumatic guillotine sensor, end trimmer sensor, and heated infeed fence.
9. Wait for glue pot and infeed fence to reach working temperatures. The machine is now ready to begin edgebanding.
10. Place straight edge of workpiece on infeed end of table and press it firmly against infeed fence.
11. Carefully slide workpiece under panel feeder, making sure to keep hands and fingers away from moving conveyor belt. When you feel panel feeder grab workpiece, remove hands and fingers and allow panel feeder to advance workpiece through to outfeed end of table.



Figure 8-1: Edgebanding Controls



Figure 8-2: Placing the Workpiece

NOTE

For long workpieces, it may be necessary to support trailing end of workpiece with your hands or a roller stand until it begins to move across the table.

Then, as the workpiece begins to exit outfeed end of the table, support leading end of the workpiece with hands or roller stand while panel feeder continues to feed workpiece through.

12. Receive edgebanded workpiece at outfeed end of table. Allow panel feeder to completely finish feeding workpiece, then remove workpiece from the table.

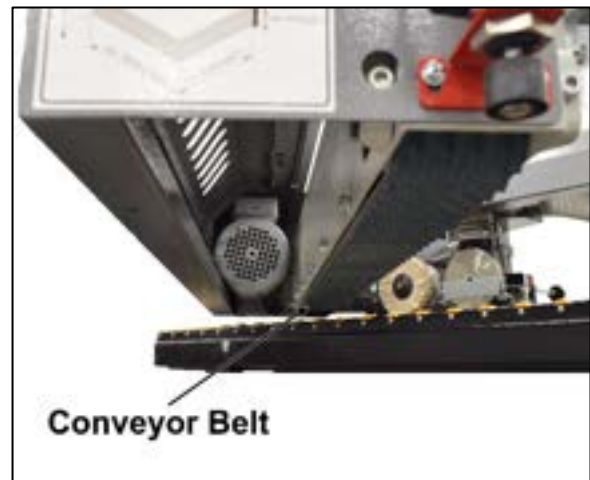


Figure 8–3: Conveyor Belt

9.0 Troubleshooting

Review the troubleshooting procedures in this section if a problem develops with your machine. If you need replacement parts or additional help with a procedure, call Laguna Tools customer service.

NOTE

Please gather the serial number and manufacture date of your machine before calling.

9.1 Motor and Electrical

Symptom	Possible Cause	Possible Solution
Machine does not turn on, one or more motors do not start, or a breaker trips.	1. Emergency Stop button depressed/at fault. 2. Master power switch off/at fault. 3. Panel feeder/rear access panel left open. 4. Plug/receptacle at fault/wired wrong. 5. Power supply circuit breaker tripped/fuse blown. 6. Incorrect power supply voltage/circuit size. 7. Inadequate air pressure. 8. The glue pot has not reached the working temperature. 9. Blown fuse on machine. 10. Thermal overload relay(s) tripped. 11. Motor wires connected incorrectly. 12. Wiring open/has high resistance. 13. Start capacitor(s) at fault.	1. Rotate the button head to reset. Replace. 2. Turn switch ON; test/replace switch. 3. Close and secure panel feeder/rear access panel. 4. Test for good contacts; correct wiring. 5. Ensure circuit is sized correctly and free of shots; reset circuit breaker/replace fuse. 6. Ensure correct power supply voltage/circuit size is being used. 7. Ensure incoming air pressure is at least 6 SCFM @ 100 PSI; adjust air pressure regulator to 100 PSI. 8. Allow glue pot to reach 180°C. 9. Check/replace blown fuses.

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	14. Contactor(s) not energized/has poor contacts. 15. Centrifugal switch at fault. 16. Circuit board at fault. 17. Motor(s) at fault.	10. Reset; contact tech support if relay frequently trips. 11. Correct the motor wiring connections. 12. Check/fix broken, disconnected, or corroded wires. 13. Test/replace. 14. Test all legs for power/replace. 15. Test/replace. 16. Inspect/replace. 17. Test/repair/replace.
One or more motors stall or are underpowered.	1. Motor(s) overheated. 2. Belt(s) slipping; oil/grease on belt(s). 3. Motor(s) wired incorrectly. 4. Plug/receptacle at fault. 5. Conveyor belt slipping/at fault. 6. Run capacitor at fault. 7. Pulley/sprocket slipping on shaft. 8. Centrifugal switch at fault. 9. Motor bearings at fault.	1. Allow motor(s) to cool; reset overload if necessary. 2. Clean/tension/replace belts(s). 3. Wire motor(s) correctly. 4. Test for good contacts/correct wiring. 5. Tension belt; replace if faulty. 6. Test/repair/replace. 7. Replace loose pulley/shaft. 8. Adjust/replace centrifugal switch if available. 9. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.

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Machine has vibration or noisy operation.	1. Motor or component loose. 2. Belt(s) worn or loose. 3. Buffing wheel(s) at fault/incorrectly mounted. 4. Motor fan rubbing on fan cover. 5. Pulley loose. 6. Machine incorrectly mounted. 7. Motor bearings at fault. 8. Belt(s) slapping cover/components. 9. Flush trimmer knives at fault. 10. End-trimmer blades dull/incorrectly mounted. 11. Spindle/arbor bearings at fault. 12. Centrifugal switch is at fault. 13. Motor shaft bent.	1. Inspect/replace damaged bolts/nuts and re-tighten with thread locking fluid. 2. Inspect belts; tension/replace belts. 3. Inspect/reinstall buffing wheel(s); replace. 4. Fix/replace fan cover; replace loose/damaged fan. 5. Re-align/replace shaft, pulley set screw, and key. 6. Tighten mounting bolts; relocate/shim machine. 7. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement. 8. Replace/realign belt(s). 9. Resharpen/replace knives; set knife alignment/height correctly. 10. Inspect/resharpen/re-install/replace blades. 11. Test by rotating spindle/arbor; rotational grinding/loose shaft requires bearing replacement. 12. Replace. 13. Test with dial indicator and replace motor.
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9.2 Glue Spindle

Symptom	Possible Cause	Possible Solution
Glue spindle does not rotate.	1. Motor does not run. 2. Too much grease was added to glue spindle. 3. Gear connection shaft stripped/broken. 4. Gear connection shaft stuck.	1. Rotate the button head to reset. Replace. 2. Remove pressure-relief set screw. 3. Inspect/replace gear connection shaft. 4. Adjust motor reducer connection plate.
Glue spindle does not dispense enough glue.	1. Glue flow out of adjustment. 2. Glue not fully melted, temperature setting too low. 3. Glue not fully melted, heater rods not working correctly. 4. Guide plate not adjusted properly. 5. Obstruction in glue shaft. 6. Burnt glue in glue spindle. 7. Glue pot thermometer not accurate.	1. Adjust glue flow. 2. Adjust glue pot temperature according to glue manufacturer's directions; confirm glue temperature using laser thermometer. 3. Inspect heater rod connections; tighten if necessary. Test heater rod amperage (top: 315W, 1.0A; lower large: 250W, 0.9A; lower small: 160W, 0.6A); replace if necessary. 4. Adjust guide plate. 5. Remove obstruction from glue shaft. 6. Remove burnt glue from glue spindle. 7. Inspect thermocouple connections and wires for damage/wear; repair/replace if necessary.

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Symptom	Possible Cause	Possible Solution
Glue not fully melted in glue pot.	1. The glue pot is still heating. 2. Glue pot temperature is set too low. 3. Heater rods at fault.	1. Wait until the glue reaches working temperature. 2. Adjust glue pot temperature according to glue manufacturer's directions; confirm glue temperature using laser thermometer. 3. Inspect thermocouple connections and wires for damage/wear; repair/replace if necessary.
Glue only adheres to lower portion of workpiece edge.	1. Panel feeder not exerting enough downward force on workpiece. 2. Panel feeder lifts up when closed and latched. 3. Guide plate not adjusted properly. 4. Adjustable pressure roller not making full contact with workpiece. 5. Pressure roller tilted. 6. Glue spindle tilted. 7. Workpiece too wide, not properly supported.	1. Lower panel feeder to 0.5 mm below actual workpiece thickness. 2. Adjust panel feeder latch. 3. Adjust guide plate. 4. Check/adjust pressure roller. 5. Adjust pressure roller so it is 90° to table. 6. Adjust the glue spindle so it is 90° to the table. 7. Pull out table extension/use additional support, such as roller stands.

9.3 End Trimmer

Symptom	Possible Cause	Possible Solution
Blades do not rotate.	1. Motor does not run. 2. Belt damaged/broken. 3. Obstruction preventing blades from rotating.	1. Inspect/replace/adjust belt. 2. Remove obstruction. 3. Replace Motor
End cut not straight/no parallel.	1. Tracer pads out of adjustment. 2. Copy plate bent. 3. Inadequate air pressure.	1. Properly adjust tracer pads. 2. Repair/replace copy plate. 3. Check/remedy air pressure.
Chips inside of panel.	1. Tracer pads out of adjustment. 2. Copy plate bent.	1. Properly adjust tracer pads. 2. Repair/replace copy plate.
Saw blades lose RPM during operation.	1. Belt is loose/damaged/broken. 2. Saw blades are dull/broken. 3. Inadequate air supply.	1. Remove zip-tie. 2. Clean shafts. 3. Check air lines for leaks/check air valves for blockages; repair.

9.3.1 Replacing End Trimmer Drive Belt

If the end trimmer drive belt becomes worn, cracked, frayed, broken, or otherwise damaged, you will need to replace it with a new one.

To replace end trimmer drive belt:

1. Disconnect machine from power and air.

2. Remove end trimmer belt cover and adjust motor to loosen belt (refer to Checking/Adjusting End Trimmer Drive Belt Tension).
3. Remove old belt and install new belt.
4. Properly tension the belt and re-install belt cover (refer to Checking/Adjusting End Trimmer Drive Belt Tension).

9.3.2 Checking/Adjusting End Trimmer Drive Belt Tension

The end trimmer motor transfers power through a cogged drive belt. The belt should be periodically checked for proper tension and, if necessary, replaced.

To check/adjust end trimmer drive belt tension:

1. Disconnect machine from power and air.
2. Open rear access cover.
3. Use a 5mm Allen key to remove the cap screws with flat washers from end-trimmer belt cover, then remove cover.

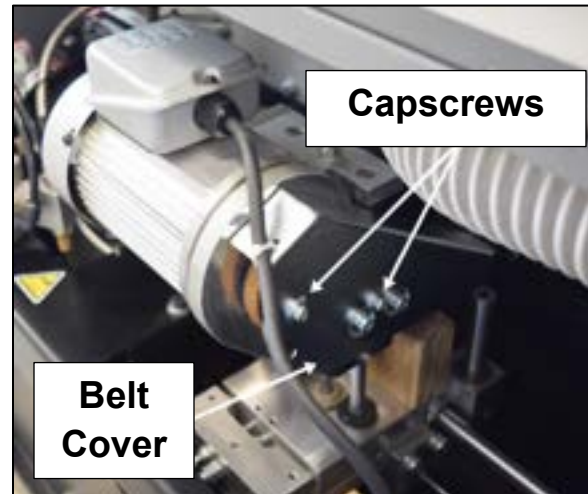


Figure 9-1: Belt Cover

NOTE

If the belt cover is attached to motor cord with a cable tie, you can leave it attached. Just slide belt cover along cord after removing it from motor.

4. Apply moderate pressure to belt to see how much it deflects.
 - If belt deflects approximately $\frac{1}{4}$ inch, it is properly tensioned and no adjustment is necessary.
 - If belt does not deflect approximately $\frac{1}{4}$ inch, it is not properly tensioned and requires adjustment proceed to Step 6.

Belt tensioning bolts can be accessed by inserting a wrench through service holes on the pulley.

5. Rotate end trimmer motor pulley by hand until adjustment hole aligns with one (1) of four (4) belt tensioning bolts.
6. Use a long 4mm Allen key to loosen, **but not remove**, all 4 bolts that secure end trimmer belt tension plate.

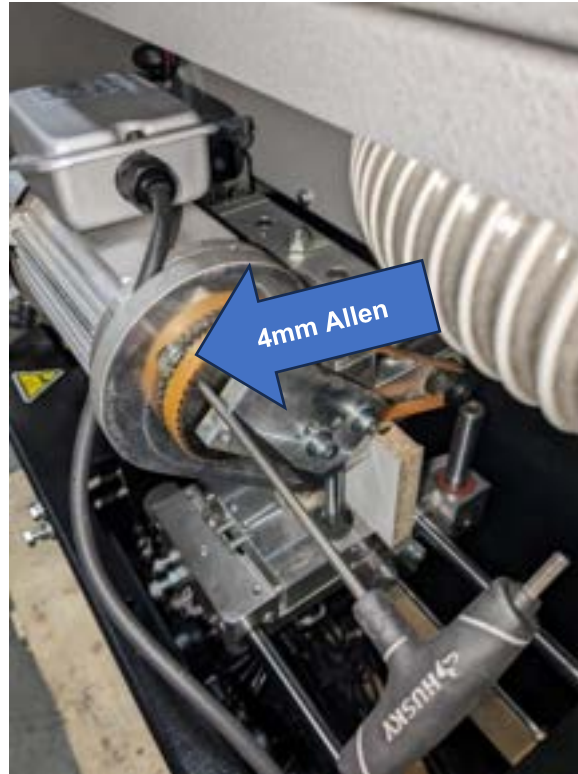


Figure 9–2: Belt Tension Plate

7. Move the motor to rear of machine to increase tension, and then retighten bolts.
8. Using a long 4mm Allen Key, loosen, but do not remove, cap screws that secure end trimmer belt tension plate.

NOTE

Do not remove these screws. If you do, it will be difficult to re-install the end trimmer belt tension plate.

9. Shift motor up or down with one hand while checking belt deflection with other hand. When belt deflection is approximately $\frac{1}{4}$ inch, tighten one (1) of four (4) motor mount bolts.
10. Check belt deflection again and, if necessary, re-adjust it, then tighten remaining motor mount capscrews.
11. Retighten all end trimmer belt tension plate bolts.
12. Re-install belt cover and close rear access cover.

9.3.3 Checking/Adjusting End Trimmer Tracers

Two (2) end trimmer tracers (left and right) orient the end trimmer blades to the workpiece in order to precisely trim the edgebanding flush with the leading and trailing ends of the workpiece.

The end trimmer tracers are factory set and should not require routine service. However, after prolonged use or if the end trimmer fails to produce satisfactory results, you may need to adjust the end trimmer tracers.

To check/adjust end trimmer tracers:

1. Disconnect machine from power and air.
2. Open panel feeder.
3. Place straight edge of workpiece on infeed table, making sure workpiece contacts entire infeed fence along its length.
4. Manually raise and move end trimmer so right end trimmer tracer contacts leading edge of workpiece then raise and lower end trimmer to verify right end trimmer blade is aligned with right tracer.
 - If the blade is aligned to tracer, then no adjustment is necessary.

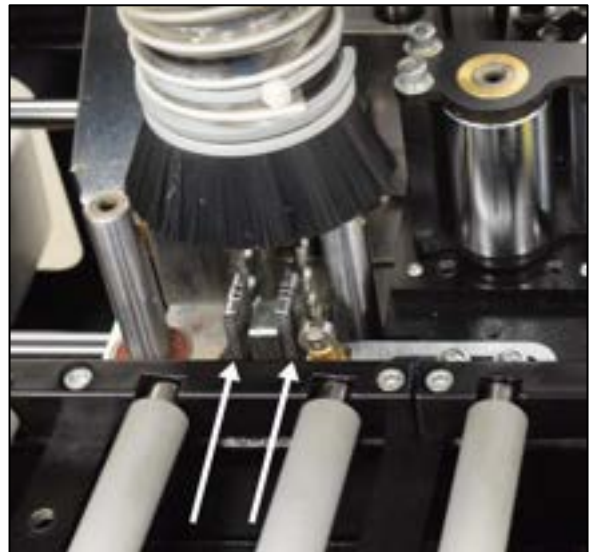


Figure 9-3: End Trimmer Tracers

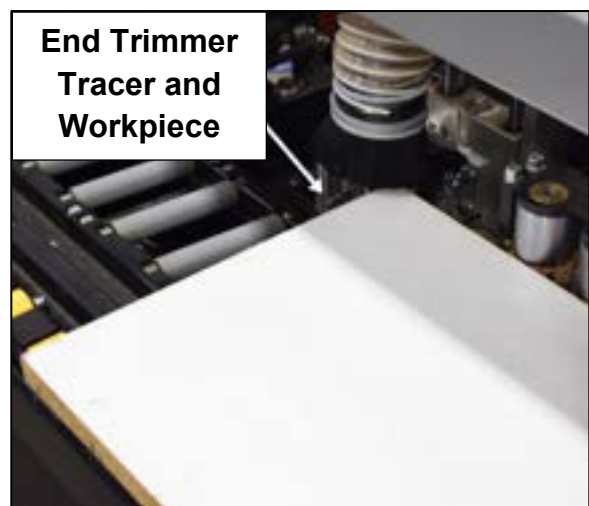


Figure 9-4: Alignment of trimmer Blade

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- If the blade is not aligned with the tracer, the tracer must be adjusted. Proceed to Step 5.
5. Rotate both screws in or out in equal amounts to bring the tracer into alignment with blade.
- For right end trimmer tracer, tighten screws to move tracer left, loosen screws to move tracer right.
 - Loosen set screw in the middle of the tracer plate.
 - Turn the top and bottom screws counterclockwise to move the tracer to the left.
 - Turn the top and bottom screws clockwise to move the tracer to the right.

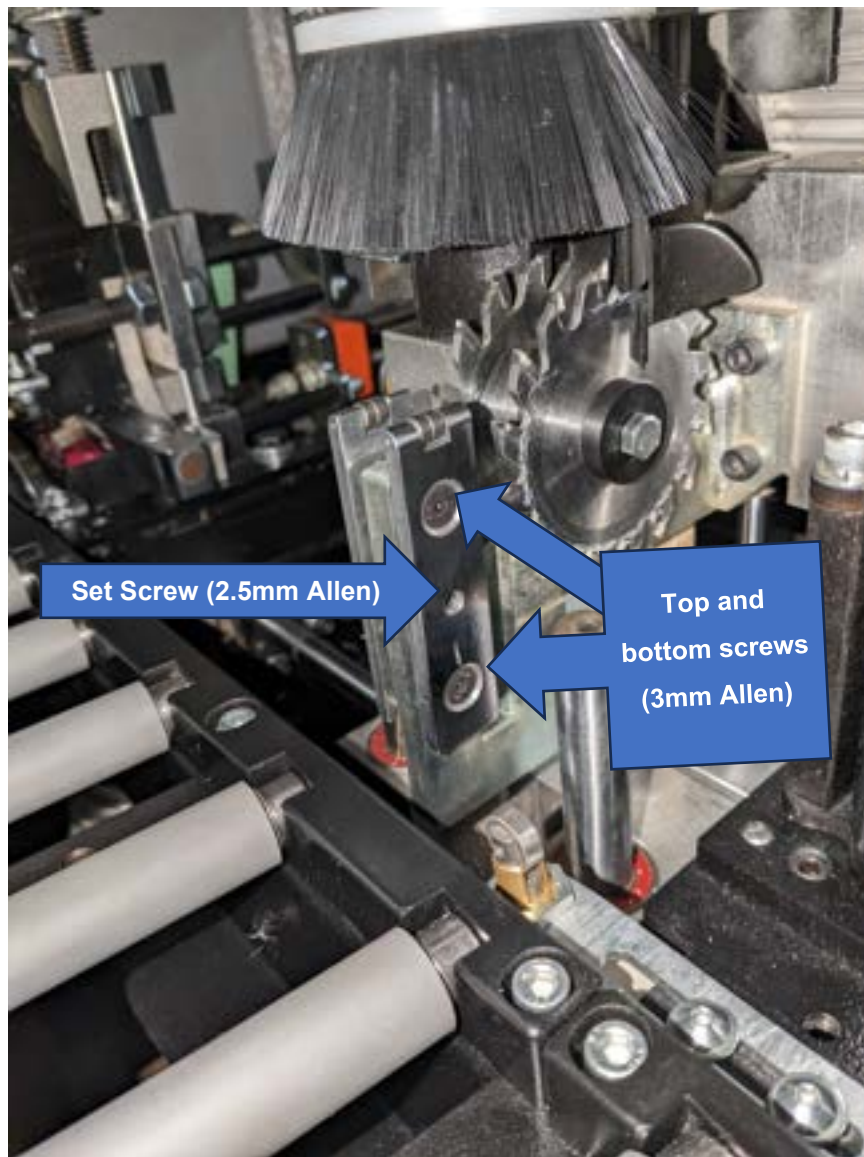


Figure 9-5: Trimmer Tracer Adjustment

6. Place the workpiece on table to left of end trimmer unit, then repeat Steps 4-5 for left end trimmer tracer.

NOTE

Belleville disc washers provide spring tension between tracers and copy plate bracket. Do not back screw all the way out or it may shoot out and get lost.

7. Run a test piece through edgebander to verify adjustment. Repeat adjusting the trimmer tracers until satisfied with results.

9.4 Flush Trimmer

Symptom	Possible Cause	Possible Solution
Cutterheads do not rotate.	1. Motor does not run. 2. Belt is loose/damaged/broken.	1. Inspect/replace belt. 2. Replace Motor
Flush trimmer does not trim proper amount of edgebanding.	Cutterheads not properly adjusted.	Properly adjust cutterheads.
Cutterheads lose RPM during operation.	1. Belt is loose/damaged/broken. 2. Cutterhead knives are dull/broken.	1. Inspect/replace belt. 2. Inspect/replace knives.
Cutterheads will not adjust in or out.	1. Debris stuck between cylinder and housing. 2. Burrs preventing movement.	1. Lubricate flush trimmer shafts to free up movement. 2. Remove cylinder, inspect/clean and lightly sand both surfaces, then re-install cylinder.

9.4.1 Replacing Flush Trimmer Drive Belt

The flush trimming motor transfers power through a serpentine drive belt. The belt is tensioned automatically by the weight of the motor and does not require adjustment. However, if it becomes worn, cracked, frayed, broken, or otherwise damaged in any way, you will need to replace it with a new one.

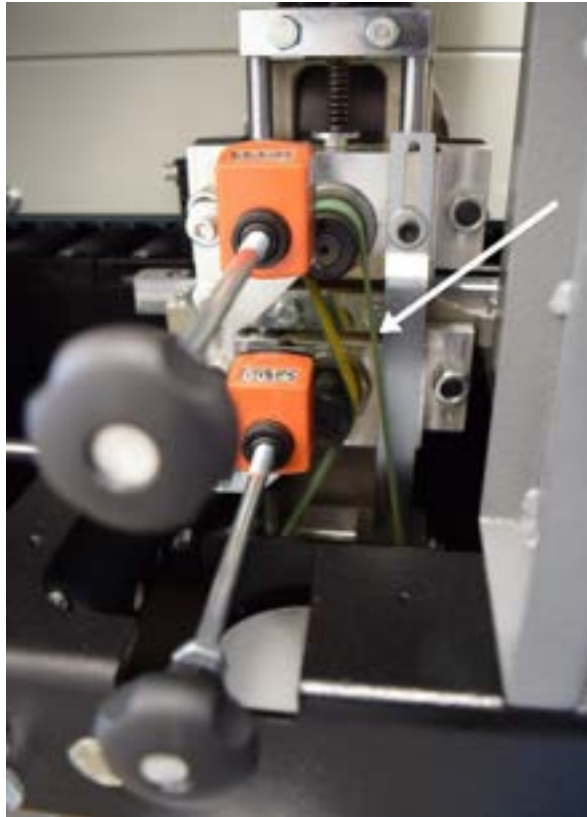


Figure 9–6: Drive Belt

To replace flush trimmer drive belt:

1. Disconnect machine from power and air.
2. Lower panel feeder all the way.
3. Open front and rear access cover.

4. Loosen the cap screw with a 5mm Allen key; this sets the top trimmer roller height. Make note of the position of this bracket. You will need to adjust and retighten this bolt.

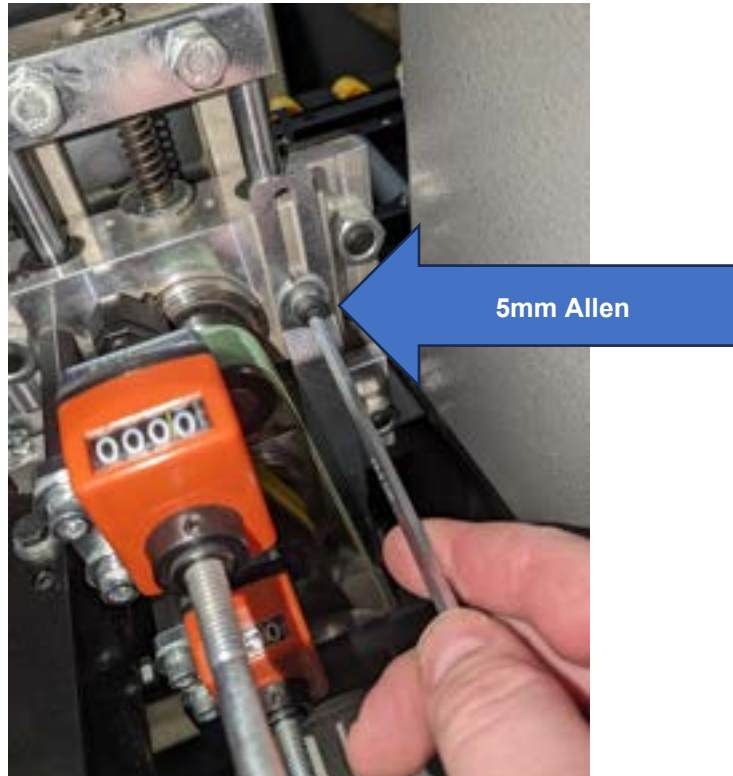


Figure 9-7: Cap Screw

5. Raise the motor by hand, then support it with a 4-inch x 4-inch x 6-inch wood block to release belt tension.

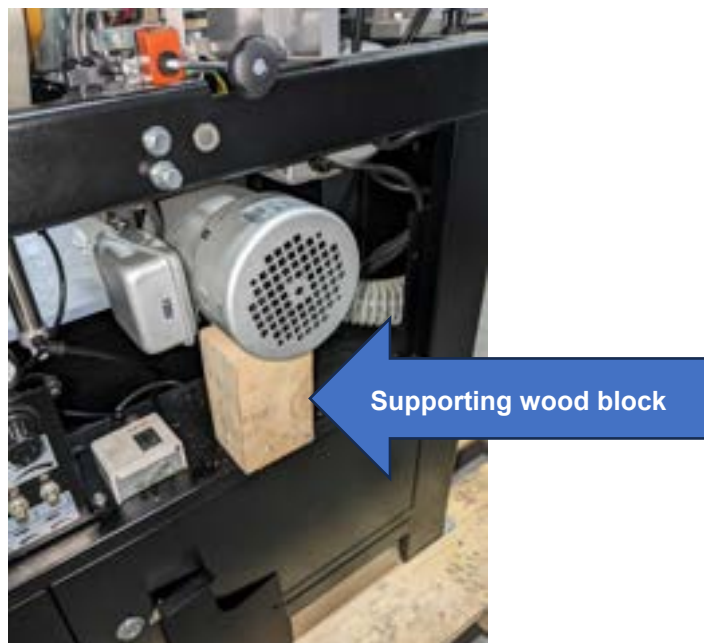


Figure 9-8: Releasing Belt Tension

6. Apply some pressure to the upper cutter to reduce the tension on the belt. Apply pressure to the metal plate behind the dial indicator. This makes it easier to slip off the top belt roller.



Figure 9–9: Applying Pressure to Upper Cutter

7. Remove the old belt by feeding the belt downward and over the pulley. The new belt is installed in the same way that it was removed. It may be easier to feed the replacement belt over the motor pulley from the top of the machine. Make sure to properly route it around the pulleys.



Figure 9–10: Removing/Replacing Belt

8. Raise the motor by hand, then remove wood block.
9. Press down on motor slightly, making sure motor contact bar drops down and contacts motor, then tighten the cap screw.
10. Close the access cover.

9.5 Panel Feeder

Symptom	Possible Cause	Possible Solution
Conveyor belt does not move.	1. Motor does not run. 2. Conveyor belt not properly tensioned.	1. Properly tension conveyor belt. 2. Replace Motor
Workpiece feeds erratically or stops feeding during operation.	1. Conveyor belt not properly tensioned. 2. Panel feeder height not properly adjusted.	1. Properly tension conveyor belt. 2. Properly adjust panel feeder height.

9.5.1 Checking/Adjusting Conveyor Belt Tension

The conveyor belt must be properly tensioned for the panel feeder to properly feed workpieces during operations. The conveyor belt tension is factory set and should not require routine adjustment. However, after prolonged use, or if the panel feeder fails to adequately feed workpieces, you will need to adjust the conveyor belt tension.

To check/adjust conveyor belt tension:

1. Disconnect machine from power and air.
2. Unlock and open panel feeder.
3. Place 8 kg (17 ½ lbs.) of downward force on conveyor belt, as illustrated in label on the panel feeder.



Figure 9-11: Conveyor Belt Downward Force Label

- If there is 3 cm (1 1/8 inch) of deflection, conveyor belt is properly tensioned and no adjustment is necessary.
 - If there is not 3 cm (1 1/8 inch) of deflection, conveyor belt is not properly tensioned and requires adjustment. Proceed to Step 4.
4. Use a 6mm Allen key to rotate conveyor belt tension screws to adjust belt tension.
- Rotate screws clockwise to tighten conveyor belt.
 - Rotate screws counterclockwise to loosen conveyor belt.



Figure 9-12: Tension Screws

NOTE

Both tension screws must be adjusted equally to maintain proper belt tracking.

5. Repeat Steps 3-4, as necessary, until conveyor belt is properly tensioned.
6. Close and lock panel feeder.

9.6 Buffing Unit

Symptom	Possible Cause	Possible Solution
Buffing wheel(s) do not rotate.	1. Motor(s) do not run. 2. Buffing wheel(s) not properly secured.	1. Tighten bolt(s) that secure wheel(s). 2. Replace Motor
Buffing wheel(s) spread glue on workpiece.	1. Too much glue applied. 2. Wrong glue for application.	1. Adjust glue flow. 2. Use appropriate glue for application, refer to glue manufacturer's instructions.
Buffing wheel(s) wear away corners of workpiece/edgebanding.	Buffing wheel(s) not properly adjusted.	Properly adjust buffing wheel(s).

9.6.1 Adjusting/Replacing Buffing Wheels

Two (2) buffing wheels finish the product to give the edges a smooth, polished appearance. Over time, the buffing wheels will wear and need to be adjusted and eventually replaced.

9.6.2 Adjusting Buffing Wheels

If the buffing wheels fail to produce smooth, polished upper and lower edges, the wheels may need to be adjusted.

To adjust buffing wheels:

1. Disconnect machine from power and air.
2. Adjust panel feeder height according to sample workpiece being used, then open panel feeder and place sample workpiece between upper and lower buffing wheels.
3. Open rear access cover, then use a 13mm wrench to loosen the (2) upper buffing motor mounting bolts shown in Figure 9-11.
4. Lower the motor so buffing wheel just barely touches the workpiece, then tighten motor mounting bolts.
5. Uses Steps 3-4 as a guide to raise or lower motor so lower buffing wheel is barely in contact with bottom surface of workpiece, then tighten lower motor mounting bolts.



