

SmartEdge Compact Edgebander Owner's Manual



LAGUNA

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Scope of This Manual

This manual outlines the basic procedures for the SmartEdge Compact Edgebander.

For detailed instructions and videos, please go to www.lagunatools.com. Refer to www.lagunatools.com for the latest manual revision.

Customer Service

For technical support, please contact Laguna Tools Customer Service by phone 1-800-332-4094.

In the space provided, record the serial number, model number, and install date of the machine.

Serial No.	
Model No.	
Install Date:	

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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 and 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. Refer to www.lagunatools.com for the latest manual revision.

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 not be modified nor used for any application other than its intended use.

PERSONAL SAFETY IS THE RESPONSIBILITY OF THE OPERATOR.

1.2 Safety Signs and Callouts

Safety signs and callouts draw attention to potential hazards during machine operation. This Owner's Manual uses the following callouts to indicate the importance of each safety message.



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, could result in death or serious injury.



CAUTION

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

NOTE

A helpful tip from Laguna Tools technical staff.

1.3 Proposition 65 Warning of Harmful Exposure

Some dust created by sanding, sawing, grinding, drilling, machining, and other construction activities contains chemicals known to the state of California to cause cancer, birth defects, or other reproductive harm. Some examples of these chemicals are:

- Lead from lead-based paint.
- Crystalline silica from bricks, cement, and other masonry products.
- Arsenic and chromium from chemically treated lumber.



DANGER

Fire Warning

Use extreme caution when working with flammable materials such as wood or acrylic, as they are more volatile than other materials.

Keep the machine clean and follow the maintenance schedule.

Always have a fire extinguisher ready to extinguish a fire.

Never leave the machine running unattended.

The tools sold by Laguna Tools are safe when used properly, as described by the American National Safety Institute, the UL Standards of safe tool use, and the IEC standards of safe tool use. Laguna Tools is in no way responsible for injury or death that occurs while using this product.

The risk of exposure varies depending on frequency of use. To reduce exposure to these chemicals, work in a well-ventilated area and work with approved safety equipment, such as face or dust masks that are specifically designed to filter out microscopic particles. For more information go to <https://www.p65warnings.ca.gov/>.

1.4 Intended Use

The machine is designed to apply edge banding materials, like veneer, laminate, or plastic, to the edges of wood panels and boards in order to enhance their appearance. Do not use this machine for anything other than its intended use.

1.5 Safety Information

The machine is an electrical appliance and precision machine. Please read and understand the entire owner's manual before attempting assembly or operation. Read and understand the warnings posted on the machine and in this manual. Failure to comply with all warnings may cause serious personal injury or damage to the machine.

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The machine is designed and intended for use by properly trained and experienced personnel only. Personnel who are not familiar with the correct and safe operation of the machine should not operate the machine until properly trained.

1. Never operate machinery under the influence of drugs or alcohol, when tired, or when distracted.
2. Stay alert at all times while operating the machine.
3. Always wear safety glasses and hearing protection.
4. 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.
5. Never stand on the machine. Serious injury may occur if the machine is tipped or if the cutting tool is unintentionally contacted.
6. Know where the emergency stop switch is located.
7. 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.
8. Use the machine only in clean areas free from excessive moisture or flammable objects.
9. Keep the working area clean and ensure adequate lighting is available.
10. Cables and cords should be inspected regularly.
11. Do not attempt to exceed the limits of the machine.
12. Keep the machine, electrical cabinet, and cables away from excessive heat, flammable substances, and sharp objects.
13. Keep the machine, electrical cabinet, and surrounding area clear of obstructions and free from excessive moisture.
14. Safety Signs should be attached to places that are easy to spot.
15. 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.
16. Exercise care with machine controls and around keypad to avoid unintentional start-up.
17. The machine must be level. Level the machine if the ground is uneven.

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18. Ensure the keys and adjusting wrenches have been removed and all the nuts and bolts are secured.
19. Keep cutting tools clean and sharp.
20. Do not use dull, gummy, or cracked cutting tools.
21. Lubricate and change accessories when necessary.
22. Keep controls clean and dry.
23. Consult the Owner's Manual or contact Laguna Tools for recommended accessories. Using improper accessories will increase the risk of serious injury or damage.
24. Keep a copy of this manual for future reference.
25. All motion parameters have been set up by Laguna Tools. If any modifications are required, please have a qualified operator perform the changes.

1.5.1 Shop Environment

1. Verify the floor can bear the weight of the machine and workpieces.
2. Ensure the floor around the machine is clean and free of scrap material, oil, and grease.
3. Do not lean material against the gantry, guide rails, or table.
4. Support the weight of the dust hose attached to the dust shoe (optional) accessory to prevent the weight of the hose from dislodging the dust shoe. Ensure that there is sufficient slack in the dust collection hose to allow the spindle to cover the entire work area.
5. Position the machine away from overhead pipes and plumbing fixtures to prevent condensation from dripping on to the spoil boards and control system components.
6. Locate the machine away from sinks, faucets, or other water supplies or storage to prevent splash-out that can damage the spoil boards and control system components.
7. Provide adequate room between this machine and other machines in the shop to reduce the chance of accidental jarring when transporting lumber or other heavy materials through the shop and while materials are being worked on other machines.
8. Verify there is adequate space between machines to allow for the possibility the workpiece will extend over the end of the machine.
9. 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.

10. Store cutting tools in a dry location and prevent contact to preserve the cutting edge.

1.5.2 Health and Safety

1. Always wear approved personal health and safety equipment as indicated for the materials and type of operations that will be performed. These should include face, eye, respiratory, hearing, and body safety protection devices. Wear safety glasses/face shield and ear protectors (plugs or muffs) even during short periods of operation.
2. Before operating this machine: remove all hand, wrist, or neck jewelry and push sleeves up over the elbows. Do not wear loose clothing which may become caught in the machine and confine long hair. Non-slip footwear or anti-skid floor strips are recommended.
3. Use a dust mask or other safeguards to avoid inhaling dust generated from wood products. Install dust collection equipment consistent with shop ventilation practices and budget. Remove dust and debris from the floor frequently to prevent slipping. Drilling, sawing, sanding, or machining wood products generates wood dust and other substances known to the State of California to cause cancer. Wood products also emit chemicals known to the State of California to cause birth defects or other reproductive harm (California Health and Safety Code Section 56).
4. In addition to other health hazards, dust from wood and other materials is flammable. Do not operate welding, wood burning, smelting, soldering, or other high-heat tools on the machine or vicinity.
5. Do not operate this machine while tired or under the influence of drugs, alcohol, or any medications.

1.5.3 Electrical Safety

1. Verify the switch is in the OFF position before connecting the machine to the power supply.
2. Verify the machine is properly grounded and the circuit is protected with a fuse or circuit breaker in accordance with local codes. Install a separate circuit if necessary to limit power loss when multiple machines in the shop are operating simultaneously. If necessary, place a cover on the outlet to prevent accidental disconnection.
3. Verify all machine adjustments or maintenance with the machine unplugged from the power source.
4. Follow effective lockout procedures to reduce the risk from high voltage wires and components and prevent accidental operation.
5. Do not operate in a damp or wet location or exposed to rain, fog, or snow.

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6. Keep the electrical cord away from sharp edges, heat or moving parts, and do not store materials on top of it. Position the cord so it will not become a tripping hazard.
7. While the use of an extension cord is discouraged, if it is necessary, verify the cord is in good condition, meets the current requirements, and is located so as not to present a tripping hazard.

1.5.4 Additional Safeguards

1. Remove and store adjusting keys and wrenches before turning on the power. If necessary for visibility, apply safety markings to adjusting wrenches and keys.
2. Install safety guards consistent with general shop safety practices. Always keep safety guards in place when the machine is in use. If removed for maintenance purposes, use extreme caution, and replace the guards immediately after completion of maintenance.
3. Check damaged parts immediately. Before further use of the machine, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function.
4. Keep visitors a safe distance from the work area. Keep children away.
5. Control liquids in the shop to limit the possibility of spillage that can damage the machine and potentially cause damage or personal injury from electric shock or fire. Never use the table to apply or dry finishes.

1.5.5 Maintenance

1. Disconnect the machine from power when performing any maintenance.
2. Establish a weekly and monthly maintenance checklist and follow it diligently.
3. Routine maintenance should include periodic checks for alignment of moving parts, looseness, or binding of moving parts, worn or bare wires, breakage of parts, skewed mounting, and any other conditions that may affect its operation or cause injury. Analyze breakage or damage to determine the cause and take appropriate remedial action.
4. Do not operate the machine if a component of the control system is damaged. It should be properly repaired or replaced before use.
5. Follow instructions for lubricating and changing accessories.
6. Store maintenance tools and supplies nearby, consistent with the shop maintenance practices and resources.

1.5.6 Operational Practice

1. Never leave the machine running unattended. Always be in close reach of the emergency stop button.
2. Turn off the power and do not leave the machine until it comes to a complete stop.
3. Avoid pinch points and entanglement hazards. Keep hands and clothing away from any moving objects, rotating/moving cutting tools, ball screws, bearings, gantries, guide rails, and any other hazards while in operation.
4. Use the right tool at the correct speed and feed rate. Do not force a tool or attachment to do a job for which it was designed. The right tool will do the job better and more safely.
5. Do not touch a cutting tool immediately after use. It will be hot and may cause skin burns. Exercise caution when handling any cutting tool and accessories. If the cutting tool is hot, keep a heat-resistant glove or oven mitt on hand for this purpose.
6. Do not lay a hot cutting tool on its side.
7. Use recommended accessories; improper accessories may be hazardous.
8. Do not use dull, gummy, or damaged cutting tools such as blades, bits, etc. Keep cutting tools clean and sharp for the best and safest performance.
9. Turn off the machine before cleaning. Use a vacuum, brush, or compressed air to remove chips or debris. Do not use bare hands.
10. Do not climb or stand on the machine. Serious personal injury and costly damage could occur if the machine tips over or any component is dislodged.
11. Remove loose items and unnecessary workpieces from the table before starting the machine.
12. Inspect the material of the workpiece to detect any defects that may result in ejection of large pieces of scrap.
13. Verify the workpiece is free from nails, hardware, or other foreign objects.

[illegible]

2.0 Electrical Requirements & Components

This machine 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.

WARNING

All electrical components must be performed by a qualified electrician and follow any local codes and ordinances. Failure to comply may result in serious injury.

2.1 Grounding Instructions

Laguna Tools CNC machines must be grounded. This grounding provides a path of least resistance for electrical current, which during a malfunction will reduce the risk of electrical shock.

All CNC machines are equipped with an electrical cord with grounding conductor and plug. The plug must be used with a matching outlet that is properly installed and grounded in accordance with local codes and ordinances.

These plugs must not be modified, if a matching outlet is needed, one must be installed by a qualified electrician.

Improper installation may result in electrical shock.

WARNING

If grounding instructions are not completely understood or if in doubt as to whether the machine is properly grounded, a qualified electrician should be consulted.

The use of extension cords is discouraged. It is recommended to place the machines as near to the power source as possible.

WARNING

Consult a certified electrician for any wiring or extension cord concerns

3.0 Definitions

1. **Edgebander:** A machine used to apply edgebanding materials to the edges of panels, such as plywood, particleboard, or MDF, to create a finished look and protect the edges.
2. **Hot Melt Adhesive:** A thermoplastic adhesive used in edgebanders, activated by heat to bond the edgebanding material to the panel.
3. **Glue Pot:** A component of the edgebander where the hot melt adhesive is heated and stored before application.
4. **Trimming Unit:** A part of the edgebander that trims excess edgebanding material to ensure a clean finish.
5. **Buffing Unit:** A component that polishes the edges after the edgebanding is applied, giving a smooth and finished appearance.
6. **End Trimming Unit:** A unit that trims the ends of the edgebanding to match the panel's dimensions.
7. **Edge Scraping Unit:** A component that scrapes off any excess adhesive or material from the edges.
8. **Dust Collection System:** A system integrated into the edgebander to collect dust and debris generated during the edgebanding process.

4.0 Compressed Air Requirements

This machine requires compressed air different stations. 87 PSI of clean dry air is required.

NOTE

It is recommended to attach an air dryer to the compressed air system to help reduce moisture in the lines.

Moisture in the lines can cause damage to the machine and reduce the supplied air quality.

5.0 Specifications

SmartEdge Compact Edgebander Specification Table	
Dust Collection CFM Requirements	20 CFM (cubic feet per minute)
Compressed Air requirements	14 CFM at 90 PSI
Power Requirements	220 V, 60Hz, 50A, 3 Phase
Sealing Belt Thickness	.01"–.11"(.4 – 3mm)
Feed Speed	630"–946" in/min (16–24m/min)
Panel Thickness	.4"–1.96"(10–50mm)
Panel Length	5.9" (150mm)
Panel Width	1.96" (50mm)
Dust Port Outer Diameter	4 ³ / ₄ " (121mm)
Minimum Panel size (W x L)	2.3" x 11.8" , 5.9" x 5.9" (60 x 300mm , 150 x 150mm)
Machine Dimensions (L x W x H)	15' x 5' x 8' (4572mm x 1524mm x 2438.5mm)
Recommended Working Area (L x W)	20' x 10' (2743mm x 2438mm)
Machine Weight	3800 lbs (1724kg)
Controller	Delta Touchscreen Controller

6.0 Receiving the Machine

Following delivery and before the driver has 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 forks or fork extensions.

7.0 SmartEdge Compact Overview

The SmartEdge Compact is a multifunctional edge banding machine. It is equipped with the addition of , this machine has all the features you've come to expect from a Laguna Edgebander. This machine can apply a perfect edge finish for you every time.

7.1 Features

- End Cutting
- Top & Bottom Trim
- Buffing
- Corner Scrapping



1. **Viewer Window** – This window allows an operator to safely view the edgebanding process. This window also opens up if maintenance is needed.
2. **Glue Pot**– The glue pot is a container that holds the glue. CAUTION! HOT!
3. **Touchscreen Controller** – This controls the edgebander functions.

**All images in this manual are for reference only; your machine may vary slightly, but all steps and concepts still apply*

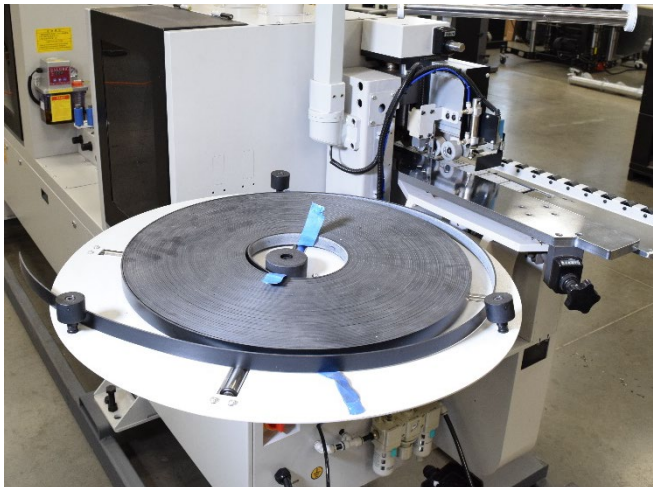
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7.1.1 Control Panel



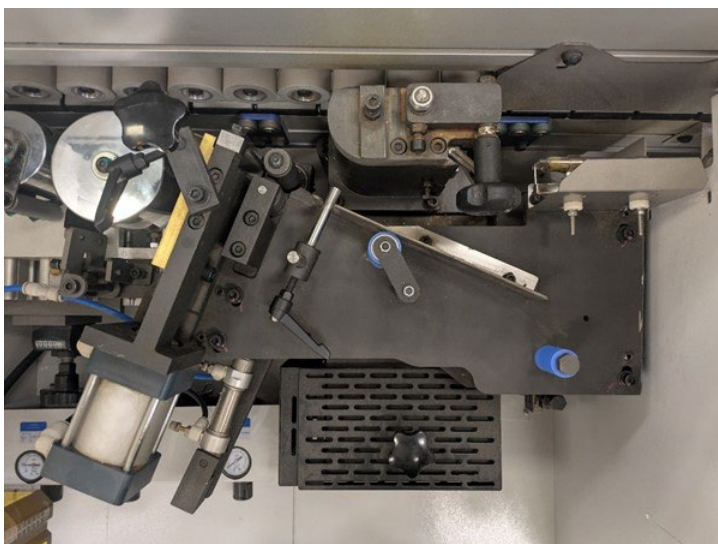
The control panel allows an operator to engage various stations, adjust temperature, change settings, and troubleshoot equipment.

7.1.2 Material Support



The material plate holds the edgebanding and helps to align it with material.

7.1.3 Feeding & Gluing Station



This station is responsible for feeding, gluing, and cutting.

This is the most intricate and complex component of this machine. It's recommended to have a thorough understanding of this component and all associated adjustments.

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7.1.4 Pressure Rollers



The pressure rollers are pneumatically charged and responsible for ensuring a bond between edgebanding and material.

7.1.5 End Cutting Station



This station cuts the excess edgebanding from the material ends. This station is activated by a switch at the front of the machine. Dust will be sucked vertically into the dust collection system and edgebanding pieces will fall into the collection tray below.

7.1.6 Corner Scrapping Station



The Scrapping Station removes the small amount of leftover wood particles produced from the Fine Trimming Station. The amount of material removed during scrapping can be as small as 100 microns in thickness.

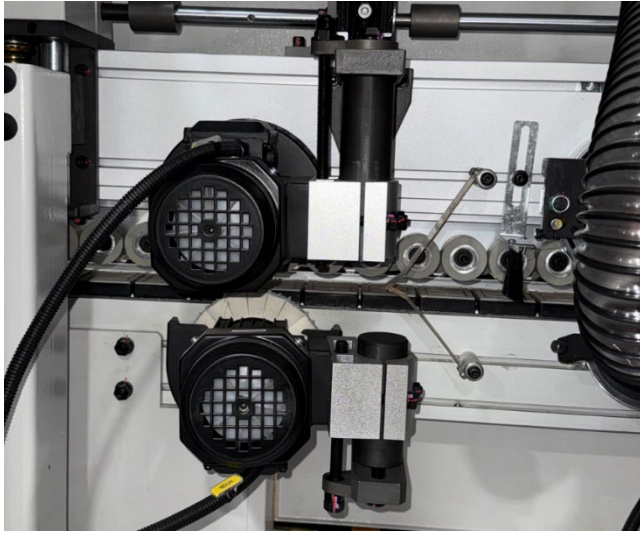
7.1.7 Trimming Station



The Trimming Station cuts excess material from the edge, creating a smooth rounded profile. The cutter can be oriented to produce a flat or rounded over profile depending on material thickness and type. For example, real wood is thin and would be cut with a straight cut, whereas thicker synthetic materials can support rounded edges.

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7.1.8 Buffing Station



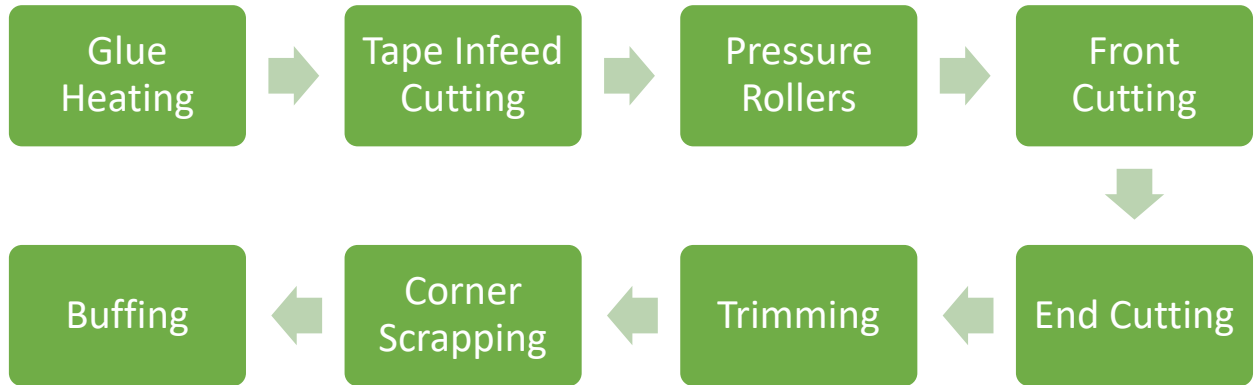
The Buffing Station removes excess glue residue from the surface of the material, while simultaneously buffing the edgebanding to a shiny finish. The buffing pads need to be replaced frequently, as glue residue builds up on the pads.

7.1.9 Material Conveyor



The conveyor is driven by a large motor and idle pulley that help rotate numerous individual track pieces. These track pieces slide along rails the length of the machine. Large amounts of friction and force is exerted onto these components and regular maintenance is critical to prevent premature failure. The secondary feed support should be utilized whenever possible to avoid twisting material in the conveyor system.