Figure 9-13: Buffing Wheel Adjustment Mounting Bolts

NOTE

Do not adjust buffing wheels any closer to the workpiece than described in Steps 4 and 5. The buffing wheels increase in diameter when motors are running and will create too much load on motors, which may cause premature failure of the buffing motors and/or other components.

9.6.3 Replacing Buffing Wheels

If the buffing wheels are worn beyond adjustment or are damaged, they will need to be replaced.

To replace buffing wheels:

1. Disconnect machine from power and air.

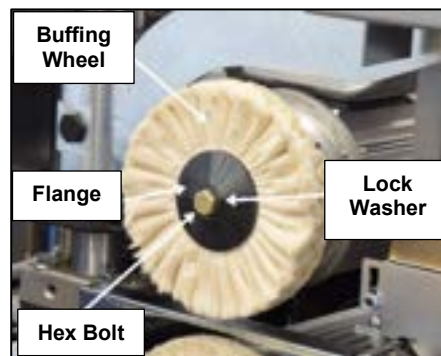


Figure 9-14: Buffing Wheel

2. Use a 13mm wrench to remove the hex bolt securing upper buffing wheel. **Bolt has lefthand threads (clockwise to loosen; counterclockwise to tighten).**

NOTE

If arbor spins, secure it by inserting a 5 mm hex wrench into arbor capscrew.

3. Remove lock washer, flange, and buffing wheel.
4. Install new buffing wheel and re-install flange, lock washer, and hex bolt, in reverse order from removal.

NOTE

Orient components in same direction as they were before removal.

5. Repeat Steps 2-4 with lower buffing wheel. The lower hex bolt has regular threads.
6. Follow steps in Adjusting Buffing Wheels.

9.7 Adjusting Limit Switches

Two (2) adjustable limit switches trigger the guillotine and the end trimmer. The switches are factory set and should not require routine adjustment. However, after prolonged use, or if your edgebanding results are unsatisfactory, the switches may need to be adjusted.

9.7.1 Adjusting Guillotine Limit Switch

When the workpiece passes over the guillotine limit switch, the guillotine severs the edgebanding, leaving a portion of excess that is then trimmed flush by the flush trimmer. If the guillotine leaves too much or too little excess edgebanding, you will need to adjust the switch.

To adjust guillotine limit switch:

1. Disconnect machine from power and air.
2. Loosen adjustment screws using a 3mm Allen key.

- If guillotine does not leave enough excess edgebanding, move switch toward infeed table, then retighten adjustment screws.
- If guillotine leaves too much excess edgebanding, move switch toward outfeed table, then retighten adjustment screws.

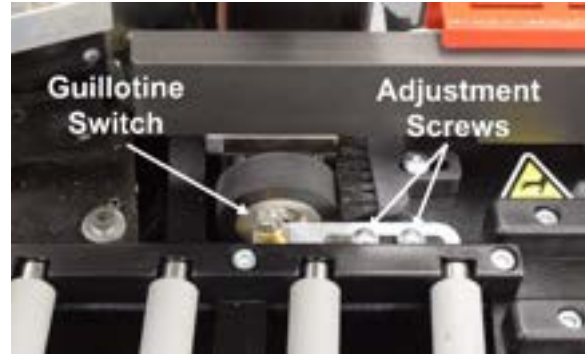


Figure 9-15: Guillotine Limit Switch and Adjustment Screws

9.7.2 Adjusting End Trimmer Switch

When the workpiece passes over the end trimmer switch, the end trimmer trims the leading and trailing ends of the glued edgebanding flush with the ends of the workpiece. If the end trimmer fails to trim the edgebanding flush with the ends of the workpiece, you will need to adjust the switch.

The end trimming switch will unlikely need any adjustments unless it has become loose or damaged. It is advisable to verify that the trimming plates are set correctly before proceeding with any switch adjustments.

To adjust end trimmer switch:

1. Disconnect machine from power and air.
2. Loosen adjustment screws using a 3mm Allen Key
 - If the end trimmer leaves too much edgebanding on the leading end of workpiece edge and not enough on the trailing end, move switch toward infeed table, then retighten adjustment screws.
 - If the end trimmer leaves too much edgebanding on the trailing end of workpiece edge and not enough on the leading end, move switch toward outfeed table then retighten adjustment screws.

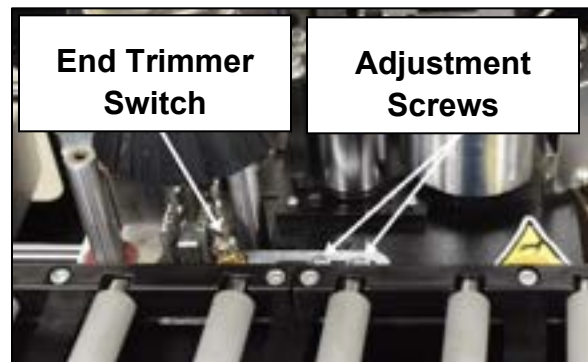


Figure 9-16: End Trimmer Limit Switch and Adjustment Screws

9.7.3 Checking/Adjusting Pressure Roller Unit

The pressure roller unit consists of two (2) rollers – one fixed and one adjustable – that apply pressure to the edgebanding against the workpiece immediately after the glue is applied.

The fixed, non-adjustable roller applies constant pressure to the edgebanding, while the adjustable roller is spring-loaded, allowing for pressure adjustment.

The adjustable pressure roller is set at the factory and should not require routine service.

However, if the pressure roller unit causes too much glue to squeeze out during operations, or if you are getting poor bonding results, you may need to adjust the pressure roller.

Properly adjusting the pressure roller unit is largely a matter of trial and error. Your results may vary depending on the glue type, glue temperature, workpiece thickness, and edgebanding thickness. Always use a teste piece to verify your settings after adjusting the pressure roller unit.

To check/adjust pressure roller unit:

1. Disconnect machine from power and air.
2. Set infeed fence to "0".
3. Rotate glue spindle adjustment knob clockwise several turns to move glue spindle out of the way.
4. Open panel feeder.

- Place straight of workpiece against fence and adjustable pressure roller.

One (1) Workpiece at least 36 inch long. This workpiece must be a

machined surface without any deviations along its length. The measurement for this procedure is $\frac{1}{2}$ of a millimeter. Wood or other manufactured materials will have variances too great to achieve an accurate measurement. A precision level with a machined side may be acceptable as a workpiece.

5. Adjustable pressure roller should keep workpiece approximately 0.040 inch (1 mm) away from fixed pressure roller.
6. Push workpiece against adjustable pressure roller, toward back of machine, until workpiece contacts both pressure rollers and entire fence along its length. Because adjustable pressure roller is spring-loaded, this should require moderate force.
 - If Step 6 requires moderate force, the pressure roller unit is properly adjusted and no further steps are necessary.

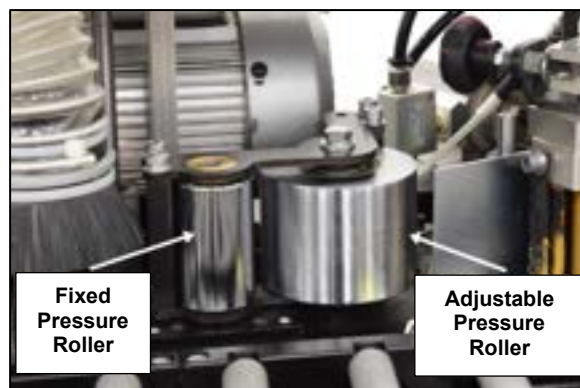


Figure 9-17: Pressure Rollers

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- If Step 6 requires excessive force, or if the workpiece does not contact adjustable pressure roller at all, pressure until is not properly adjusted. Proceed to Step 7.
7. Open rear access cover.
 8. Use a 10mm wrench to loosen the pressure roller jam nut.
 9. Rotate the pressure roller adjustment bolt.
 - Rotate bolt *clockwise* to move pressure roller away from workpiece and reduce pressure.
 - Rotate bolt *counterclockwise* to move pressure roller toward workpiece and increase pressure.
 10. Repeat Steps 6 and 9 until satisfied with adjustment, then retighten jam nut from Step 8 to secure setting and close rear access cover.



Figure 9–18: Glue Spindle Adjustment Knob

11. Rotate glue spindle adjustment knob counterclockwise all the way to move glue spindle forward to working position.
12. Close and lock panel feeder, then run a test piece of the same material and thickness as your intended workpiece through edgebander to verify satisfactory results. If necessary, repeat Steps 1-12.

9.8 Edgebanding Results

Symptom	Possible Cause	Possible Solution
Edgebanding moves up or down relative to workplace.	Pressure roller angle out of adjustment.	Adjust pressure roller so it is 90° to table.
Edgebanding cut too short (early) or too long (late).	1. Inadequate workpiece support. 2. The guillotine limit switch is out of adjustment. 3. Copy plate bent.	1. Pull out table extension. 2. Properly adjust guillotine limit switch. 3. Repair/replace copy plate.
Too much/not enough edgebanding left on top or bottom.	Flush trimmer cutterheads not properly adjusted.	Properly adjust flush trimmer cutterheads.
Scrape marks on face of edgebanding.	Debris/sharp edges/burrs/extra glue obstructing path of edgebanding.	Inspect entire path of edgebanding; clean away debris; sand/file sharp edges/burrs.
Gaps in edgebanding on finished workpiece.	1. Guillotine limit switch set too low. 2. Panel feeder not exerting enough downward force on workpiece.	1. Raise position of guillotine limit switch. 2. Lower panel feeder 0.5 mm below actual workpiece thickness.
Ends not cleanly cut.	End trimmer saw blades dull.	Sharpen/replace end trimmer saw blades.

10.0 Maintenance

Performing regular maintenance will ensure optimal performance of the machine. Please follow these maintenance procedures.

Failure to follow maintenance procedures will void the warranty.

Always disconnect power to the machine before performing maintenance. Failure to do this may result in serious personal injury or damage to the machine.



To reduce risk of shock or accidental startup, always disconnect the machine from power before adjustments, maintenance, or service.

For optimum performance from this machine, this maintenance schedule must be strictly followed.

To maintain a low risk of injury and proper machine operation, if you ever observe any of the items below in the “Daily” tab, shut down the machine immediately and fix the problem before continuing operations.

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	Daily	Weekly	Monthly
Lubricate glue spindle	X		
Clean/Lubricate end-trimming motor sliders	X		
Check for dull or damaged end-trimming saw blade(s)	X		
Check for dull or damaged flush-trimmer knives	X		
Worn or damaged wires	X		
Any other unsafe condition	X		
Clean of any glue residue on machine		X	
Drain water in air filter collection cups		X	
Lubricate flush-trimmer adjustment shafts		X	
Clean and lubricate guillotine assembly		X	
Blow dust out of motor fans with compressed air		X	
Clean/vacuum dust buildup from all edgebanding components and motors			X
Lubricate edgebanding feed gears			X
Lubricate flush-trimmer adjustment shafts			X
Motor belt tension, damage, or wear			X
Conveyor belt tension, damage, or wear			X
Inspect entire machine for loose parts or signs of abnormal wear			X

10.1 Cleaning and Protecting

Cleaning the BANDIT 3 is relatively easy. Vacuum excess wood chips and sawdust and wipe off the remaining dust with a dry cloth or blow off with compressed air. If any resin has built up, use a resin-dissolving cleaner to remove it.

Protect the unpainted cast-iron infeed fence by wiping it clean after every use and after it cools – this ensures moisture from wood dust does not remain on the bare metal surface. Keep the infeed fence rust-free with regular applications of products like G96 Gun Treatment, SLiPiT or Boeshield T-9.

10.2 Lubrication

NOTE

The recommended lubrication is based on light-to-medium usage. Keeping in mind that lubrication helps to protect the value and operation of the machine, these lubrication tasks may need to be performed more frequently than recommended here, depending on usage.

Failure to follow reasonable lubrication practices as instructed in this manual could lead to premature failure of machine components and will void the warranty.

10.2.1 Glue Spindle

The glue spindle is lubricated by a grease fitting on the back of the machine.

To lubricate the glue spindle, use the included grease gun to squirt a small amount of grease into fitting, then wipe away any excess grease with a rag.

Lube Type: T26419 or NLGI#2 Equivalent

Lube Amount: As Needed

Lube Frequency: 30 Hours of Use



Figure 10-1: Glue Spindle Grease Fitting

10.2.2 End Trimmer Motor Sliders

The end trimmer motor sliders must be kept clean and lubricated to allow the smoothest possible movement of the end trimmer motor.

To lubricate the end trimmer motor sliders, open the rear access cover to access the sliders. Wipe the sliders clean with a rag, then apply a light film of machine oil to the sliders. Manually move the motor back and forth and up and down to evenly distribute the oil along the sliders.

Lube Type: T26685 or ISO 32 Equivalent

Lube Amount: As Needed

Lube Frequency: Daily



Figure 10-2: End Trimmer Motor Sliders

10.2.3 Flush Trimmer Adjustment Shafts

The flush trimmer adjustment shafts require a small amount of lubrication to allow smooth adjustment and prevent the shafts from seizing up.

To lubricate the flush trimmer adjustment shafts, use a cotton swab, small oil can, or other means to apply a light film of machine oil to the shafts, then adjust the upper and lower cutterheads in and out a few times to evenly distribute the oil.



Figure 10-3: Flush Trimmer Adjustment Shafts

Lube Type: T26685 or ISO 32 Equivalent

Lube Amount: As Needed

Lube Frequency: Daily



Figure 10-4: Edgebanding Feed Gears

10.2.4 Edgebanding Feed Gear

The edgebanding feed gears should be checked and, if necessary, lubricated periodically to ensure proper feeding of edgebanding during operations.

To lubricate the gears, remove the rear access panel, apply a small amount of hafts to the teeth, wipe away any excess grease with a rag, then re-install the rear access panel.



Figure 10–5: Edgebanding Feed Gear

Lube Type: T26419 or NLGI#2 Equivalent

Lube Amount: As Needed

Lube Frequency: Monthly

10.2.4.1 Checking/Calibrating Infeed Fence Stop

WARNING

To reduce risk of shock or accidental startup, always disconnect the machine from power before adjustments, maintenance, or service.

For the best results, the infeed fence stop should be periodically checked for accuracy and, if necessary, calibrated.

To check/calibrate infeed fence stop:

1. Disconnect machine from power and air.

2. Loosen infeed fence lock lever, rotate knurled cylinder clockwise until stop plate contacts stop bolt, then retighten lock lever.

3. Check fence scale.

- If the fence scale reads "0" the infeed fence stop is calibrated, and no adjustment is necessary.
- If fence scale does not read "0" infeed fence stop is not calibrated. Proceed to Step 4.

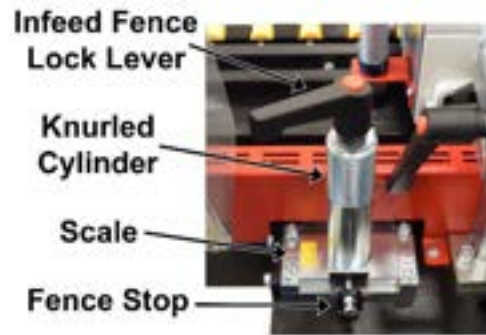


Figure 10-6: Checking Infeed Fence

4. Use a 10mm wrench to loosen jam nut.

5. Loosen stop blot a few turns.

6. Loosen infeed fence lock lever, rotate knurled cylinder until fence scale reads "0".

- Rotate cylinder clockwise to move fence toward stop bolt.
- Rotate cylinder counterclockwise to move fence away from stop bolt.

7. If necessary, repeat Steps 5-6 until you can adjust fence to "0".

8. Retighten lock lever.

9. Tighten the stop bolt until it contacts the stop plate, then tighten jam nut to secure stop bolt. Infeed fence stop is now calibrated.

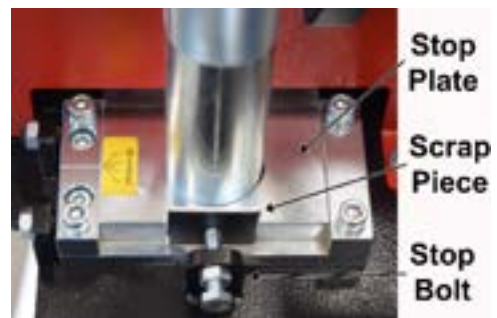


Figure 10-7: Calibrating Infeed Fence

10.2.4.2 Removing/Changing Glue

If your edgebanding operation requires a different type of glue, or if the glue becomes contaminated with debris, you will need to remove the old glue and replace it with new glue pellets.

NOTE

The glue pot is Teflon-coated. Do not scratch the surface when servicing.

To remove/change glue:

1. Turn machine **OFF** and wait for glue pot to completely cool.
2. Turn machine **ON** and wait for glue pot to reach 80°-90° C.
3. Use a wood stick (approximately 6 inches x 1 inch x ½ inch) to peel up one side of glue.
4. Use pliers to grip peeled up portion of glue and pull block of glue out of glue pot.

NOTE

Be careful not to scratch glue pot surface.

5. Turn machine **OFF** and allow glue pot to completely cool.
6. Clean any remaining glue and debris from the bottom and sides of glue pot.
7. Carefully add glue pellets until they reach ¾ inch (2 cm) below top of glue pot.
8. Turn machine **ON** and allow glue pot to reach working temperature.
9. When glue pellets are completely melted, check glue level and, if necessary, add program amount of glue.



Figure 10-8: Glue Pot

10.2.4.3 Replacing End Trimmer Blades

CAUTION

Saw blades are extremely sharp. Even dull blades can cause serious cuts when handled improperly. To reduce risk of injury, always wear leather gloves when working around blades.

If the end-trimmer fails to make clean, precise cuts, the blades may be dull or damaged, requiring replacement.

To replace end trimmer saw blades:

1. Disconnect machine from power and air.
2. Manually raise the end trimmer unit and support it with wood block for best access to blades.
3. Use a 4 mm Allen key to remove end trimmer dust shroud assembly.
4. Use a 6 mm Allen key to secure the end trimmer spindle and use a 10 mm wrench to remove hex bolt that secures end trimmer blades. Alternatively, secure the end trimmer by inserting a hex wrench through hole in spindle.



Figure 10-10: End Trimmer Raised with Wood Block



Figure 10-11: Remove the End Trimmer Blades

NOTE

Hex bolt has lefthand threads. Rotate bolt clockwise to loosen; rotate bolt counterclockwise to tighten.

5. Remove blade flange, outer blade, spacer, and inner blade.
6. Install new blades with spacer, flange, and hex bolt removed in Steps 4-5 in reverse order from removal.

NOTE

Orient components in same direction as they were before removal.

10.2.4.4 Replacing Flush Trimmer Cutterhead Knives

If the flush trimmer fails to produce straight, clean upper and lower edges that are flush with the top and bottom surfaces of the workpiece, the flush trimmer cutterhead knives (upper) and (lower) may be dull or damaged requiring replacement.

The disposable upper and lower flush trimmer knives are held in place by blocks and set screws.

To replace flush trimmer cutterhead knives:

1. Disconnect machine from power and air.
2. Unlock and open panel feeder, then raise it all the way up.
3. Rotate upper or lower cutterhead until knife, lock, and set screw are accessible.
4. Loosen set screw with a 3mm Allen Key, remove knife, being careful not to drop or misplace block, install new knife, then retighten set screw.
5. Repeat Steps 3-4 with remaining knives on cutterhead.
6. If necessary, repeat Steps 3-5 with knives of other cutterhead.
7. Close and lock panel feeder.

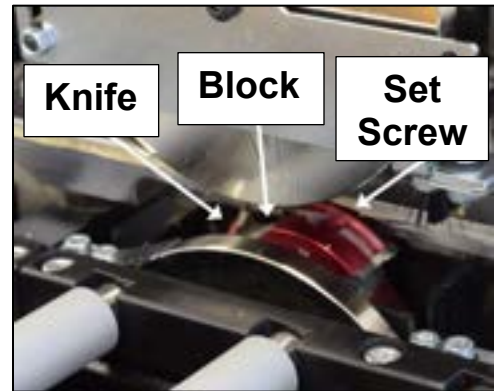
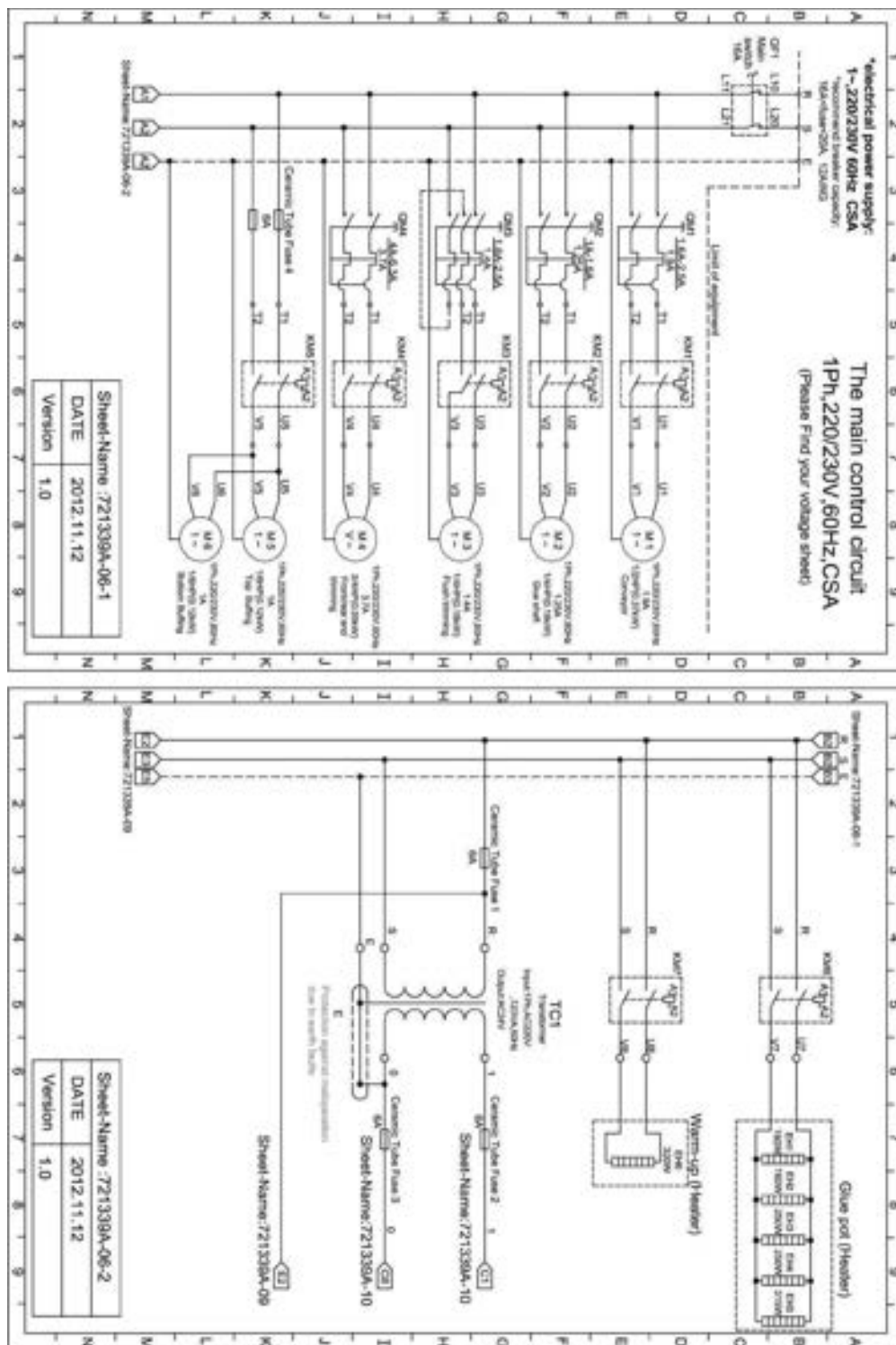


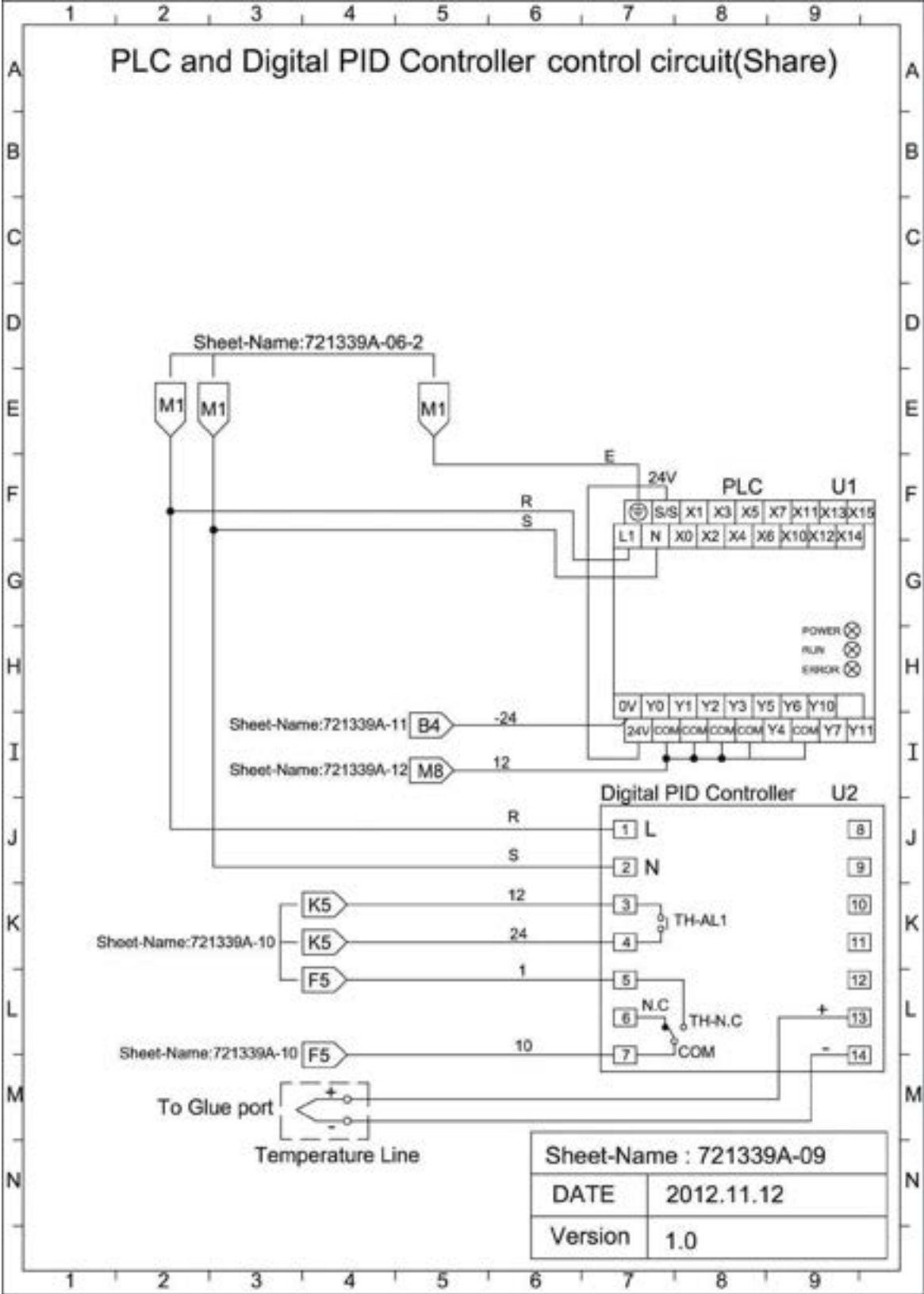
Figure 10-12: Flush Trimmer Knife Components

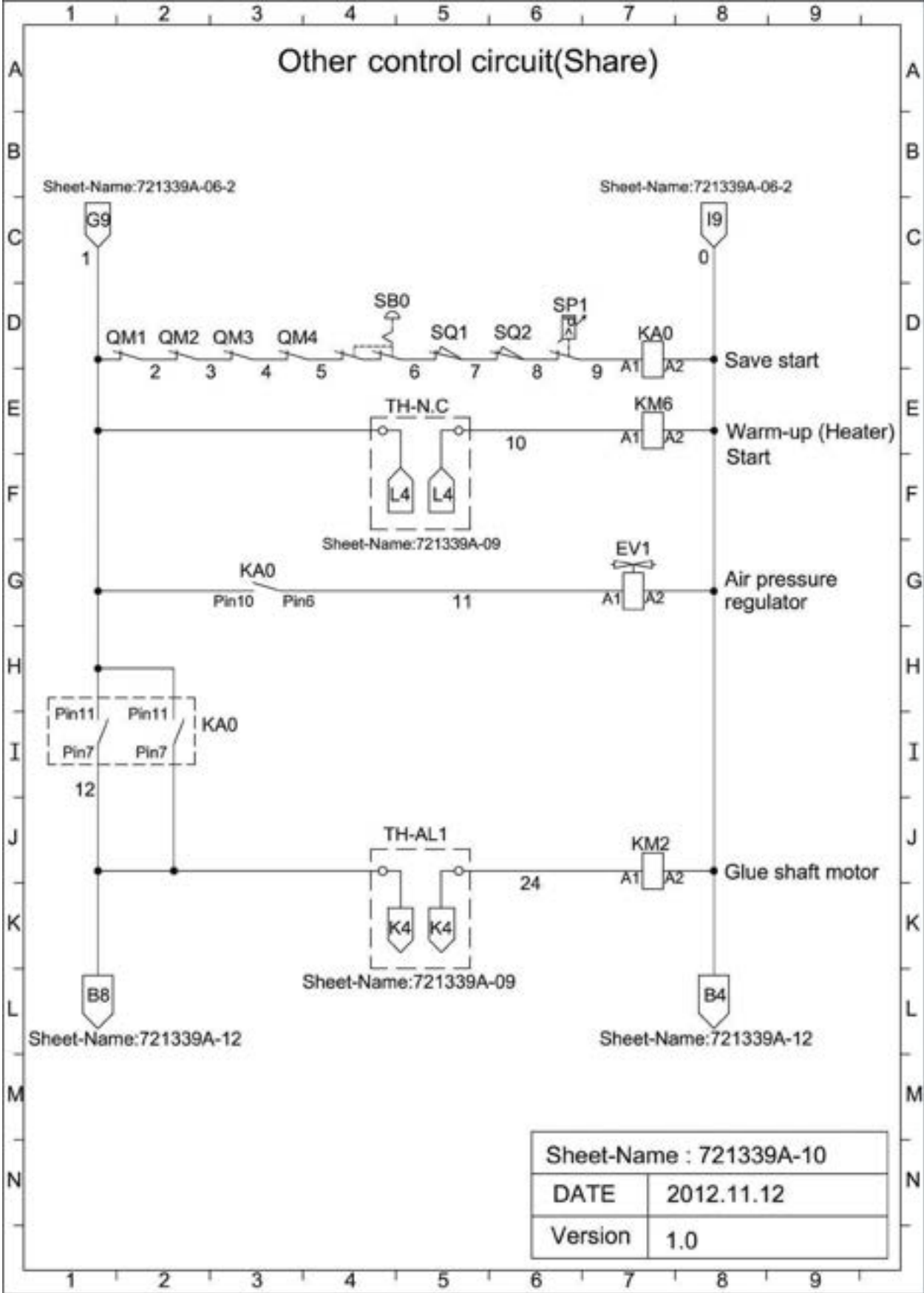
11.0 Wiring Diagrams

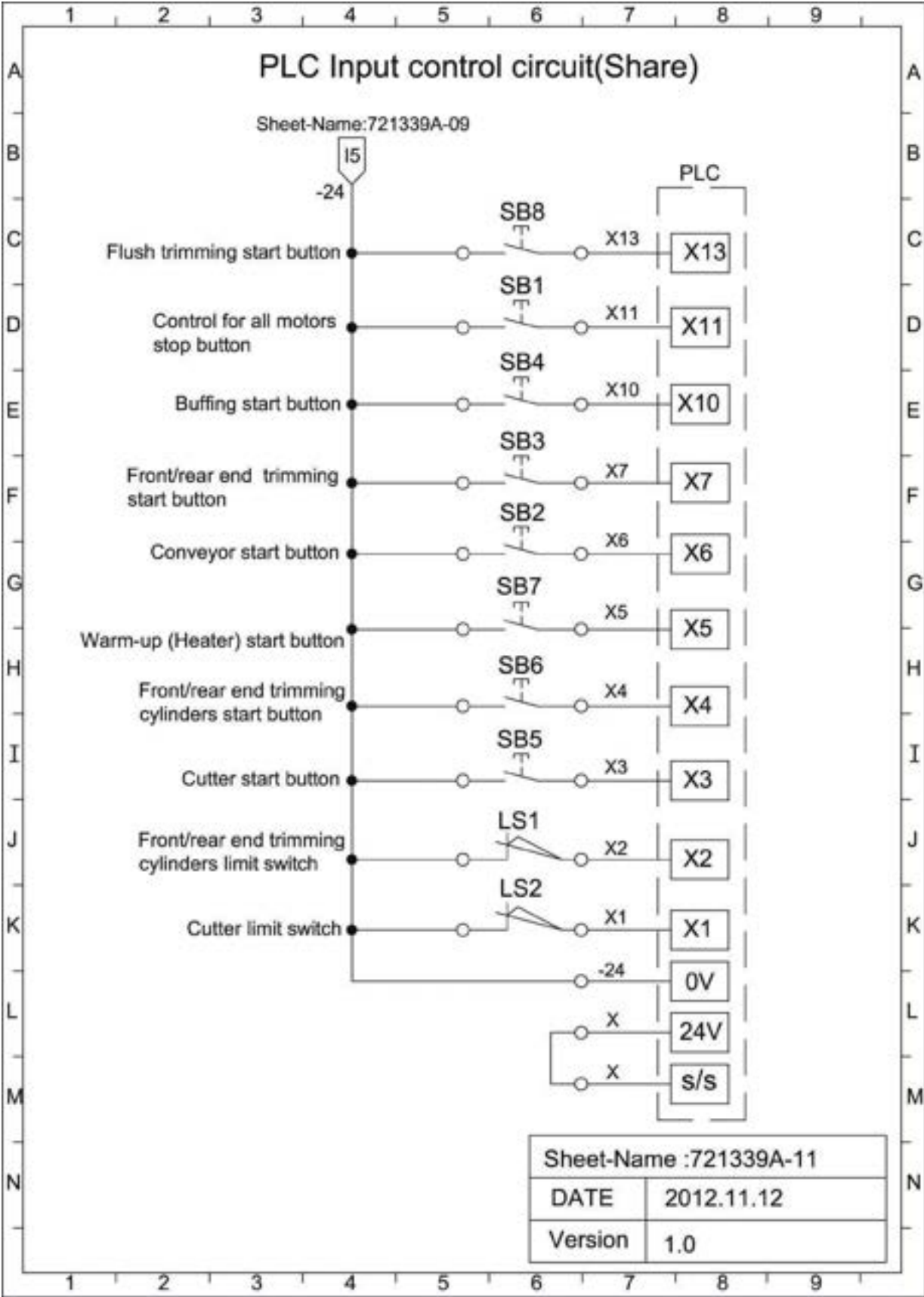
The wiring diagrams are separated into two sections: **Section 11.1:** Older diagrams (2012) and **Section 11.2:** New diagrams (2015). Both are included for reference.