8.0 Edgebanding Process



9.0 Setup and Assembly

Please carefully read and understand all setup and assembly instructions before beginning this procedure.

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.

DANGER

DO NOT plug in the machine until setup and assembly is complete.

9.1 Machine Placement

When unpacking the machine, 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.

9.2 Placement

Select the area where the Machine will be operated. The physical environment where the Machine is located is important to safe assembly and operation. Before removing the Machine 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 a safe exit path in the event of an emergency.
2. Select a solid level floor rated to hold the weight of the Machine and workpieces under both static and dynamic loads. Laguna Tools recommends concrete flooring. Consult a licensed and experienced professional if in doubt.

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3. Locate the Machine near a power source and dust collector.
4. Allow an area for the storage of workpiece materials, finished products, and tools.
5. Leave ample space around the machine for the operator to handle both the equipment and the materials being cut.
6. Leave enough space around the machine to open or remove doors/covers as required by the maintenance described in the Owner's Manual.

9.3 Dust Collection

Allow enough space for proper dust collection from the machine. For optimal operation, ensure that the machine is located in a dry environment free from excessive moisture, extreme weather conditions, hazardous chemicals, or airborne abrasives.

9.4 Unloading and Unpackaging 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 | 3. Heat shrunk in plastic |
| 2. In a box | 4. Sitting on a pallet |

BEFORE unpacking your machine, inspect the packaging, invoice, and the shipping documents supplied by the driver. When unpacking the machine, verify there are no signs of damage to the parts or machine you have received.

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

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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/cabinets around the machine, it cannot be installed or serviced in the future if necessary.

Tools needed:

- Crowbar or prybar
- Forklift (6000 lb) pallet jack
- Drill with Phillips, torx, flathead, or Allen head bit.
- Tin snips

This machine can be transported with a manual or power forklift. The load bearing should be 3 tons or above. The methods of transportation are as follows:

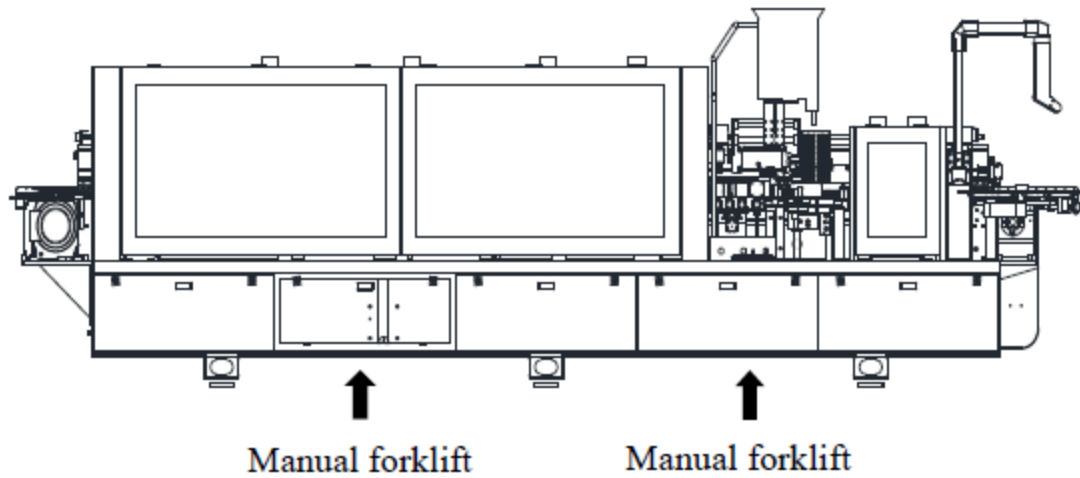


Figure 9–1: Method 1

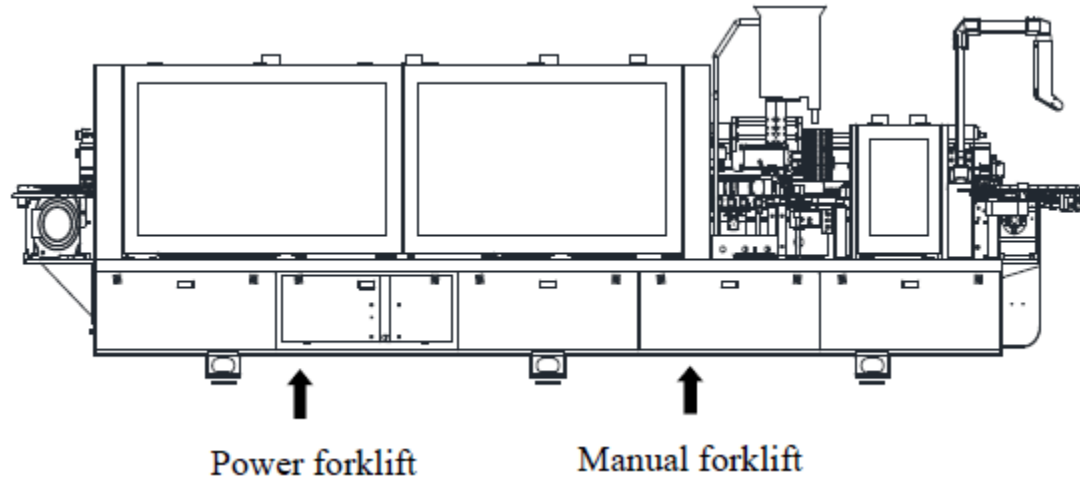


Figure 9–2: Method 2

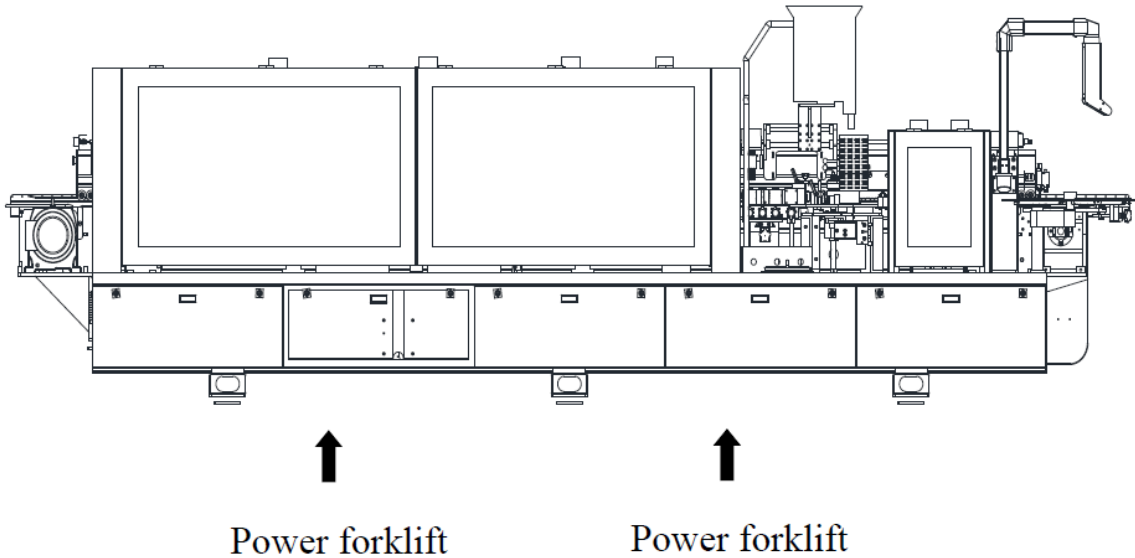


Figure 9–3: Power Forklift

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 the appropriate head bit to remove any screws that are securing the machine to the pallet/crate.
5. If necessary, use the prybar to remove screws/nails and any surrounding wood.
6. Use the forklift to lift the machine and remove the pallet/crate.
7. Lower the machine gently on the floor.
8. Ensure that all parts/components are present and in good condition.

9.5 Package Contents & Hardware

- One (1) Edgebanding Machine
- Toolbox
- Allen keys (mm) [1.5, 2, 2.5, 3, 4, 5, 6, 8, 10, 14]
- Wrenches (mm) [10, 13, 18, 41, 32]
- Phillips Screwdriver
- Pipe Wrench
- Key for Control Box
- Owner's Manual
- Packing List
- Finish Roller
- Leveling Feet (4 bolts & 4 metal plates)

Remove all contents from the shipping boxes. Do not discard the carton or packing materials until the assembly is complete. Accessories commonly ship inside the machine or stand packaging and can be easily overlooked. There may be extra packing contents or hardware that is included.

9.6 Tools Required for Assembly

- Philips Screwdriver
- Small Phillips Screwdriver

9.7 Preparation for installation

Power Supply: Use a 380V power source with a neutral wire and a ground wire. The power lines should be of specific thickness: some 4mm² and others 6mm².

Air Source: You'll need an air compressor with a pressure above 0.6MPa and a pipe that's 12mm wide.

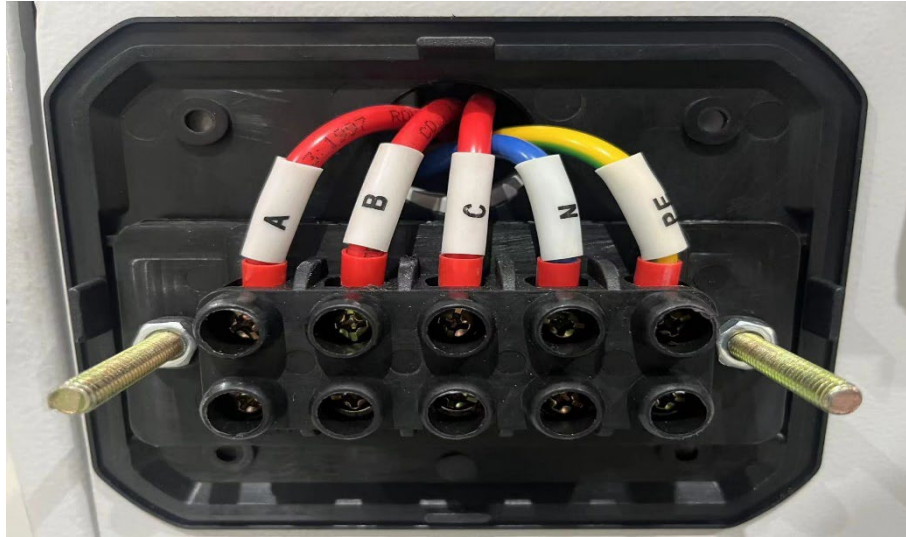
Vacuum Equipment: Make sure you have vacuum equipment with a dust pipe that's 96mm wide and a 4-inch vacuum pipe.

Installation Site: Clear enough space for the machine and ensure the ground is solid.

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Place the edge sealing machine in the correct position with a power forklift or manual forklift, adjust the machine to the horizontal position with the anchor screw, and then secure the machine with the anchor bolt.

Connect the Power supply



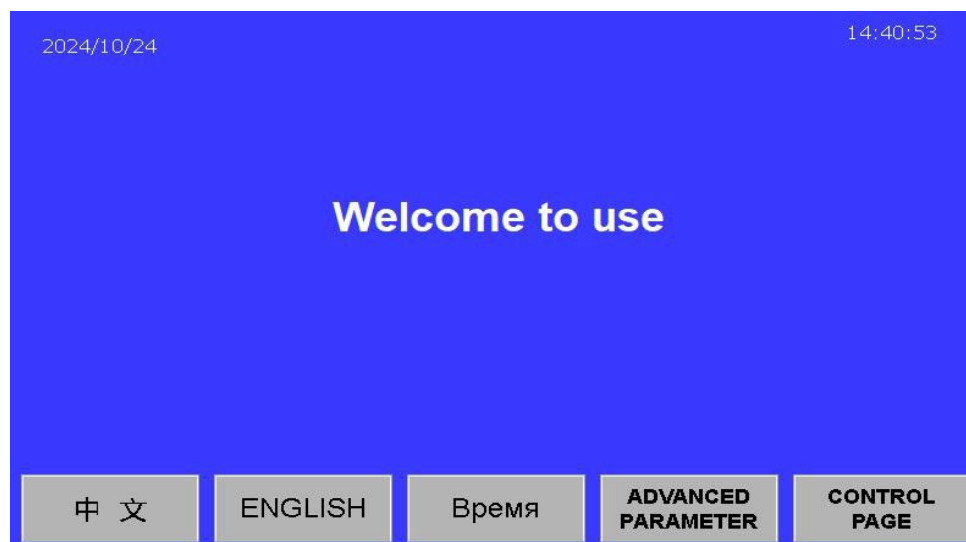
Red represents: Hot Wire (A, B, C)

Blue represents: Neutral Wire (N) —DO NOT UTILIZE

Yellow-green represents: Ground Wire (PE)

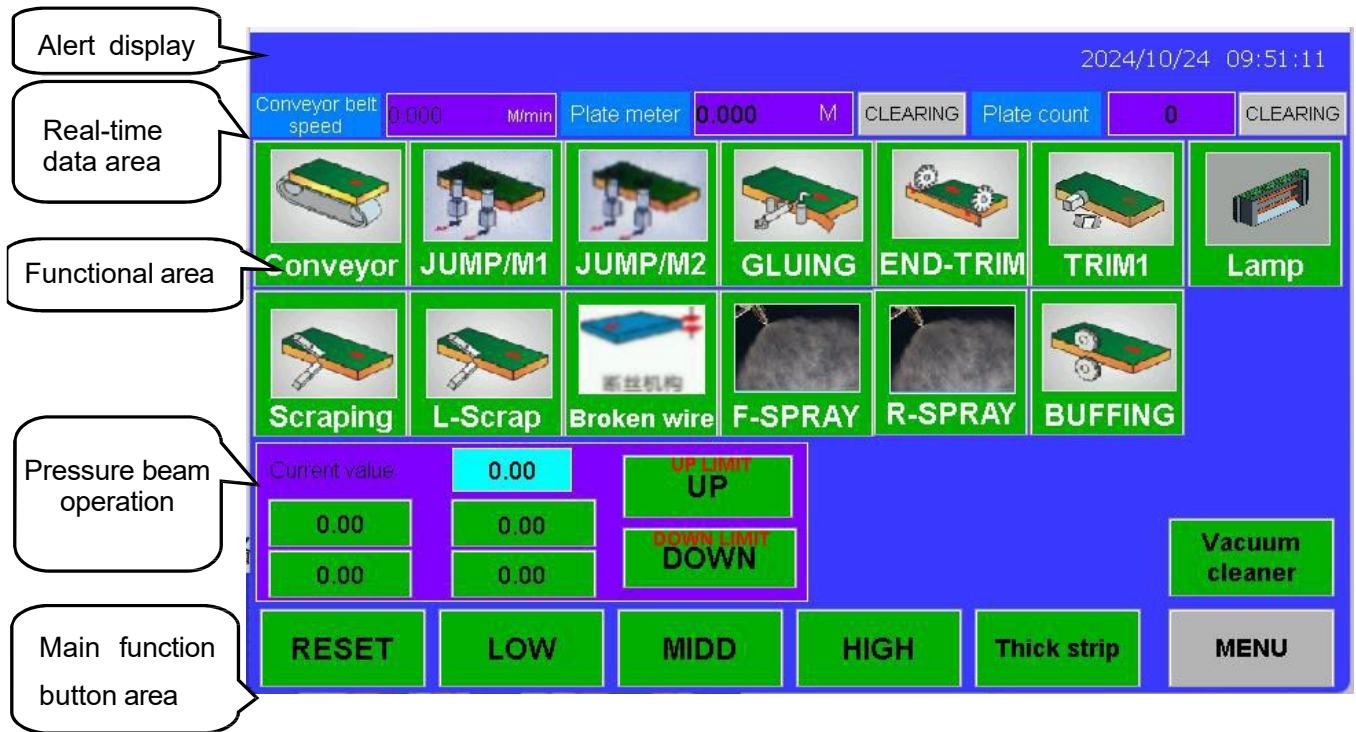
Pass the main power cord from the junction box cover and connect the five wires to the terminal on the junction box to lock the rear cover of the power cord. Note the position of each line connecting terminal, as shown in the figure above. The power supply can be turned on only after the confirmation. If the polishing wheel rotates in the opposite direction or the press beam lifting motor rises in the opposite direction, then change any two fire lines of the main power line.

10.0 Control Panel and Touchscreen Functions



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Click the "Control Interface" button to enter the main interface, as shown in the figure below.



Click the "menu button" and "I / O interface" to enter the X input point monitoring interface, as shown in Figure 4.2-4

X0	Conveyor encoder phase A	X10	EMERGENCY STOP	X20	
X1	Conveyor encoder phase B	X11	Buffing alarm	X21	Low temperature alarm
X2	Compression beam encoder phase A	X12	Pressure beam overload	X22	
X3	Compression beam encoder phase B	X13	Upper limit	X23	
X4	Start travel switch	X14	Down limit	X24	Inverter alarm
X5	Door travel switch	X15	Rear end trim switch	X25	
X6	Air pressure switch	X16	Rear end proximity switch	X26	Board superelevation
X7	Belt jog	X17		X27	

START PAGE

CONTROL PAGE

Output

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Click "Output point" to enter the monitoring interface of Y output point, as shown in Figure 4.2-

Y0	MIDD	Y20	JUMP/M dust	Y40	Lamp
Y1	HIGH	Y21	Belt cylinder	Y41	Vacuum cleaner
Y2	conveyor inverter	Y22	Cut tape in	Y42	
Y3	1# Premilling inverter	Y23	Cut tape out	Y43	
Y4	2# Premilling inverter	Y24	Front trim valve	Y44	
Y5	glue inverter	Y25	Front trim decompression	Y45	
Y6	end trim inverter	Y26	Rear trim valve	Y46	
Y7	Trimming inverter	Y27	Trimming in	Y47	
Y10		Y30	TRIM2 regulating valve	Y50	Scraping in
Y11	red light	Y31	Scraping regulating valve	Y51	Scraping dust
Y12	yellow light	Y32		Y52	Broken wire
Y13	green light	Y33		Y53	Broken wire blow
Y14	Material limiting cylinder	Y34		Y54	L-scraping
Y15	F-spray	Y35	Buffing	Y55	L-scraping dust
Y16	JUMP/M1	Y36	UP	Y56	R-spray
Y17	JUMP/M2	Y37	DOWN	Y57	Plate dust

START PAGE

CONTROL PAGE

INPUT

Click "Menu" and "Parameter Setting", enter the password 1234, and enter the "Parameter 1" interface, as shown in Figure 4.2-6,

	Plate head position	0.00	Plate end position	0.00		
	M1 IN	M1 OUT	M2 OUT	M2 IN	Dust for jump	Dust for jump off
LOW	0.00	0.00	0.00	0.00	0.00	0.00
MIDD	0.00	0.00	0.00	0.00	0.00	0.00
HIGH	0.00	0.00	0.00	0.00	0.00	0.00
	Tape on	Tape time	Glue coating	Gluing off	Cut tape	1#No-Go space
LOW	0.00	0.00	0.00	0.00	0.00	0.00
MIDD	0.00	0.00	0.00	0.00	0.00	0.00
HIGH	0.00	0.00	0.00	0.00	0.00	0.00
Pluse	0				P/mm	0.00
Restore Factory	Parameter 2	Parameter 3	Manufacturer parameters	CONTROL PAGE		

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Click "Parameter 2", "Parameter 3" and "manufacturer parameter" to enter the corresponding parameter page as shown in Figure 4.2-7

Pulse setting of conveyor PLUSE 0 P/mm 0.00		Meter setting Setting(long) 0.00 Setting(short) 0.00 Input board length 0.00 Input board length 0.00 Slope 0.00000 Offset 0.0000 Offset 0.0000	
Pressure beam parameter settings Current pulse 0 Current location 0.00 P/cm 0.00 Buffer height 0.00 Upper limit height # # # Lower limit height # # #		Height selection # # # # # # # # # # # # Glue parameters Temperature deviation 0.0 Low temperature deviation 0.0	
		Save parameters Factory reset	
START PAGE		Parameter 1 Parameter 2 Parameter 3 CONTROL PAGE	

Delta Control Module



PV: Present value

SV: Set value

°C, °F: Celsius or Fahrenheit LED

1, 2: ALM1/ALM2 alarm output LED

A/M: Auto-Tuning and manual mode LED

OUT1, OUT2: Output LED

: "Select" and "Set up" keys

: "Set value tuning" keys

There are three modes of operation: operation, regulation, and initial setting. When power is applied, controller defaults into the operation mode. Press the **SET** key to switch to regulation mode. If the **SET** key is pressed for more than 3 seconds, controller will switch to the initial setting mode. Pressing the **SET** key while in the regulation mode or initial setting mode forces the controller to return to the operation mode.