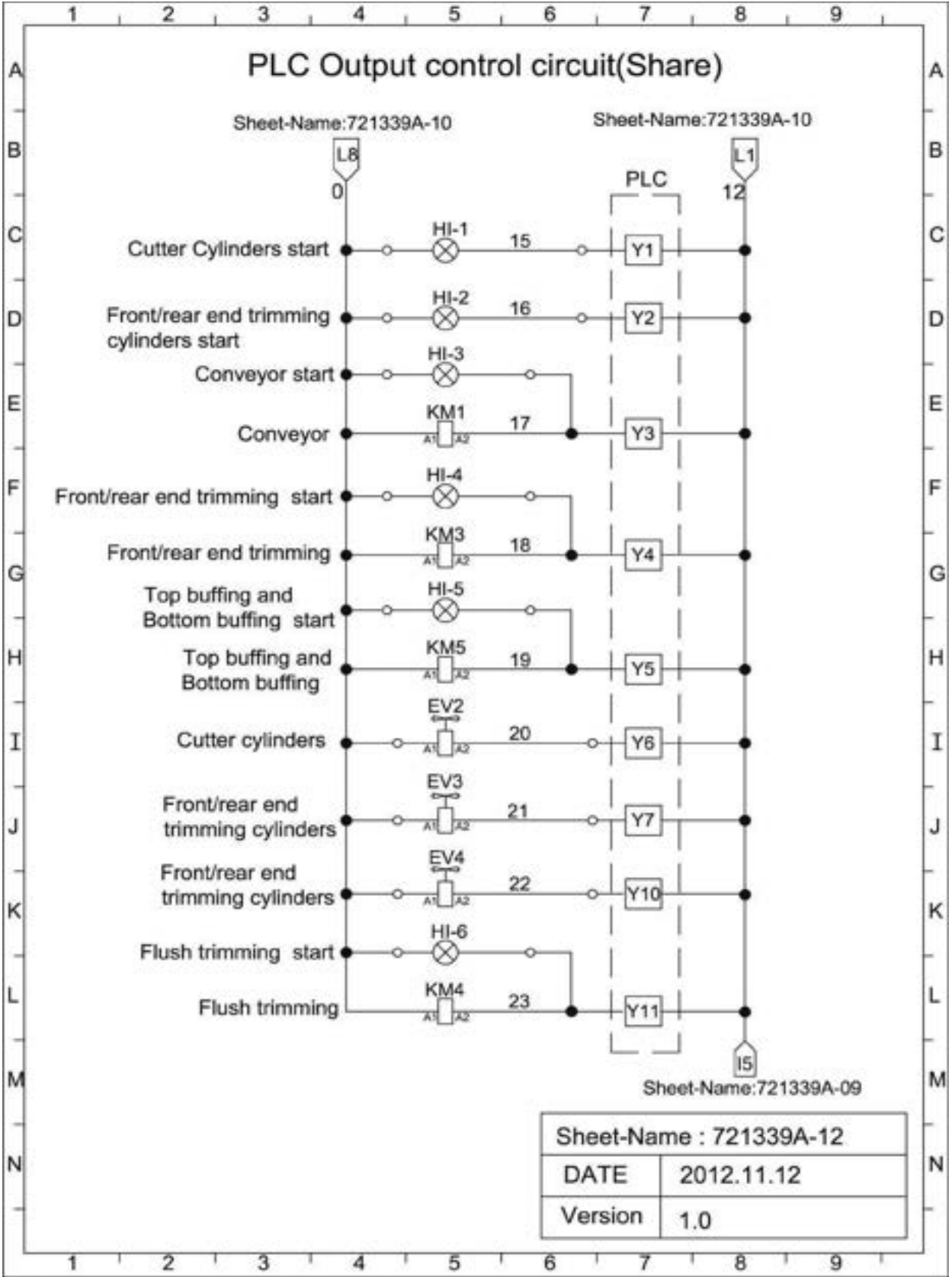
11.1 Older Wiring Diagrams (2012)



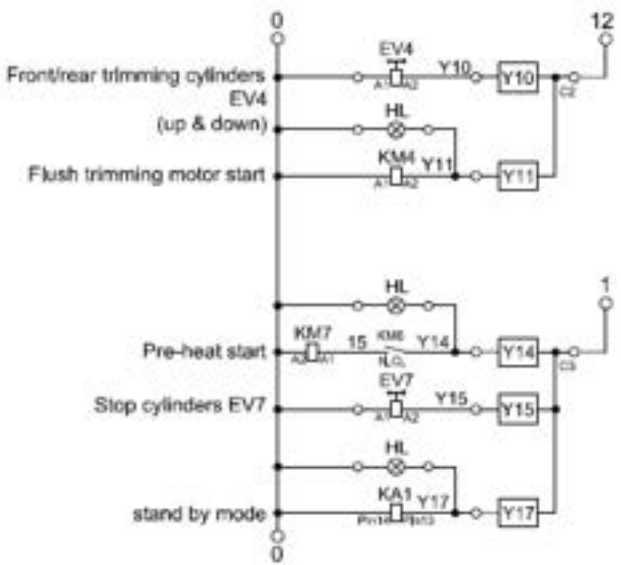
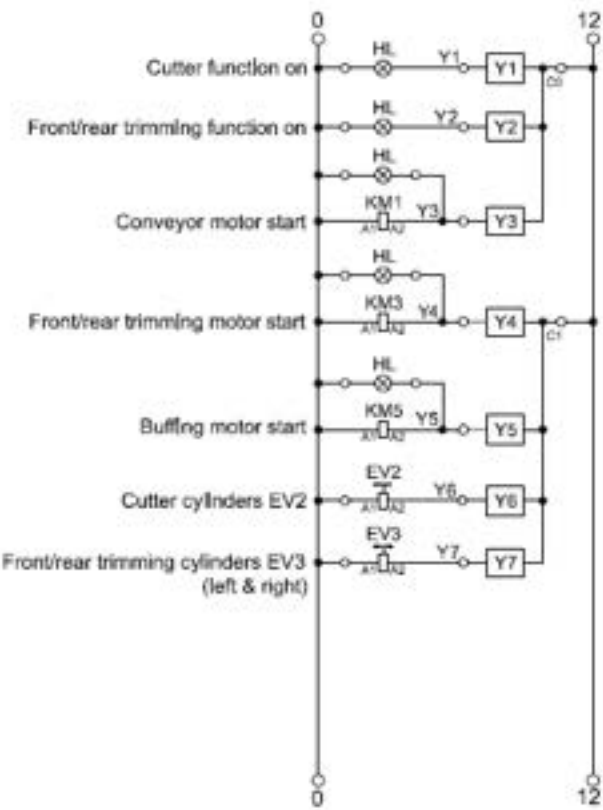






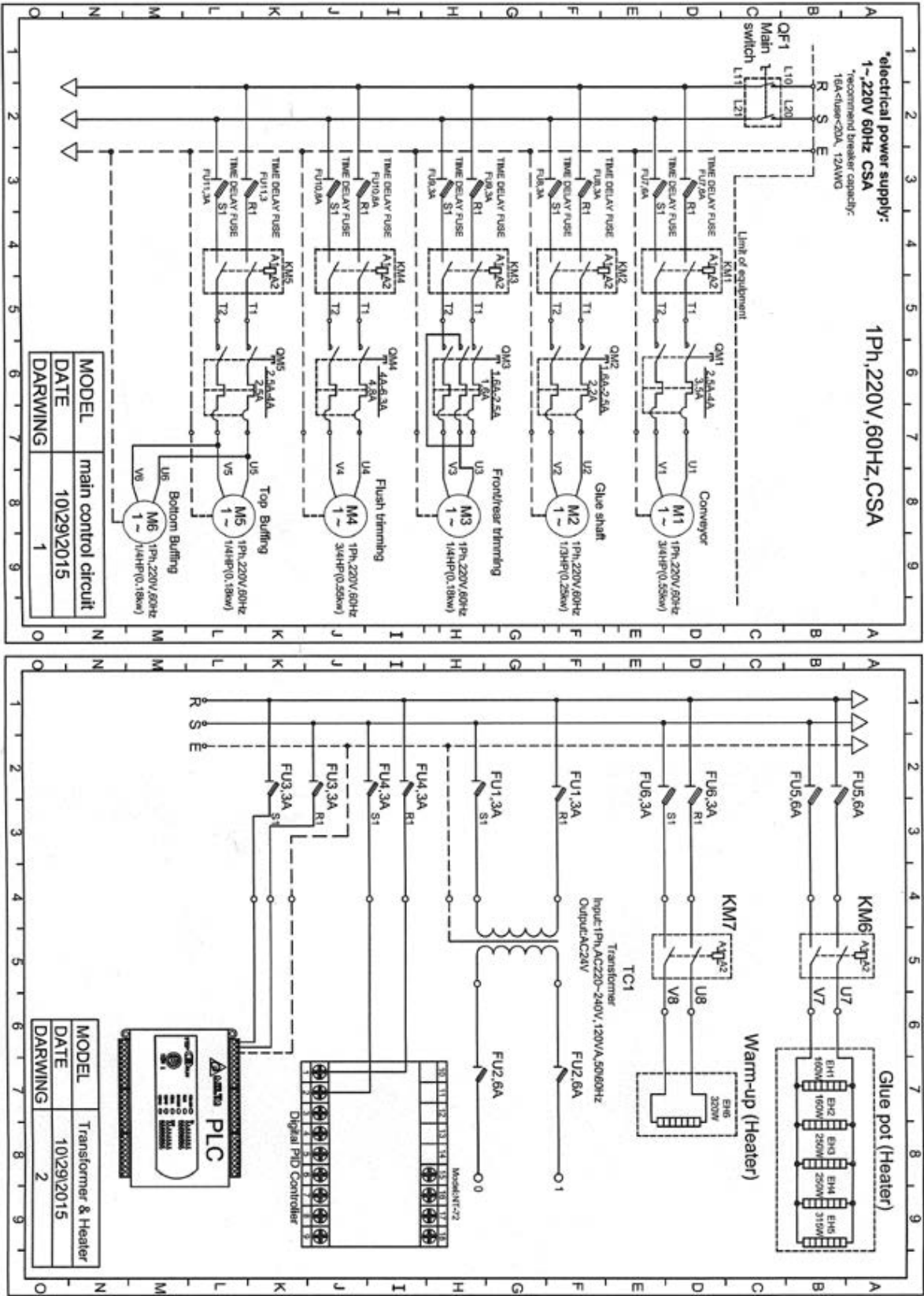


Power Supply—PLC Output

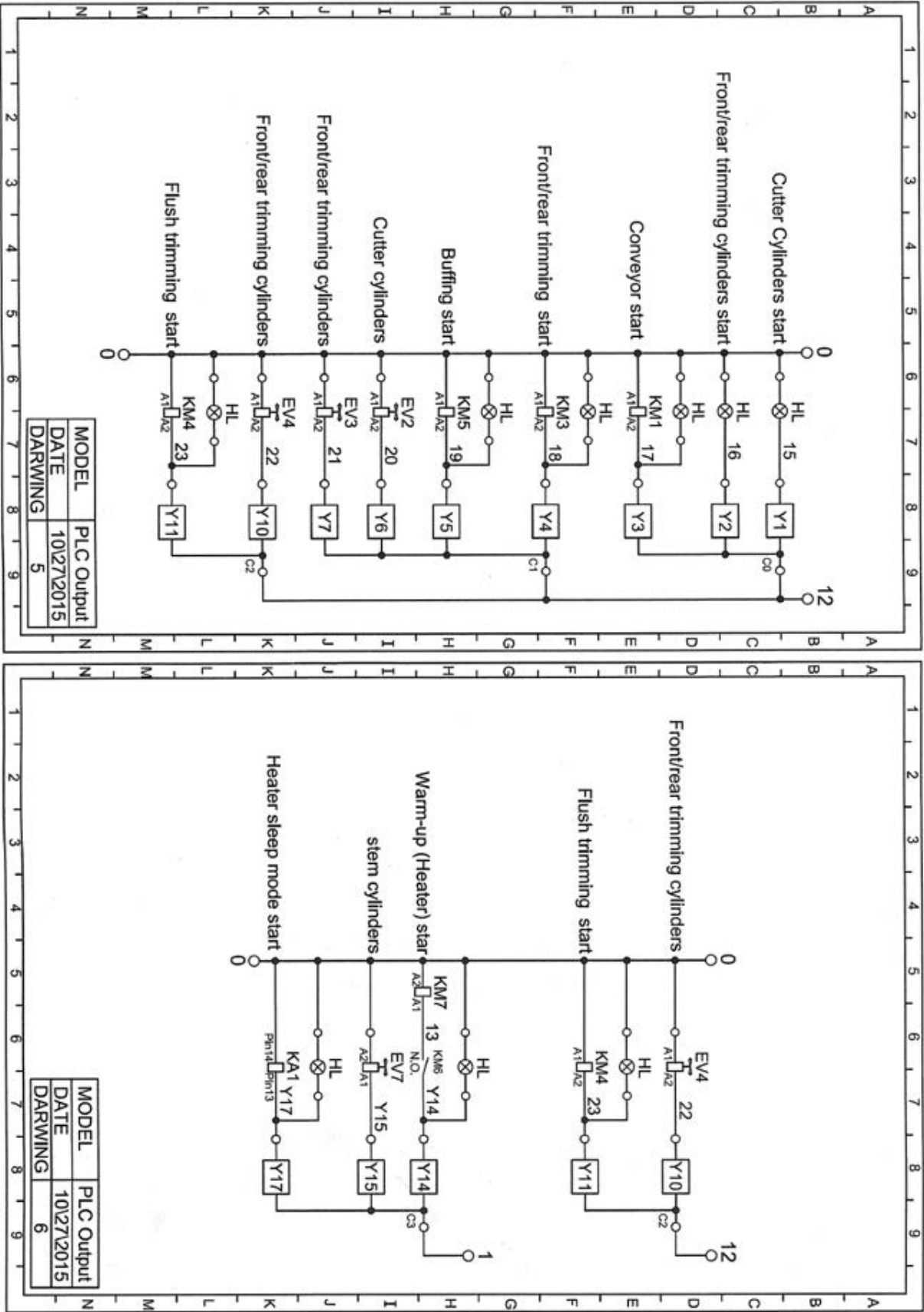


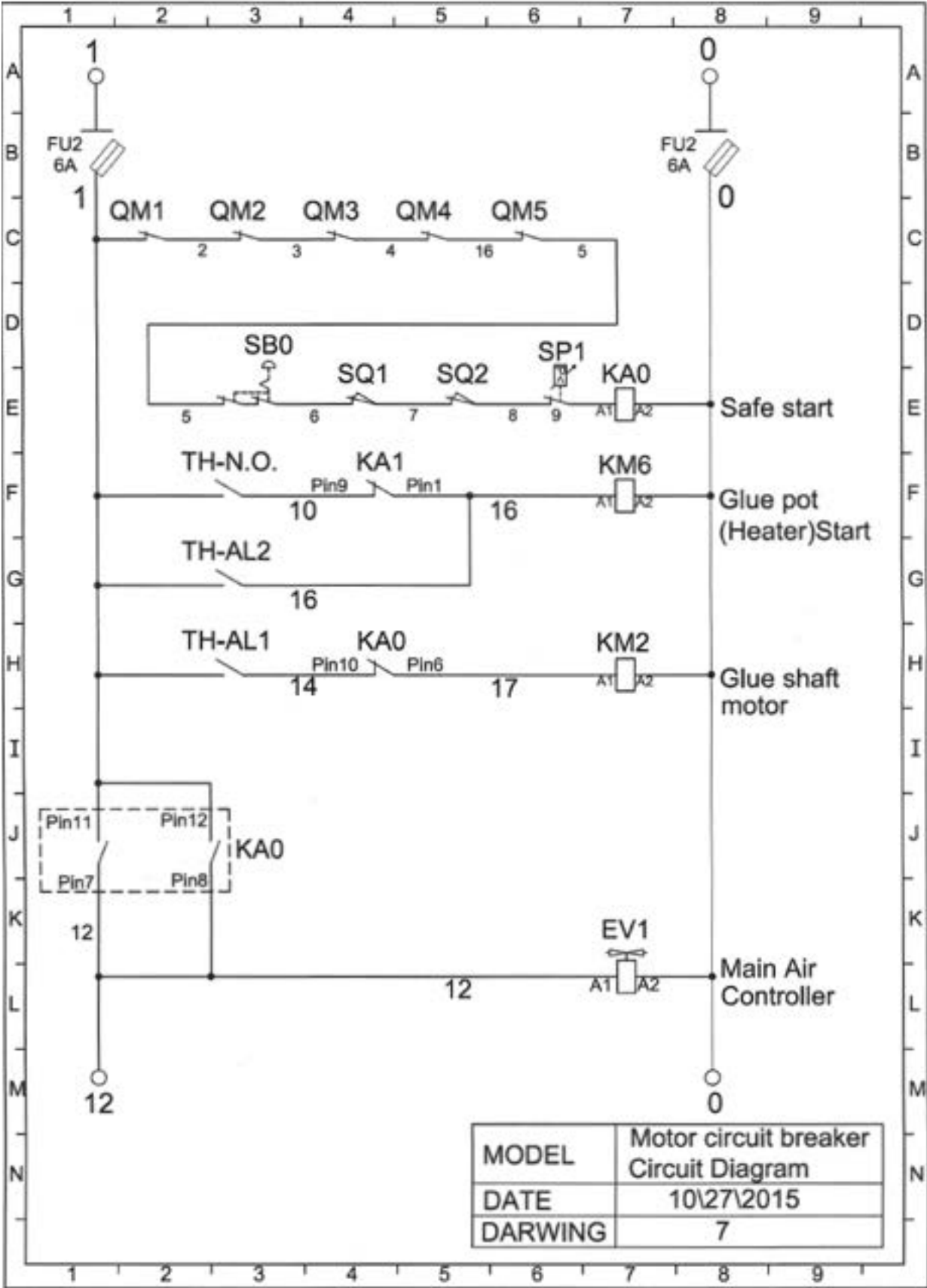
PLC Output

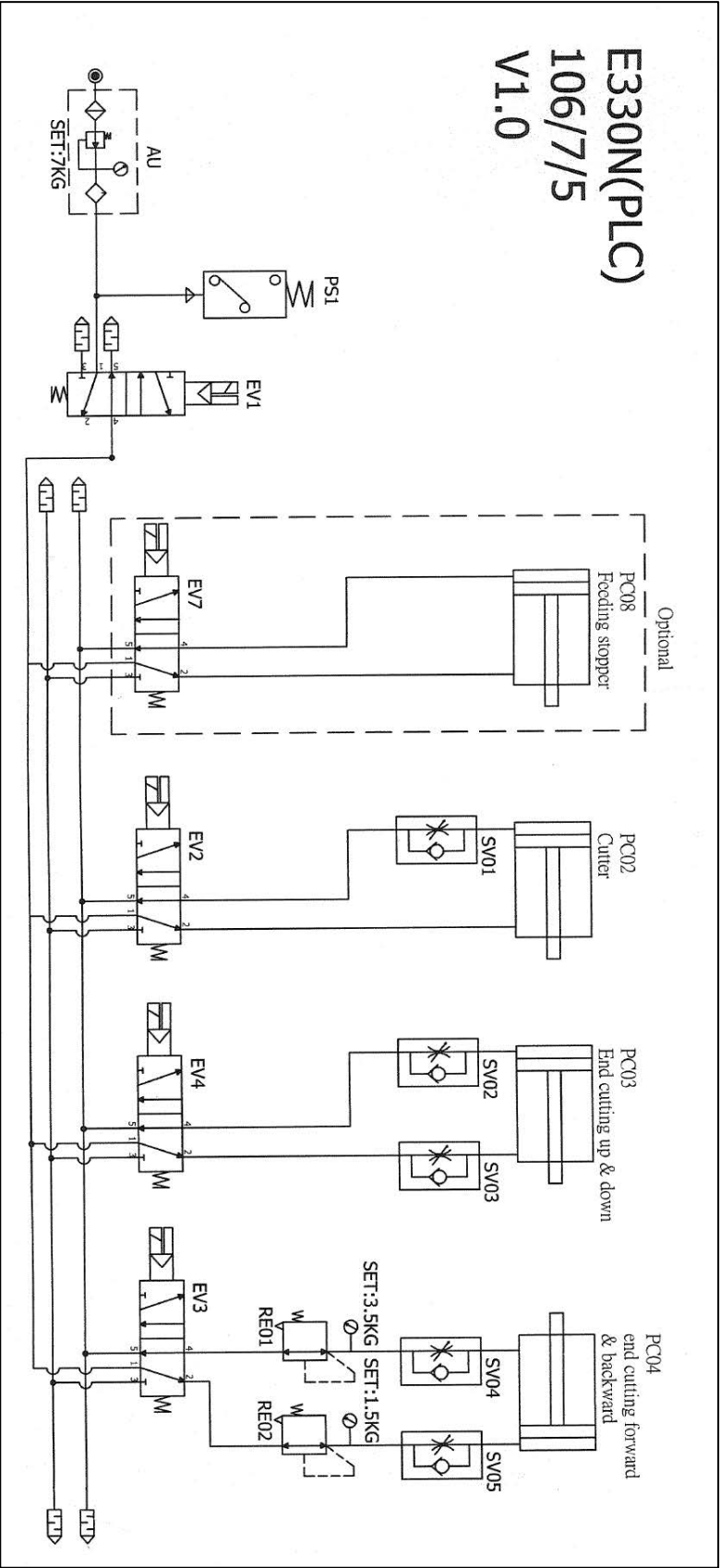
11.2 New Wiring Diagrams (2015)



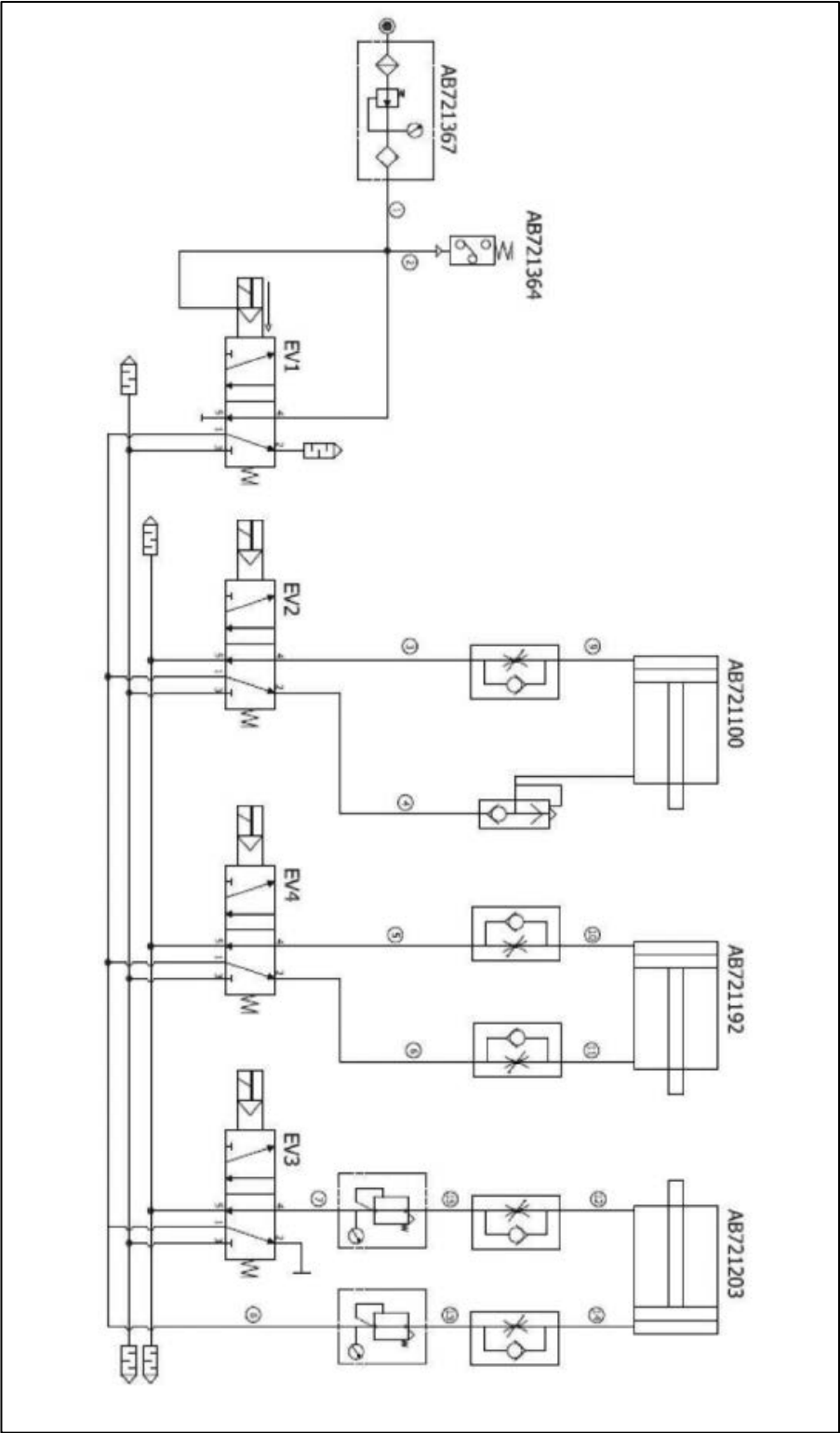


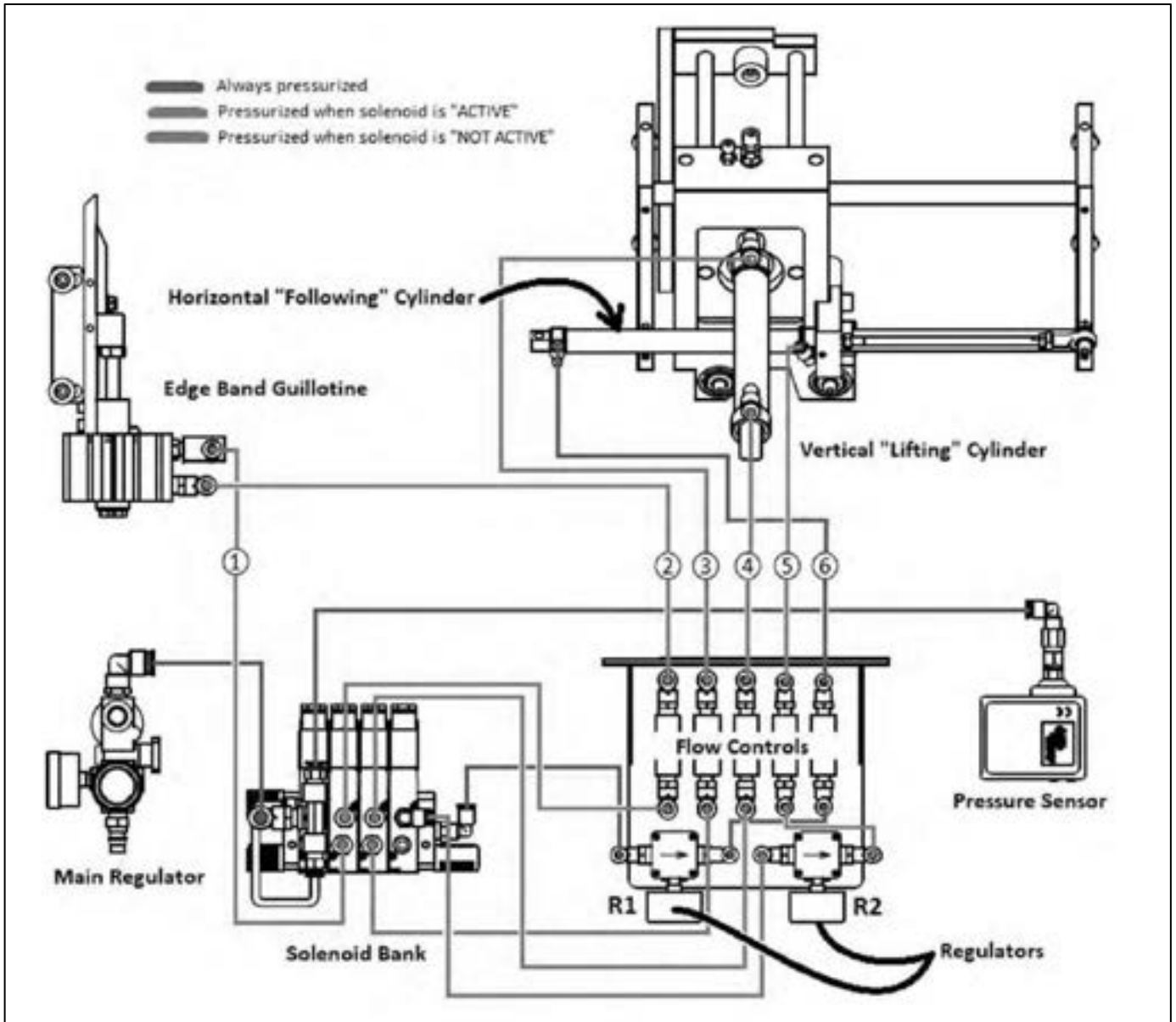






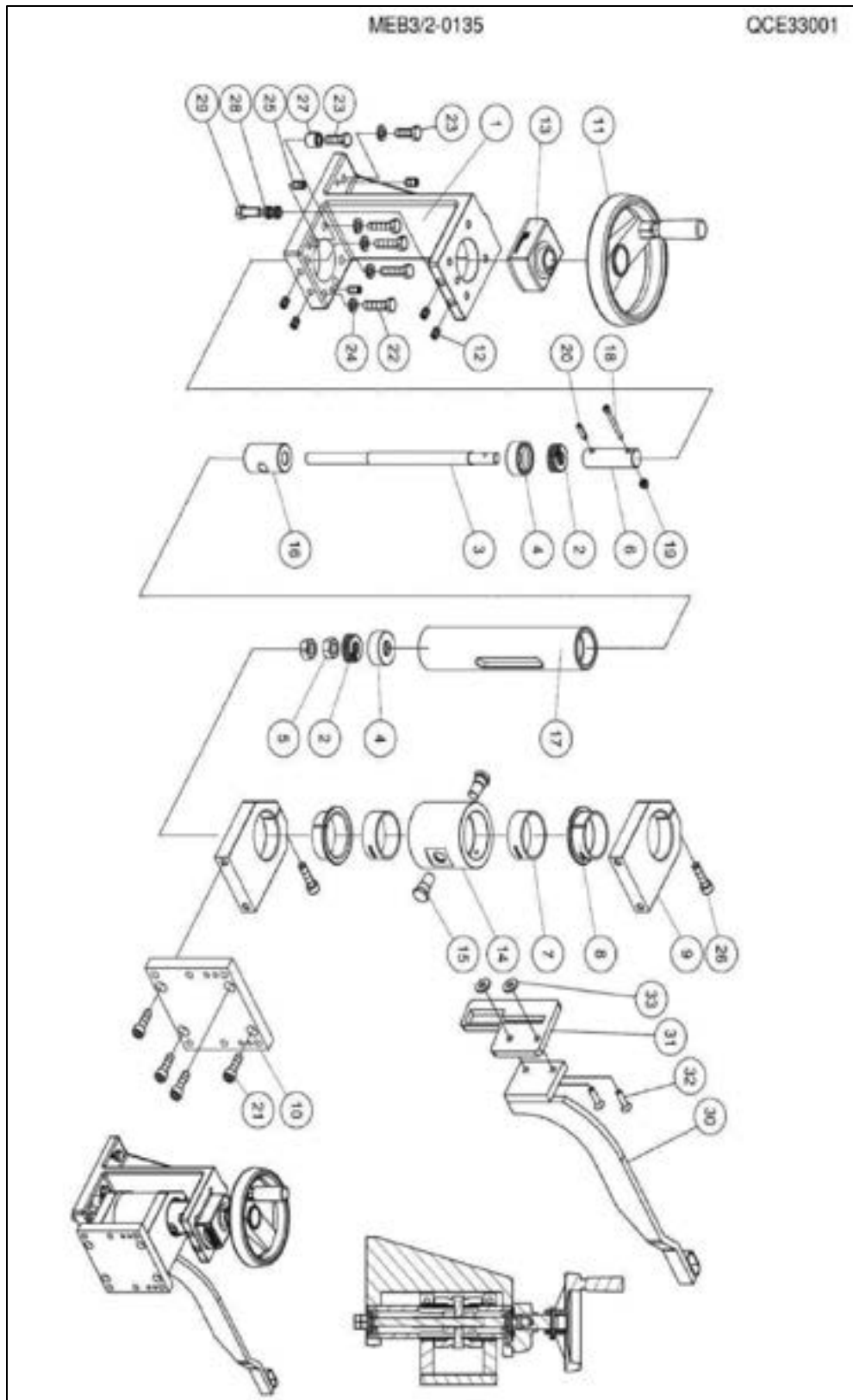
12.0 Pneumatic System Diagrams





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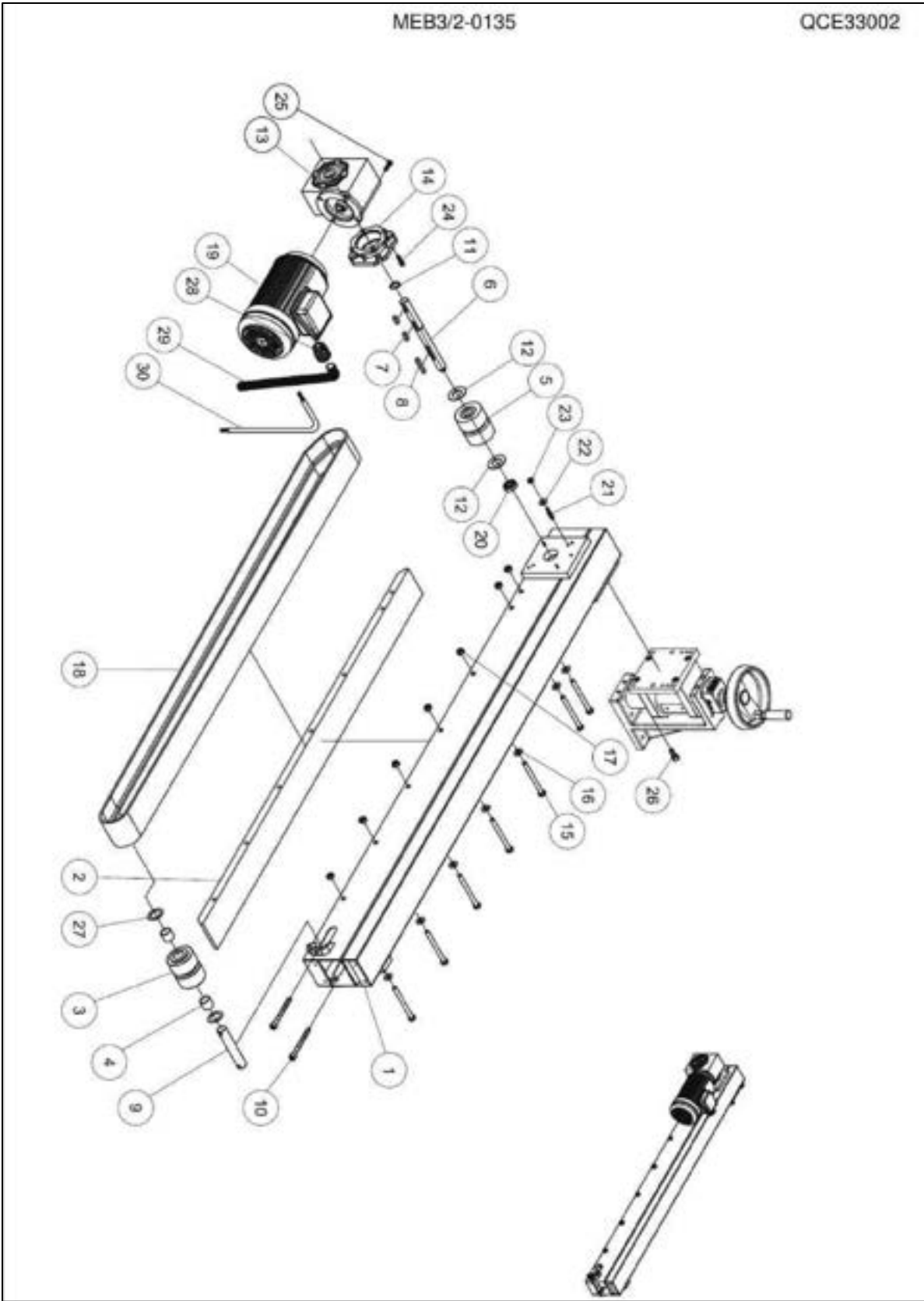
13.0 Exploded Parts & Parts List



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MEB3/2-0135 QCE33001

ITEM	PART NUMBER	PARTS NAME	QTY
1	721010	Pressure Beam Bracket	1
2	994301	Thrust Bearing	2
3	721004	Precision Screw Pole	1
4	721013	Bearing Bushing	2
5	NH121900	Hex Nut	2
6	721002	Adapter Shaft	1
7	BD452001	Bushing Bearing	2
8	BD452002	Bushing Bearing	2
9	721006	Slider Plate	2
10	721012	Fixed Plate	1
11	721011	Handle Wheel	1
12	SS080204	Set screw	4
13	721001	Position Indicator	1
14	721009	Slider Ring	1
15	721007	Locate Bolt	2
16	721005	Screw Ring	1
17	721003	Column	1
18	SR050903	Cap Screw	1
19	NL050800	Nylon Nut	1
20	PS052000	Spring Pin	1
21	SR080500	Cap Screw	4
22	SH080700	Hex Head Bolt	4
23	SH080500	Hex Head Bolt	3
24	WS080000	Spring Washer	6
25	SS089400	Set screw	4
26	SR080600	Cap Screw	1
27	200999	Bushing	1
28	201346	Bushing	2
29	SH080200	Hex Head Bolt	2
30	721057	Support Bracket	1
31	721323	Fixed Plate	1
32	SM060500	Pan Head Screws Hexagon	2
33	WF061920	Washer	2

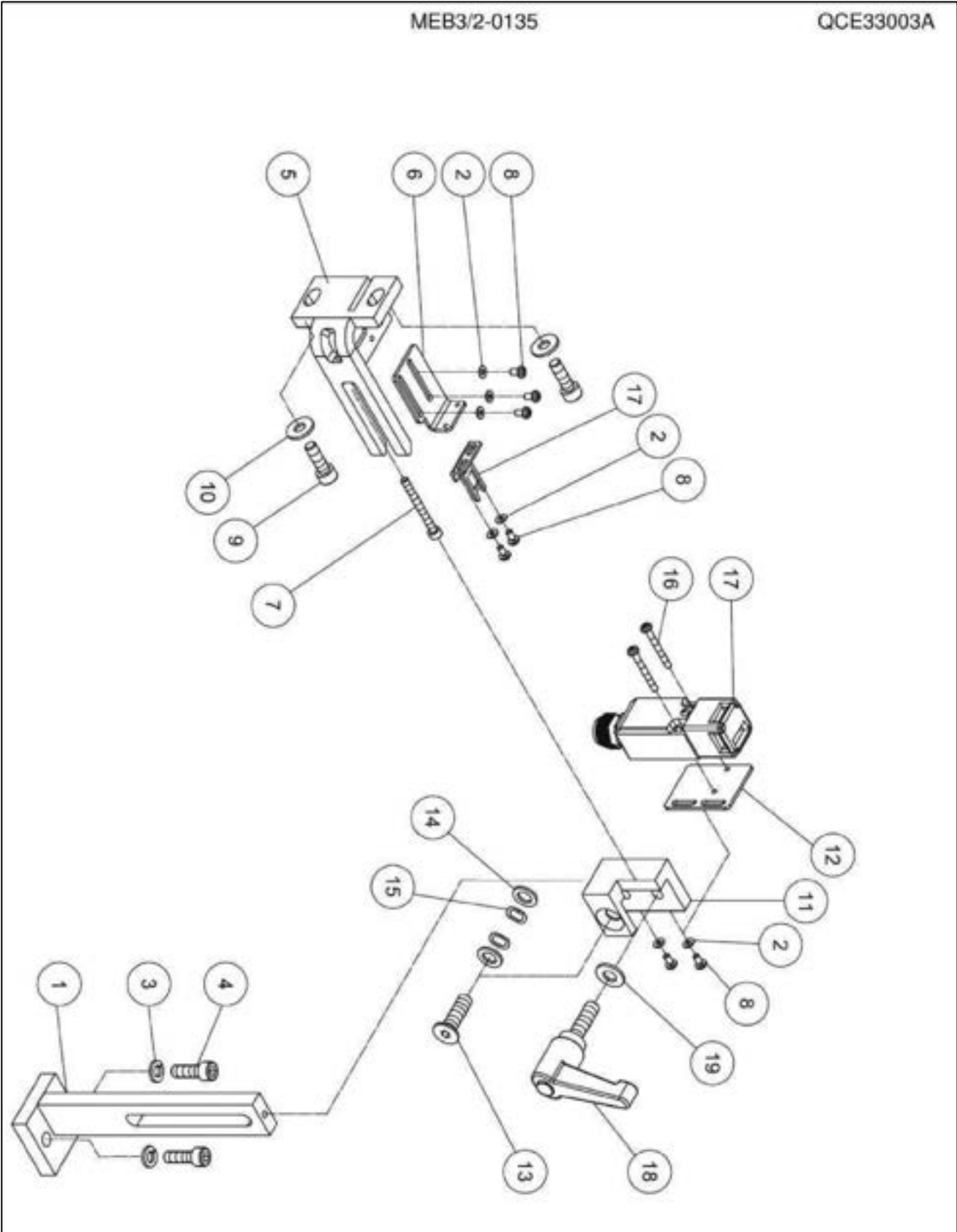


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MEB3,2-0135

QCE33002

ITEM	PART NUMBER	PARTS NAME	QTY	NOTE
1	721016	Conveyer Seat	1	
2	721020	Conveyer By The Board	1	
3	721018	Roll Wheel	1	
4	994353	Bushing Bearing	2	
5	721023	Roll Wheel	1	
6	721022	Transmission Shaft	1	
7	KD060620	Flat Key	2	
8	KD060640	Flat Key	1	
9	721019	Shaft	1	
10	SR081600	Cap Screw	2	
11	RS180000	C-Type Retaining Ring	1	
12	721025	Gasket	2	
13	721026	Reducer		50Hz
	721026A	Reducer		60Hz
14	721027	Reducer Flange	1	
15	SH081803	Hex Head Bolt	7	
16	WFW 820	Washer	7	
17	NF081300	Flange Hex Nut	7	
18	721017	Conveyer	1	
19	MA721021	Motor		220/380V 3-
	MA721021A	Motor	1	220V 1.
20	BB600104	Ball Bearing	1	
21	SS060640	Set screw	4	
22	WF062330	Washer	4	
23	NH061000	Hex Nut	4	
24	SJ060400	Round Socket Head Cap Screw	4	
25	SH060400	Hex Head Bolt	4	
26	SR080400	Cap Screw	6	
27	991706	Washer	2	
28	203481	Nylon Box Connector	1	
29	203475	Wave Tube	0.7	700mm
30	IM721002	Motor Cord	1	380'.3- CE
	IM721032	Motor Cord		220V 1 - CE

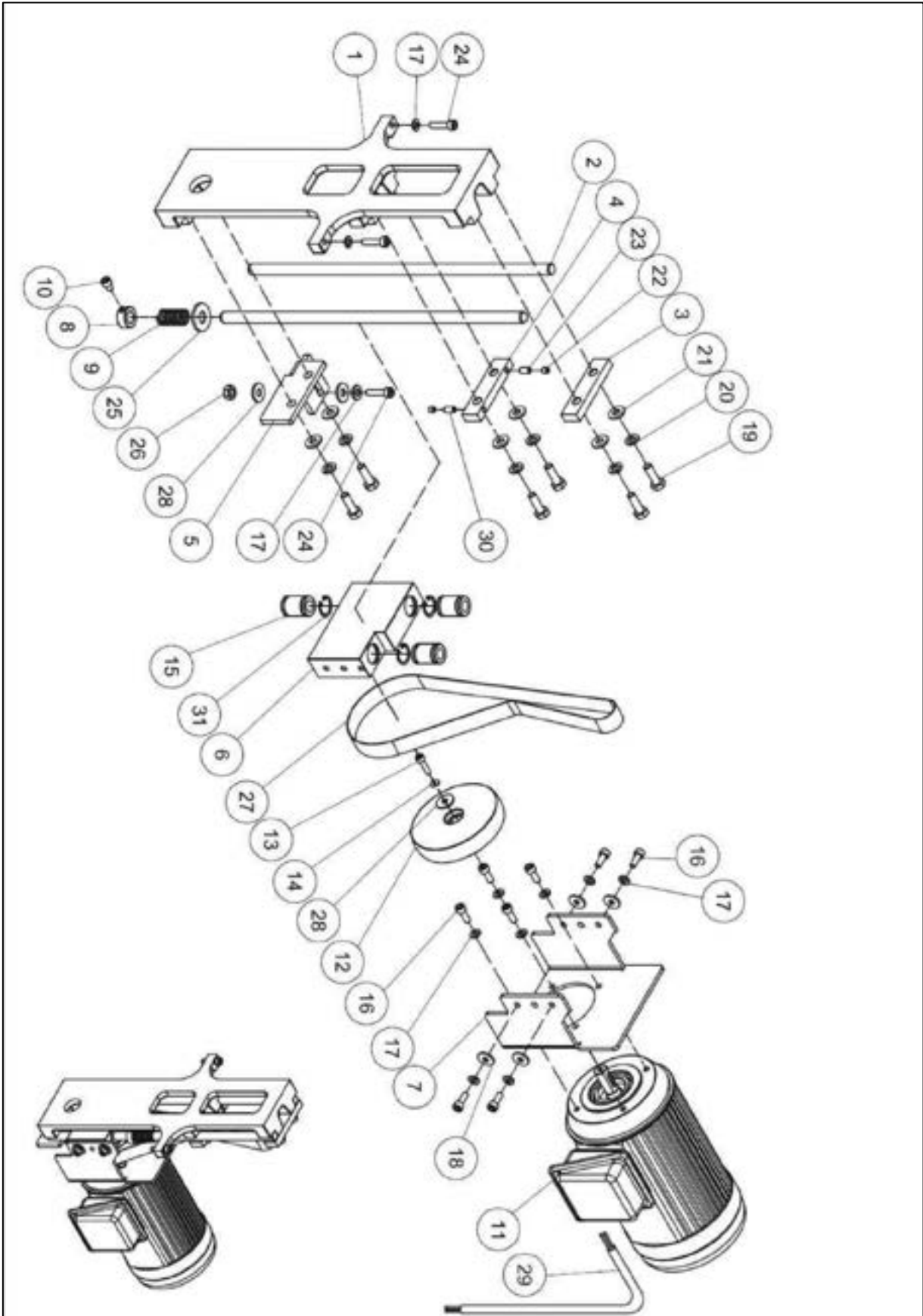


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MEB3/2-0135

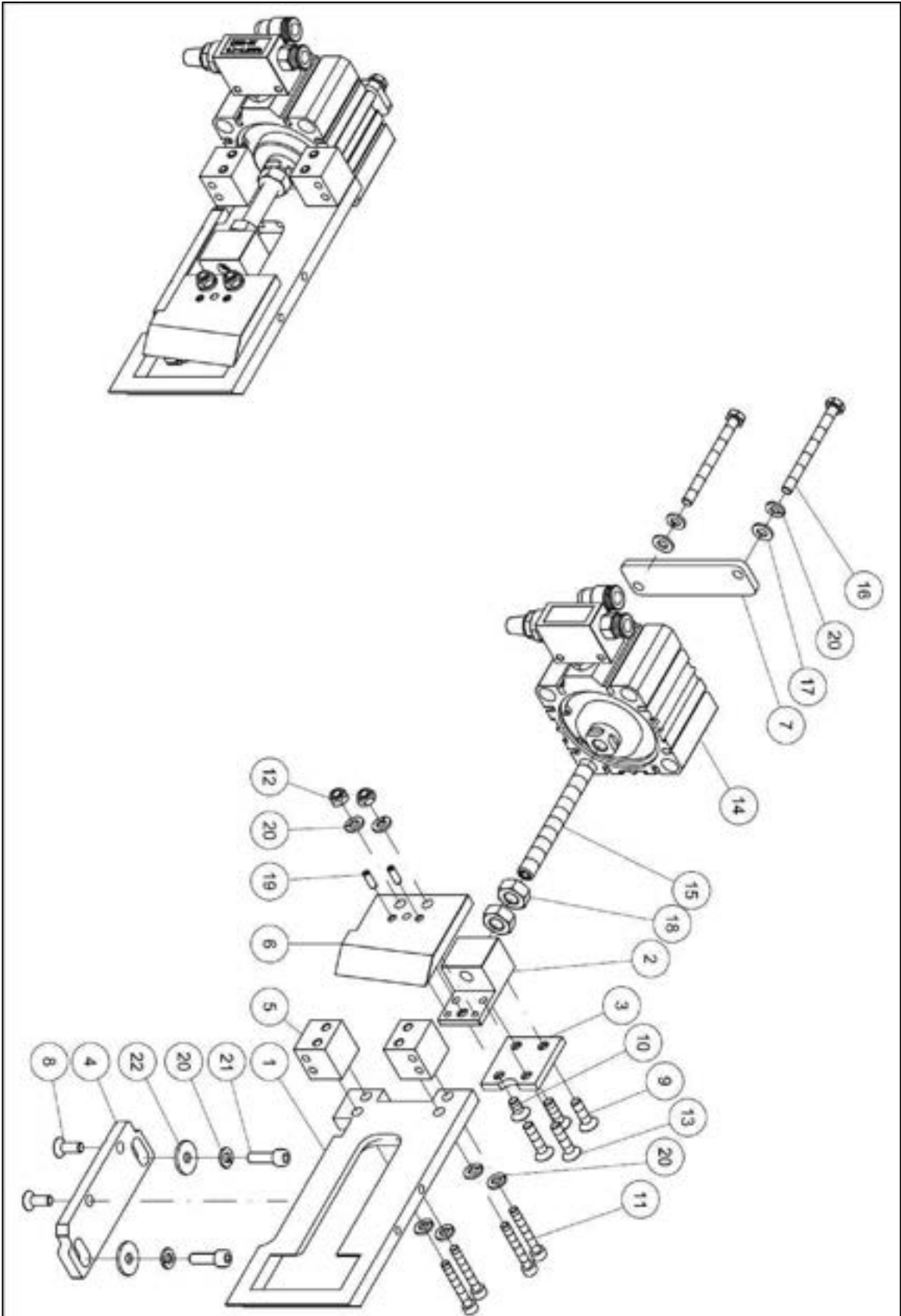
QCE33003A

ITEM	PART NUMBER	PARTS NAME	QTY
1	721032	Adjustment Column	1
2	WF040810	Washer	7
3	WS080000	Spring Washer	2
4	SR080400	Cap Screw	2
5	721036	Locate Plug	1
6	721038	Plug Fixed Plate	1
7	SR051003	Cap Screw	1
8	SP049200	Pan Head Screw	7
9	SJ080400	Round Socket Head Cap Screw	2
10	WF081820	Washer	2
11	721033	Adjustment Bracket	1
12	721039	Limits Fixed Plate	1
13	SM100700	Countersunk Head Cap Screw	1
14	WF102020	Washer	2
15	WW101503	Wave-Type Washer	3
16	SP040600	Pan Head Screw	2
17	AB136457A-A	Door safety Switch ASM.	1
18	721031	Quick Release Handle	1
19	WF102730	Washer	1



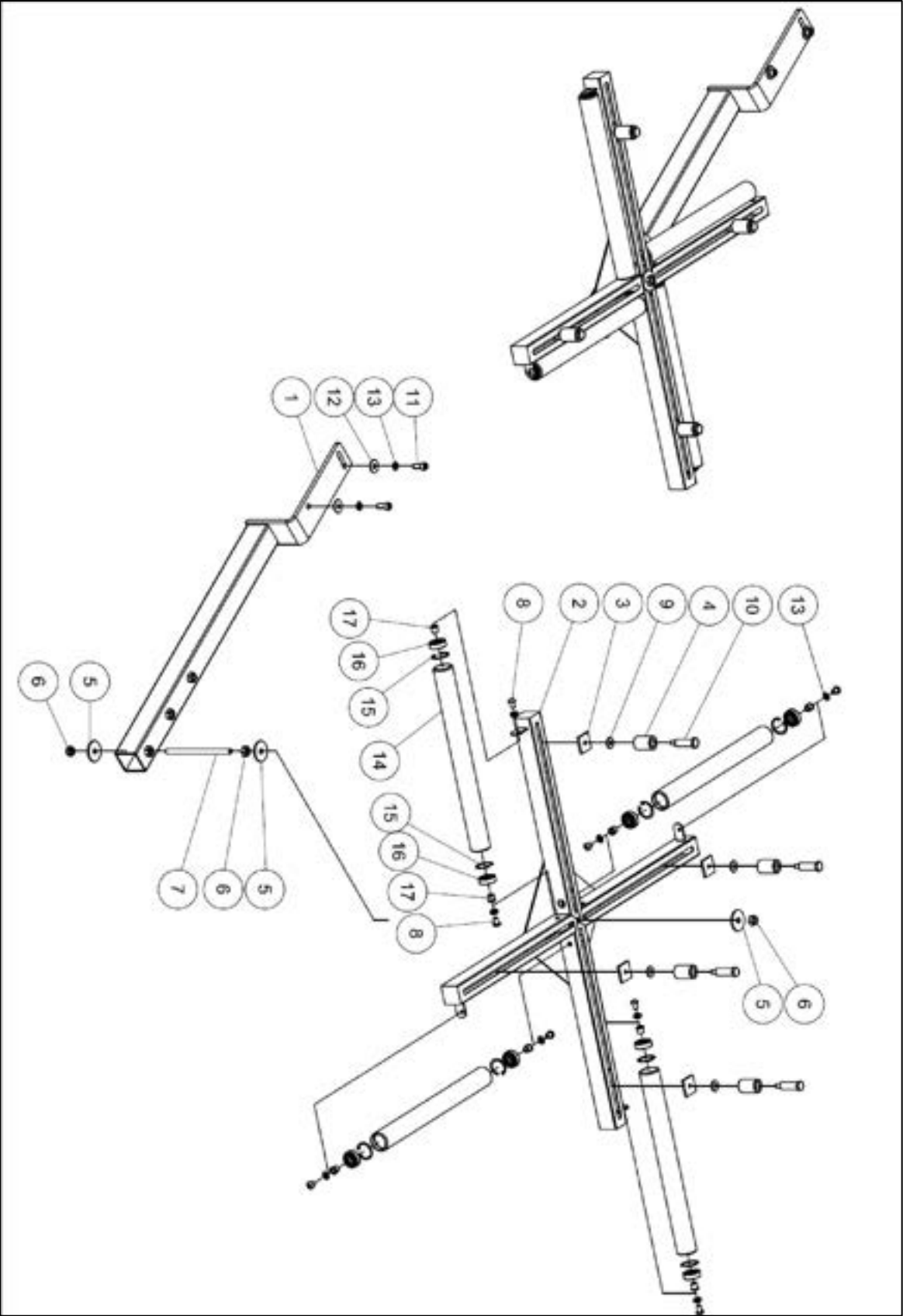
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ITEM	PART NUMBER	PARTS NAME	QTY	NOTES
1	76	Rail Seat	1	
2	77	Chrome Rod Park	2	
3	721079	Platen	1	
4	721080	Platen	1	
5	721087	Fuselage Connecting Plate	1	
6	721086	Motor Movements Block	1	
7	721084	Motor Fixed Plate	1	
8	721089	Positioning Ring	1	
9	721088	Compression Spring	1	
10	SR060200	Cap Screw	1	
11	MA721083	Motor	1	220/380V 3~
	MA721083A	Motor	1	220V 1~
12	721085	Flat pulley	1	
13	SR059400	Cap Screw	1	
14	WF051210	Washer	1	
15	BL210402	Linear Bearing	3	
16	SR069400	Cap Screw	8	
17	wS060000	Spring Washer	11	
18	WF061620	Washer	4	
19	SH080500	Hex Head Bolt	6	
20	WS080000	Spring Washer	6	
21	WF081820	Washer	6	
22	SS069150	Set Screw	2	
23	SS060400	Set Screw	1	
24	SR060500	Cap Screw	3	
25	WF132225	Washer	1	
26	NH061000	Hex Nut	1	
27	LF290020	Plat Belts	1	
28	WF061920	Washer	3	
29	IM721003	Motor Cord	1	380V 3-
	IM721033	Motor Cord	1	220V 1-
30	SS069400	Set Screw	1	
31	RR210000	Retaining Ring (for bores)	3	