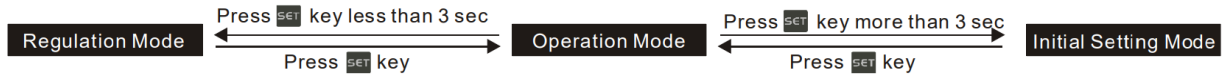
PV/SV: Sets the temperature set point and displays the temperature process value.

Use keys to set the temperature set point.

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Setting method: While in any function mode, press the  key to select the desired function and use the   keys to change the settings. Press the  key to save the changes.

The flow chart below shows how to switch the settings and internal functions:



Adjusting Temperature:

1. Put the machine in operation mode.
2. Press the   keys to **increase or decrease** the set temperature value. (the display should flash)
3. Press the  key to confirm temperature (the display should stop flashing).

Other Settings: For more advanced parameters, refer to the operating manual.

11.0 Adjustments

11.1 Pressure Beam

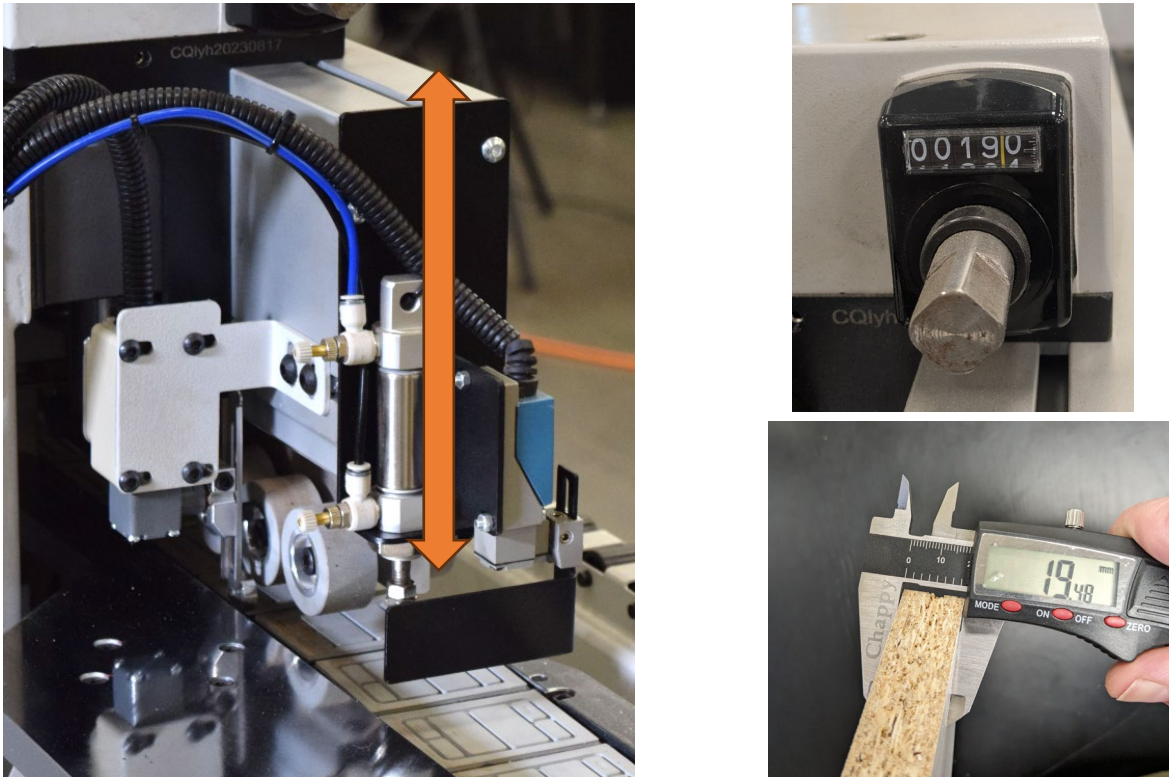


Figure 11-1: Pressure Beam Pictures

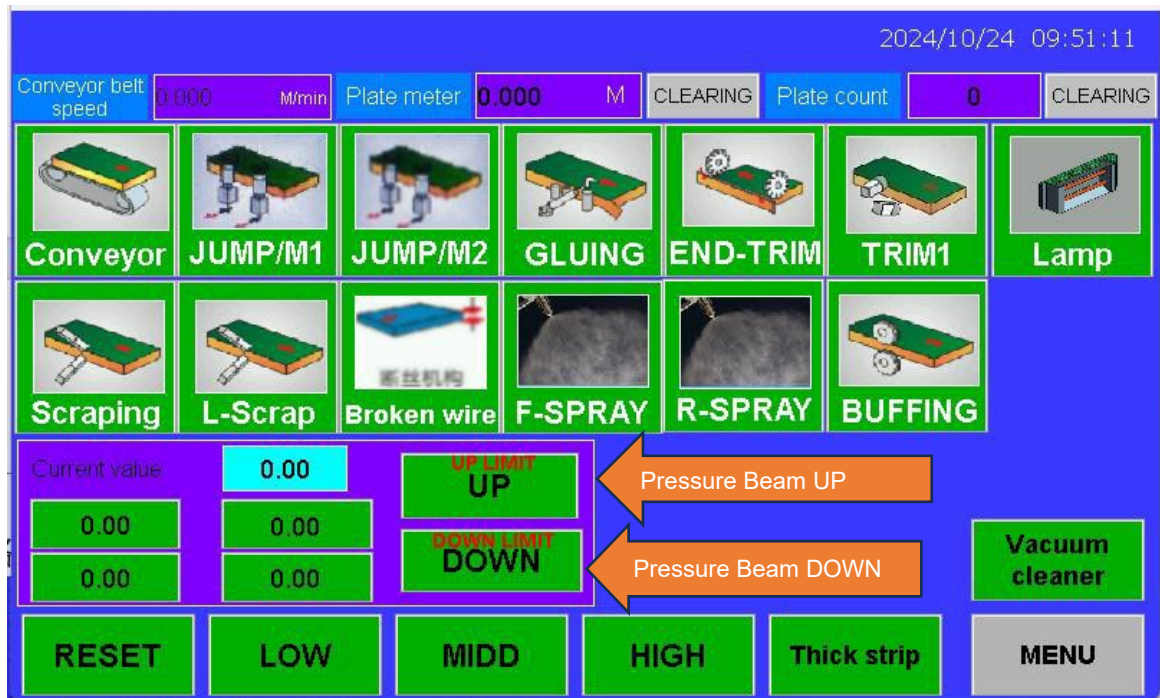
The pressure beam runs the length of the machine and holds the material against the conveyor tracks.

Anytime new material is introduced into the machine you must verify the thickness.

In Figure 11-1 above example, set the pressure bar to 00190. The number to the right of the line on the dial indicator is a decimal place. Round to the nearest tenths when measuring with a digital caliper.

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The pressure bar can be adjusted with “PB up” and “PB Down” on the control screen. Do not use any manual effort to adjust the pressure bar as the reduction gear box will not rotate.

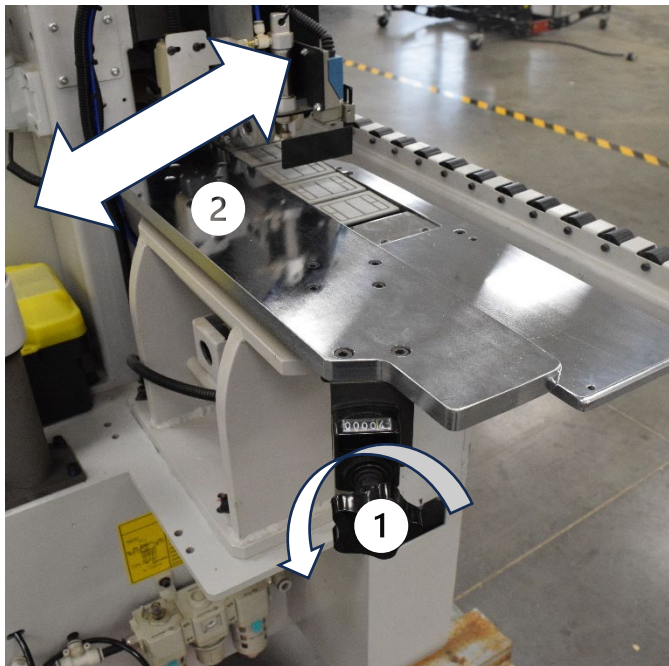


Pressure Beam Operation

- a) The machine is pre-calibrated with 3mm of roller tension from the factory and then the dial is set back to zero. Any excess pressure put onto the rollers of the machine will cause premature roller failure and possible damage to the machine. External rollers are easily replaced, however internal rollers require an immense amount of time and effort to replace. That is why it is critical to measure the thickness of material.

11.2 Material Fence

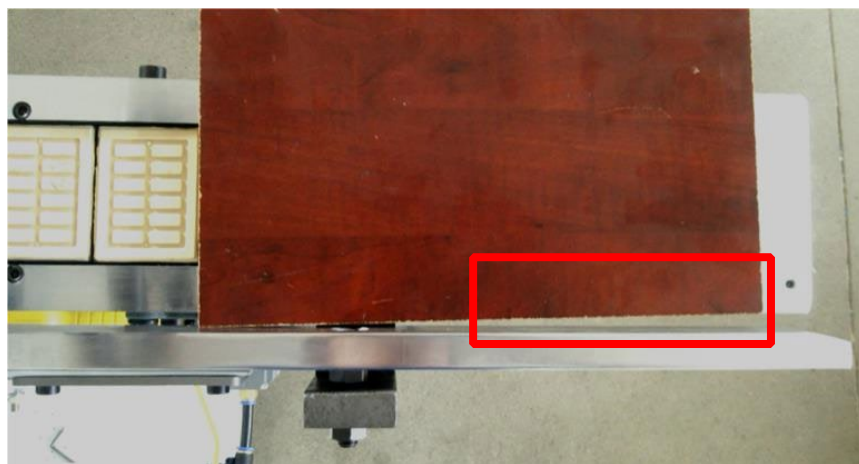
The material fence aligns material with the track and helps to ensure operations are smoothly maintained with each station. The fence can also be adjusted to set the depth of the milling amount.



Turning the knob “1” will move the fence in and out. The dial indicator “3” is the measurement of the fence in mm. In the example photo above the reading would be 0001.0mm. The yellow line represents a decimal place. Any numbers to the right of that line is represented in tenths.

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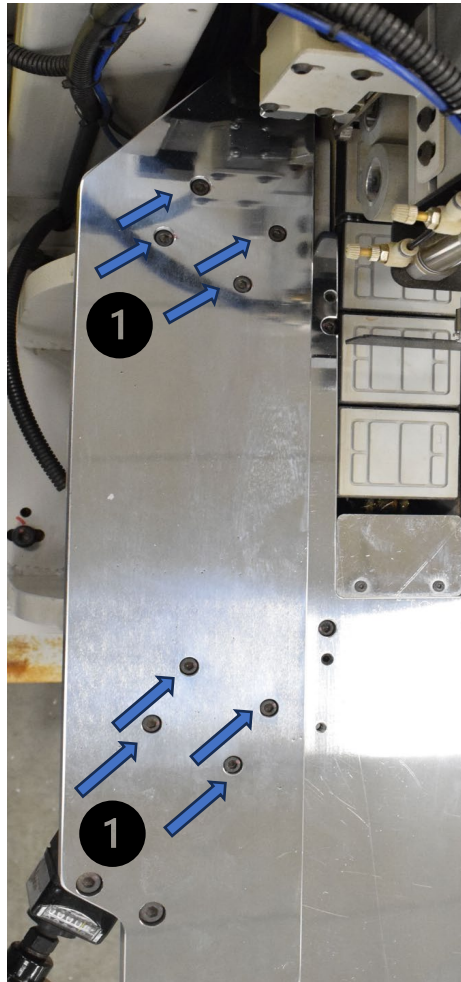
- i. If maintaining outside measurements of material are critical then the milling depth would be set the same as the thickness of edgebanding material. Example: If you are using .5mm thick edgebanding you would set the dial indicator to 0000.5mm.
 - ii. If final material measurements are not critical after edgebanding then the depth of milling cut can be any value. It should be set to produce a clean chip free material edge.
 - iii. The maximum milling depth is 1mm. Do not set the machine to mill over 1mm of material or damage may incur.
2. If material is fed into the machine at an angle, the edgebanding tape will not adhere to the material. Below are examples that show material that is **incorrectly** fed into the machine.



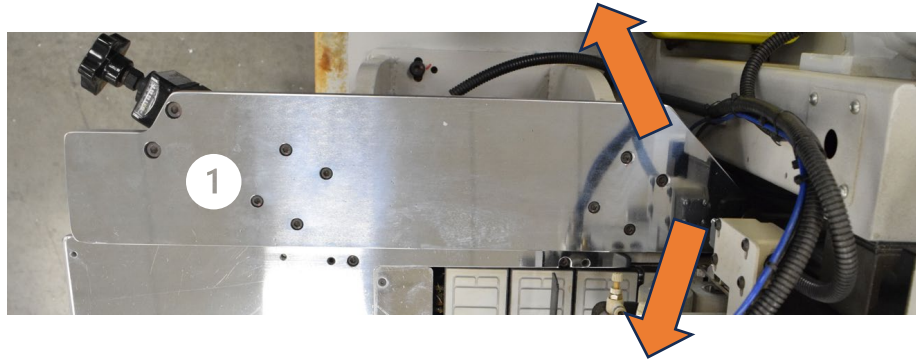
3. Alignment of the Material Fence

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- a. The alignment of the material fence is set from the factory and generally does not need to be adjusted. If you find that material is being fed into the machine correctly and edgebanding material is out of alignment then adjustments to the fence need to be made.
- b. Please note that any adjustments to the fence will result in a realignment and calibration of all proceeding stations.



Alignment of the Material Fence is accomplished by loosening the bolts that connect the fence to the bearing blocks. The nuts to loosen are labeled as “1” in the picture below.



The loosened bolts allow the fence to pivot on bolt “1”. This allows the fence feed angle to be adjusted by 1-2 degrees in either direction.

1. Turn the machine off and allow the glue pot to cool.
2. Temporarily turn on the machine to Raise the pressure beam to maximum height then turn the machine off so that no heating cycles occur. You don't want to melt any plastic tool if using as a glue pot spacer.
3. Pull the gluepot backwards.

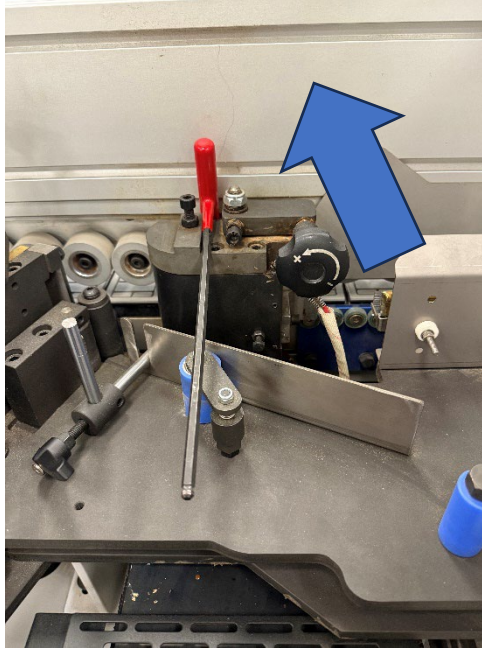
WARNING

THE GLUE POT UNIT IS HOT! USE EXTREME CAUTION! USE APPROVED HEAT RESISTANT GLOVES.



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Insert a spacer between the pressure beam and the glue pot then allow the tension of the glue pot to clamp a spacer in place. In this example we are using the handle of a large Allen wrench to clamp a spacer in place. A piece of wood would be another suitable alternative.



Locate a level that has 2 parallel machined surfaces on it. Alternatively, there are machined bars of steel that maintain accuracy over roughly a 3 foot distance. If you can locate any machined steel for calibration that would be ideal over a level. Levels could be out of square or straightness depending on many factors including cost, manufacturer, input materials, temperature etc.. Most of the time we choose machined bar stock to align the fence.



Place the level against the material fence ensuring there is no gap or the level does not touch any pressure rollers or anything else that could alter the angle. It may be easier to also clamp the level to the fence like the photo below.



Measure from the side of the level and the edge of a track piece on the plastic material. Measure the distance using the second and the eighth track after the front of the material fence and the edge of the plastic material on a section of track. We will refer to these measured values as “1” and “2”. A set of digital calipers is the easiest method to measure this distance.

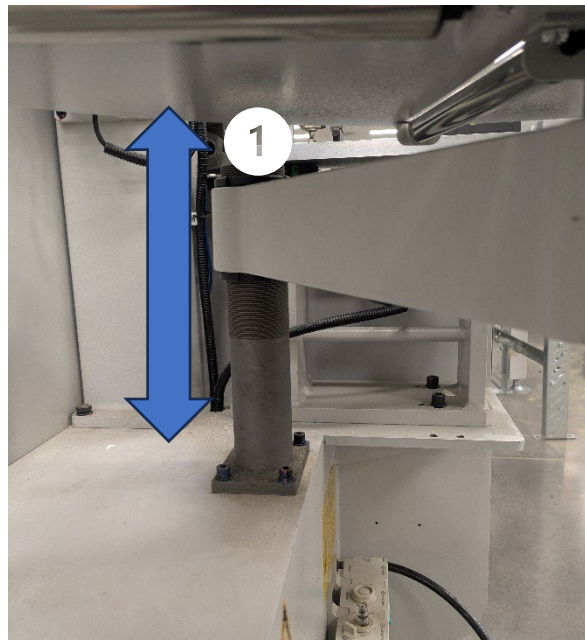




1. Compare your values at “1” and “2”. These values should be similar with minimal difference. You want to achieve the smallest difference between these numbers that you are able to. A method of adjusting the fence adjustment bolts and then rechecking will occur several times to achieve a tight variance.

Please note that the value that we have for our digital caliper may vary slightly from the caliper you choose to use. The actual number of the values of “1” and “2” is less important and the variance between “1” and “2” is critical. When adjusting our machine, we were able to create a variance of zero.

11.3 Material Support



The overall height of the material support can be adjusted vertically.

Loosen the bottom lock nut at “1”, rotate the retaining nuts, and adjust to the desired position.

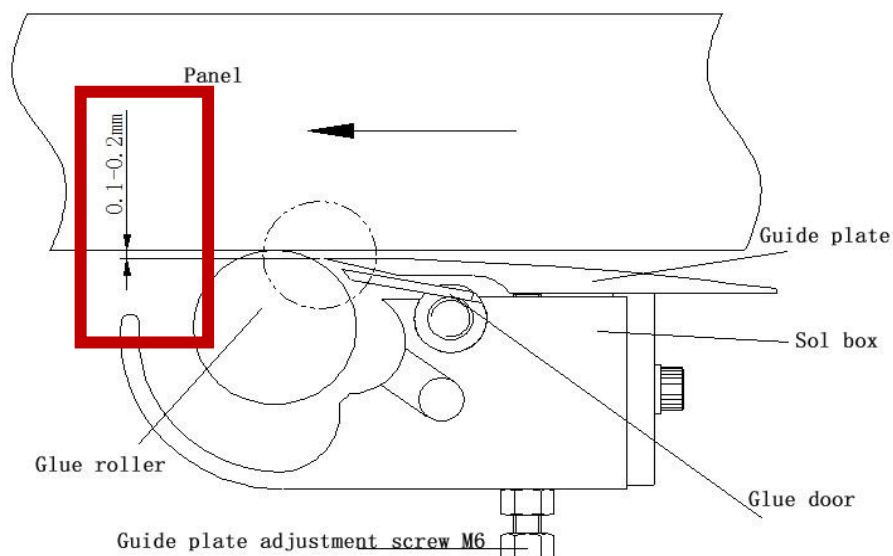
It is best to have the support plate 1/16” inch higher than the deck of the Glue Heating Station.

12.0 Stations and Adjustments

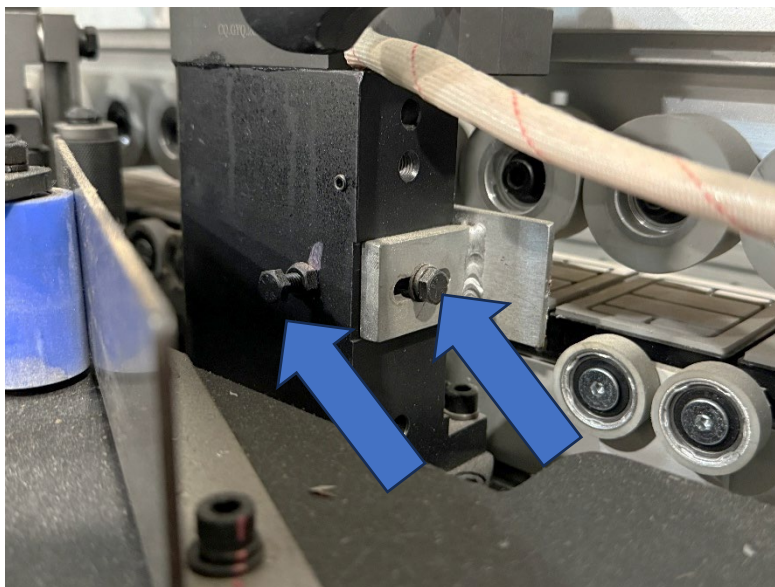
12.1 Gluing Station

12.1.1 Adjustment of the thickness of “Glue Float” layer

The illustration below is a top view of the glue spindle in relation to the guide plate and is set from the factory. The glue roller will have .1mm to .2mm of offset from the guide plate. This distance is fixed and generally no adjustment is needed.

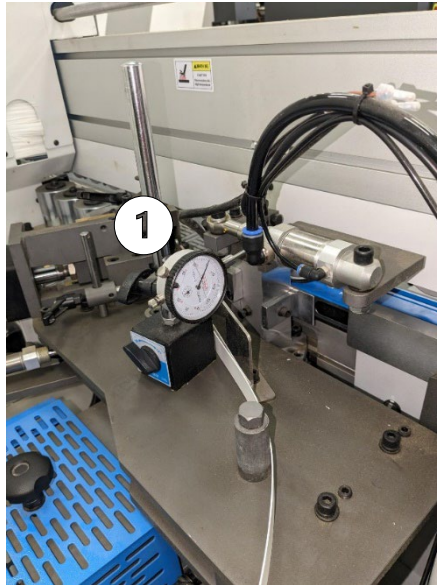


If any change is needed, ie removal of glue spindle, the photo below shows where the guide plate adjustment screw is located. The adjustment screw has a locknut on it and must be loosed to adjust. The retaining bolt on the glue plate needs to be loosed before making any adjustments.

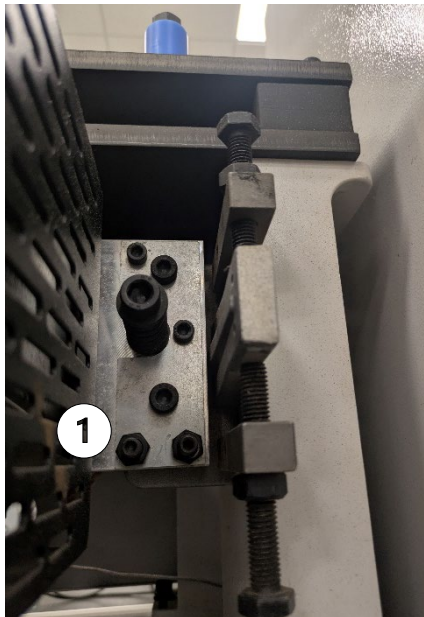


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When material is feed into the machine the glue spindle comes into contact and pushes the glue pot or deflects. When properly adjusted, the glue pot should deflect 1 mm. It takes a trained eye to visually check this movement. The best means of checking or measuring this would be to utilize a dial indicator mounted on a magnetic base referenced from the side of the glue pot. Your machine may look different than the picture below.



Place a magnetic base dial indicator onto the tape feeding deck to measure the amount of movement the gluepot can travel. See “1” in photo above. The dial indicator in the photo is measuring reference at the air fitting elbow. Any other solid reference point is acceptable as long as it is repeatable and accommodates your measuring device.

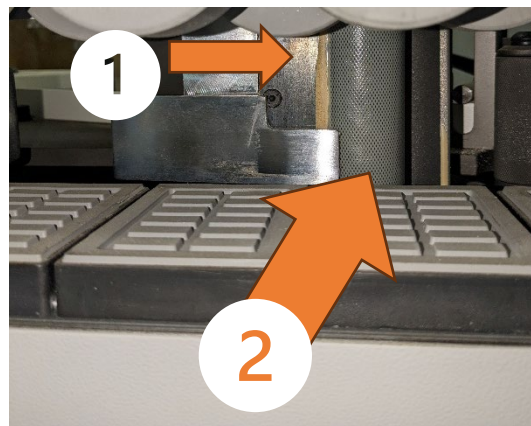


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The screw closest to the "1" can be utilized to adjust the glue pot deflection. Unlock the jam nut and then turn the set screw. *Counterclockwise* increases movement. *Clockwise* decreases movement. Refeed material in between adjustments and monitor dial indicator value. Retighten the jam nut after adjustment.

12.1.2 Adjustment of Glue Amount

1. Ensuring the correct glue amount is important to successful bonding between material and edgebanding. Too little glue and the edgebanding bond will fail resulting in wasted time and materials. Too much glue results in gummed up equipment, shorter consumable life, and increased labor for cleanup.
2. This machine has one continuous flow of glue.
3. Adjustment Procedure:
 - a. To adjust the glue amount turn the glue adjustment knob *clockwise* to decrease glue amount and *counterclockwise* to increase.



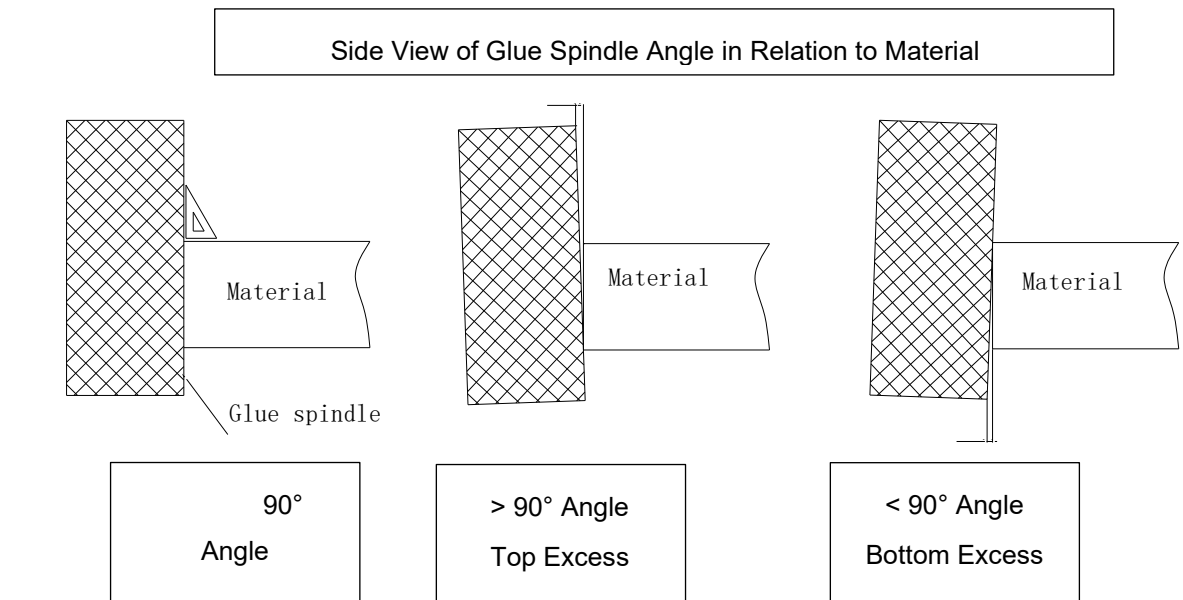
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The operator must raise the pressure beam to visually inspect the glue flow. The glue flow door is labeled "1". This opens and closes when the air cylinder is activated.

"2" is the glue spindle and you will be able to visually see glue on this spindle when idle or active.

12.1.3 Adjustment of Verticality Between Glue Roller and Material

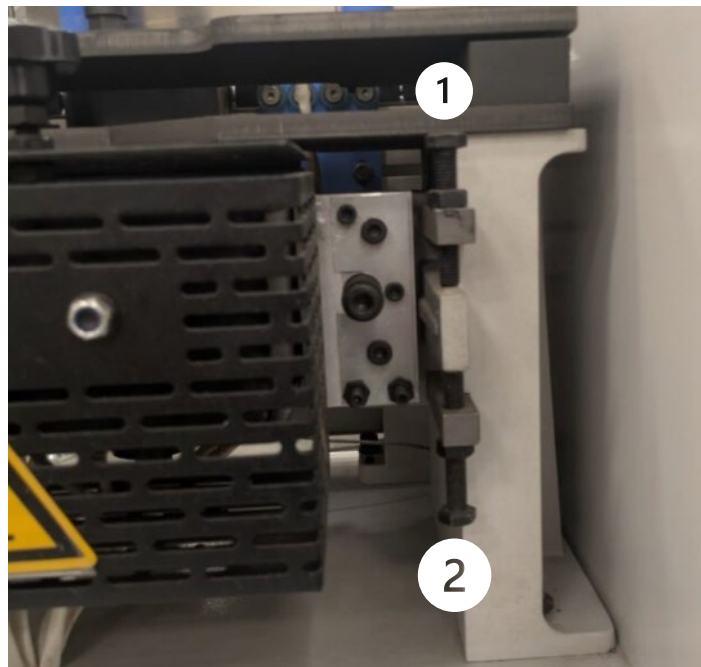
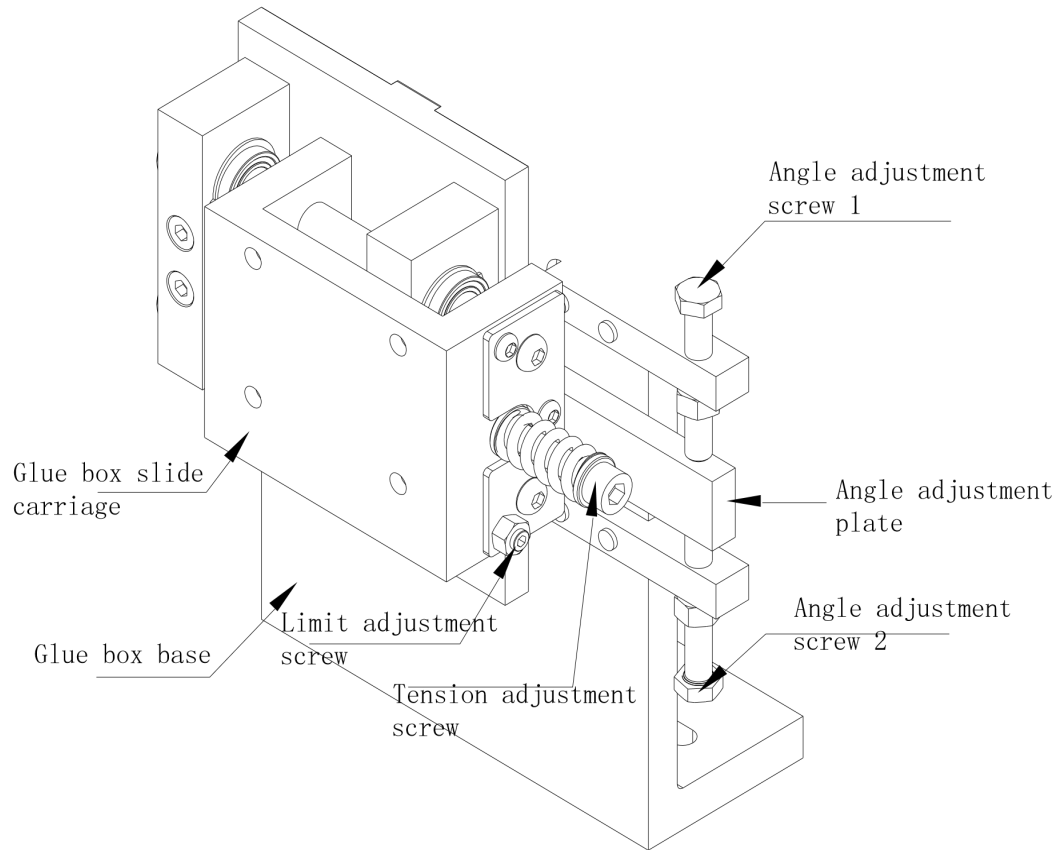
1. Note: Glue pot can reach high temperatures. Take care to avoid injury when making adjustments.
2. Ideally the angle of the glue spindle in relation to the material being feed into the machine is set at 90 degrees and rarely needs to be adjusted. Most material that is $\frac{3}{4}$ inch or below will rarely show any indication of an incorrect spindle angle. Generally any variance in spindle angle that produces less than acceptable results appears when edgebanding material $\frac{3}{4}$ inch or thicker.
3. Below is an illustration of a glue spindle and possible angle scenarios. If the glue spindle is out of calibration, you will see glue applied to either the bottom or the top of the edge of the material.



a.

b. Adjustment Procedure

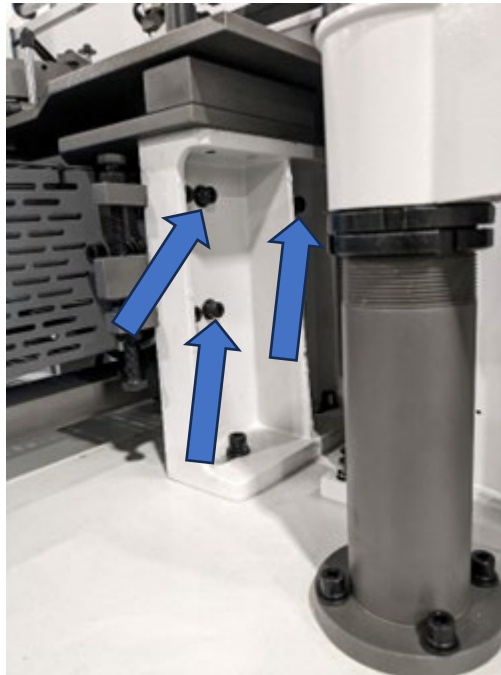
- i. The glue spindle should be adjusted as close as possible to 90 degrees. Performing an exact measurement of this can be challenging as no reference point can be measured as the point that needs to be measured is a glue spindle covered in glue and heated at or above 190 degrees Celsius. Trial and error seems to be the best method for this process.
- ii. The illustration below shows the location of 2 screws responsible for angle adjustments. These screws are "Angle Adjustment Screw 1" and "Angle Adjustment Screw 2".



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Photo above shows “Angle Adjustment Screw 1” labeled as “1” and “Angle Adjustment Screw 2” labeled as “2”

4. If you find that the glue pot is not adjusting in angle the bolts retaining the glue pot to the support tower may need to be loosened temporarily while making adjustments. Attempt a small adjustment with the steps below and verify change in angle before committing to larger adjustments. This step is rarely needed and the glue spindle angle generally changes without needed to perform this step.
5. Please Note: Damage could result to adjustment hardware if retaining bolts are too tight and restrict movement.



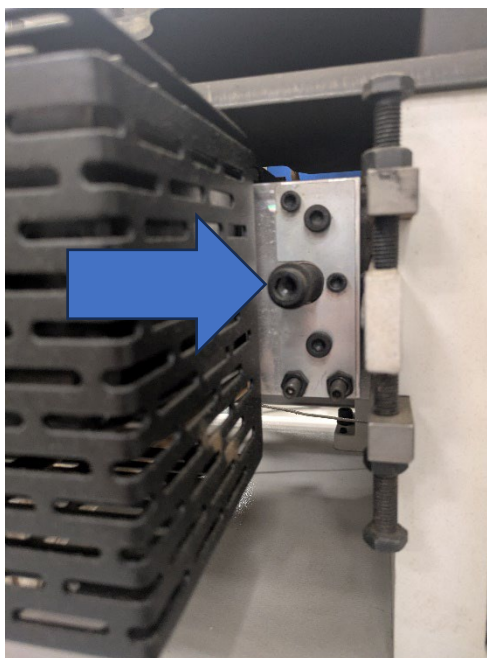
6. If you find that the glue spindle is $> 90^\circ$ Angle and applying excess glue to the top of the material perform this adjustment:
 - a. Loosen both jam nuts.
 - b. Turn “1” clockwise while equally turning “2” counterclockwise. If you turn one bolt a $\frac{1}{4}$ of a turn you need to turn the other bolt $\frac{1}{4}$ turn.
 - c. Test material and repeat until satisfied.
 - d. Once satisfied with results tighten the jam nuts.
7. If you find that the glue spindle is $< 90^\circ$ Angle and applying excess glue to the bottom of the material perform this adjustment:
 - a. Loosen both jam nuts.

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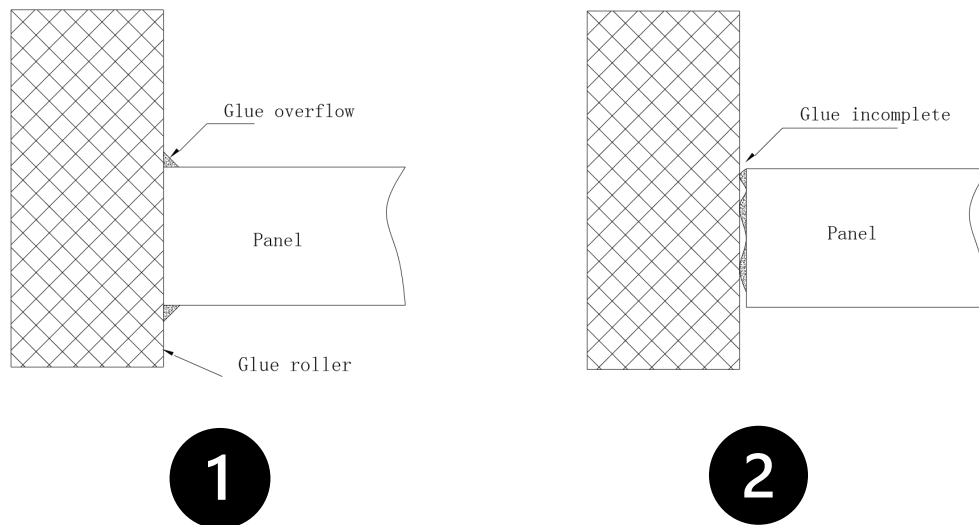
- b. Turn "1" counterclockwise while equally turning "2" clockwise. If you turn one bolt a $\frac{1}{4}$ of a turn you need to turn the other bolt $\frac{1}{4}$ turn.
- c. Test material and repeat until satisfied.
- d. Once satisfied with results tighten the jam nuts.

12.1.4 Gluepot Spindle Tension

1. It is possible to adjust the amount of tension that the glue pot exerts on the material when actively applying glue. Generally there is never a need to adjust this tension and is set from the factory. It is recommended to check glue temperature, glue age, and glue float adjustments before adjusting glue pot tension.
2. Tension is adjusted by loosening or tightening the spring assembly pointed out in the photo below.



- a.
 - i. Turn this bolt counter clockwise to reduce tension.
 - ii. Turn this bolt clockwise to increase tension.

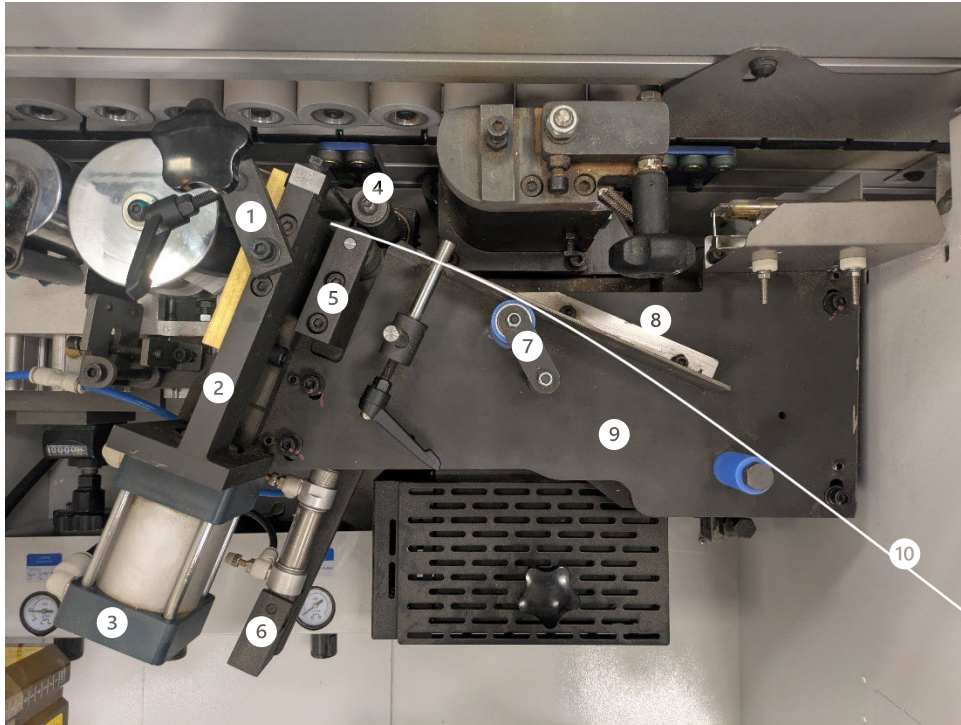


b.