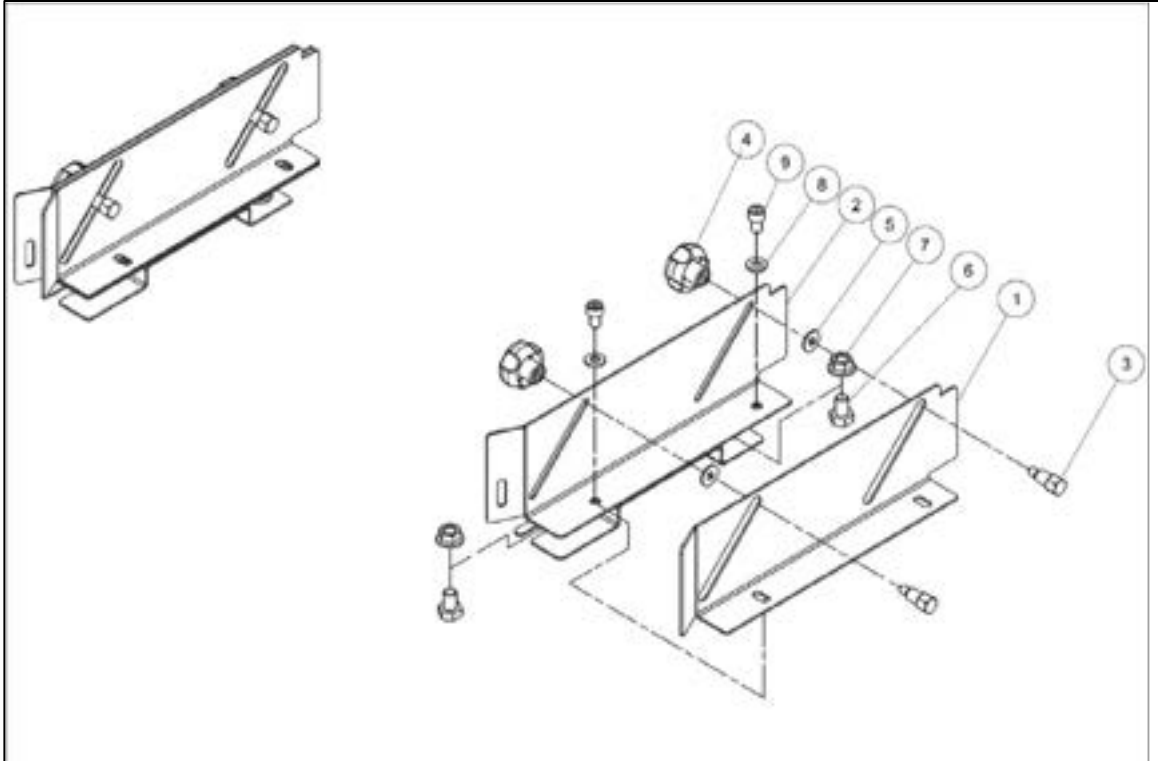
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ITEM	PART NUMBER	PART NAME	QTY
1	93	Cutter Plate	1
2	103	Tool Fixed Block	1
3	721094	Guides	1
4	721102	Locate Plate	1
5	721092	Locate Block	2
6	721101	Cutter	1
7	721091	Locate Plate	1
8	SM069400	Countersunk Head Cap Screw	2
9	SM060400	Countersunk Head Cap Screw	2
10	SM069300	Countersunk Head Cap Screw	1
11	SR060700	Cap Screw	4
12	NL061000	Nylon Nut	2
13	SM060500	Countersunk Head Cap Screw	2
14	AB721100	Cylinders ASM.	1
15	SS101800	Set Screw	1
16	SH061403	Hex Head Bolt	2
17	WF061310	Washer	2
18	NH101700	Hex Nut	2
19	PS041200	Spring Pin	2
20	WS060000	Spring Washer	10
21	SR060400	Cap Screw	2
22	WF061920	Washer	2

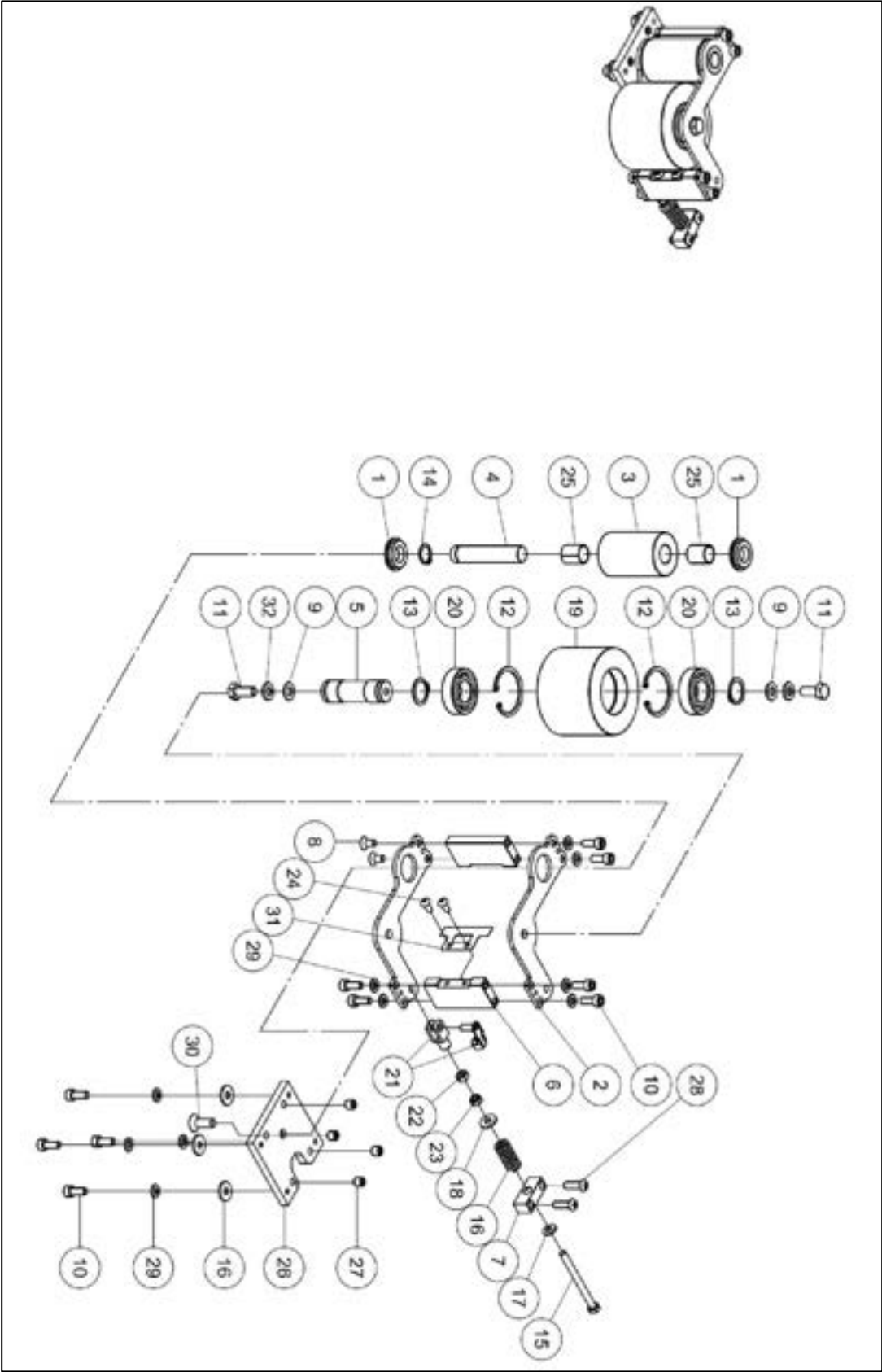


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ITEM	PART NUMBER	PART NAME	QTY
1	106	Support Rib	1
2	109	Edge With a Bracke	1
3	721107	Four Corners of the Nut	4
4	721108	Wheel	4
5	WF104030	Washer	3
6	NH101700	Nut	3
7	721105	Screw Pole	1
8	SJ089400	Round Socket Head Cap Screw	8
9	WF081820	Washer	4
10	721111	Class Screw	4
11	SR080400	Cap Screw	2
12	WF082520	Washer	2
13	WS080000	Spring Washer	10
14	721110	Wheel	4
15	RR320000	C-Type Ring	8
16	BB620102	Ball Bearing	8
17	17058	Self-Lubricating Bearing	8
18	NH101700	Hex Nut	2
19	PS041200	Spring Pin	2
20	WS060000	Spring Washer	10
21	SR060400	Cap Screw	2
22	WF061920	Washer	2

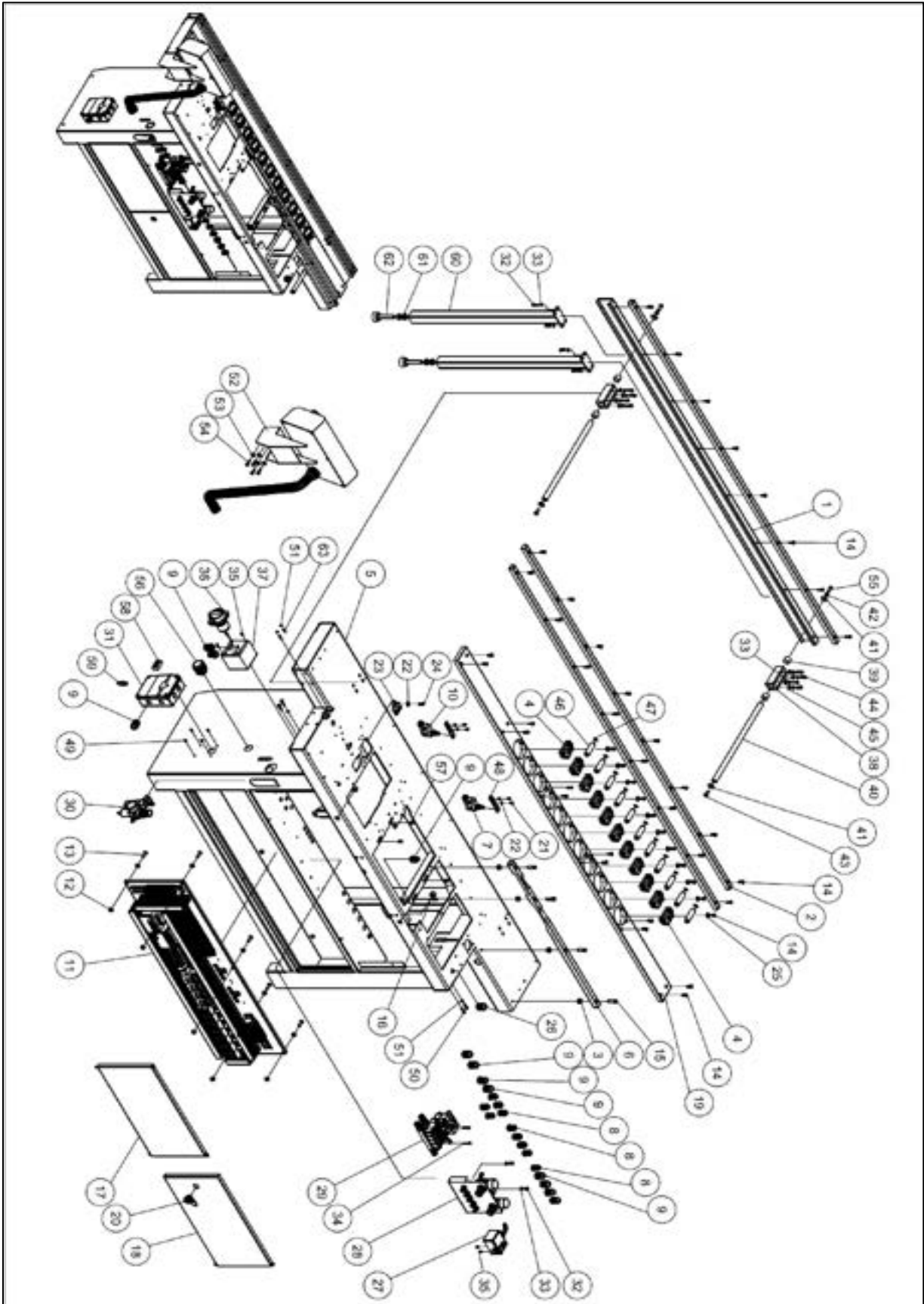


ITEM	PART NUMBER	PARTS NAME	Q'TY
1	721113	Left Guides	1
2	721112	Right Guides	1
3	721114	Stage Screw	2
4	721115	Plum Nut	2
5	WF051210	Washer	2
6	SH089300	Hex Head Screw	2
7	NF081300	Flange Hex Nut	2
8	WF061310	Washer	2
9	SR060200	Cap Screw	2



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ITEM	PART NUMBER	PARTS NAME	QTY
1	721117	Every Ring	2
2	721118	Fixed Plate	2
3	721119	Wheel	1
4	721120	Wheel Spindle	1
5	721122	Wheel Spindle	1
6	721124	Support Block	2
7	721128	Fixed Block	1
8	SM069300	Countersunk Head Cap Screw	2
9	WF081820	Washer	2
10	SR069400	Cap Screw	10
11	SH080400	Hex Head Bolt	2
12	RR420000	c-Type Ring	2
13	RS200000	C-Type Ring	2
14	RS150000	C-Type Ring	1
15	SH061300	Hex Head Bolt	1
16	721127	Spring	1
17	WF061310	Washer	1
18	WF061620	Washer	5
19	721123	Wheel	1
20	BB600403A	Ball Bearing	2
21	721125	Y-type Connector	1
22	NH061000	Hex Nut	1
23	NL061000	Nylon Nut	1
24	SJ059200	Round Socket Head Cap Screw	2
25	BD152001	Dry Bearing	2
26	721116	Fixed Base	1
27	SS089200	Set Screw	4
28	SJ060400	Round Socket Head Cap Screw	2
29	WS060000	Spring Washer	10
30	SM0804003	Countersunk Head Cap Screw	1
31	721129	Scraped plate	1
32	WS080000	Spring Washer	2
33	WF062320	Washer	1

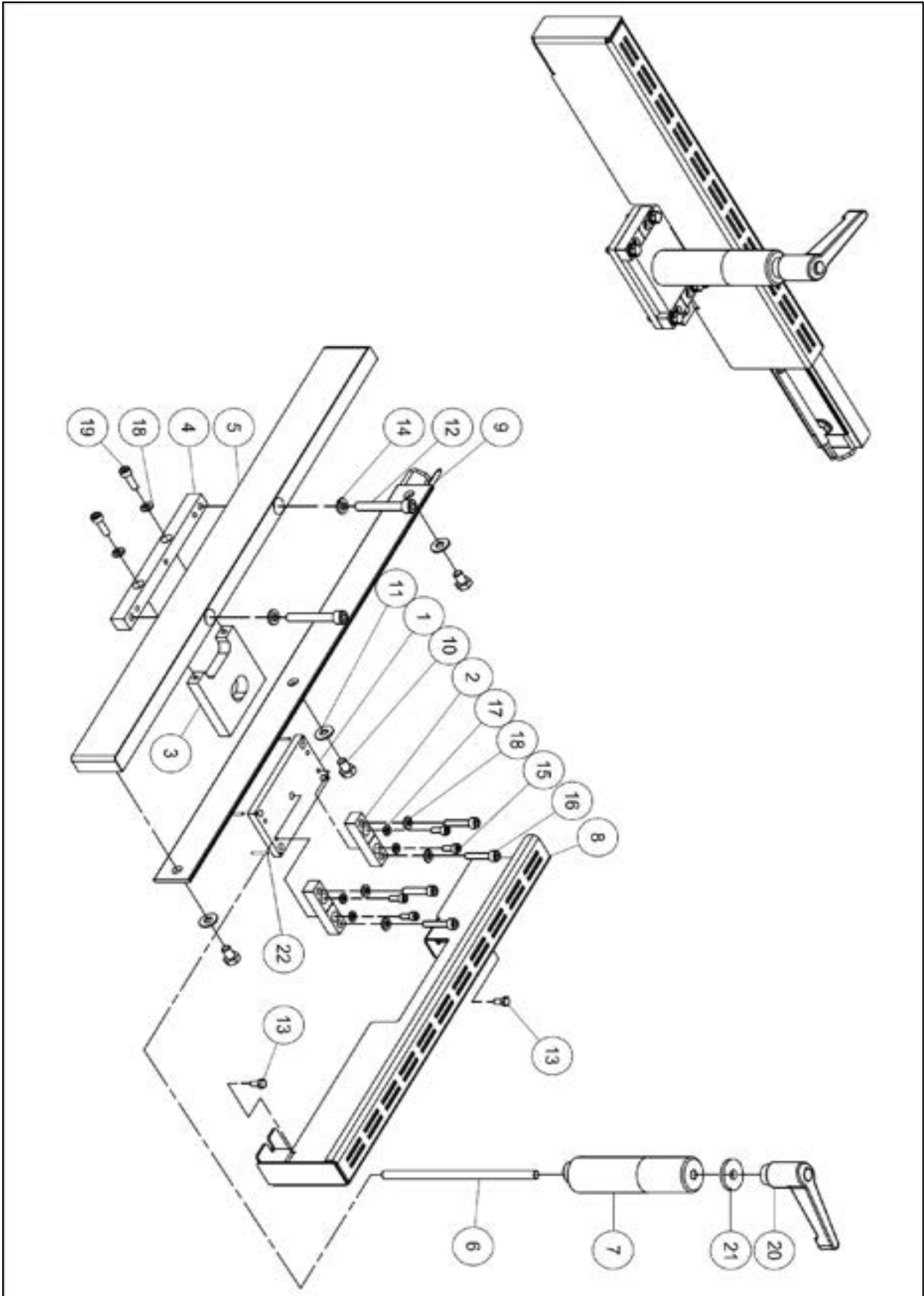


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ITEM	PART NUMBER	PARTS NAME	QTY
1	721141	Extension Bracket	1
2	721132	Pad	3
3	721137	Gasket	4
4	721134	Wheel Seat	11
5	721131	Body	1
6	721138	By The Board	1
7	AB205397A-B	Limits Switch Asm	1
8	709409	Outlet Beads	11
9	136013	Outlet Beads	12
10	AB.205397A-A	Limits Switch Asm.	1
11	AB721339	Distribution Bottom Plate	1
	AB721339A	Distribution Bottom Plate	1
	AB721339D	Distribution Botton Plate	1
12	NF081300	Hex Flange Nut	10
13	SJ080500	Round Socket Head Cap Screw	5
14	SR069400	Cap Screw	47
15	SR080600	Cap Screw	4
16	203249	Powerful Magnet Group	2
17	721338	Distribution BOX Door	1
18	721340	Distribution Box Door	1
19	721133	Platform	1
20	721342	Mechanical Locks	1
21	SJ050200	Roud Socket Head Cap Screw	4
22	WF051210	Washer	5
23	1.35051	Brush	1
24	SJ050400	Round Socket Head Cap Screw	1
25	WF061820	Washer	11
26	203481	Nylon Box Connector	1
27	AB721364	Pressure Switch Unit	1
	AB721364A	Pressure Switch Unit	1
28	AB721370	Pressure Adjustment Group	
29	AB721350	Solenoid Valve	1
	AB721350A	Solenoid Valve	1
30	AB721367	Three Point Combination Group	1
31	201105	Power Box	1
	201105A	Power Box	1
32	SR069300	Cap Screw	6
33	WS060000	Spring Washer	14
34	SP040600	Pan Head Screw	

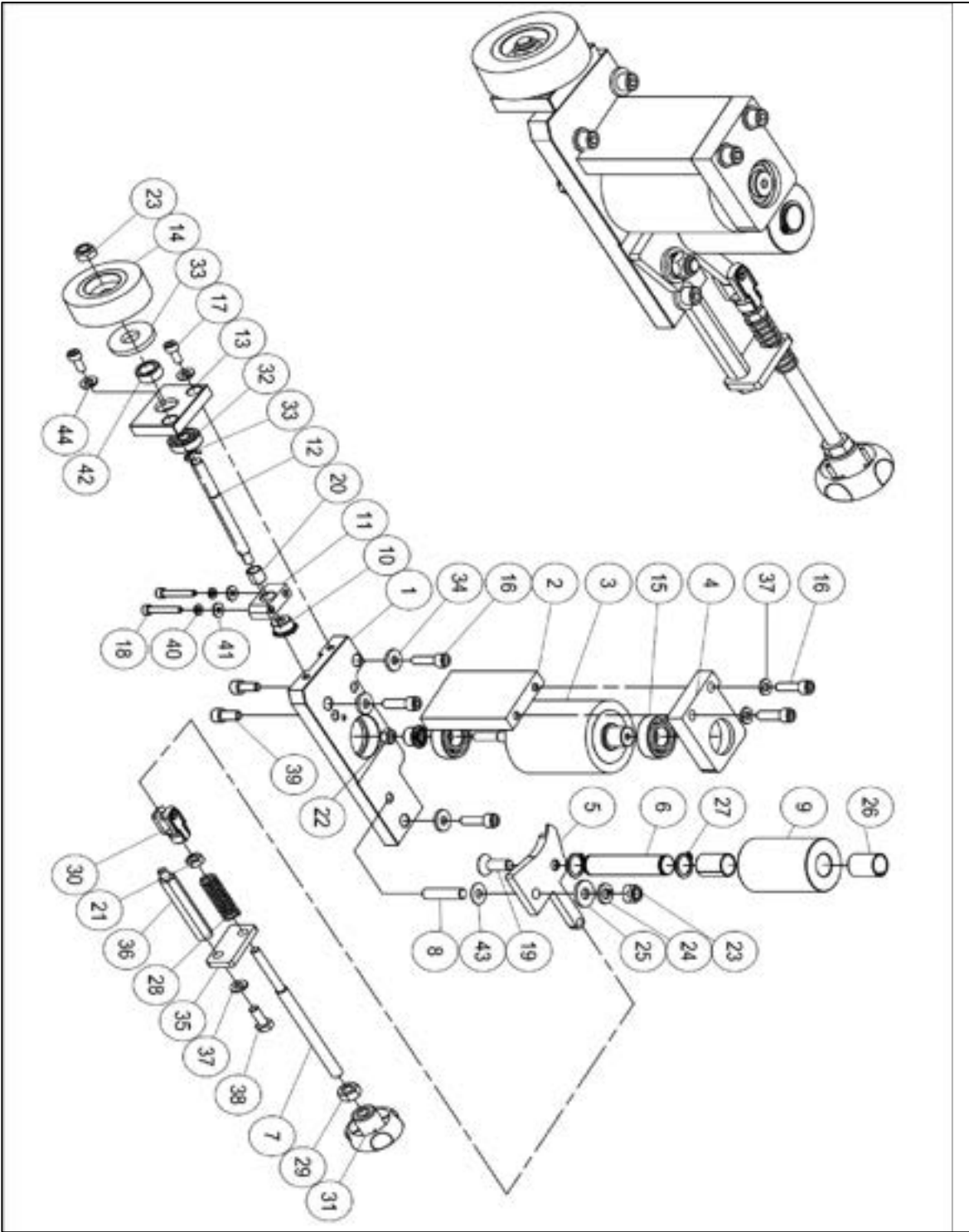
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35	SP040300	Pan Head Screw	6
36	994809	Power Switch	1
37	721145	Switch Box	1
38	721143	Extension of the Suppression Block	2
39	994353	Bushing Bearing	4
40	721144	Extension Rod	2
41	WF082320	Washer	4
42	WS080000	Spring Washer	2
43	SH089300	Hex Head Bolt	2
44	SR060400	Cap Screw	8
45	WF061620	Washer	8
46	721135	Wheel	11
47	WF101605	Washer	11
48	721139	Limit Switch Fixed Plate	2
49	SP069300	Pan Head Screw	4
50	SR060500	Cap Screw	4
51	NH061000	Hex Nut	4
52	AB721341	Control Box Asm.	1
53	WF081820	Washer	4
54	SR089300	Cap Screw	4
55	SJ089400	Round Socket Head Cap Screw	2
56	998808	Wave Tube	1
57	SS089200	Set Screw	4
58	994805		1
59	721336	Grounded Steel Plate	1
60	721379	Support Tube	2
61	NH121900	Hex Nut	4
62	201544	Adjust Foot	2
63	SS069400	Set Screw	2



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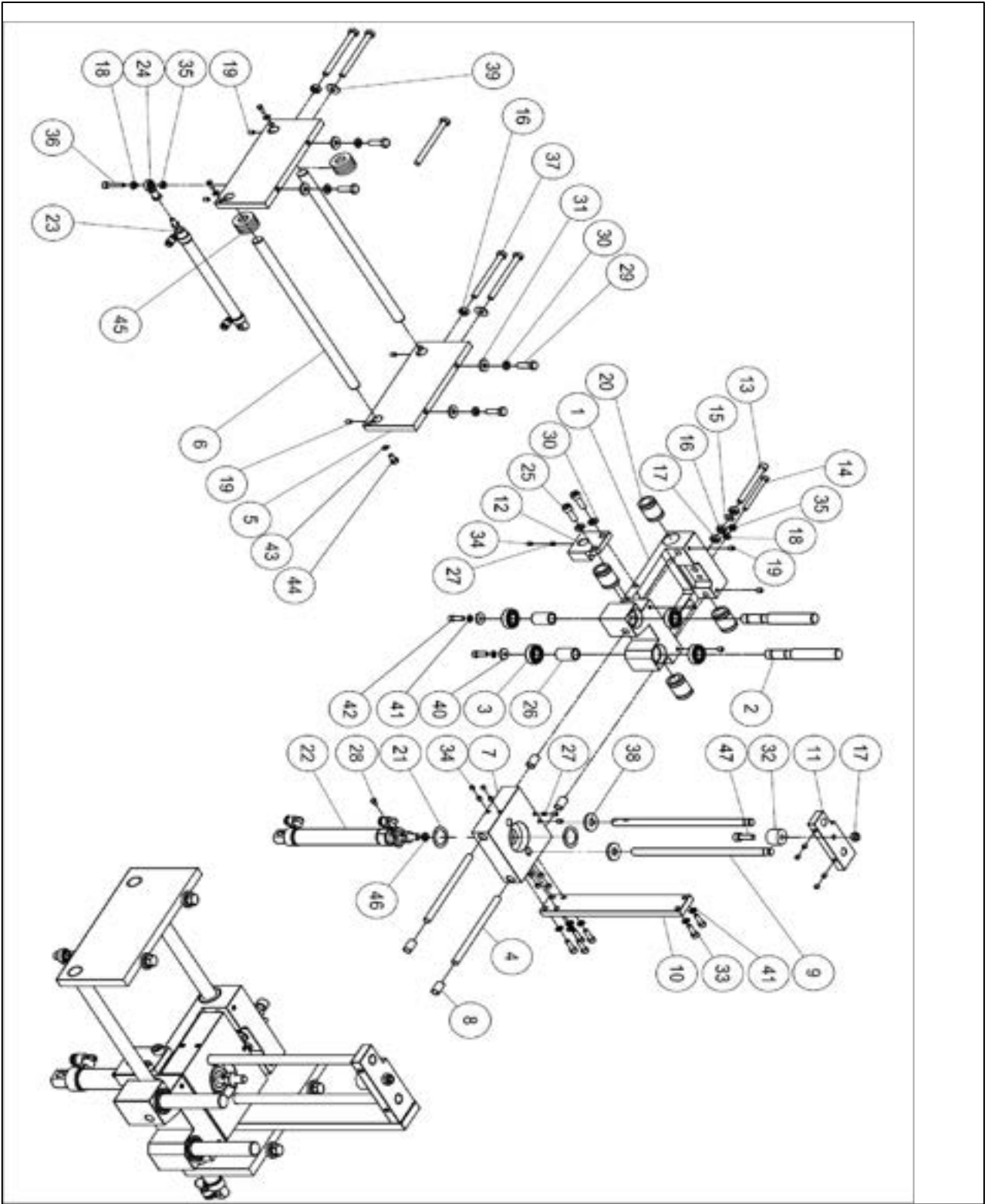
ITEM	PART NO	PARTS NAME	QTY
1	721151	Base Bracket	1
2	721152	Limit Block	2
3	721147	Slider	1
4	721146	Fixed Block	1
5	721 153	Board Plate	1
6	721149	Screw Pole	1
7	721148	Adjustment Screw Pole	1
8	721 155	Heater Plate Cover	1
9	721154	Electric Heating	1
10	SH089300	Hex Head Bolt	3
11	WF081820	Washer	3
12	SR081100	Cap Screw	2
13	SG050200	Hex Head Bolt (W/Flange)	2
14	WS080000	Spring Washer	2
15	SR059300	Cap Screw	4
16	SR060600	Hex Head Bolt	4
17	WS050000	Spring Washer	4
18	WS060000	Spring Washer	6
19	SR060400	Cap Screw	2
20	721150	Quick Release Handle	1
21	WF082730	Washer	1
22	PP031200	PIN	4



ITEM	PART NO	PARTS NAME	Q'TY
1	721161	Fixed Plate	1
2	721162	Booster Plate	1
3	721163	Wheel	1

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4	721164	Bearing Fixed Plate	1
5	721165	Clutch Plate	1
6	173	Wheel Shaft	
7	721169	Rod	1
8	72 166	Shaft	1
9	721175	Wheel	1
10	721176	Gear	2
11	721177	Fixed Bracket	1
12	721179	Transmission Shaft	1
13	721180	Bearing Fixed Plate	1
14	721181	Wheel	1
15	BB600203A	Ball Bearing	2
16	SR060400	Cap Screw	5
17	SR059300	Cap Screw	2
18	SR040500	Cap Screw	2
19	SM080400	Pan Head Screws Hexagon	1
20	BD081001	Bushing Bearing	1
21	NH061000	Hex Nut	1
22	NL061000	Nylon Hex Nut	1
23	NL081300	Nylon Nut	2
24	WS050000	Spring Washer	1
25	WF081820	Washer	1
26	BD152001	Bushing Bearing	2
27	RS150000	C-Type Ring	2
28	721167	Spring	1
29	NH081300	Hex Nut	1
30	721125	Y-Type Connector	1
31	721056	Plum Nut	1
32	BB608002A	Ball Bearing	1
33	RS070000	S-Type Ring	1
34	WF061620	Washer	3
35	721168	Connector Plate	1
36	721182	Six Hex Pole	1
37	WS060000	Spring Washer	3
38	SH069400	Hex Head Bolt	1
39	SR069300	Cap Screw	2
40	WS040000	Spring Washer	1
41	WF040810	Washer	1
42	200964	Shaft	1
43	992607	Washer	1
44	WS050000	Spring Washer	2

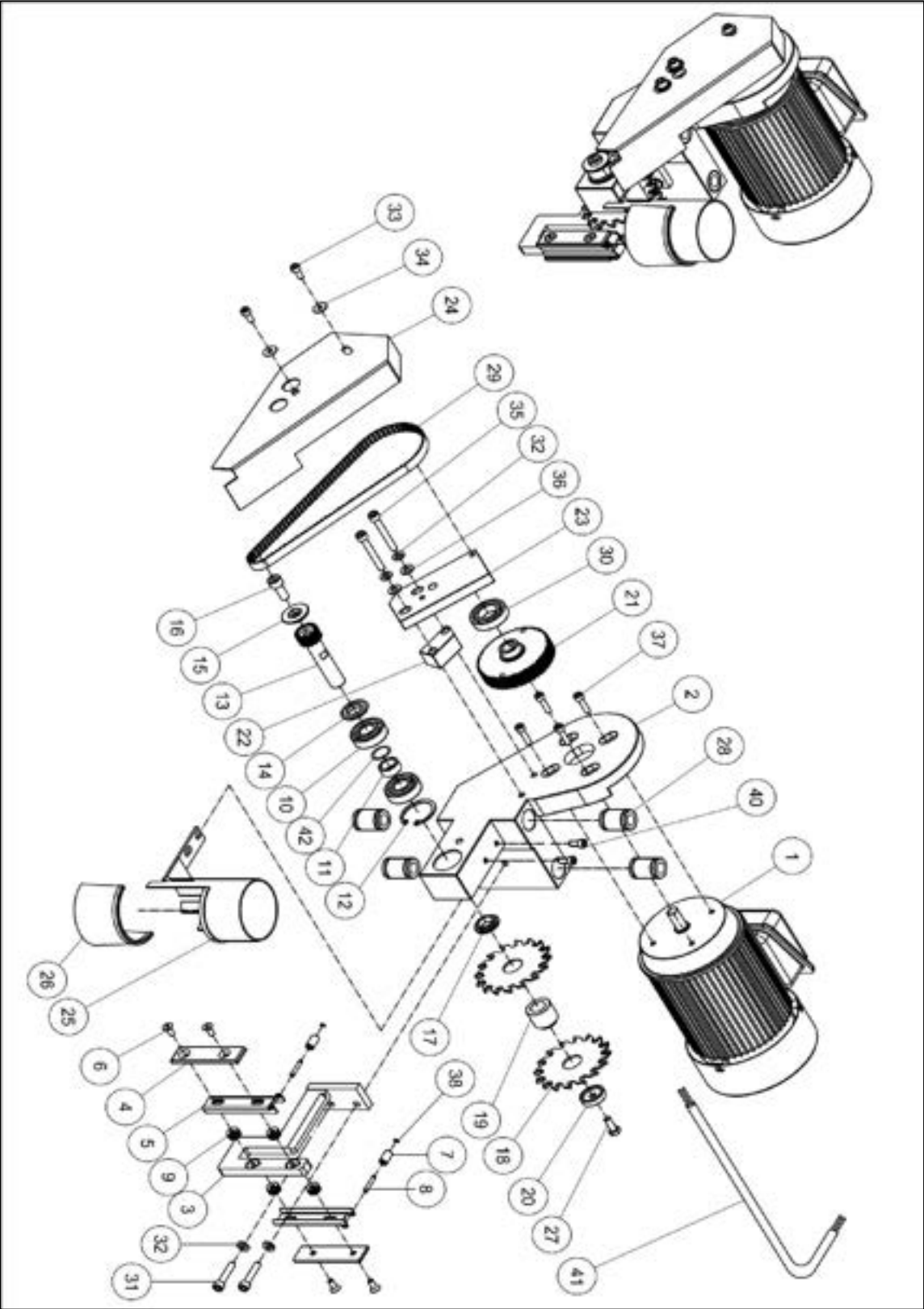


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ITEM	PART NO	PARTS NAME	Q'TY
1	721186	Translation Base	1
2	721191	Chrome Rod Park	2
3	BB600203A	Ball Bearing	4
4	721206	Chrome Rod Park	2
5	721188	Fixed Plate	2
6	721187	Chrome Rod Park	2
7	194	Lifting Block	
8	BD102001	Dry Bearing	4
9	72 197	Chrome Rod Park	2
10	721198	Fixed Plate	1
11	721199	On the Fixed Plate	1
12	721202	Cylinder Fixed Block	1
13	SR081600	Cap Screw	1
14	SR061400	Cap Screw	1
15	721205	Disc Washer	1
16	NH081300	Hex Nut	4
17	NL081300	Nylon Nut	2
18	NL061000	Nylon Nut	2
19	SS069250	Set Screw	10
20	BL280502	Linear Bearing	4
21	WF253510	Washer	2
22	AB721192	Pneumatic Cylinder ASM.	1
23	AB721203	Pneumatic Cylinder ASM.	1
24	721201	The Rod-end Bearing	1
25	SR080400	Cap Screw	2
26	721189	Interval Sets	2
27	721072	ABS Strips	0.01
28	SH049100	Hex Head Bolt	1
29	SH0805403	Hex Head Bolt	4
30	WS080000	Spring Washer	6
31	WF082030	Washer	4
32	721200	Buffer Blocks	1
33	SR060400	Cap Screw	6
34	SS069150	Set Screw	13

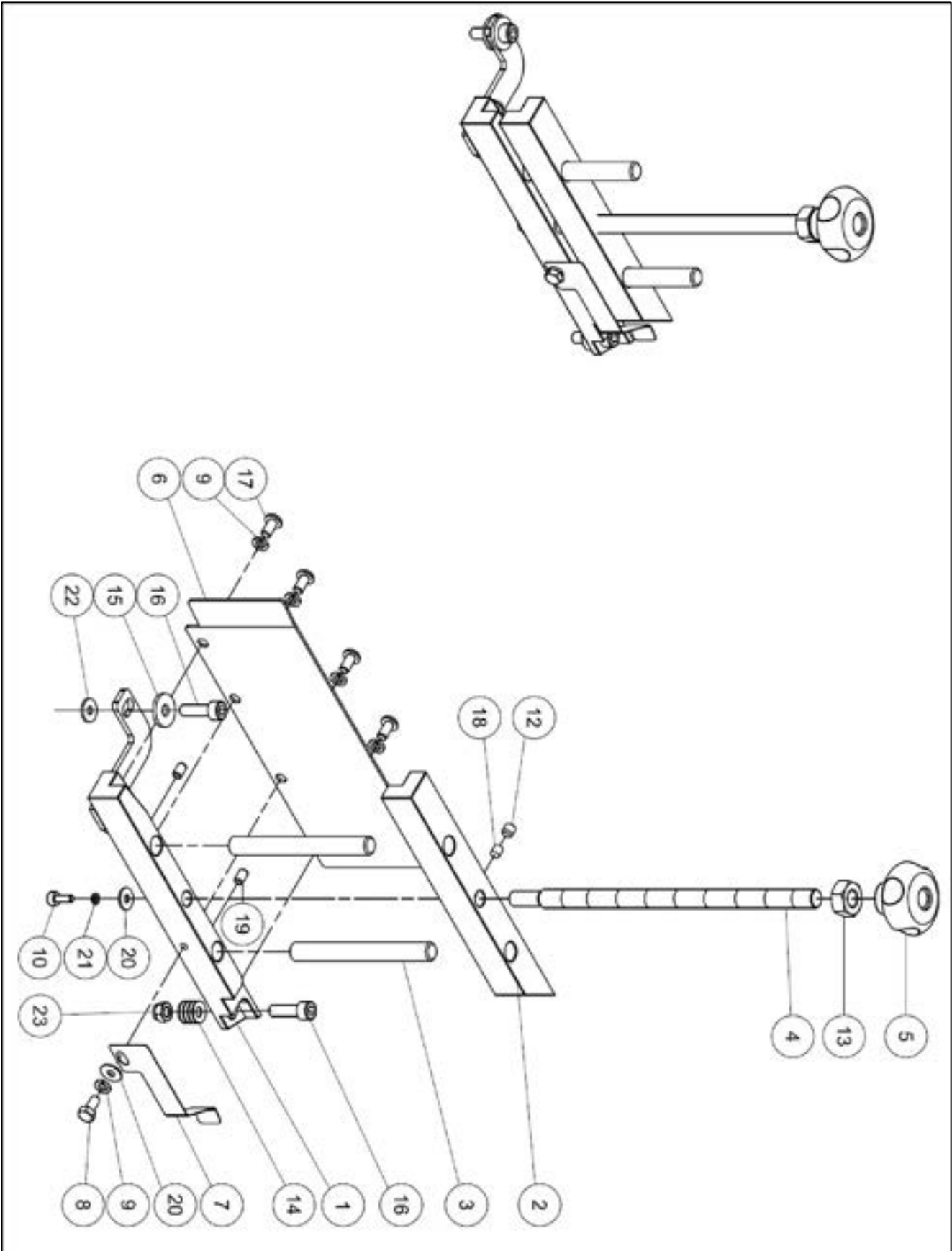
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35	NH061000	Hex Nut	2
36	SR060600	Cap Screw	1
37	SH081600	Hex Head Bolt	4
38	721204	Buffer Blocks	2
39	WF082030	Washer	4
40	WF061920	Washer	2
41	WS060000	Spring Washer	8
42	SR069400	Cap Screw	2
43	WF051210	Washer	4
44	SH050200	Hex Head Bolt	4
45	721185	Buffer Blocks	8
46	WS100000	Spring Washer	1
47	SJ080500	Round Socket Head Cap Screw	1



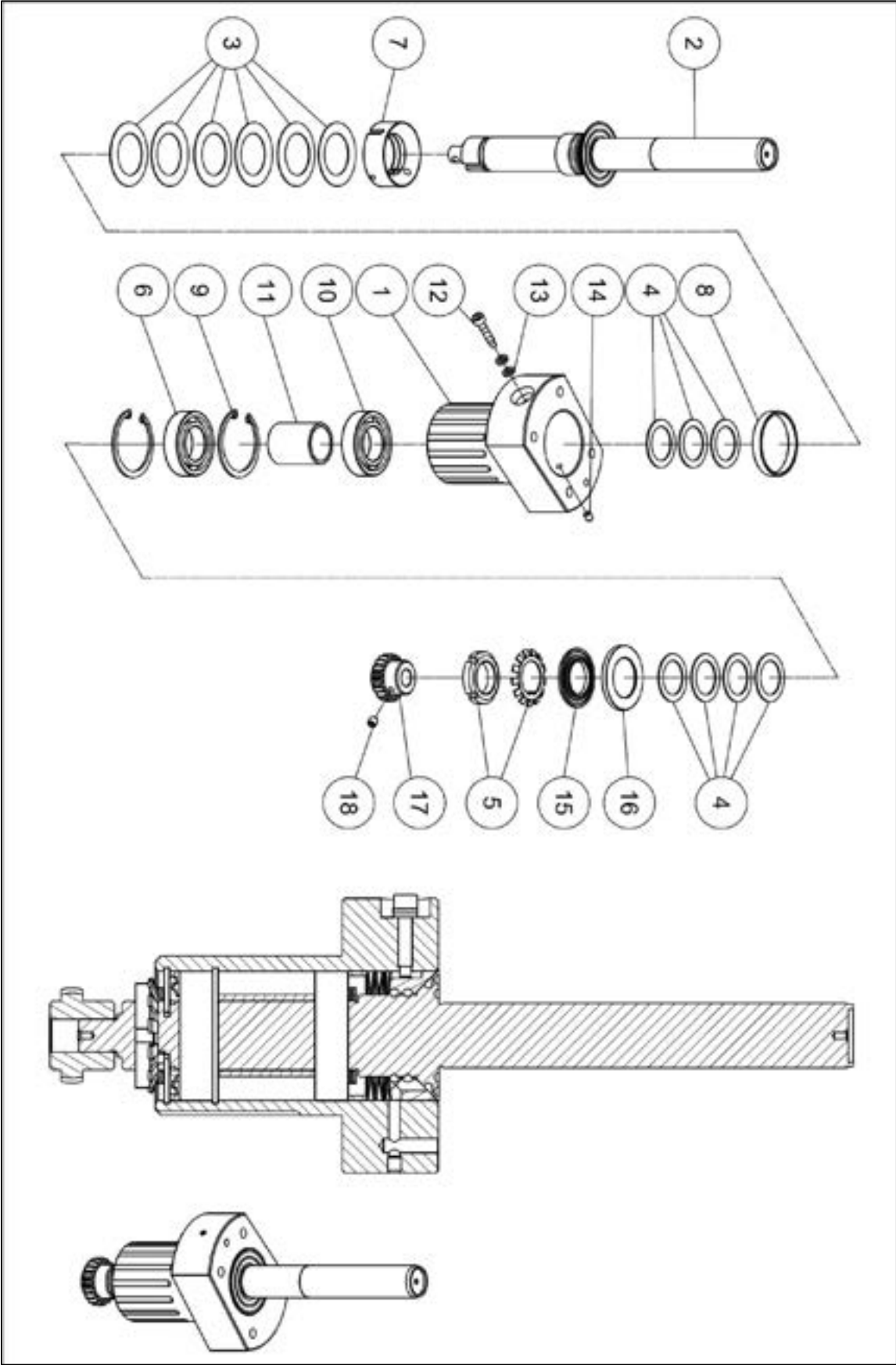
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ITEM	PART NUMBER	PART NAME	QUANTITY	NOTE
1	MA721216	Motor		
2	721215	Motor Fixed Bracket	1	1/4 HP (.18kW) 2P , 220V 1~
3	221	Support By the Board		
4	721227	By the Board	2	
5	72226	Wheel Fixed Flakes	2	
6	SM059300	Pan Head Screws Hexagon	4	
7	721228	Brass Ring	2	
8	721233	Plug	2	
9	721232	Disc Washers	24	
10	BB620204	Ball Bearing	2	
11	721222	Shaft	1	
12	RR350000	C-Type Ring	1	
13	721224	Repair Spindle	1	
14	721220	Pully Washer	1	
15	720229	Stop Flakes	1	
16	SR080400	Cap Screw	1	
17	721223	Flange	1	
18	721218	Cutter	2	
19	721219	Spacer Ring	1	
20	721217	Flange	1	
21	721214	Gear Type Pulley	1	
22	721225	Pad	1	
23	721212	Belt Adjustment Block	1	
24	721211	Cover	1	
25	721230	Dust Cover	1	
26	721231	Brush	0.05	112mm
27	SH069402	Hex Head Bolt	1	
28	BL210402	Linear Bearing	4	
29	721213	Toothed Belt	1	
30	BB690404	Ball Bearing	1	
31	SR060400	Cap Screw	2	
32	WS060000	Spring Washer	2	
33	SR059300	Cap Screw	2	
34	WF051210	Washer	2	
35	SR060800	Cap Screw	2	
36	WF061920	Washer	2	
37	SR059400	Cap Screw	4	
38	RE025000	E-Type Ring	2	
39	WS050000	Spring Washer	2	
40	SG050200	Hex Head Bolt (W/Flange)	2	
41	IM721001	Motor Cord	1	380V3- CE
	IM721031	Motor Cord	1	220V 1-CE
42	992622	Washer	1	



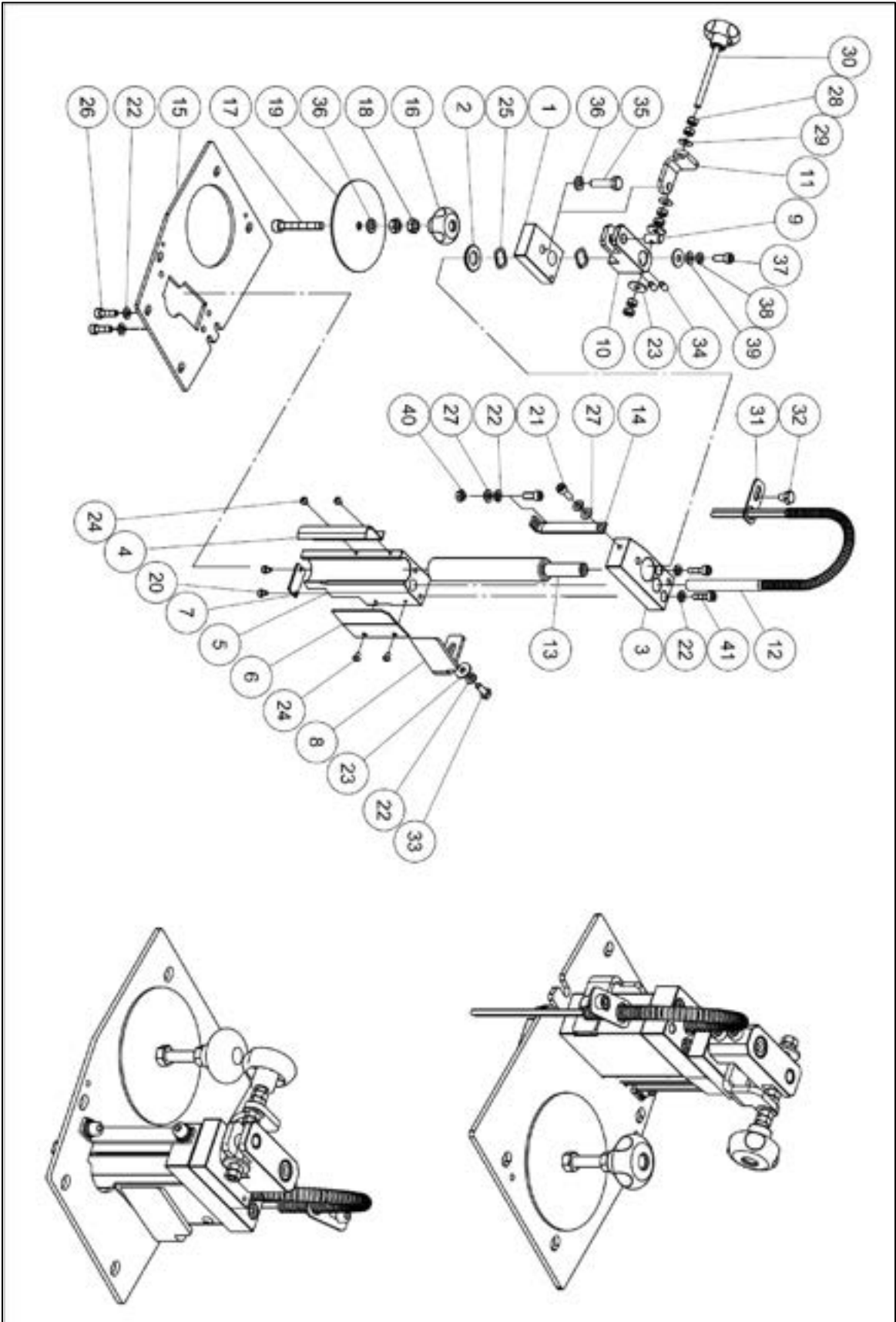
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ITEM	PART NO	PARTS NAME	QTY
1	721236	Low side Pressure Plate	1
2	721237	Upside Pressure Plate	1
3	721238	Chrome Rod Park	2
4	721239	Adjustment Screw	1
5	721240	Plum Nut	1
6	721242	Protection Plate	1
7	721244	Spring Flakes	1
8	SH0S0200	Hex head Bolt	1
9	WS50000	Spring Washer	5
10	SJ040200	Round Socket Head Cap Screw	1
12	SS069100	Set Screw	1
13	NH101700	Hex Nut	1
14	206395	Disc Washers	8
15	WF061820	Washer	2
16	SR060400	Cap Screw	2
17	SJ0S0200	Round Socket Head Cap Sefew	4
18	721072	ABS Strips	0.01
19	SS059200	Set Screw	2
20	WF0S1210	Washer	2
21	WS040000	Spring Washer	1
22	WF061310	Washer	1
23	NL061000	Ny1on Nut	1



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ITEM	PART NO	PARTS NAME	SIZE	Q'TY
1	721253	SPREAD GLUE BASE		1
2	721255	SPREAD GLUE SHAFT		1
3	721247	DISC WASHER		6
4	WF253510	Flat Washer	t25' t35'1T	7
5	721252	LOCKING NUT & STAR WASHER		1
6	BB600502A	BALL BEARUNG	600522	1
7	721246	BUSHING		1
8	721248	BUSHING		1
9	RR470000	RETAINING RING	R47	2
10	BB600500A	BALL BEARUNG	6005	1
11	721250	BUSHING		1
12	721251	STEP BOLT		1
13	WS0S0000	Spring Washer	MS	2
14	SS059100	SETSCREW	M5x6	1
15	721257	PREVENT OUST INSIDE RING		1
16	721256	PREVENT DUST OUTSIDE RING		1
17	721308	SHAFT JOIN GEAR		1
18	SS069200	SETSCREW	M6x8L	1

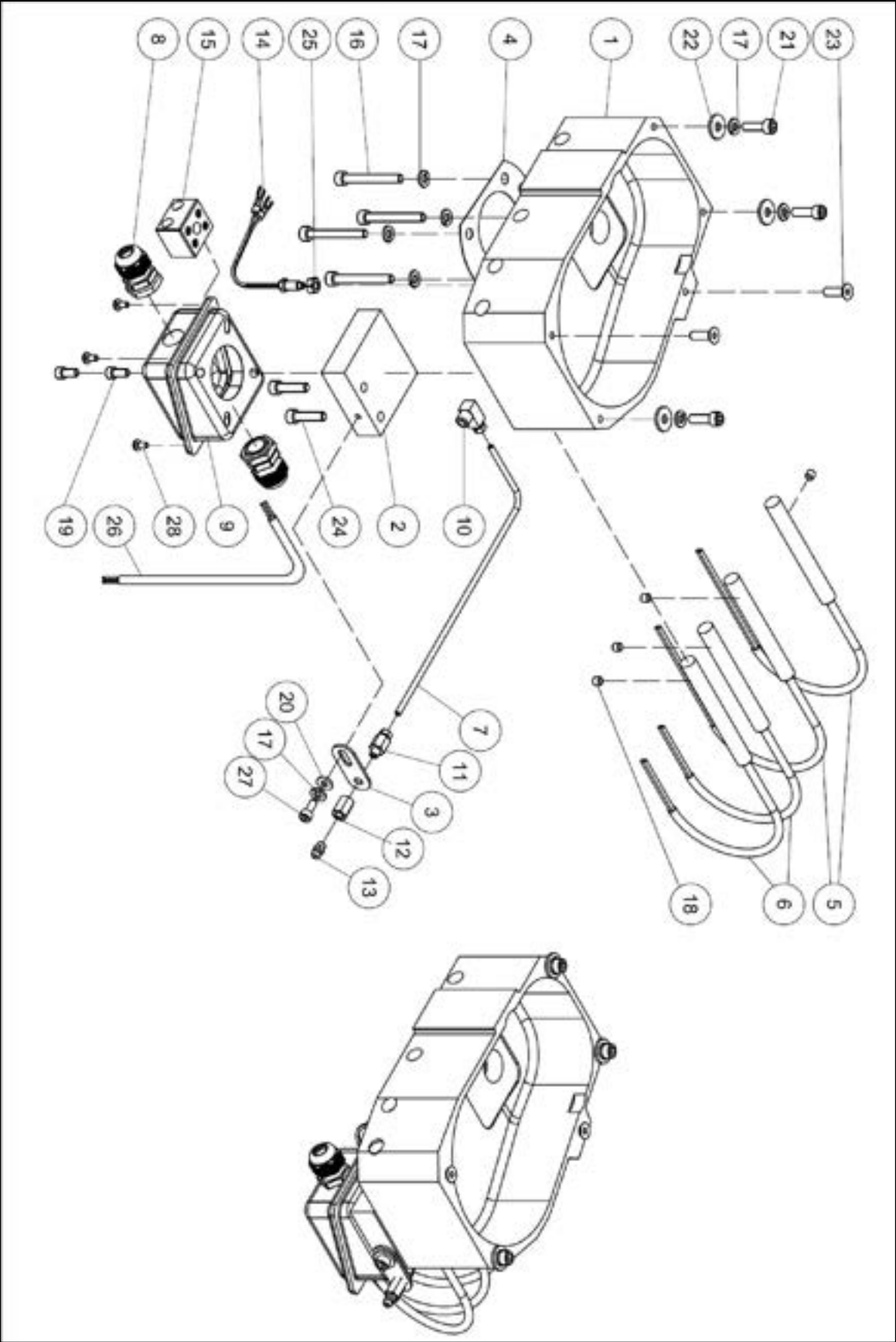


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ITEM	PART NO	PARTS NAME	Q'TY
1	721261	LOCATE BLOCK	1
2	721262	SPACER	1
3	721264	LOCATE BLOCK	1
4	721266	COVER PLATE	1
5	721267	ADJUST BSAE	1
6	721268	COVER PLATE	1
7	721269	COVER PLATE	1
8	721270	GUIDE PLATE	1
9	721272	SHAFT	1
10	721273	ADJUST BLOCK	1
11	721274	LOCATE PLATE	1
12	721275	ELECTRIC HEAT STICK	1
13	721265	ADJUST ROTATE TUBE	1
14	721263	SUPPORT PLATE	1
15	721271	GLUE 6ARREL UPPER COVER	1
16	721056	KNOB	1
17	SR081100	HEX SOCKET BOLT	1
18	NH081300	NUT	2
19	721278	GLUE BARREL COVER	1
20	SR049100	HEX SOCKET BOLT	2
21	SR069400	HEX SOCKET BOLT	2
22	WS060000	SPRING WASHER	7
23	WF061920	FLAT WASHER	3
24	SJ049100	HEX SOCKET SUTTONHEAD SCREW	4
25	WW152203	WAVE WASHER	2
26	SR0693403	HEX SOCKET BOLT	2
27	WF061310	FLAT WASHER	2
28	NH061000	NUT	6
29	206395	DISC WASHER	2
30	721276	KNOB SCREW	1
31	721277	LOCATE PLATE	1
32	SG069200	Hex Head Bolt (W/Flange)	1
33	SH0694403	HEX HEAD BOLT	1

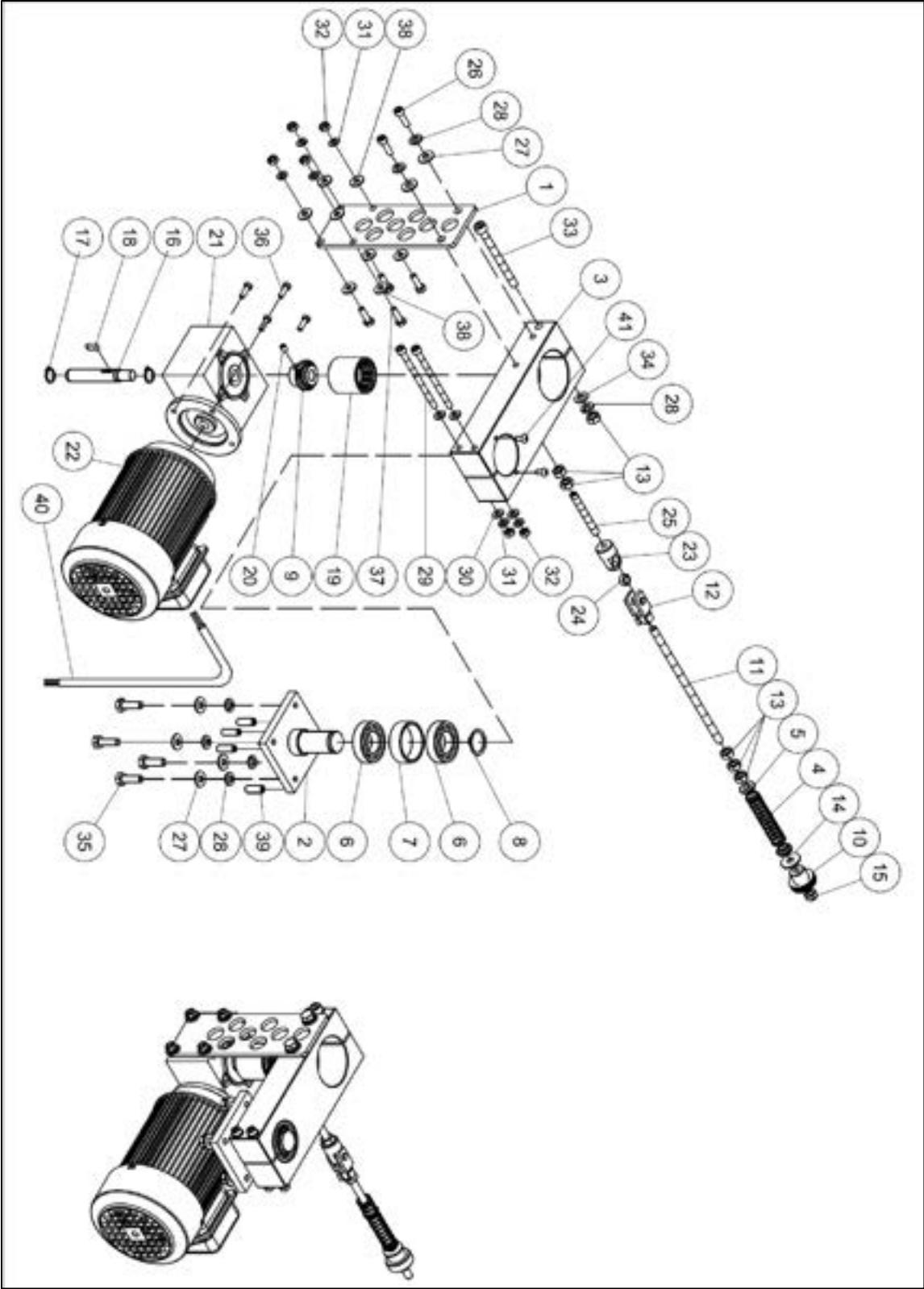
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34	SS069200	SETSCREW	2
35	SH0806403	HEX HEAD BOLT	1
36	WS080000	SPRING WASHER	2
37	SR0594403	HEX SOCKET BOLT	1
38	WS050000	SPRING WASHER	1
39	WF051210	FLAT WASHER	1
40	NF061000	FLANGE NUT	1
41	SR0604403	HEX SOCKET BOLT	2



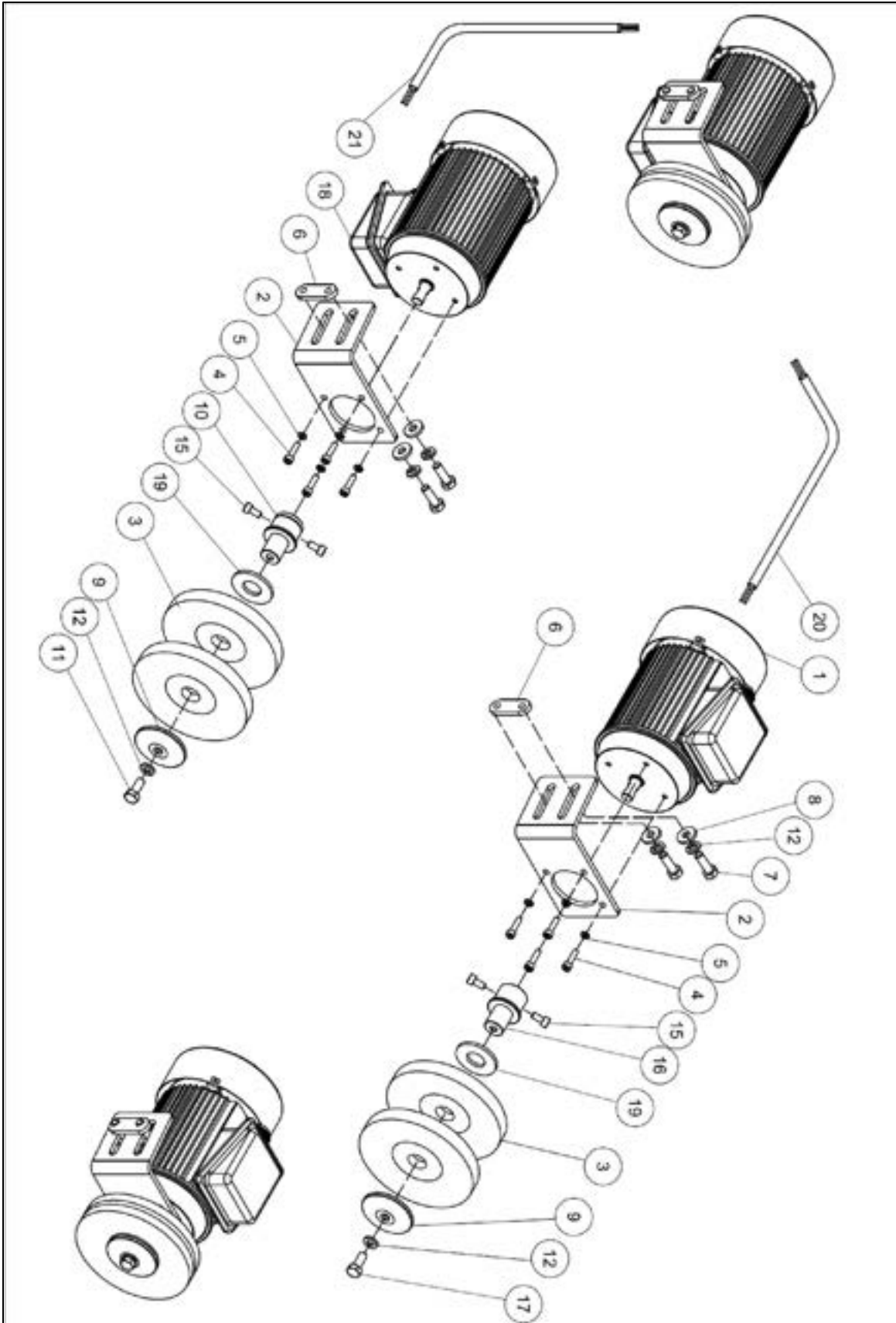
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ITEM	PART NO	PARTS NAME	Q'TY
1	721281	Coines	1
2	721286	Electricity Boards	1
3	721283	Fixed Plate	1
4	721293	Non-Asbestos Gasket	1
5	721284	Electric Rods	2
6	721285	Electric Rods	2
7	721282	Brass	0.3
8	709411	Outlet Beads	2
9	721287	Connector Box	1
10	721292	Lubrication Of Joints	1
11	721289	Lubrication Of Joints	1
12	721290	Adapter	1
13	203198	Grease Nipple	1
14	721288	Temperature Line	1
15	721280	Ceramic Terminal Block	1
16	SR061003	Cap Screw	4
17	WS060000	Spring Washer	8
18	SS069100	Set Screw	4
19	SR059300	Cap Screw	2
20	WF061310	Washer	1
21	SR0604403	Cap Screw	3
22	WF061920	Washer	3
23	SM0604403	Pan Head Screws Hexagon	2
24	SR060500	Cap Screw	2
25	NH561000	Nut	1
26	IC721012	Power Cord	1
27	SR069300	Cap Screw	1
28	SP049200	Pan Head Screw	4