- i. You may notice that scenario “1” is happening. In this case the tension of the glue roller is too high and needs to be reduced. In extreme situations tension could be so high that the material is pressed out of the conveyor track altogether.
- ii. In scenario “2” tension is so low that the glue spindle may skip or bounce off material when first making contact. Adjust to a higher tension.
- iii. This is much more an artform than science. Trial and error method is the best procedure.

12.2 Tape Feed and Cutting Station

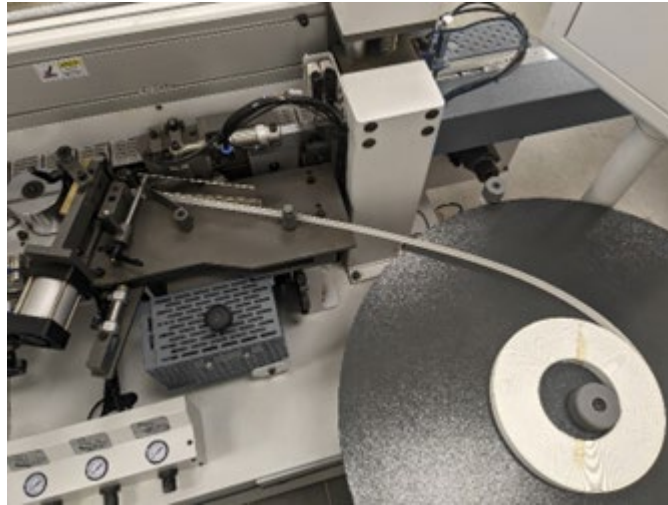
The tape feed and cutting unit is used to pull edgebanding to the material's edge and automatically cut it at just the right time. Below is a top down illustration with part name call outs for reference.



- "1" Secondary Material Feed Retainer
- "2" Gullitiene Cutter
- "3" Air Cylinder
- "4" Edgebanding Feed Roller
- "5" Adjustable Edgebanding Feed Idle Roller
- "6" Air Cylinder for Edgebanding Feed Roller
- "7" Edgebanding Pressure Plate
- "8" Edgebanding Feed Fence
- "9" Taping Mechanism Deck
- "10" Edgebanding Material

12.2.1 Edgebanding Orientation On Material Plate

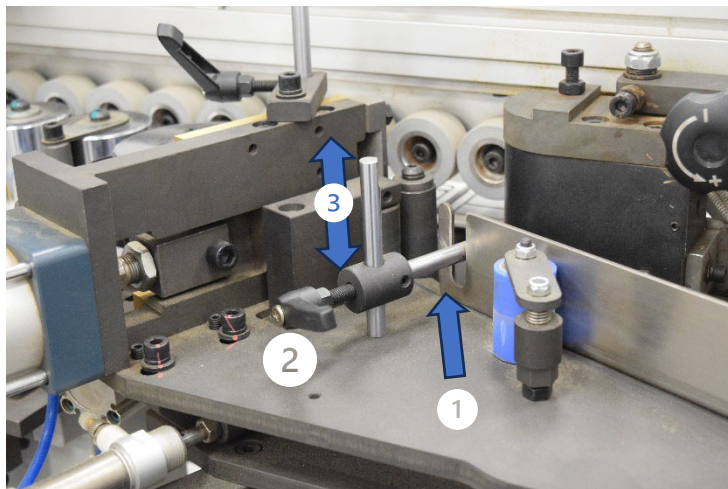
Edgebanding material will be fed into the machine in the orientation below. The image below is for reference only; your machine may vary slightly, but all steps and concepts still apply



- a)
- i) Rolls of edgebanding material will unroll slightly as the material is pulled into the machine. In the photo above we utilize masking tape for handling purposes.

12.2.2 Material Guides

The Primary Material Guide ensures that the edgebanding material is in line with the feed rollers. Raise the primary guides well above the height of the edgebanding. Feed edgebanding material thru both guide plates then adjust the clearance of the guide plates to .5mm from the top of the edgebanding material.

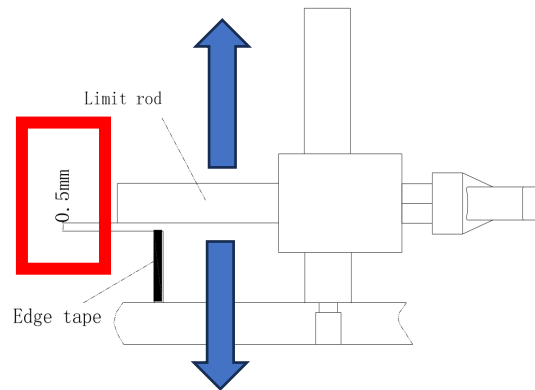


“1” This is the limiting rod. This rod will rest .5mm above the edgebanding material.

“2” This handle loosens the primary material guide. Pull handle outward to adjust angle of handle if necessary.

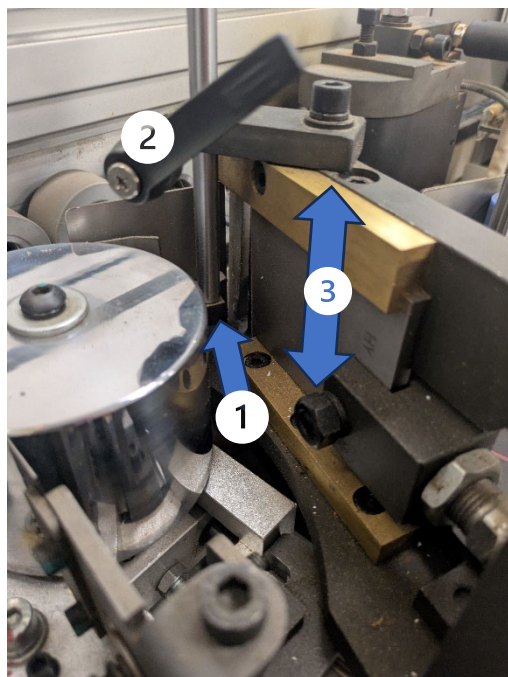
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"3" The primary material guide will slide vertically along this shaft.



Side view illustration of edgebanding in relation to limiting rod.

The Secondary Material Guide ensures that the edgebanding is in line with the edge of the material.



"1" This is the limiting guide plate. This plate will rest .5mm above the edgebanding material.

"2" This handle loosens the primary material guide. Pull handle outward to adjust position of handle angle adjustment if necessary.

"3" The primary material guide will slide vertically along this shaft.

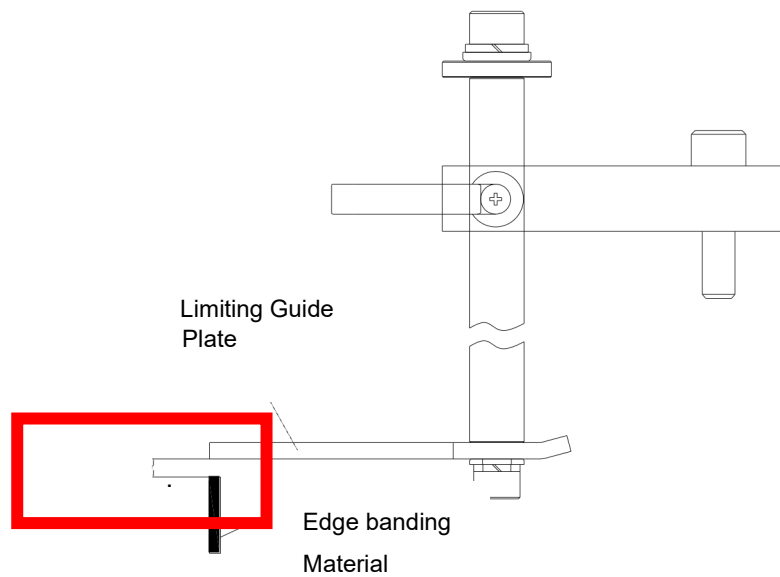
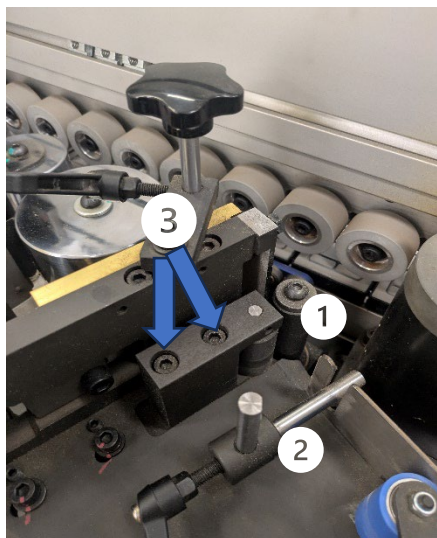


Figure 11-1: Side View of Secondary Material Guide

12.2.3 Material Feed Rollers

- 1) Once the machine has reached melting temperature the feed rollers spin in unison with the glue spindle. When activated the feed roller is pressed against the idle roller via air piston and pulls edgebanding material thru the mechanism. Generally there must be a minimum gap of 1mm between the idle roller and the feed roller at idle. You may need to adjust this gap especially when using thicker materials up to 3mm. Most machines are set up for 1mm edgebanding and will constantly feed 3mm edgebanding into machine until emergency stop is pressed. You must check this variance to avoid equipment damage.

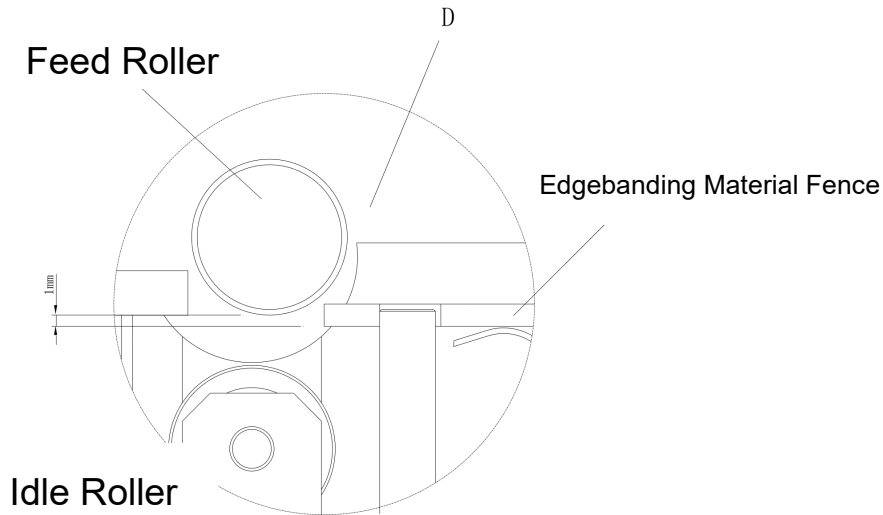


“1” Feed Roller

“2” Idle Roller

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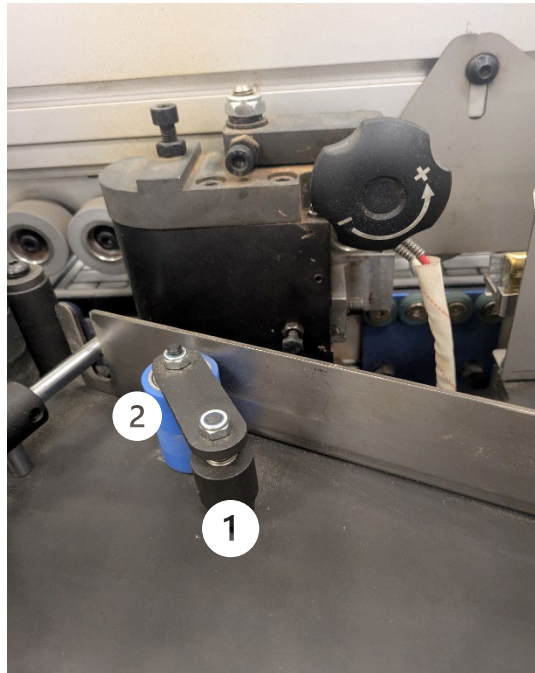
- i) "3" Idle Roller position adjustment screws. Loosen these screws then slide the idle roller back or forward depending on material. Roller can rest on material and a 1mm space between edgebanding material and feed roller should be maintained.



- ii) This is an illustration of the feeding mechanism looking top down.

12.2.4 Material Retention Holder

The material retention holder helps to keep edgebanding material in place. Too much tension and the feed rollers will chew thru the edgebanding. Too little tension and the material will be pulled out of position and failure in tape application will occur.

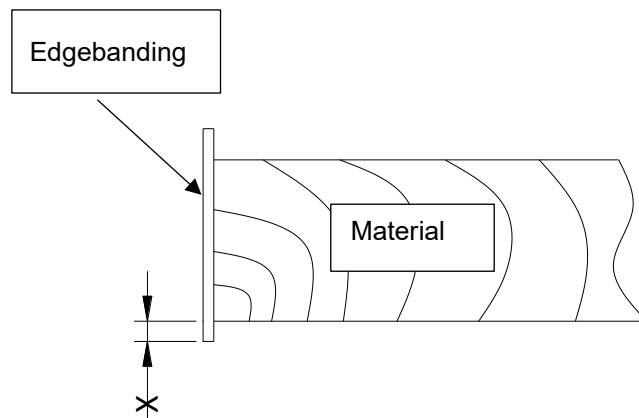


"1" This bolt can be loosened to adjust the tension of the material holder.

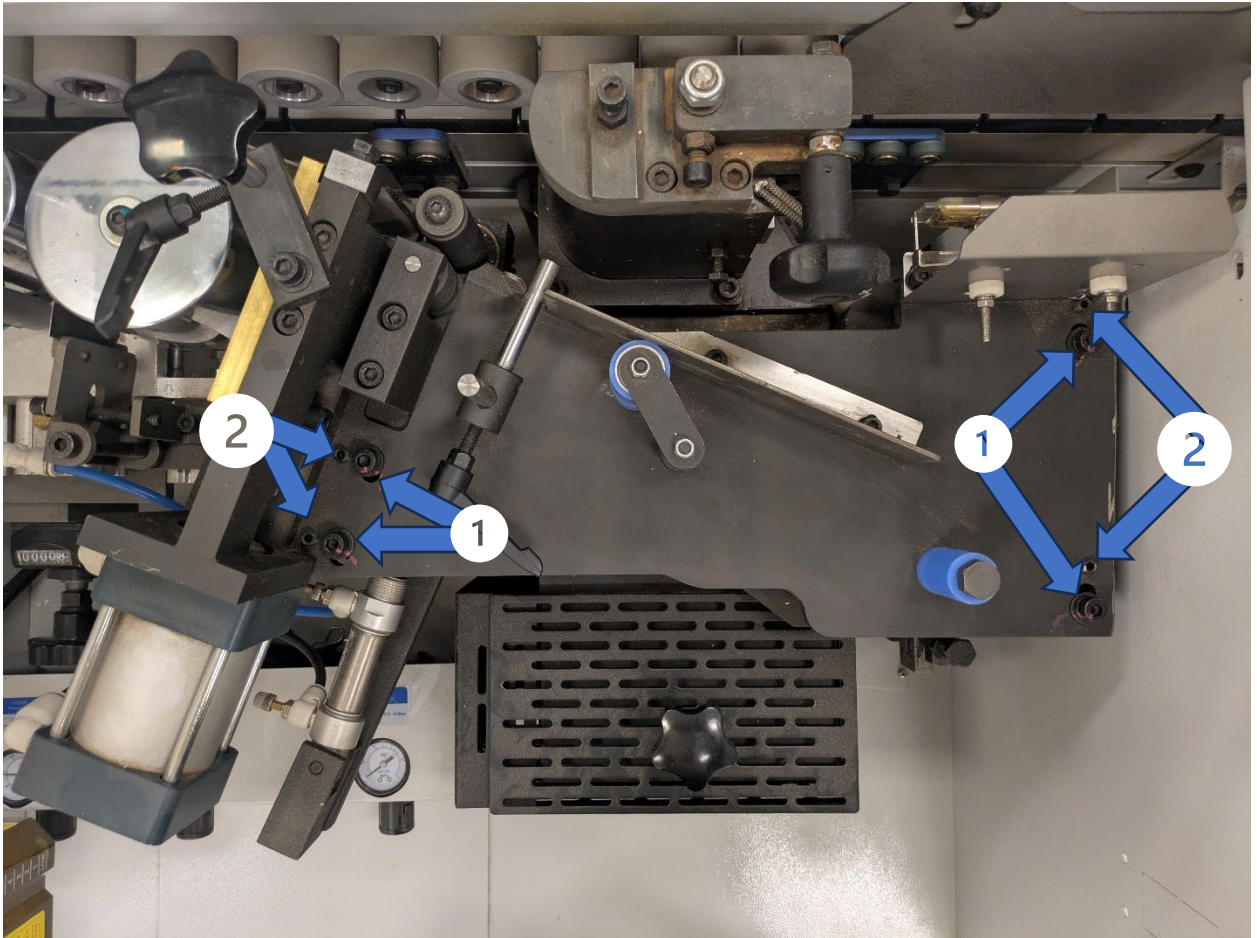
- i) "2" The tension of the material holder should press against the edgebanding material. Material should slide thru with minimal resistance.

12.2.5 Adjustment Of Lower Tape Offset

- 1) The orientation of edgebanding material on the edge of material is critical to successful operation of the machine. Generally $\frac{1}{16}$ th of an inch above and below the material thickness is recommended. If the lower portion of material is found to be out of spec and applied too low or high the deck of the edgebanding unit can be adjusted higher or lower. Please note that this edgebanding deck is set from the factory and will rarely if ever need to be adjusted. In the rare case that the deck is removed it can be reinstalled maintaining any adjustments.

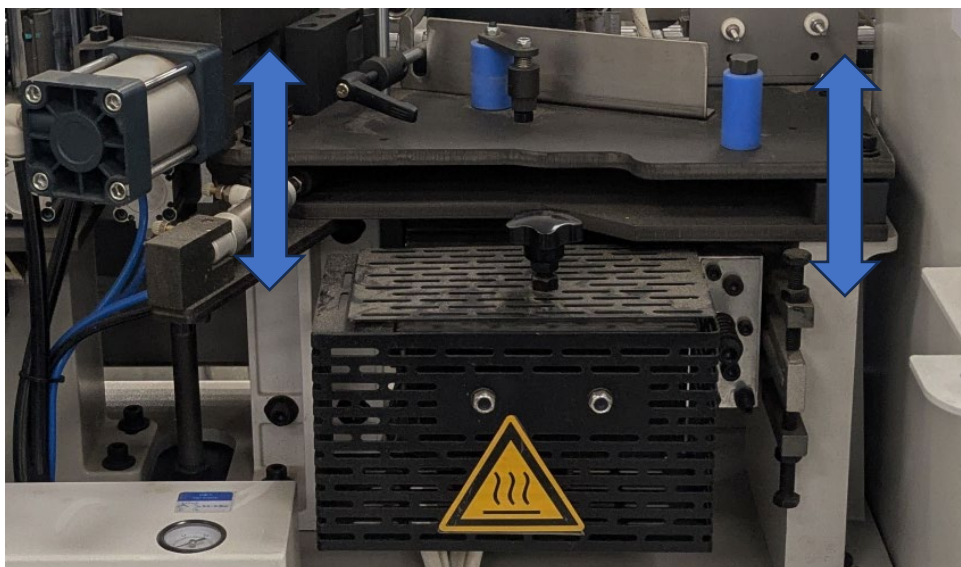


- a)
 - i) This illustration is a side view exploring the concept of lower tape offset. "X" should be maintained at $\frac{1}{16}$ of an inch.
 - b) The edgebanding material deck can be adjusted altering the orientation of the edgebanding.



"1" These bolts need to be loosened in order to make any adjustment.

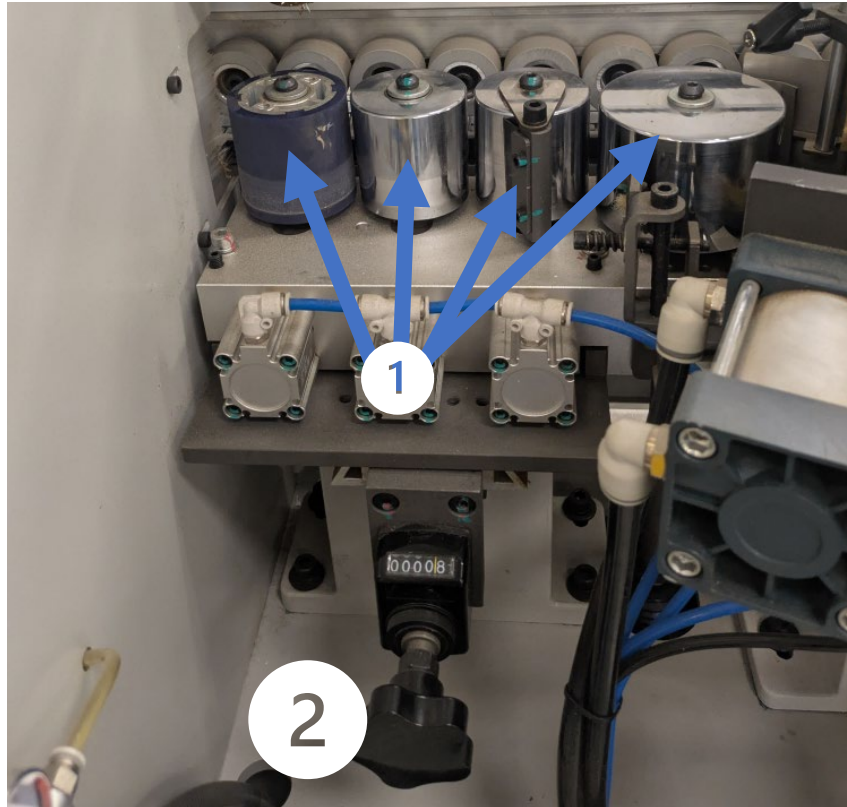
"2" These set screws can be adjusted to manipulate the height of the material deck. Rotate each screw in equal amounts to keep the deck level with the original plane of operation.



- i) The material deck has a small amount of adjustability along the horizontal axis.

12.3 Pressing Station

The pressure station is responsible for pressing and bonding the edgebanding against the material. Each roller is pneumatically activated into place and can deflect a small amount when material is passing over them. The amount of deflection is small and therefore proper adjustment needs to be made to reduce any excess force on the material which can lead to track slippage and excessive wear on equipment.



The pressure rollers are labeled as “1” and should freely move when machine is powered off and should be forward when machine is turned on. Test for movement regularly. Material can build up in the shafts of the rollers and impeded movement.

“2” this is the adjustment knob for the thickness of edgebanding material use for various jobs. This knob should be checked and adjusted any time a change in edgebanding material is loaded into the machine.



The dial indicator should be adjusted to the thickness of the edgebanding material. Any numbers to the right of the yellow line is in tenths. For this example above the measurement is set to 1.0 mm. If material is only .5 mm thick then the adjustment would read “00005”

Adjust the lower air pressure knobs that correspond with the pressure rolling station. Adjust the knobs until the edgebanding material is firmly bonded. Adjust the pressure only within the specific range that is indicated on the sticker.



Test with a board to ensure there is no gap between the pressure roller and the sealing edge.

12.4 End Cutting Station

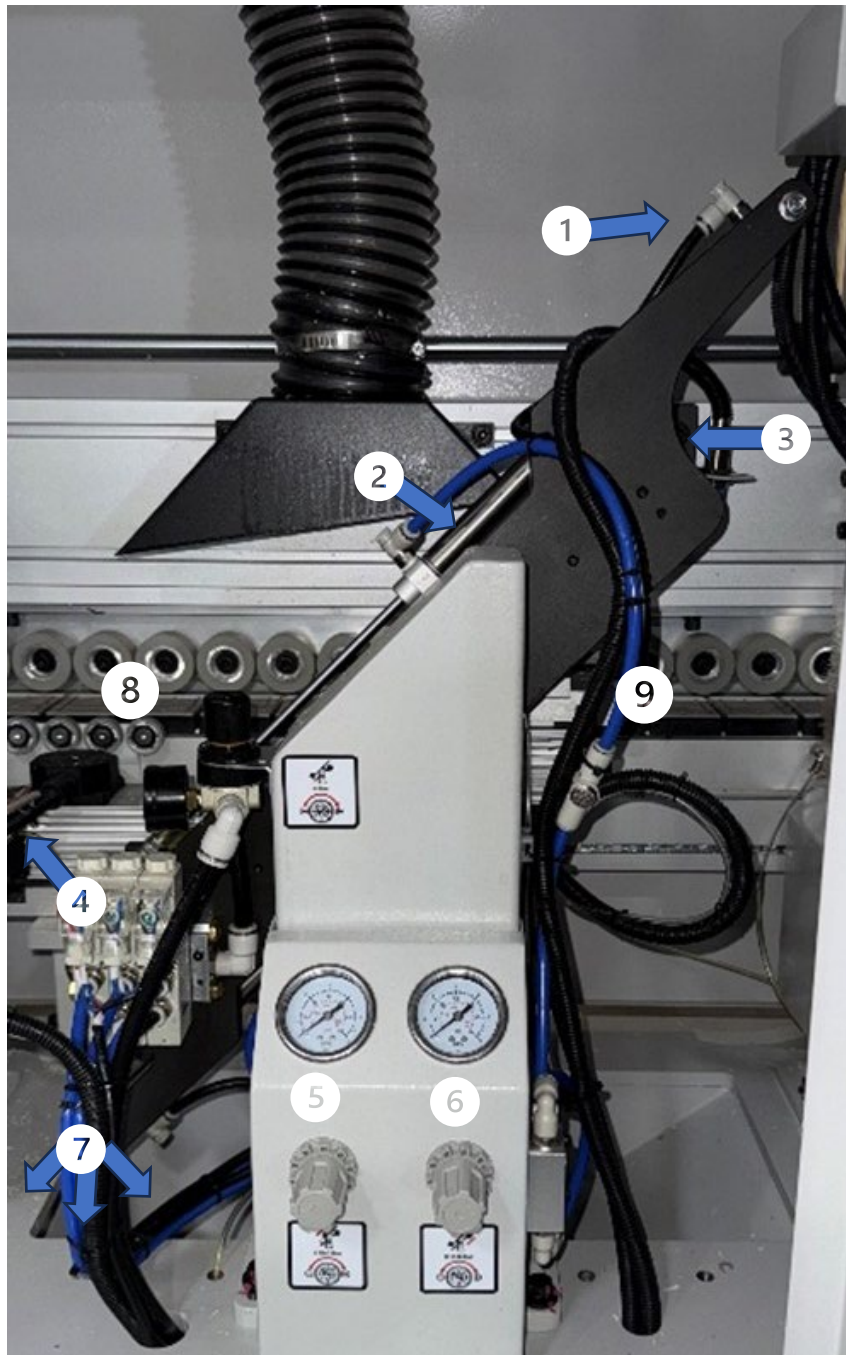
The end cutting unit trims off the excess edgebanding from the end of the material after it has been glued and pressed onto the material. The end cutting station is one of the most complicated units on the machine combining sensors, pneumatics and linear motion. This end cutting station is tuned at our facility utilizing an air compressor that maintains a perfect 100psi air supply. Before looking to adjust the motion control systems of this station it is advisable to investigate the air supply first. Variances in air supply can result in motion that is either too slow or too fast and produce negative results.

The process is as follows:

1. **Start:** Board touches the front switch, initiating the end repair mechanism.
2. **Front End:** Board moves with the conveyor belt, contacts the front end, and pushes the repair part to remove excess material. Cylinder action accelerates and breaks away from the board.
3. **Back End:** Cylinder action presses bearings on the board surface. When the board is removed, the cylinder thrust removes excess sealing belt. Cylinder action pulls the mechanism back to the top.
4. **Cycle Completion:** Front end repair cylinder returns to position, completing the cycle.

(Note: If the travel switch is touched when the switch is off, a head dislocation alarm will occur.)

12.4.1 Adjustments

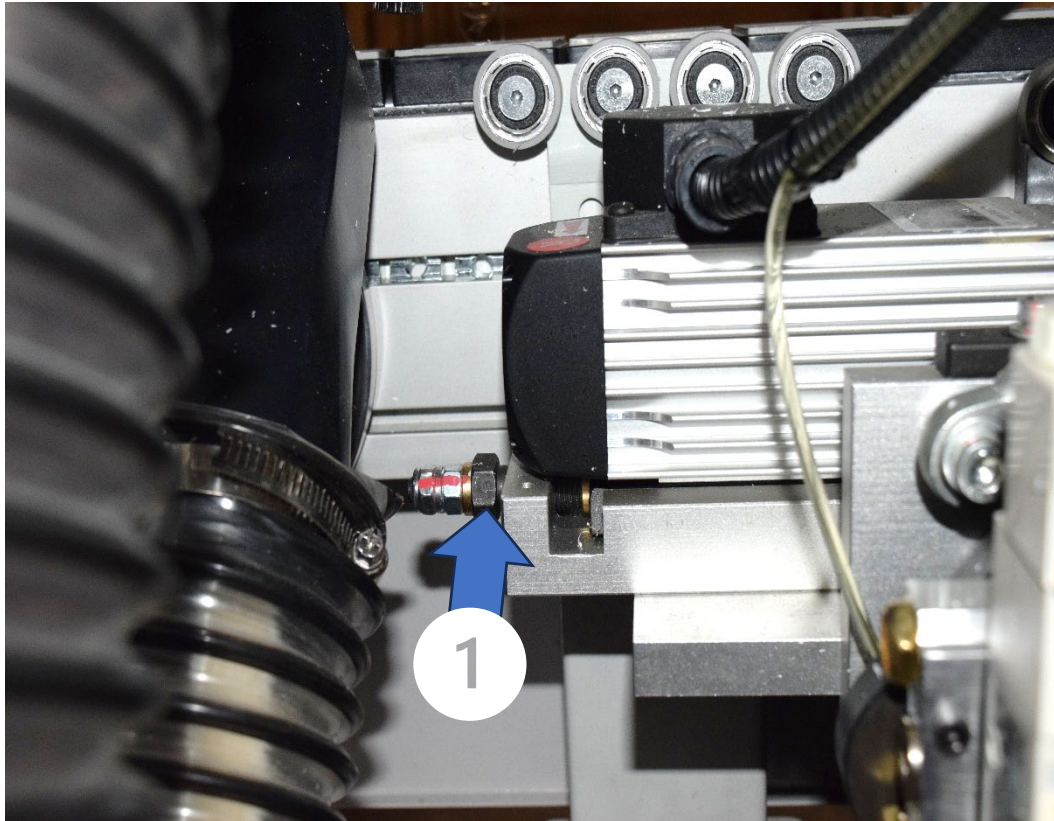


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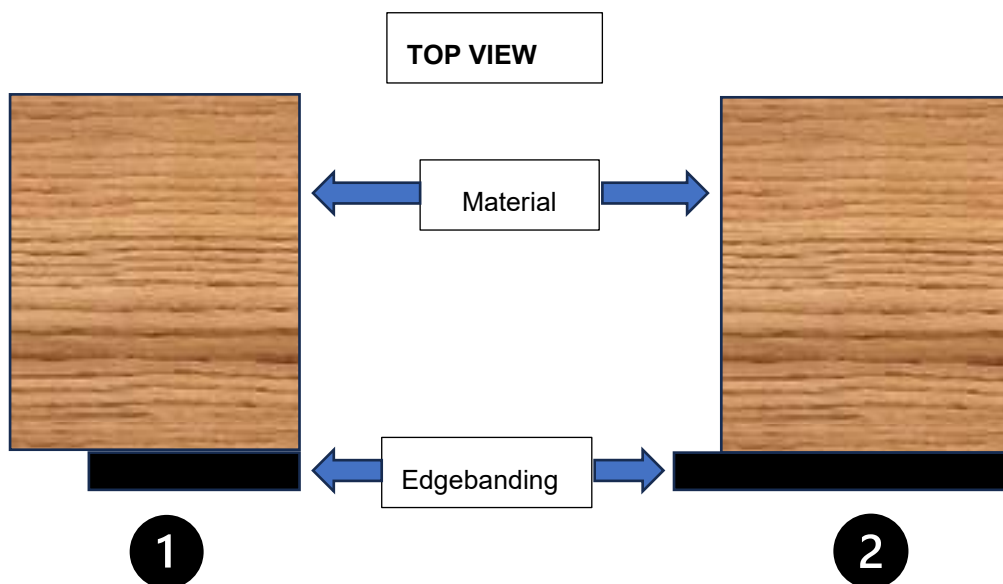
1. **Air cylinder expansion/contraction control valve.** There are four of these in total on this station. These valve are adjusted by pulling the knob up and then rotating to desired outcome. These valves are adjusted from the factory and rarely if ever need to be adjusted. See picture below for adjustment reference to increase or decrease pressure.



2. **Air cylinder.**
3. **Proximity sensor.** This sensor detects when the rear cutting mechanism is in its resting position when the machine is pressurized. There is a red light that illuminates on the proximity sensor when the station is pressurized.
4. **Gray adjustment bolt.** Used to adjust the length of the end cut.
5. **Primary air supply regulator.** This regulator will always read air pressure. Setting is called out on machine sticker. Pressure on this regulator can be changed to effect the overall speed of the cut.
6. **Secondary air supply regulator.** This valve is adjusted for active cutting pressure. Air setting is called out on machine sticker. This valve normally will read 0psi until material is feed into machine and station is activated. Generally this valve needs to be set to a higher pressure that the primary air supply regulator.
7. This large open channel on the interior deck of the machine is used to catch loose end trimming pieces. Periodically check this space and clean accordingly.



When adjusting the length of edgebanding cut use the gray adjustment bolt in the above photo labeled as “1”.



Turning the gray adjustment bolt on the end cutting motor mount will adjust the depth of cut. A clockwise turn will cut deeper or remove more material.

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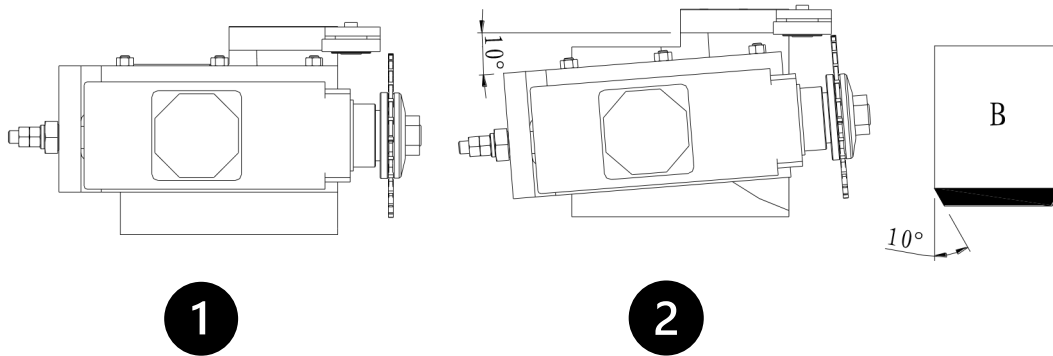
In situation “1” the gray adjustment bolt would be turned in a counterclockwise direction.

In situation “2” the gray adjustment bolt would be turned in a clockwise direction.

The rotation of this adjustment bolt can have large impacts on cut location. It is recommended to start with rotating $\frac{1}{4}$ turn at a time.

There can be a slight amount of backlash in the adjustment mechanism. Meaning that a small $\frac{1}{16}^{\text{th}}$ turn in the opposite direction can have no effect at all. This is because there is a small amount of play withing the teeth of the screw mechanisms. Each machine's play with differ slightly from batch to batch. Adjustment of the end cutting length is an art and the best approach is trial and error.

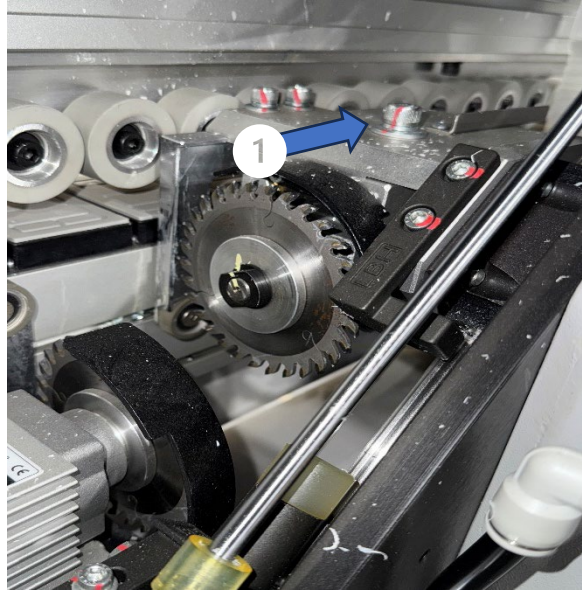
End Cutting Blade Angle



The blade angle of the end cutters can be adjusted to your preference.

Generally no adjustment to the angle of blade needs to be adjusted and is set from the factory.

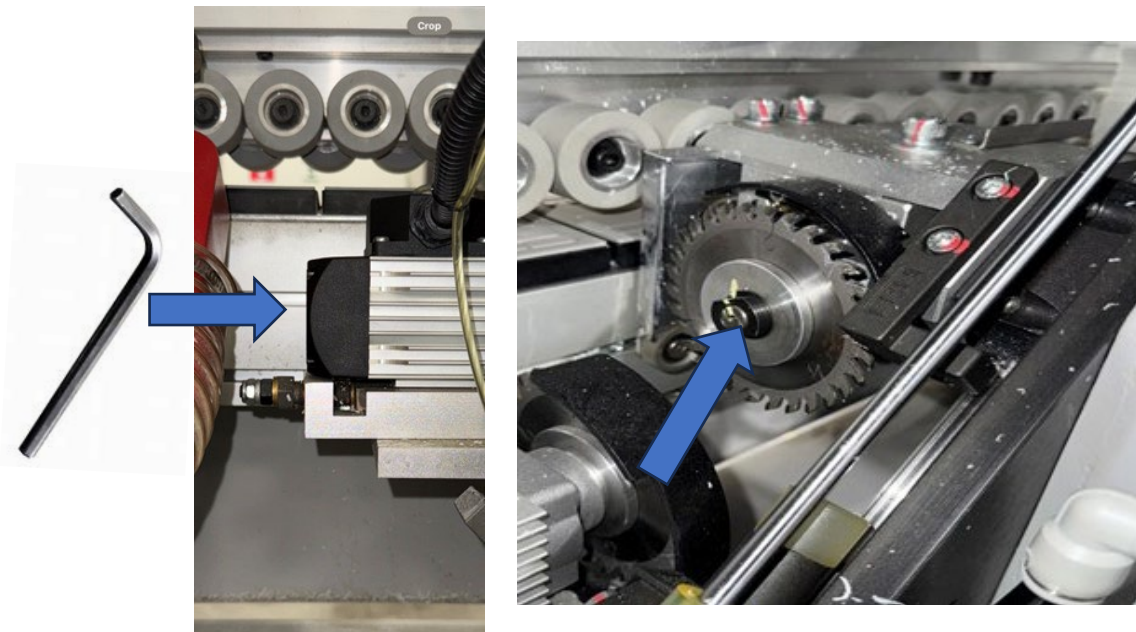
The machine is shipped with about 2 degrees of angle or near zero adjustment. #1 for reference. The end cut station can be adjusted to up to 10 degrees of angle. See #2 for reference.



To perform any adjustments, loosen the bolt in the photo above labeled as #1. The motor can then be twisted to the desired angle. It may take considerable amount of effort to initially rotate the motor. Retighten once adjusted.

- i) Please note measuring motor angle with any gauge is not easily achieved. This adjustment is more of a trial and error method.

12.4.2 Blade Replacement



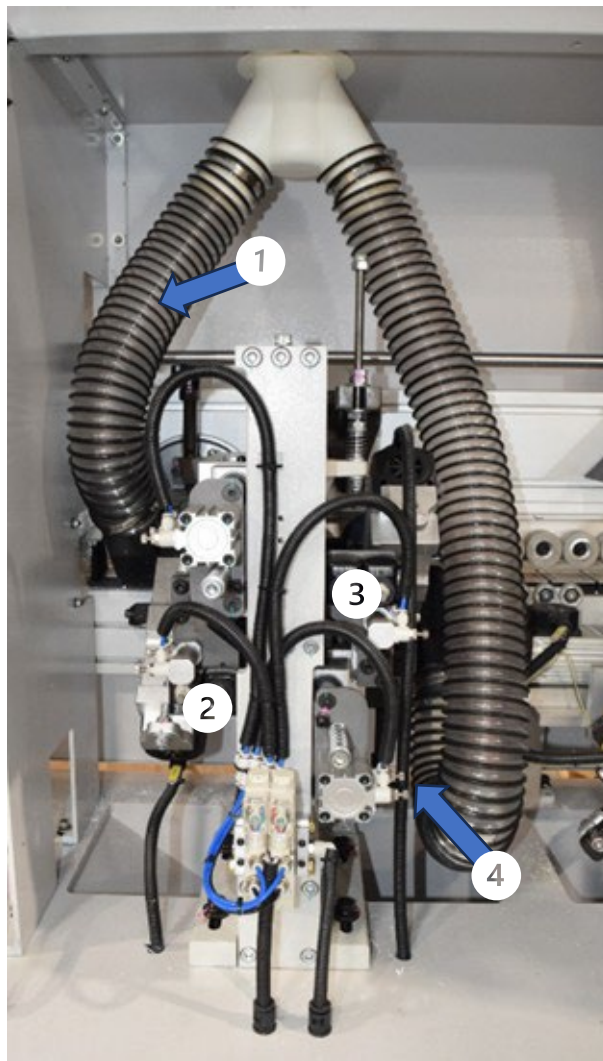
1. Insert an Allen wrench into the back of the motor.
2. Use a 17mm wrench to remove nut.