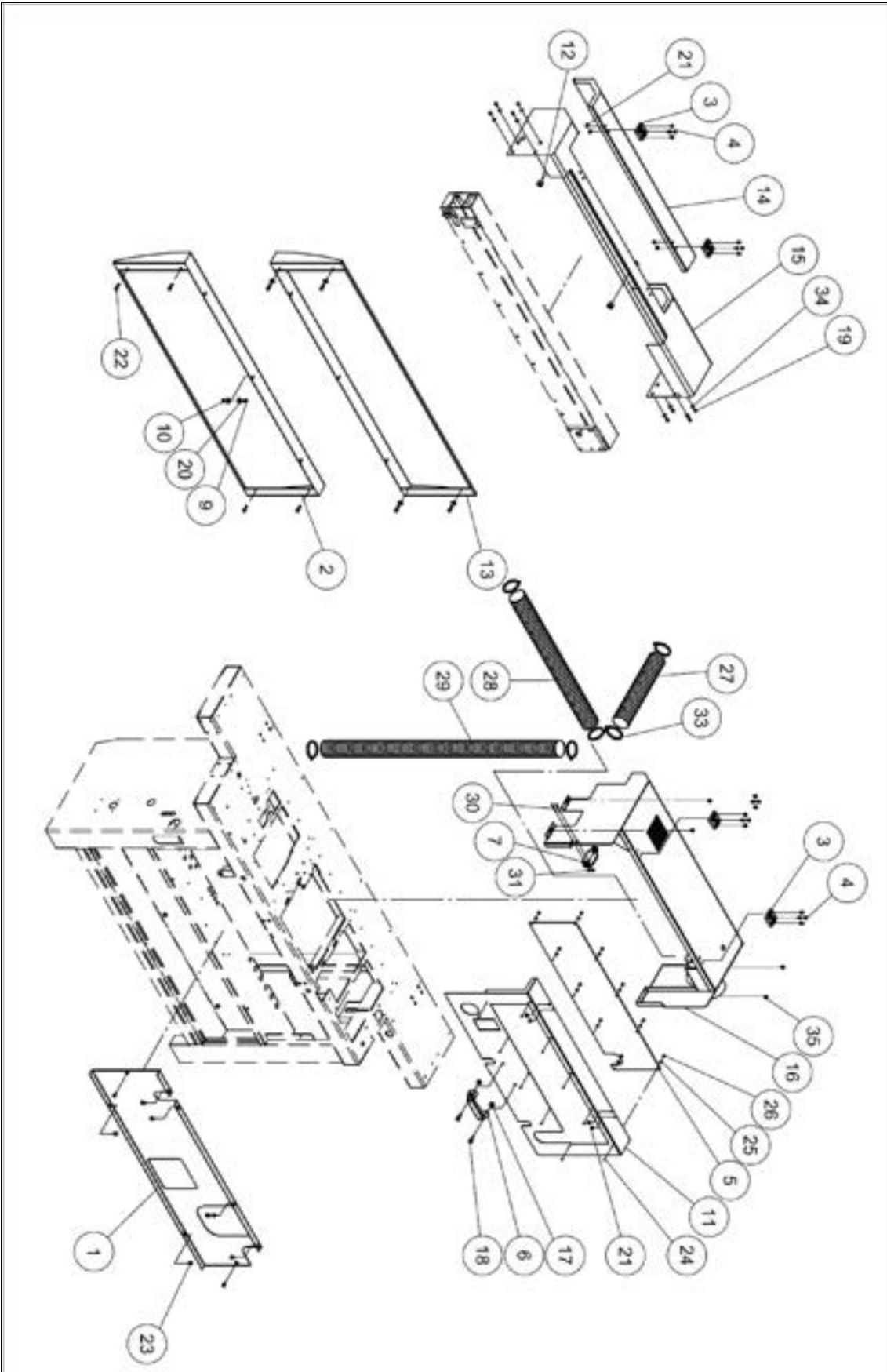
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ITEM	PART NO	PARTS NAME	Q'TY
1	721312	Motor Fixed Plate	1
2	721297	Spindle Bracket	1
3	721299A	Fixed Bracket	1
4	721304	Spring	1
5	721305	Gasket	2
6	BB600502A	Ball Bearing	2
7	721313	Ring	1
8	RS250000	C-Type Ring	1
9	721308	Spindle Connector Gear	1
10	721306	Plum Nut	1
11	721303	Screw Poll	1
12	721301	Y-type Connector	1
13	NH081300	Hex Nut	6
14	WF082320	Washer	1
15	NL081300	Nylon Nut	1
16	721309	Transmission Shaft	1
17	RS140000	C-Type Ring	2
18	KD050515	Key	1
19	721307	Spindle Connector Ring	1
20	SS069200	Set Screw	1
21	721310	Reducer	1
	721310A	Reducer	1
22	MA721311	Motor	1
	MA721311A	Motor	1
23	721300a	Connector	1
24	200964	Shaft	1
25	SS081300	Set Screw	1
26	SR080400	Cap Screw	2
27	WF081818	Washer	6
28	WS080000	Spring Washer	7
29	SR061803	Cap Screw	2
30	WF061310	Washer	4
31	WS060000	Spring Washer	6
32	NH061000	Hex Nut	6
33	SR081803	Cap Screw	1
34	WF081820	Washer	1
35	SH080600	Hex Head Bolt	4
36	SH059300	Hex Head Bolt	4
37	SH060401	Hex Head Bolt	4
38	WF061620	Washer	8
39	SS089400	Set Screw	4
40	IM721004	Motor Cord	1
	IM721034	Motor Cord	1
41	SJ069200	Round Socket Head Cap Screw	2



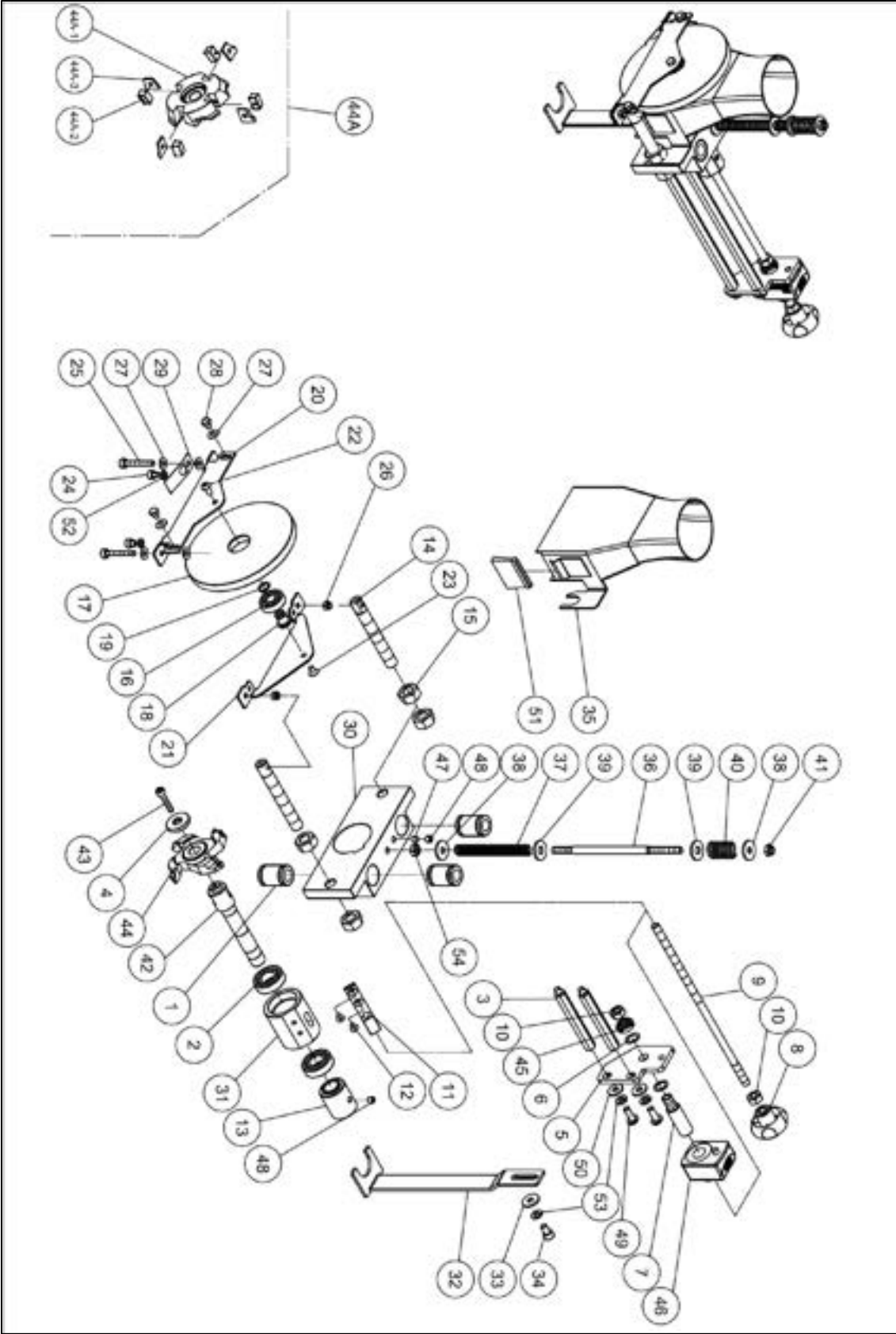
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ITEM	PART NUMBER	PARTS NAME	QTY
1	MA721321R	Motor	1
2	721319	Motor Fixed Plate	2
3	721317	Wheel	4
4	SR059400	Cap Screw	8
5	WS050000	Spring Washer	8
6	721324	Fixed plate	2
7	SH080500	Hex head bolt	4
8	WF082030	Washer	4
9	721316	Flange Flakes	2
10	721322	Wheel Spindle	1
11	S,H08.0400	Hex head bolt	1
12	ws08000	Spring Washer	6
15	SR069300	Cap Screw	4
16	721318	Wheel Spindle	1
17	sh080402	Hex Head	1
18	MA721321L	Motor	1
19	721320	Washer	2
20	M721036	Motor Cord	1
21	m721035	Motor Cord	1



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ITEM	PART NO	PARTS NAME	Q'TY
1	721327	Back Cover	1
2	721326	Front Cover	1
3	721330	Plastics Hinge	4
4	SJ059300	Round Socket Head Cap Screw	16
5	721333	Transparent Cover	1
6	201624	Handle	1
7	AB721037-B	Door Safety Switch ASM.	1
8	AB136457A-B	Door Safety Switch ASM.	1
9	SR069300	Cap Screw	1
10	NF061000	Flange Nut	1
11	721335	Cover	1
12	203249	Powerful magnet group	2
13	721326	Front Cover	1
14	721332	Cover	1
15	721328	Cover	1
16	721329	Cover	1
17	NF081300	Flange Nut	2
18	SR089400	Cap Screw	2
19	SJ059200	Round Socket Head Cap Screw	8
20	WF061920	Washer	2
21	NF050800	Flange Nut	8
22	SG069300	Hex Head Bolt (W/Flange)	8
23	SG069200	Hex Head Bolt (W/Flange)	8
24	SP040200	Pan Head Screw	10
25	WF040810	Washer	10
26	NH040700	Hex Nut	10
27	721345	Hose	1
28	721346	Hose	1
29	721347	Hose	1
30	SP040600	Pan Head Screw	2
31	NH040700	Hex Nut	2
32			
33	L1500000000000000		6
34	WF051210	Washer	8
35	SG059200	Hex Head Bolt (W/Flange)	4

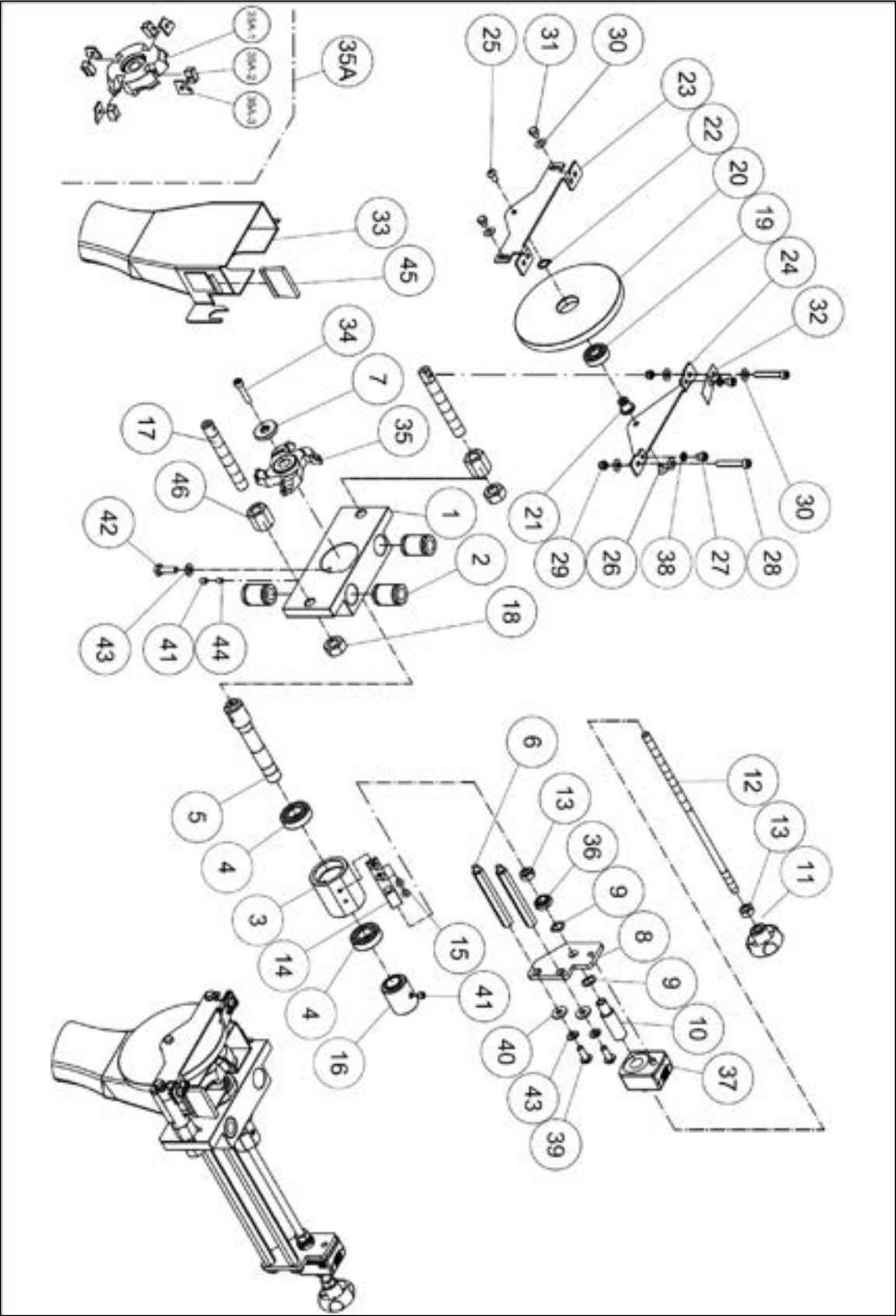


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ITEM	PART NUMBER	PARTS NAME	Q'TY
1	BL210402	Linear Bearing	3
2	BB600204	Ball Bearing	2
3	721182	Six Hexagonal Column	2
4	721043	Spindle Cover	1
5	721061	Fixer Plate	1
6	WW101503	Wave-Type Gasket	2
7	721060	Adapter Shaft	1
8	721056	Plum Nut	1
9	721055	Adjustment Screw Pole	1
10	NH081300	Hex Nut	2
11	721063	Connection Plate	1
12	SM049200	Pan Head Screws Hexagon	2
13	721046	Flat Pulley	1
14	721042	Support Screw Pole	2
15	NH121900	Hex Nut	4
16	B0600004	Ball Bearing	1
17	721069	Profiling Wheel	1
18	721070	Wheel Spindle	1
19	RS100000	C-Type Ring	1
20	721066	Pressure Wheel Fixed Plate	1
21	721067	Pressure Wheel Fixed Plate	1
22	SJ059200	Round Socket Head Cap Screw	1
23	SM059200	Countersunk Head Cap Screw	1
24	SR050200	Cap Screw	2
25	SR050600	Cap Screw	2
26	NL050800	Nylon Nut	2
27	721232	Disc Washers	6
28	SG059200	Hex Head Bolt (W/Flange)	2
29	721068	Spring Scratch Plate	1
30	721047	Upside Sliding Bracket	1
31	721045	Upside Shaft	1
32	721081	Locate Adjustment Plate	1
33	WF061920	Washer	1
34	SR069300	Cap Screw	1
35	721041	Dust Cover	1
36	721054	Screw Pole	1
37	721058	Spring	1

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38	WF062330	Washer	2
39	WF082320	Washer	2
40	721059	Spring	1
41	NL061000	Nylon Nut	1
42	721044	Upside Spindle	1
43	SR050400	Cap Screw	1
44	721049	Upside Tool Blade	1
44A	AB721049A	Low side Tool Set.	1
44A-1	721049A-1		1
44A-2	721049A-2		4
44A-3	721049A-3		4
45	721071	Lock Nut	1
46	721064	Position indicator	1
47	721072	ABS Strips	0.01
48	SS069150	Set Screw	2
49	SR069400	Cap Screw	2
50	WF061620	Washer	2
51	721073	Hairbrush	0.02
52	WS050000	Spring Washer	2
53	WS060000	Spring Washer	3
54	NH061000	Hex Nut	1

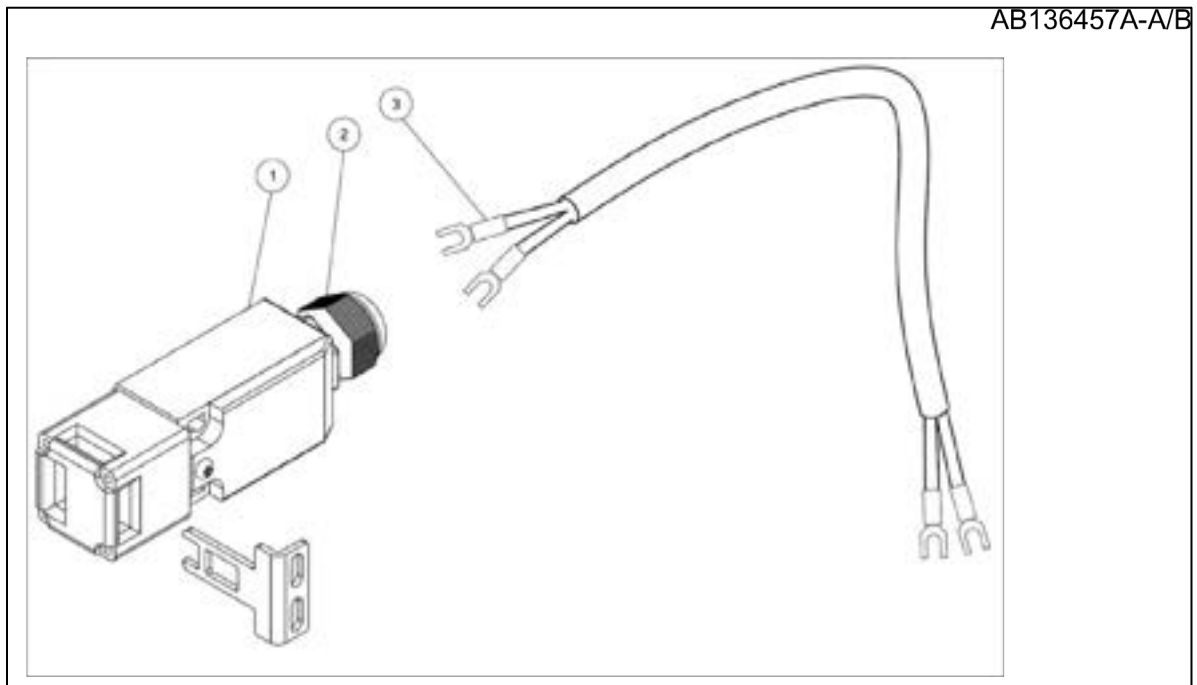


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ITEM	PART NUMBER	PARTS NAME	Q'TY
1	721048	Low side Sliding Bracket	1
2	BL210402	Linear Bearing	3
3	721052	Low side Shaft	1
4	BB600204	Ball Bearing	2
5	721051	Low side Spindle	1
6	721182	Six Hexagonal Column	2
7	721043	Spindle Cover	1
8	721061	Fixer Plate	1
9	VV101503	Wave-Type Gasket	2
10	721060	Adapter Shaft	1
11	721056	Plum Nut	1
12	721055	Adjustment Screw Pole	1
13	NH081300	Hex Nut	2
14	721063	Connection Plate	1
15	SM049200	Countersunk Head Cap Screw	2
16	721046	Flat Pulley	1
17	721042	Support Screw Pole	2
18	NH121900	Hex Nut	2
19	B9600004	Ball Bearing	1
20	721069	Profiling Wheel	1
21	721070	Wheel Spindle	1
22	RS100000	S-Type Ring	1
23	721066	Pressure Wheel Fixed Plate	1
24	721067	Pressure Wheel Fixed Plate	1
25	SJ059200	Round Socket Head Cap Screw	1
26	SM059200	Countersunk Head Cap Screw	1
27	SR050200	Cap Screw	2
28	SR050600	Cap Screw	2
29	NL050800	Hex Nut	2
30	721232	Disc Washers	6
31	SG059200	Hex Head Bolt (W/Flange)	2
32	721068	Spring Scratch Plate	1
33	721050	Dust Cover	1

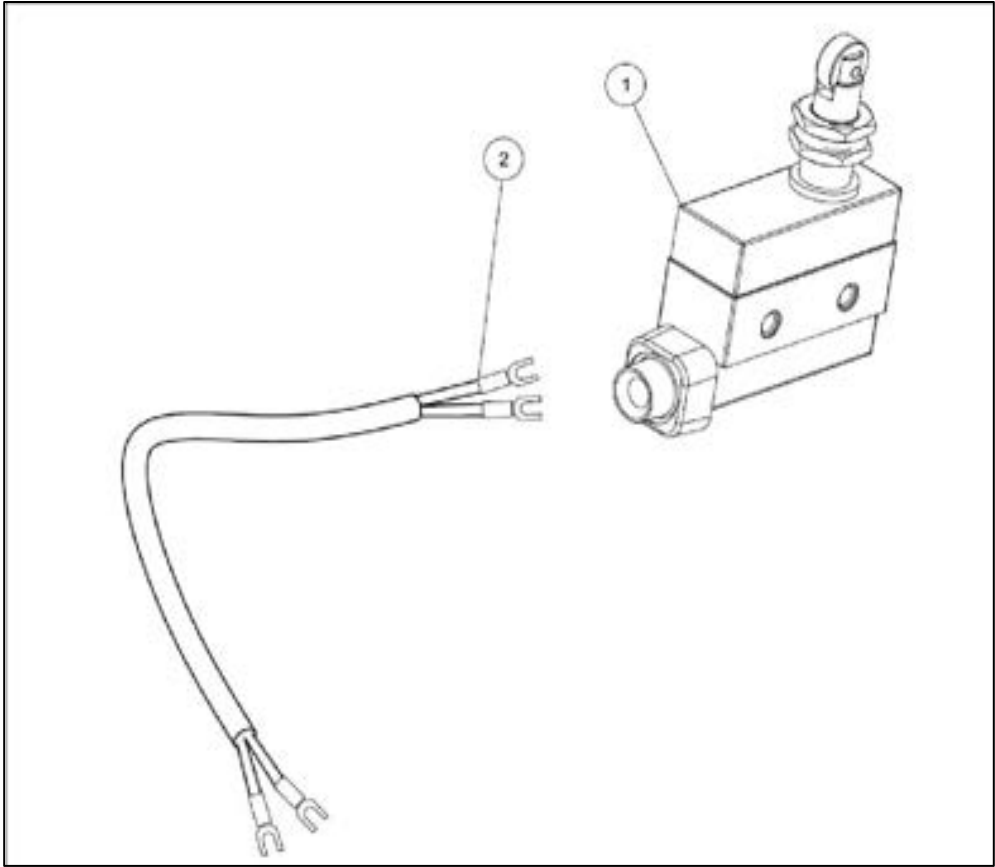
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34	SR050402	Cap Screw	1
35	721053	Lowside Tool	1
35A	AB721053A	Lowside Tool Set.	1
35A-1	721053A-1		1
35A-2	721053A-2		4
35A-3	721053A-3		4
36	721071	Lock Nut	1
37	721064	Position indicator	1
38	WS050000	Spring Washer	2
39	SR069400	Cap Screw	2
40	WF061620	Washer	2
41	SS069150	Set Screw	2
42	SR060400	Cap Screw	1
43	WS060000	Spring Washer	3
44	721072	ABS Strips	0.01
45	721073	Hairbrush	0.02
46	721065	Hex Nut	2



AB136457A-A/B

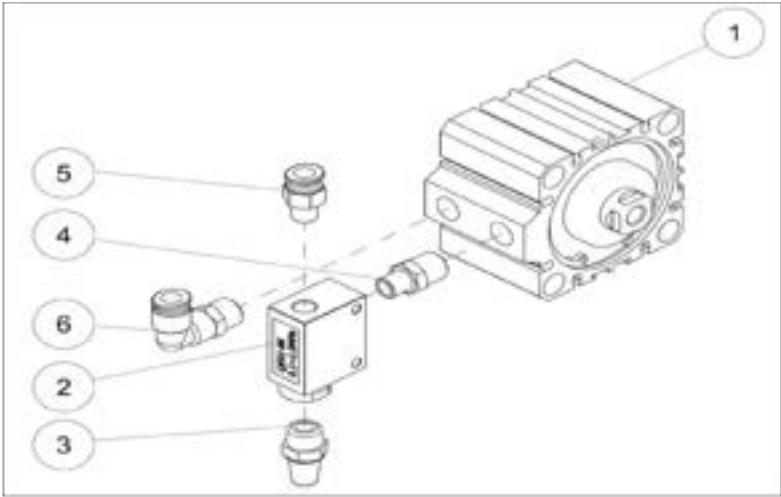
ITEM	PART NO	PARTS NAME	Q'TY
1	136457A	Door Safety Switch	1
2	709411	Outlet Beads	1
3	IC71008 or IC721009	Switch Cord	1



AB205397A-A/B

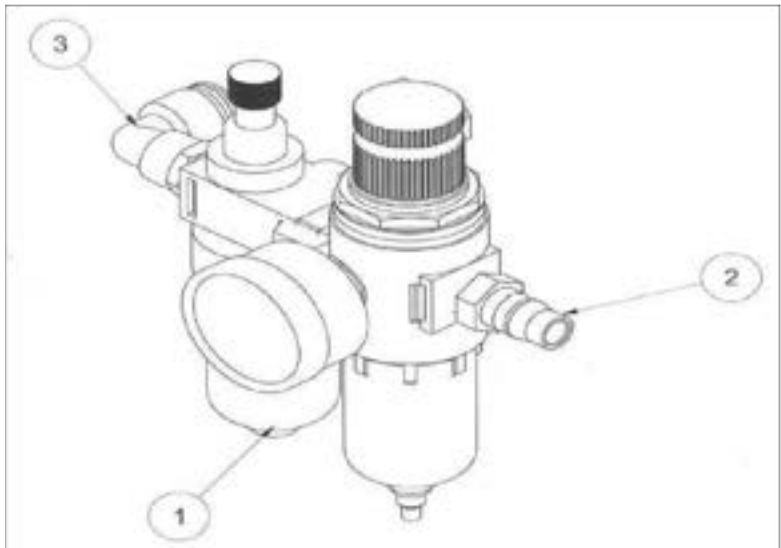
ITEM	PART NO	PARTS NAME	Q'TY
1	205397A	Limits Switch	1
2	C721007 or C721010	SWITCH CORD	1

AB721100
AB721367



AB721100

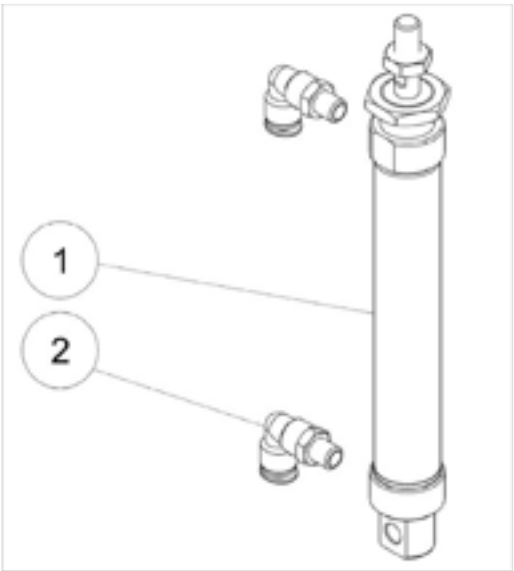
ITEM	PART NO	PARTS NAME	QTY
1	721100	Cylinders	1
2	721097	Rapid Exhaust Valve	1
3	721373	Valve Sflencer	1
4	721099	Adapter	1
5	721096	Threaded Through	1
6	721095	L-Type Joints	1



AB721367

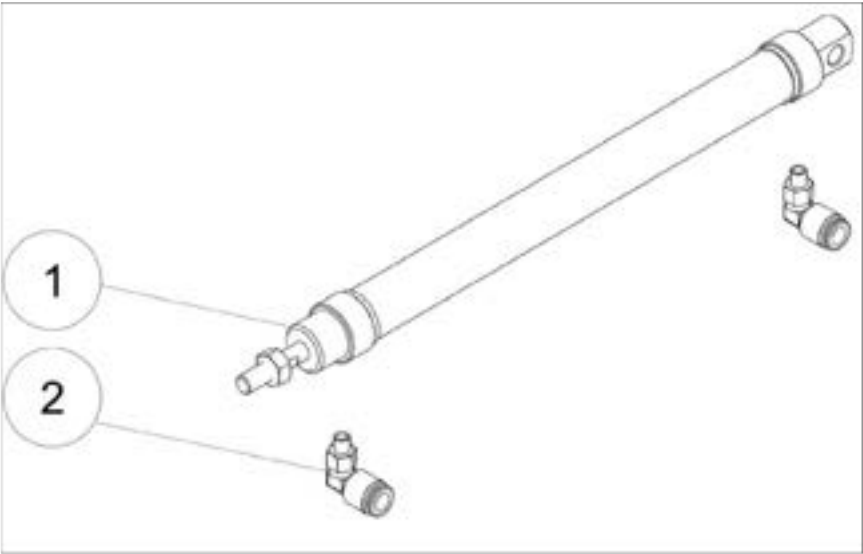
ITEM	PART NO	PARTS NAME	QTY
1	721367	Filter & Regulator + Lubricator	1
2	205744	C-Type Quick Joints	1
3	721357	L-Type Joints	1