3. Please note that the retaining nut on the right, or back end cutter, motor is left hand threaded.

12.5 Trimming Station

The Fine Trimming Station cuts excess material from the edge, creating a smooth rounded profile. The cutter can be oriented to produce a flat or rounded over profile depending on material thickness and type. For example, real wood is thin and would be cut with a straight cut, whereas thicker synthetic materials can support rounded edges.

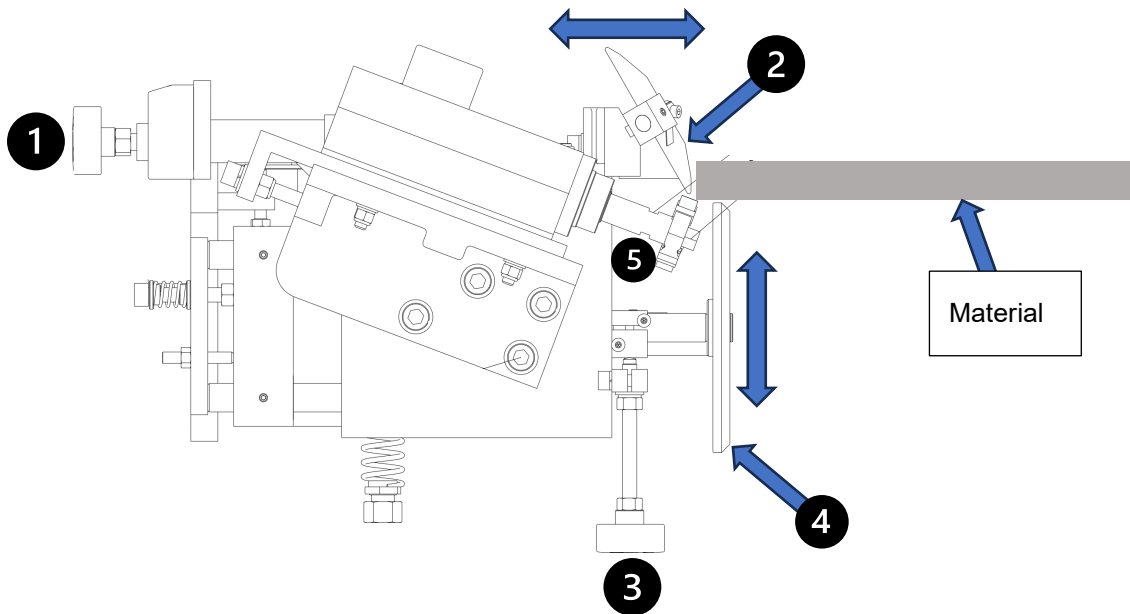
12.5.1 Adjustments



1. **Top trimming vertical adjustment knob.** (Behind dust hose in picture) Clockwise rotation of the knob will decrease the amount of material removed.
2. **Top trimming horizontal adjustment knob.** A larger number will remove more material.

3. **Bottom trimming horizontal adjustment knob.** A larger number will remove more material.
4. **Bottom trimming vertical adjustment knob.** Clockwise rotation of the knob will decrease the amount of material removed.

12.5.2 Working Principle



Above is an illustration of the side view of the trimming mechanism.

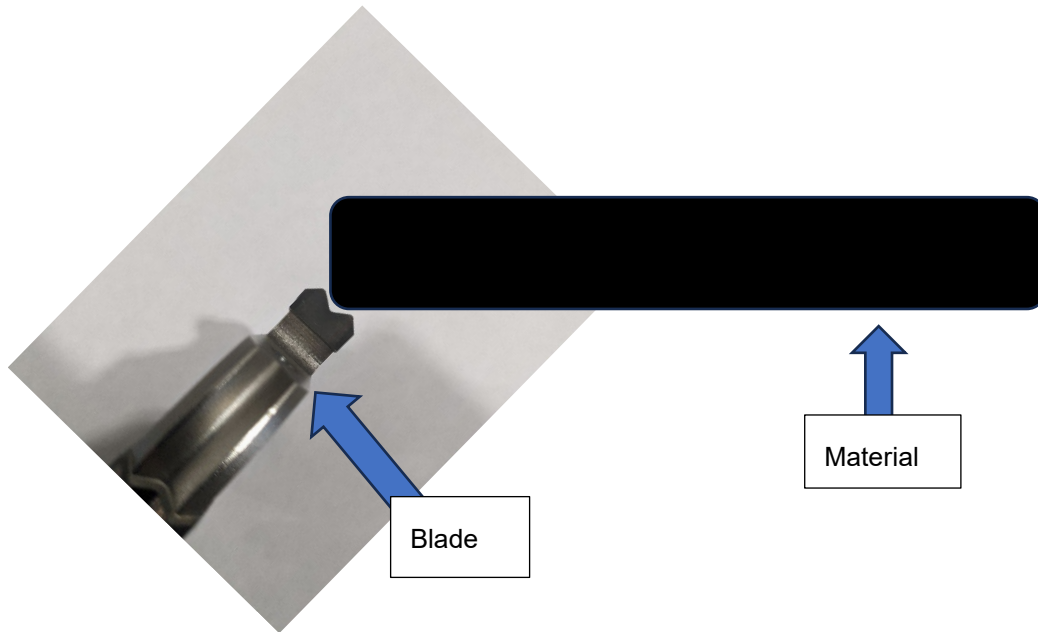
Notice that the blade "5" is set at an angle in relation to the material. Blade and motor stay fixed and following wheels are adjusted to change blade position.

When "1" is increased or decreased it moves the following wheel "2" that rides along the material edge.

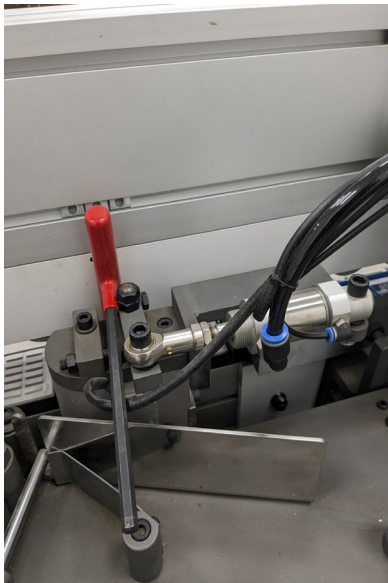
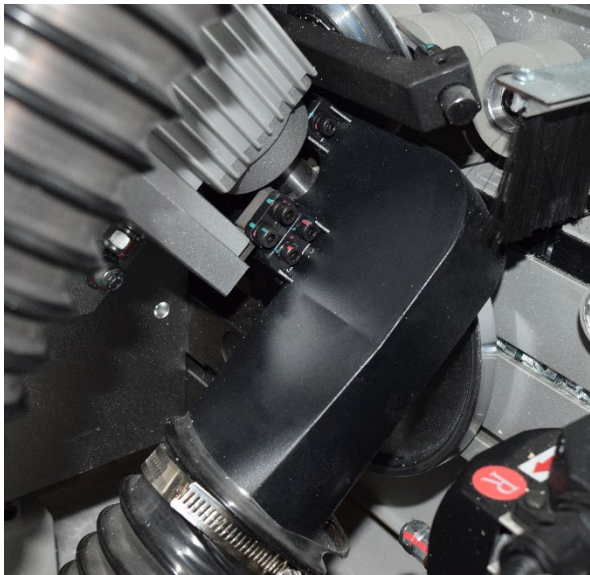
When "3" is increased or decreased it moves the following wheel "4" that rides along the surface of the material.

The blade "5" has a concave cutter that is aligned with the edge of the material using both adjustment knobs.

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The photo above shows the relationship between the material edge and the profile of the blade. You can see how the blade “teeth” are slightly larger than a 90 degree opening and the valley is a radius. The goal is to position the valley right onto the edge of the material.

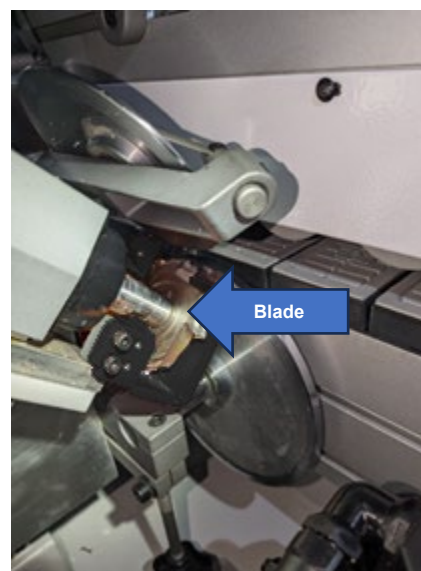
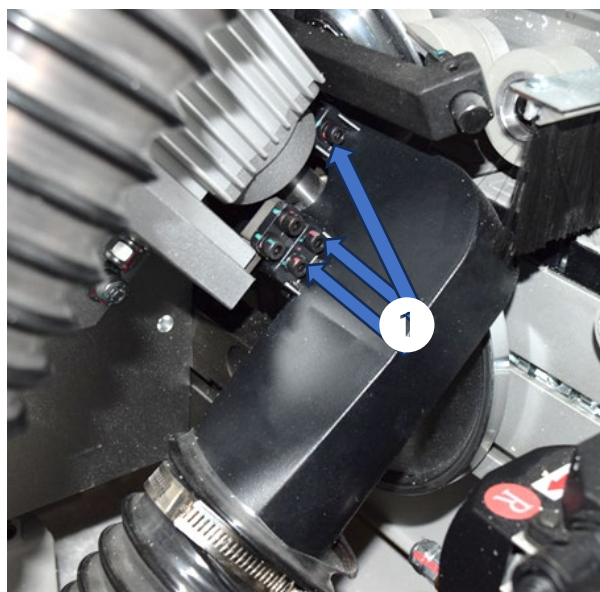


Sometimes the relationship of the blade to the corner of material is difficult to align. Utilize this method if desired:

1. Allow machine to cool.
2. Disable the glue pot with a spacer.

3. Remove the guards from the trimming unit per photo above.
4. Turn on only the track. No other stations are needed.
5. Feed a piece of material thru the machine.
6. Pause the material with the green button when material is halfway thru the station. You will have to run the cord outside of the service door so machine will function.
7. Visually inspect the relationship of the blade profile to the material's edge.
8. Adjust to position. Rotate the blade manually until the valley just touches the material.
9. Feed material out of conveyor.
10. Replace blade guards.
11. Turn on all stations and run test material through the machine. Adjust as necessary.

12.5.3 Blade Replacement

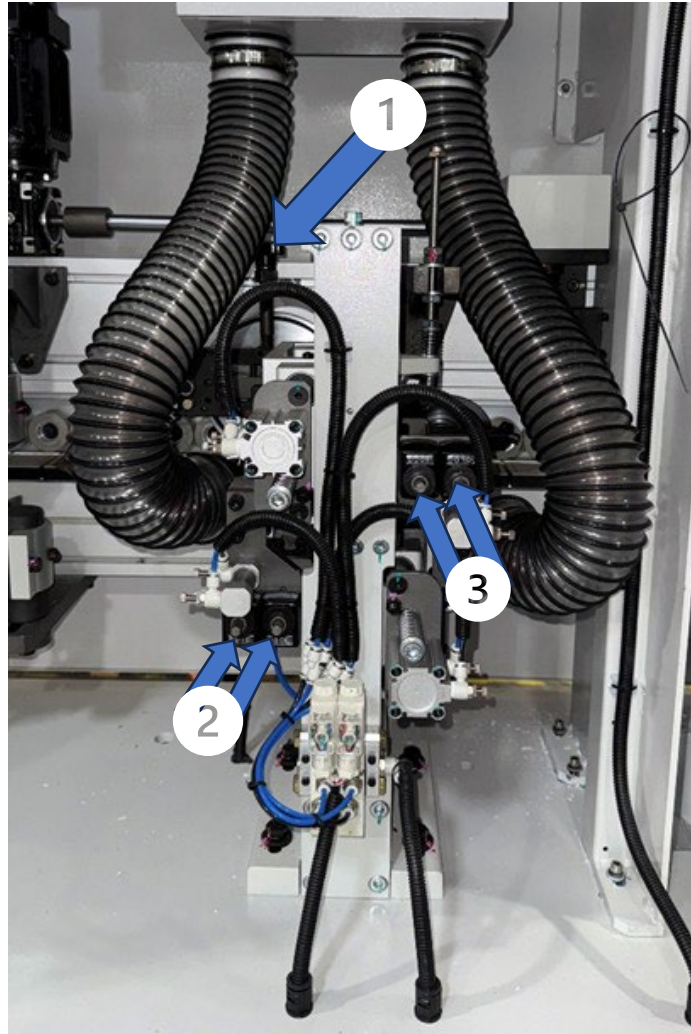


1. Remove the bolts at "1"
2. Remove the dust cover.
3. Use two 17 mm wrenches to loosen retaining nut to replace blade.
4. Please note that the nuts are left hand threaded on the right cutter.

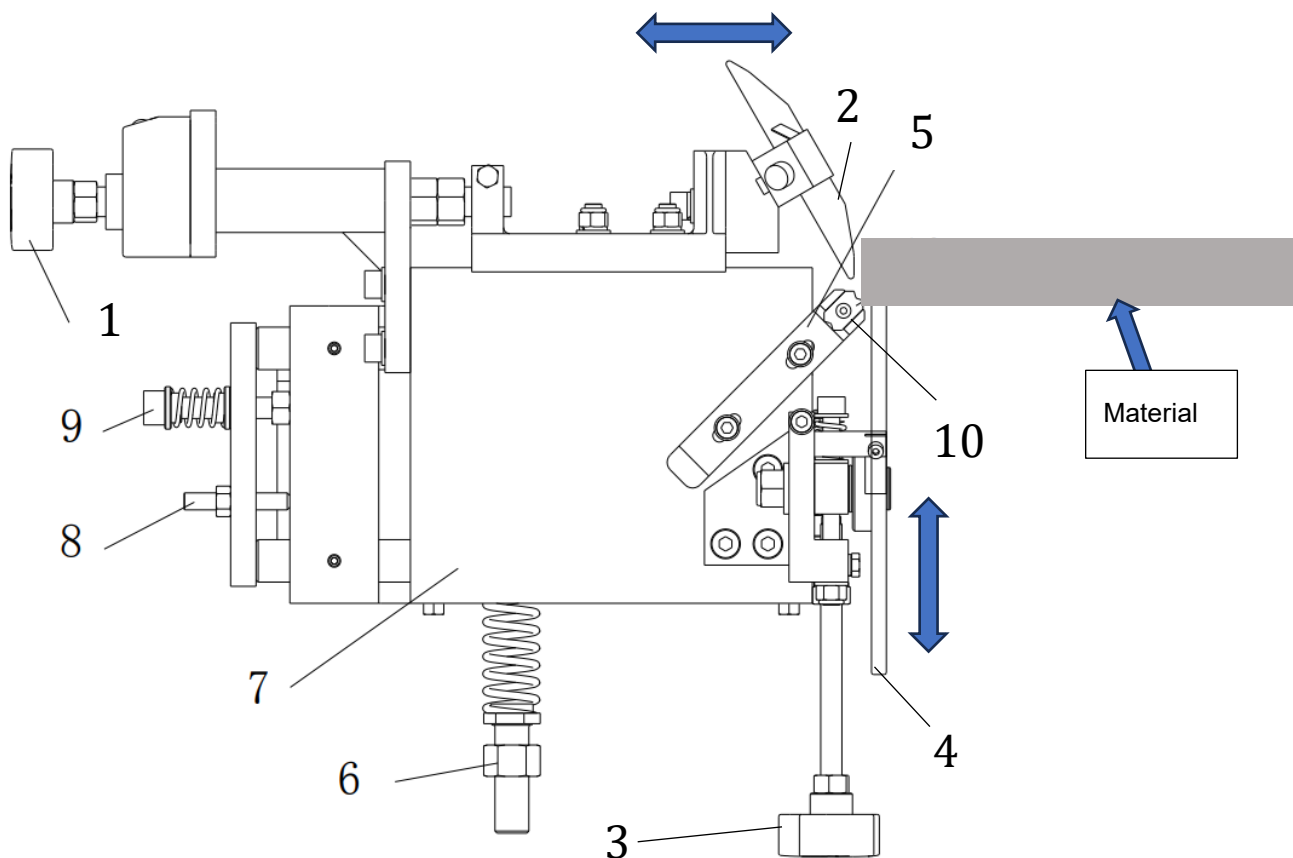
12.6 Corner Scrapping Station

The Scrapping Station removes the small amount of leftover wood particles produced from the Fine Trimming Station. The amount of material removed during scrapping can be as small as 100 microns in thickness.

12.6.1 Adjustments



1. Top scrapping vertical adjustment knob. (Behind dust hose in picture) Clockwise rotation of the knob will decrease the amount of material removed.
2. Top scrapping horizontal adjustment knobs. A larger number will remove more material.
3. Bottom scrapping vertical/horizontal adjustment knobs. Clockwise rotation of the knob will decrease the amount of material removed.



- | | |
|----------------------------------|---|
| 1. Feed Adjustment Handle | 6. Pressure Adjusting screw (bottom trimming) |
| 2. Upper Wheel | 7. Scraping slide carriage |
| 3. Guide Roller Adjusting Handle | 8. Limit Bolt |
| 4. Lower Wheel | 9. Pressure Adjusting Screw (trimming cutter) |
| 5. Scraper Carriage | 10. Scraper |

Above is an illustration of the side view of the scrapping mechanism.

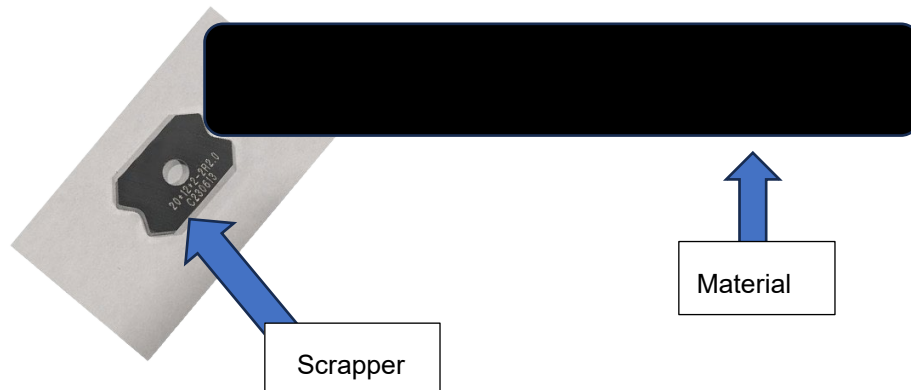
Notice that the scrapper "5" is set at an angle in relation to the material. Following wheels are adjusted to change scrapper position.

When "1" is increased or decreased it moves the following wheel "2" that rides along the material edge.

When "3" is increased or decreased it moves the following wheel "4" that rides along the surface of the material.

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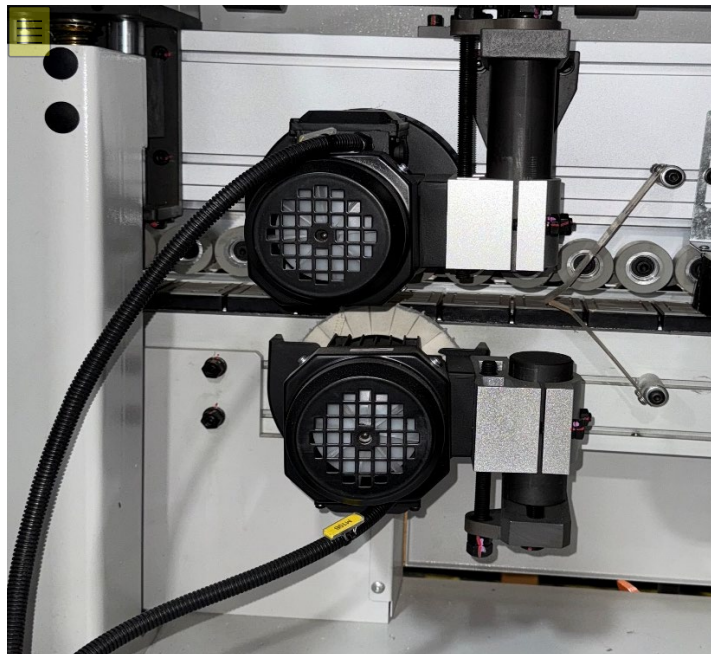
The scrapper "10" has a concave cutter that is aligned with the edge of the material using both adjustment knobs.