AB721192
AB721203



AB721192

ITEM	PART NUMBER	PARTS NAME	QTY
1	721192	Pneumatic Cylinder	1
2	721193	Elbow 90°	2



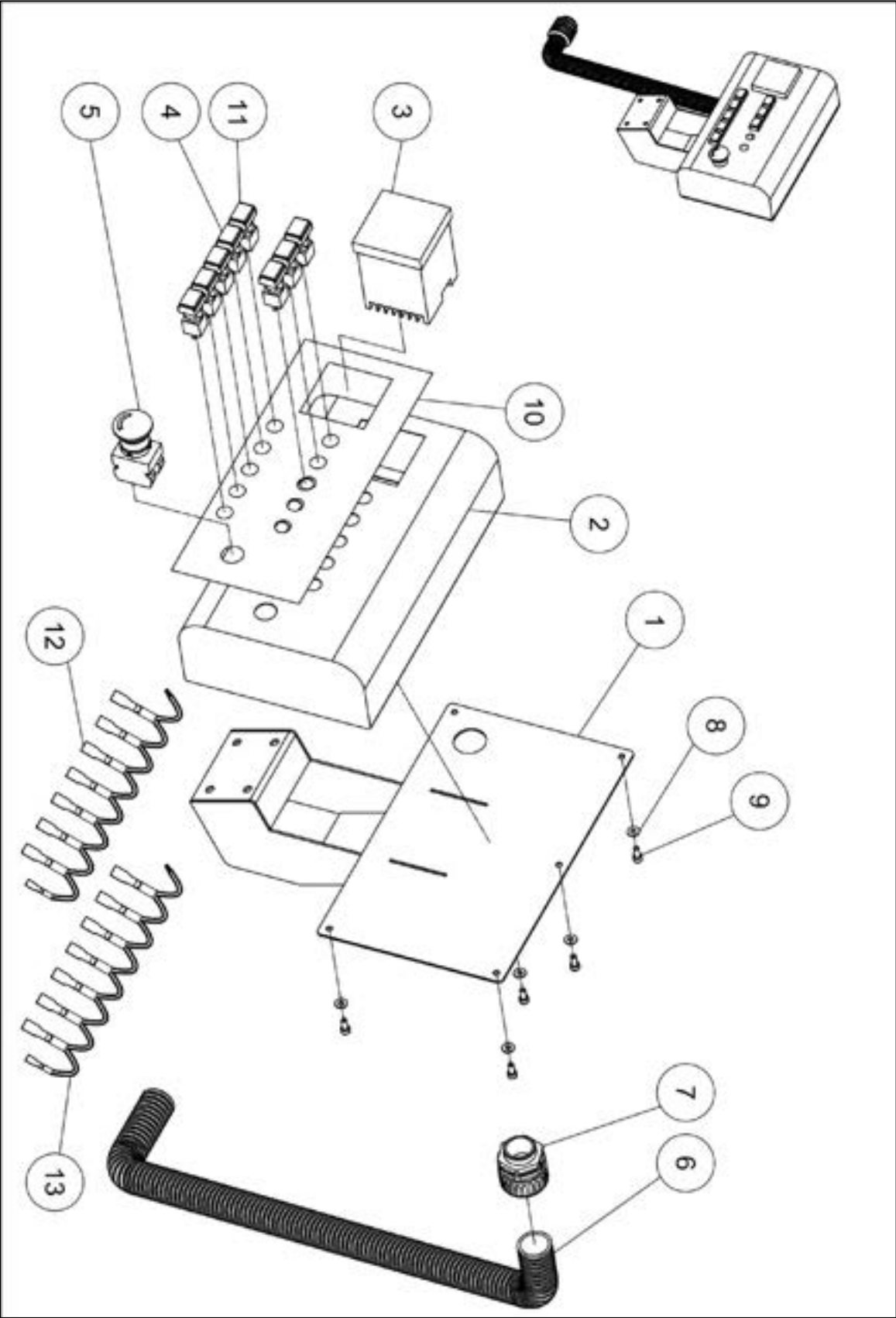
AB721203

ITEM	PART NUMBER	PARTS NAME	QTY
1	721203	Pneumatic Cylinder	1
2	721361	Elbow 90°	2



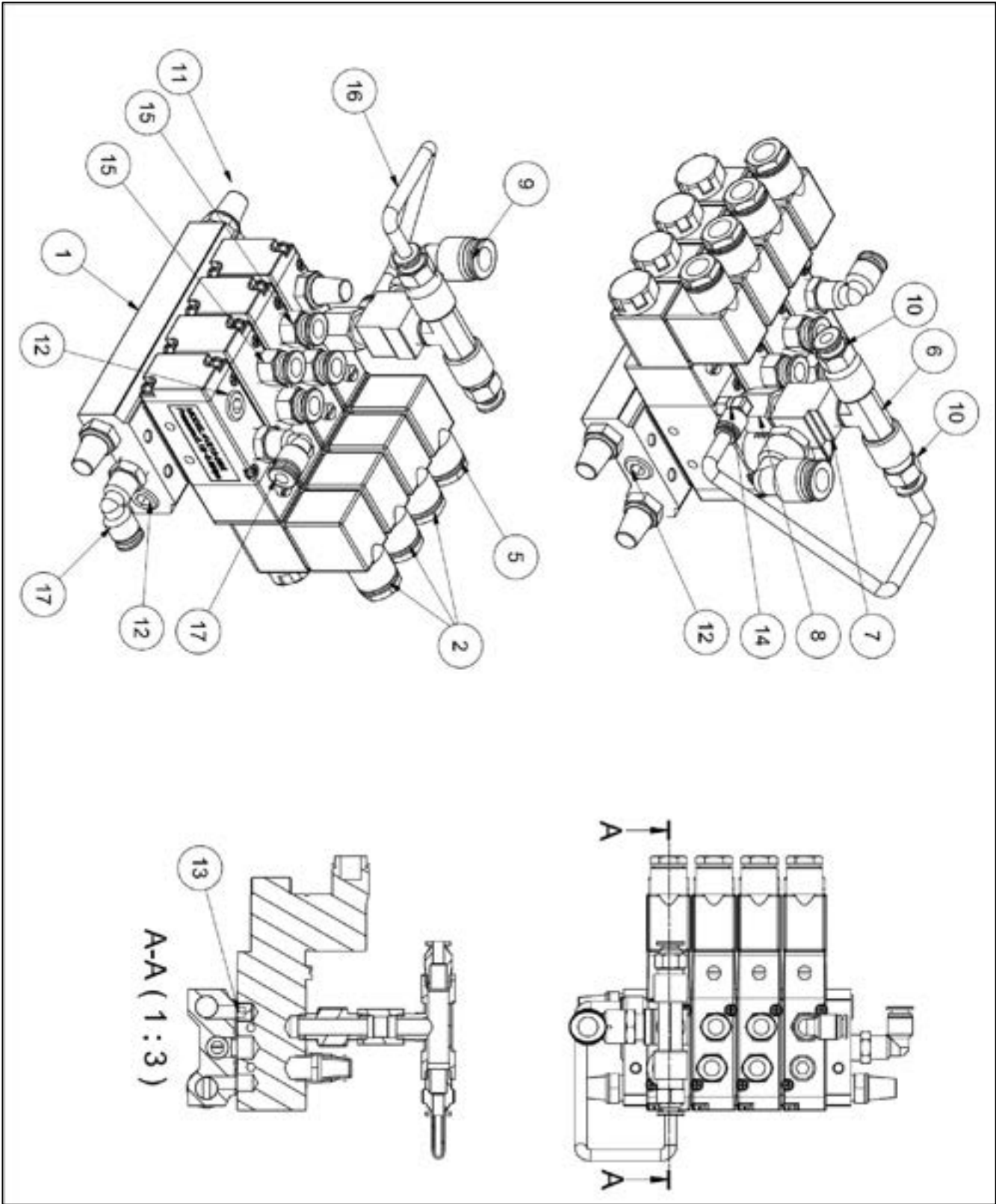
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ITEM	PART NUMBER	PARTS NAME	QTY	NOTES
1	721339	Circuit Plate	1	
2	205186	Aluminum Rail	0.32	160mm•2
3	205186	Aluminum Rail	0.31	310mm
4	205186	Aluminum Rail	0.4	400mm
5	205186	Aluminum Rail	0.27	270mm
6	207217-1	Transformer	1	
7	203756	Aluminum Rail Fix Plate	9	
8	205364	Ground Terminal	11	
9	203758	Terminal	39	
10	203755	Terminal	25	
11	721383	Motor Circuit Breaker	1	
12	205416	Fuse Holder	5	
13	721381	Programmable logic Controller	1	
14	ST040200F	Stainless Steel Tapping Screw	29	
15	721386	Ground Plate	1	
16	721389	Motor Circuit Breaker	2	
17	994761	Magnetic Contactor	7	
18	721385	RelayAC24V	1	
19	994942	Fuse 30mm	7	2pcs
20	721384	Bloq contact insert	4	
21	205180-01	Cable Tray	1.76	880mm•2
22	205180-02	Cable Tray Cover	1.76	880mm•2
23	205180-01	Cable Tray	0.18	180mm
24	205180-02	Cable Tray Cover	0.18	180mm
25	205180-01	Cable Tray	0.24	120mm•2
26	205180-02	Cable Tray Cover	0.24	120mm•2
27	203759	End Plate	2	
28	203757	End Plate	1	
29	SP059200	Pan Head Screw	3	
30	205416-02	Fuse Cover with Light	5	
31	203761	Jumper	8	
32	721391	Motor Circuit Breaker	1	
33	SF059200	Pan Head Screw (W/Flange)	1	
34	998627	Wiring clip holder	2	3/8"
35	995049	glass fiber hose	1	1000mm
36	995075	Terminal Number Marker	25	
37	995074	Terminal Number Marker	50	



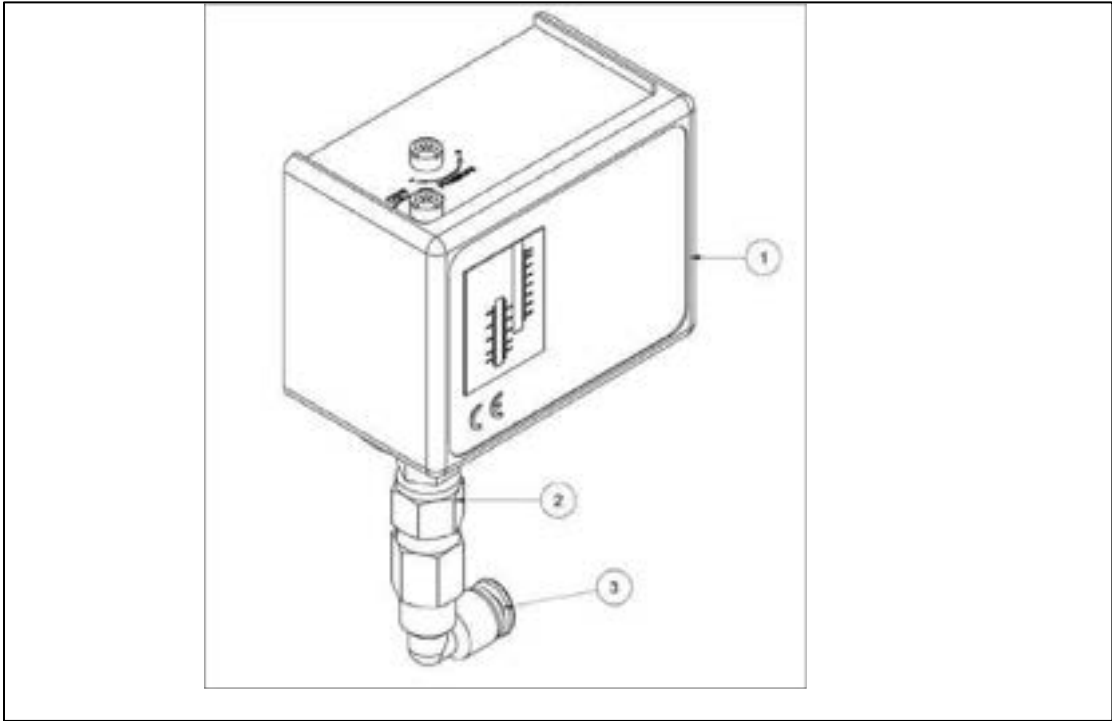
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ITEM	PART NUMBER	PARTS NAME	QTY	NOTES
1	721337	Control Box Stand	1	
2	721341	Control Box	1	
3	721387	Digital PIO Temperature Controller	1	
4	721388	Led Swatch	7	
5	994808	Stop Swatch	1	
6	204197	Wave Tube	0.7	700mm
7	998808	Wave Tube	1	
8	WF051210	Washer	5	
9	SR059300	Cap Screw	5	
10	LM721001	Label	1	
11	721397	Swatch	1	AC24V
12	IC721001	CONNECT CORD	1	24AWG
13	IC721002	CONNECT CORD	1	24AWG

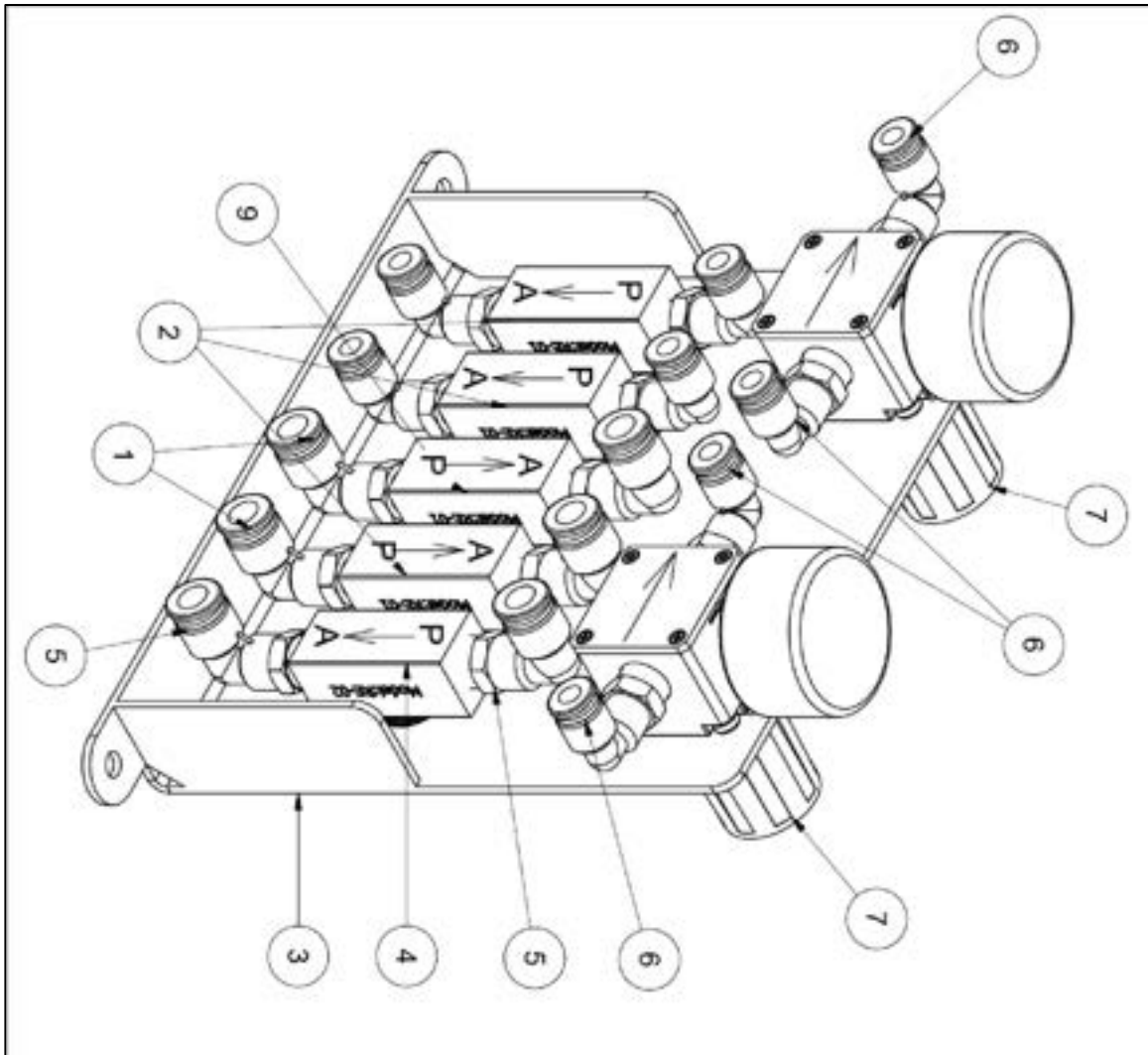


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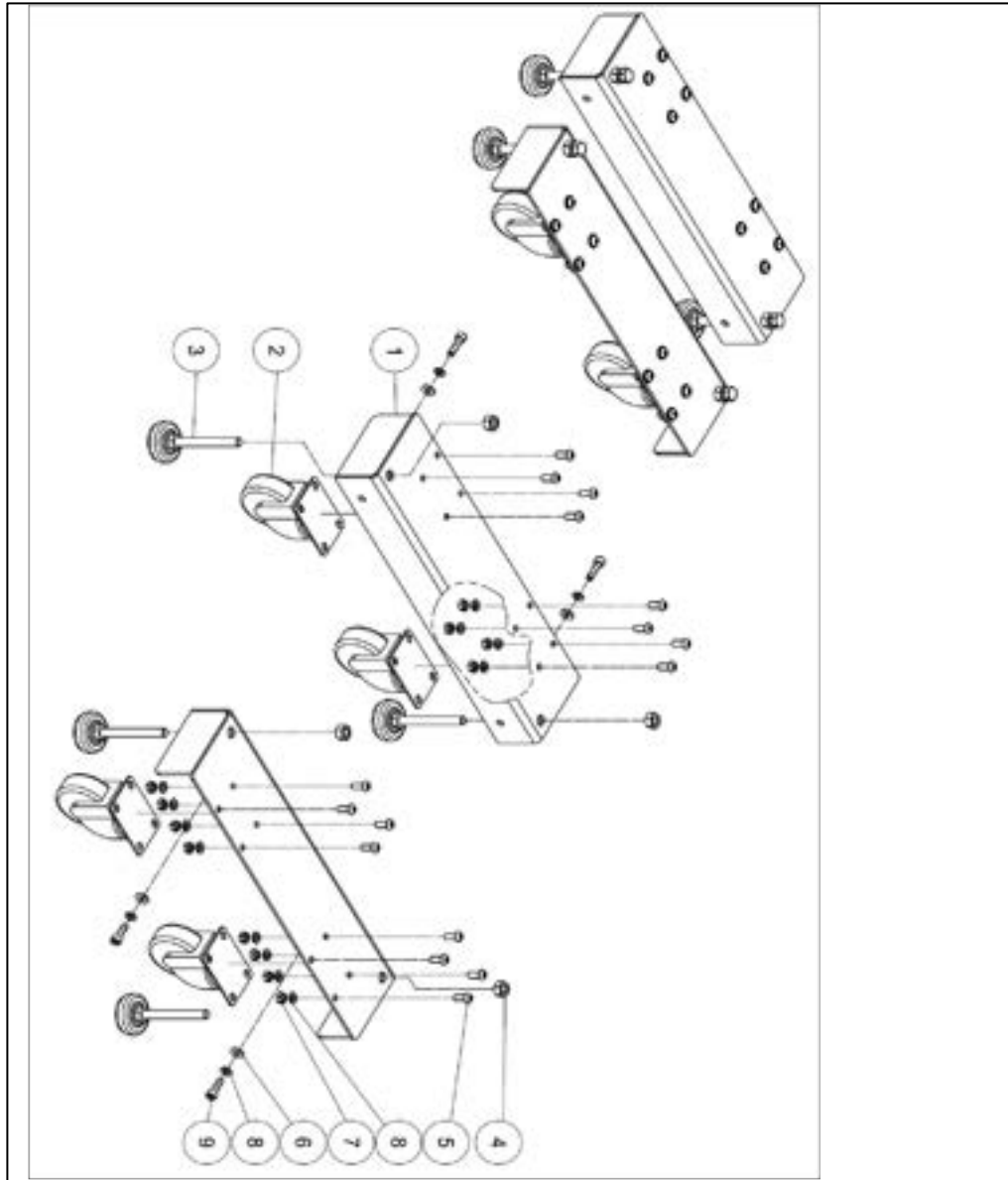
ITEM	PART NUMBER	PARTS NAME	QTY
1	721350	Aluminum Base	1
2	721351A	Solenoid Valve	3
3	SP030800	Pan Head Screw	8
4	WS030000	Spring Washer	8
5	721352A	Solenoid Valve	1
6	721354	T-Type Joints	1
7	721355	Joints	1
8	721356	Adapter	1
9	721357	L-Type Joints	1
10	721358	Threaded Through	2
11	721373	Valve Silencer	4
12	721359	Plug	3
13	721360	Plug	1
14	721361	L-Type Mini- Joints	1
15	721365	Threaded Through	4
16	721348B	Nylon Tube	0.18
17	721366	L-Type Joints	2



ITEM	PART NO	PARTS NAME	QTY
1	721364A	Pressure Switch	1
2	721362	Joints	1
3	721371	L-Type Joints	1



ITEM	PART NO	PARTS NAME	SIZE	Q"TY
1	721193	L-Type Joints	721193	4
2	721368	Aluminum Regulator	RE-01	3
3	721370	Fixed Plate		1
4	721369	Aluminum Regulator	RE-02	1
5	721095	L-Type Joints	EPL8-2	2
6	721366	L-Type Joints	EPC6-2	4
7	721353	Pressure Filter Regulator	4KG-PT1/4"	2
8	721372	L-Type Joints	EPL6-1	4
9	721363	Aluminum Regulator	ASC-01	1



ITEM	PART NO	PARTS NAME	Q'TY
1	721376	Roller Guard	2
2	721377	Roller	4
3	721378	Prevent Vibratility	4
4	NH121900	Hex Nut	4
5	SJ089400	Round Socket Head Cap Screw	16
6	WF081820	Washer	4
7	NH081300	Hex Nut	16
8	WS080000	Spring Washer	20
9	SH080400	Cap Screw	4

[illegible]

14.0 Warranties

Dealer Machinery Warranty

New woodworking machines sold by Laguna Tools carry a two-year warranty effective from the date of dealer invoice to customer/end-user. Machines sold through dealers must be registered with Laguna Tools within thirty (30) days of purchase to be covered by this warranty. Laguna Tools guarantees all new machines sold to be free of manufacturers' defective workmanship, parts, and materials. We will repair or replace, without charge, any parts determined by Laguna Tools, Inc. to be a manufacturer's defect. We require that the defective item/part be returned to Laguna Tools with the complaint. The end-user must request a Return Material Authorization (RMA) number from Customer Service. Include the RMA number with any and all returned parts/components requesting warranty coverage*. Any machines returned to Laguna Tools must be returned with packaging in the same manner in which it was received. A part or blade is being returned must have adequate packaging to ensure it is not damaged during shipping. In the event the item/part is determined to be damaged due to lack of maintenance, cleaning, or misuse/abuse, the customer will be responsible for the cost to replace the item/part, plus all related shipping charges. This limited warranty does not apply to natural disasters, acts of terrorism, normal wear and tear, product failure due to lack of maintenance or cleaning, damage caused by accident, neglect, lack of or inadequate dust collection, misuse/abuse or damage caused where repair or alterations have been made or attempted by others.

* The issue of an RMA number is for reference only; it DOES NOT indicate acceptance of the warranty claim.

CNC Limited Warranty

New CNC machines sold by Laguna Tools carry a one-year warranty effective from the date of shipping. Laguna Tools guarantees all new machines sold to be free of manufacturers' defective workmanship, parts, and materials. We will repair or replace, without charge, any parts determined by Laguna Tools, Inc. to be a manufacturer's defect. If the defective item/part is determined to be damaged due to lack of maintenance, cleaning or misuse/abuse, the customer will be responsible for the cost to replace the item/part, plus all related shipping charges. This limited warranty does not apply to natural disasters, acts of terrorism, normal wear and tear, product failure due to lack of maintenance or cleaning, damage caused by accident, neglect, lack of or inadequate dust collection, misuse/abuse or damage caused where repair or alterations have been made or attempted by others.

Laguna Tools, Inc. is not responsible for additional tools or modifications sold or performed (other than from/by Laguna Tools, Inc.) on any Laguna Tools, Inc. woodworking machine. Warranty may be voided upon the addition of such described tools and/or modifications, determined on a case-by-case basis. Software purchased through Laguna Tools, Inc., is not covered under this warranty and all technical

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support must be managed through the software provider. Normal user alignment, adjustment, tuning, and machine settings are not covered by this warranty. It is the responsibility of the user to understand basic woodworking machinery settings and procedures and to properly maintain the equipment in accordance with the standards provided by the manufacturer.

Parts under warranty are shipped at Laguna Tools, Inc.'s cost either by common carrier, FEDEX ground service, or a similar method. Technical support to install replacement parts is primarily provided by phone, fax, e-mail or Laguna Tools Customer Support Website. The labor required to install replacement parts is the responsibility of the user. Laguna Tools is not responsible for damage or loss caused by a freight company or other circumstances not in our control. All claims for loss or damaged goods must be notified to Laguna Tools within twenty-four (24) hours of delivery.

Please contact our Customer Service Department for more information. Only NEW machines sold to the original owner are covered by this warranty.

For warranty repair information, call 1-800-332-4094.

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No Modifications Allowed or Sold

Laguna Tools, Inc. is not responsible for additional tools or modifications sold or performed (other than from/by Laguna Tools, Inc.) on any Laguna Tools, Inc. woodworking machine. Warranty may be voided upon the addition of such described tools and/or modifications, determined on a case-by-case basis.

Normal user alignment, adjustment, tuning, and machine settings are not covered by this warranty. It is the responsibility of the user to understand basic woodworking machinery settings and procedures and to properly maintain the equipment in accordance with the standards provided by the manufacturer. Parts, under warranty, are shipped at Laguna Tools, Inc.'s cost either by common carrier, FEDEX ground service or a similar method. Technical support to install replacement parts is primarily provided by phone, fax, e-mail, or Laguna Tools Customer Support Website. The labor required to install replacement parts is the responsibility of the user. Laguna Tools is not responsible for damage or loss caused by a freight company or other circumstances not in our control. All claims for loss or damaged goods must be notified to Laguna Tools within twenty-four (24) hours of delivery. Please contact our Customer Service Department for more information. Only new machines sold to the original owner are covered by this warranty.

For warranty repair information call 1-800-332-4094.

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Laguna Tools Warranty

WARRANTY & REGISTRATION

Thank You!

Welcome to the Laguna Tools® group of discriminating industrial machinery owners. We understand that you have a choice of where to purchase your machines and appreciate the confidence you have in the Laguna Tools® brand.

Through hands-on experience, Laguna Tools® is constantly working hard to make innovative, precision products. Products that inspire you to create works of art are a joy to operate and encourage your best work.

Laguna Tools®
Imagination, Innovation, and Invention at Work

Warranty & Registration

Every product sold is warranted to be free of manufacturer's defective workmanship, parts, and materials. For any questions about this produce, the intended use or what it was designed for, customer service, or replacement parts, please contact our customer service department:

Laguna Tools® Customer Service
744 Refuge Way, Grand Prairie, Texas 75050, USA
1-800-234-1976
customerservice@lagunatools.com
www.lagunatools.com/why/customer-service/
8AM To 5PM PST, Monday through Friday

For warranty claims or to report damage upon receiving please reach out to our warranty department:

Laguna Tools® Warranty Service
744 Refuge Way, Grand Prairie, Texas 75050, USA
1-800-234-1976
customerservice@lagunatools.com
www.lagunatools.com/policies/warranty/
8AM to 5PM PST, Monday through Friday

Registration

To prevent voiding this warranty, all products sold must be registered within thirty (30) days of receiving the product. Registering the product will enable the original purchaser to receive notifications about important product changes, receive customer service, and be able to file a warranty claim against defective workmanship, parts, or materials.



Who is Covered

The applicable warranty covers only the initial purchaser of the product from the date of receiving the product. To file such claims, the original purchaser must present the original receipt as proof of purchase.

What is Covered

The warranty covers any defects in the workmanship of all parts and materials that make up the machine unless otherwise specified. Any part determined by Laguna Tools® to have a defect will be repaired or replaced (and shipped), without charge. The defective item/part must be returned to Laguna Tools® with the complaint and proof of purchase in the original packaging that it was received in. In the event the item/part is determined to be not covered by this warranty, the customer will be responsible for the cost to replace the item/part and all related shipping charges.

Warranty Limitations

This limited warranty does not apply to natural disasters, acts of terrorism, normal wear and tear, product failure due to lack of maintenance or cleaning, damage caused by accident, neglect, or lack of adequate dust collection. The warranty may be voided against proof of misuse/abuse, damage caused where repair or alterations have been made or attempted by others, using the product for purposes other than those described as intended use (unless with consent by Laguna Tools®), modification to the product, or use with an accessory that was not designed for the product. It is the responsibility of the user to understand basic woodworking machinery settings and procedures and to properly maintain the equipment in accordance with the standards provided in this manual.

Length of Warranty

All new machines and optional accessories sold through an authorized dealer carry a two-year warranty effective from the date of receiving the product. Machines sold for either commercial or industrial use have a one-year warranty. Wearable parts like throat plates, bandsaw guides, etc., have a ninety-day warranty.

Table A-1 Warranty Lengths

2 Year – New Machines Sold Through an Authorized Dealer
2 Year – Accessories Sold as Machine Options (excluding blades)
1 Year – Machines Sold for Commercial or Industrial Use
1 Year – Blades and Accessories outside of Machine Options
90 Days – Wearable Parts

Aside from being free of defects upon receiving, consumable parts, like cutters and abrasives, are not covered by this warranty unless otherwise stated by Laguna Tools®. These parts are designed to be used at the expense of the operator and are available for replacement or inventory purchase. The determination of a consumable part will be made on a case-by-case basis by Laguna Tools®.

Shipping Damage

Laguna Tools® is not responsible for damage or loss caused by a freight company or other circumstances not in the direct control of Laguna Tools®. All shipping-related claims for loss or damage to goods must be made to Laguna Tools® within twenty-four hours of delivery.

How to Receive Support

To file a warranty claim, please contact the warranty department at 1-800-234-1976. To receive customer service or technical support, please contact the customer service department at 1-800-332-4094. Parts, under warranty, are shipped at the expense of Laguna Tools® either by common carrier, FedEx ground services or similar method. Technical support to install replacement parts is primarily provided by phone, fax, email, or the Laguna Tools® Customer Service Support Website.



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Laguna Tools, Inc.

744 Refuge Way, Suite 200

Grand Prairie, TX 75050

1-800-234-1976

www.lagunatools.com

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