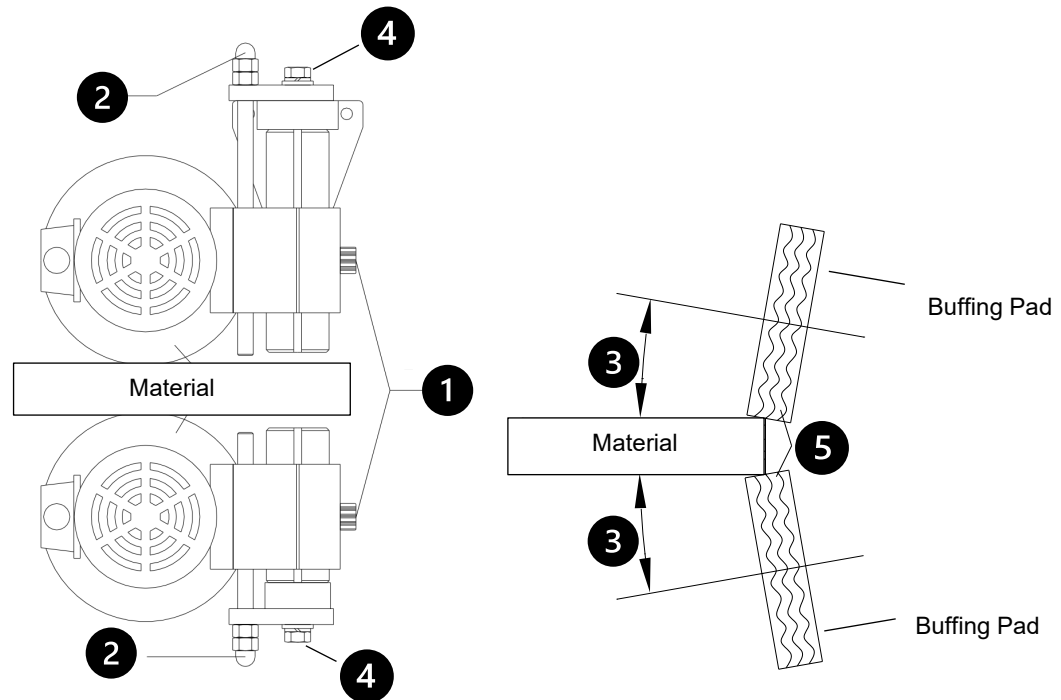
The photo above shows the relationship between the material edge and the profile of the blade. You can see how the scrapper "teeth" are slightly larger than a 90 degree opening, and the valley is a radius. The goal is to position the valley right onto the edge of the material.

12.7 Buffing Station

12.7.1 Adjustment



The buffing unit is used to remove residual glue and buff the edgebanding. Because the buffing wheel removes residue it will become saturated in adhesive overtime. This is normal and the buffing pad should be inspected and replaced regularly. If using your equipment daily you may replace a set of buffing pads monthly.



The distance of the buffering pad to the surface of the material should lightly touch the material. Too much pressure and the buffering pads will cause too much friction and melt the residue glue into the material surface.

Generally when adjusting the buffering wheel the outside of the wheel should just touch the material and then lowered 2-4mm below that.

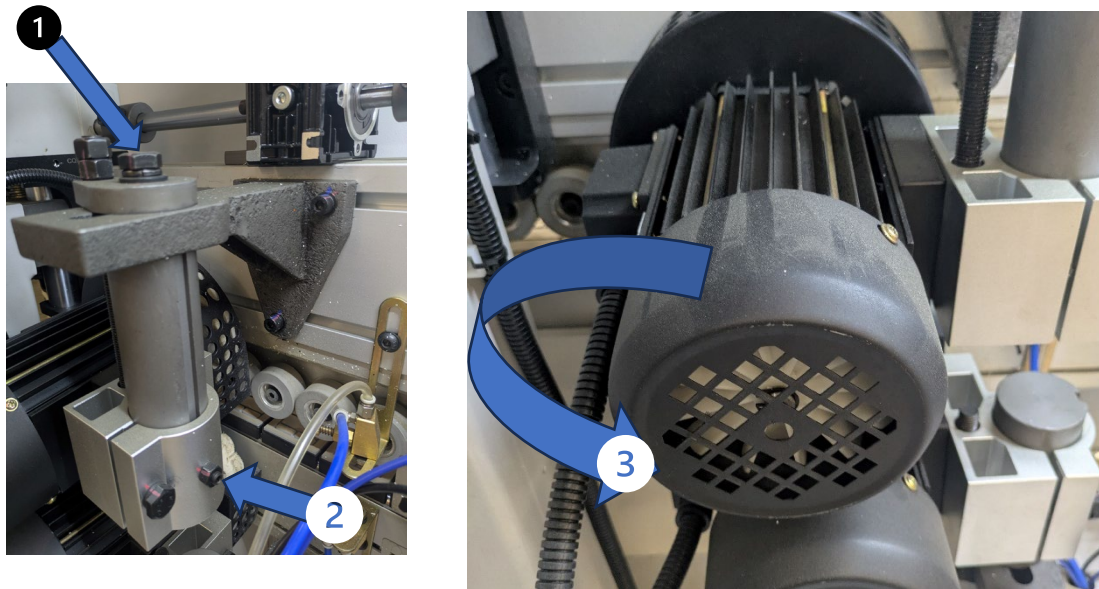
To adjust:

Loosen bolt "1" and screw bolt "2" to the desired distance. Retighten when done.

The angle of the buffering pads should be approximately 10-15 degrees.

To adjust the angle, loosen bolts "1" and rotate to desired angle. Retighten when done.

12.7.2 Buffing Wheel Replacement

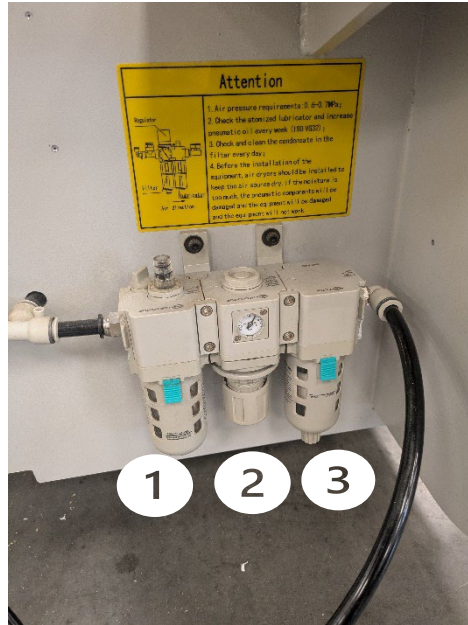


1. Mark the original location of the adjustment of the buffing wheels.
2. Loosen the bolts on "1" and "2".
3. Rotate the motor outward "3"
4. Insert a long Allen key thru the buffing cover into the buffing motor plate and feed the Allen key into the locking hole. Rotating buffing wheel and repositioning may be necessary to locate the holes.
5. Remove the bolt from the front of the buffing wheel.
6. Retighten and readjust as necessary.

12.8 Main Air Regulator

1. Adjust to 90-100psi.
2. Machine is adjusted at Laguna facility supplied with 100psi air supply.
3. Air regulator is set in bars. 100psi is 6.9 Bars

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1. Pneumatic oil cup
2. Pressure regulating knob. Pull up to unlock, adjust accordingly then press down to lock into position.
3. Water filter cup

The fitting needed for the air regulator is metric. The thread size is M10 and the tubing size is 12mm OD.

13.0 Test Run

Before operating the machine or workpiece, Laguna Tools recommends that the operator become familiar with the controller for operation of the machine.

13.1 Preliminary checks

1. Clear all setup tools and other loose items away from the machine.
2. Turn the master power switch OFF and press the Emergency Stop button in.
3. Connect machine to power by inserting power cord plug into a matching receptacle
4. Connect machine to an air supply and adjust air regulator to 90 PSI.
5. Twist the Emergency Stop button clockwise until it springs. This resets the switch so the machine can start.
6. Turn the master power switch ON. The thermoregulator display on the control panel should illuminate.
7. Watch the thermoregulator display and listen for glue spindle motor to start. When the upper number reaches 356°F (180°C), the glue spindle motor should turn ON.

13.2 Operation

1. Turn on the primary power switch, located on the side of the machine below the control panel.
2. Turn on the control panel switch.
3. Turn on the glue heating on the control panel.
 - a. Adjust the temperature of the glue heater to the values specified by the adhesive manufacturer.
4. Load edgebanding tape/material onto the material plate and feed it into the edgebanding guides. Banding should be fed up to the blade of the guillotine cutter.
5. Let glue spindle rotate for at least 3 minutes after machine reaches operating temperature. This ensures that the glue spindle is fully primed.
6. Turn on all applicable stations.
7. Feed material into the machine.
8. Inspect the edgebanding and make any adjustments if needed.

13.3 Starting Sequence

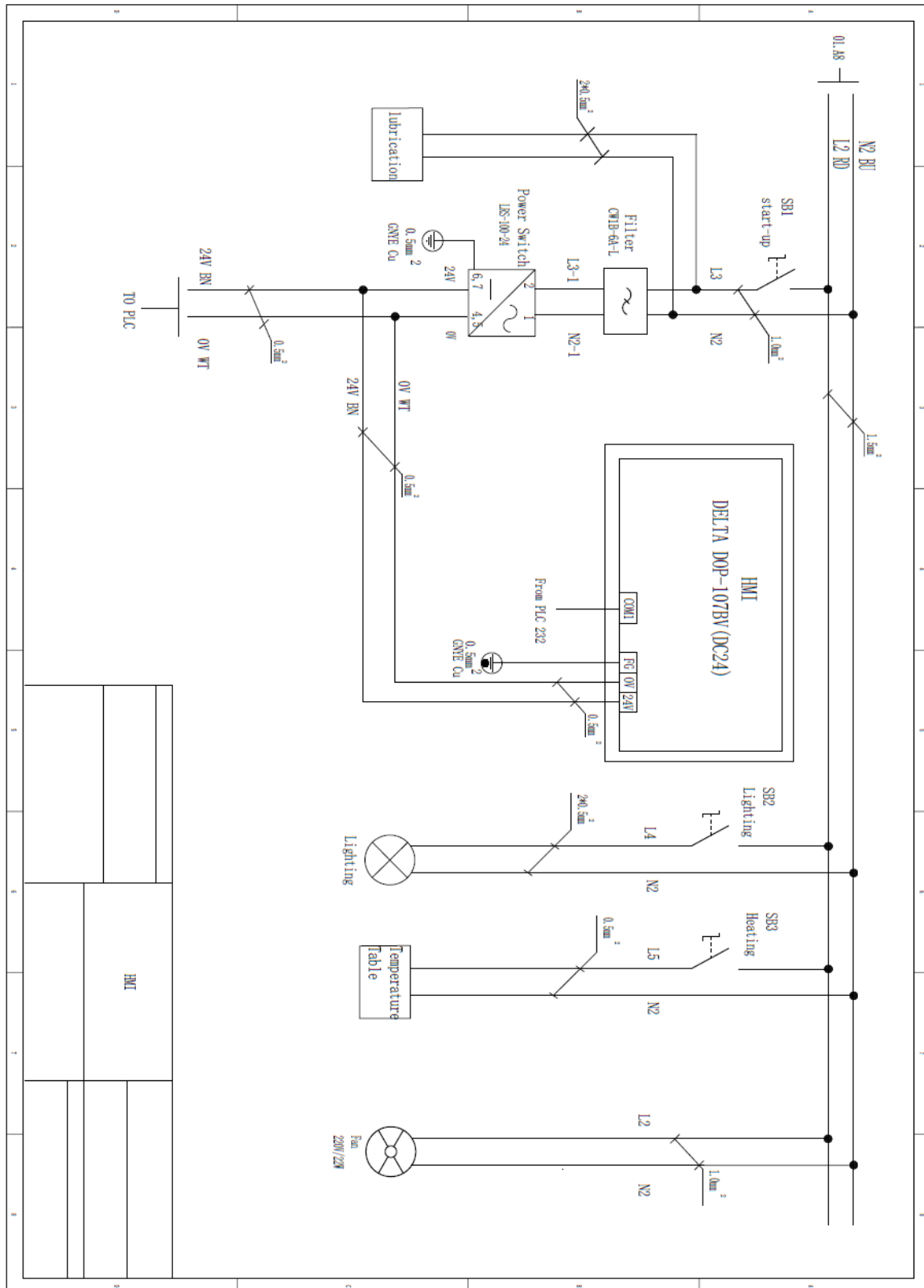
1. Connect machine to air supply.
2. Switch on the primary power switch located on the side of the machine below the control panel.
3. Turn the switch on the control panel to on.
4. Turn on glue heating on the control panel.

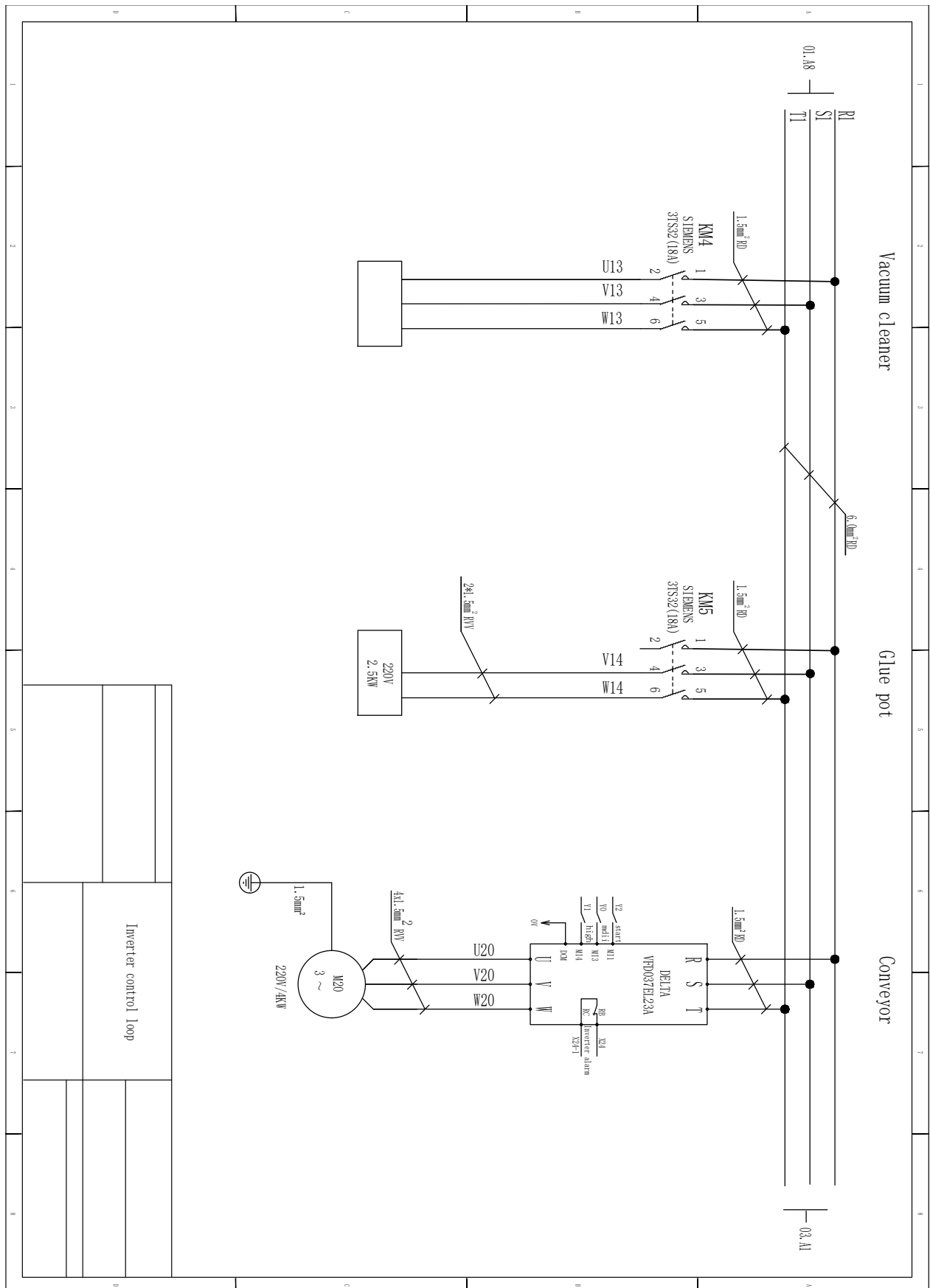
5. Adjust the temperature of the glue heater to the values specified by the adhesive manufacturer.
6. Load edgebanding material onto the material plate and feed into the edgebanding guides. Banding should be fed up to the blade of the guillotine cutter.
7. Let glue spindle rotate for at least 3 minutes after machine reaches temperature. This is to ensure that the glue spindle is fully primed.
8. Turn on all applicable stations.
9. Feed material into the machine.

13.4 Power Off Sequence

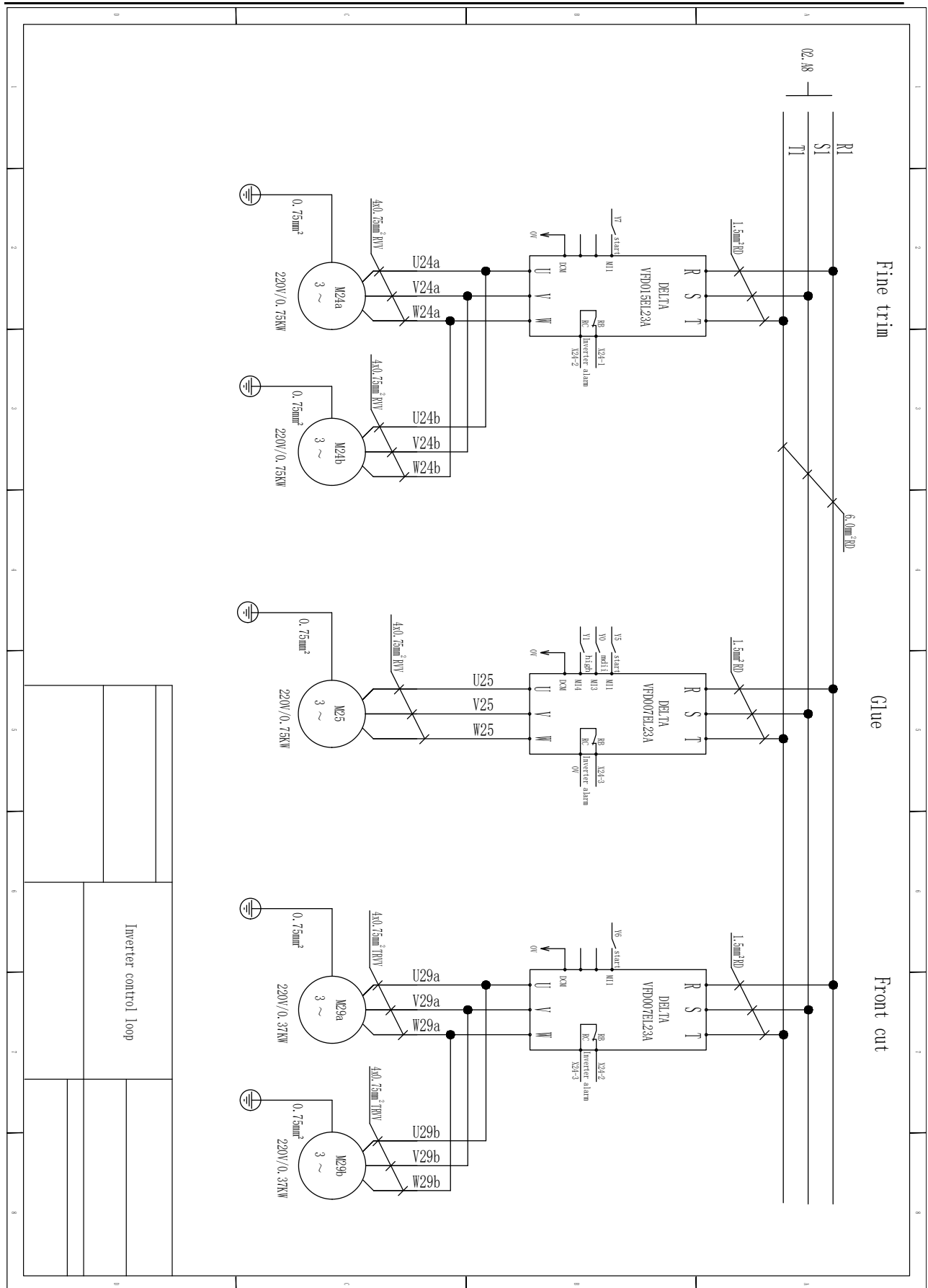
1. Turn off all stations and heaters on the control panel.
2. Turn off power switch on the control panel.
3. Turn off main power switch on the side of the machine.
4. Turn off any air supply.

14.0 Wiring Diagrams





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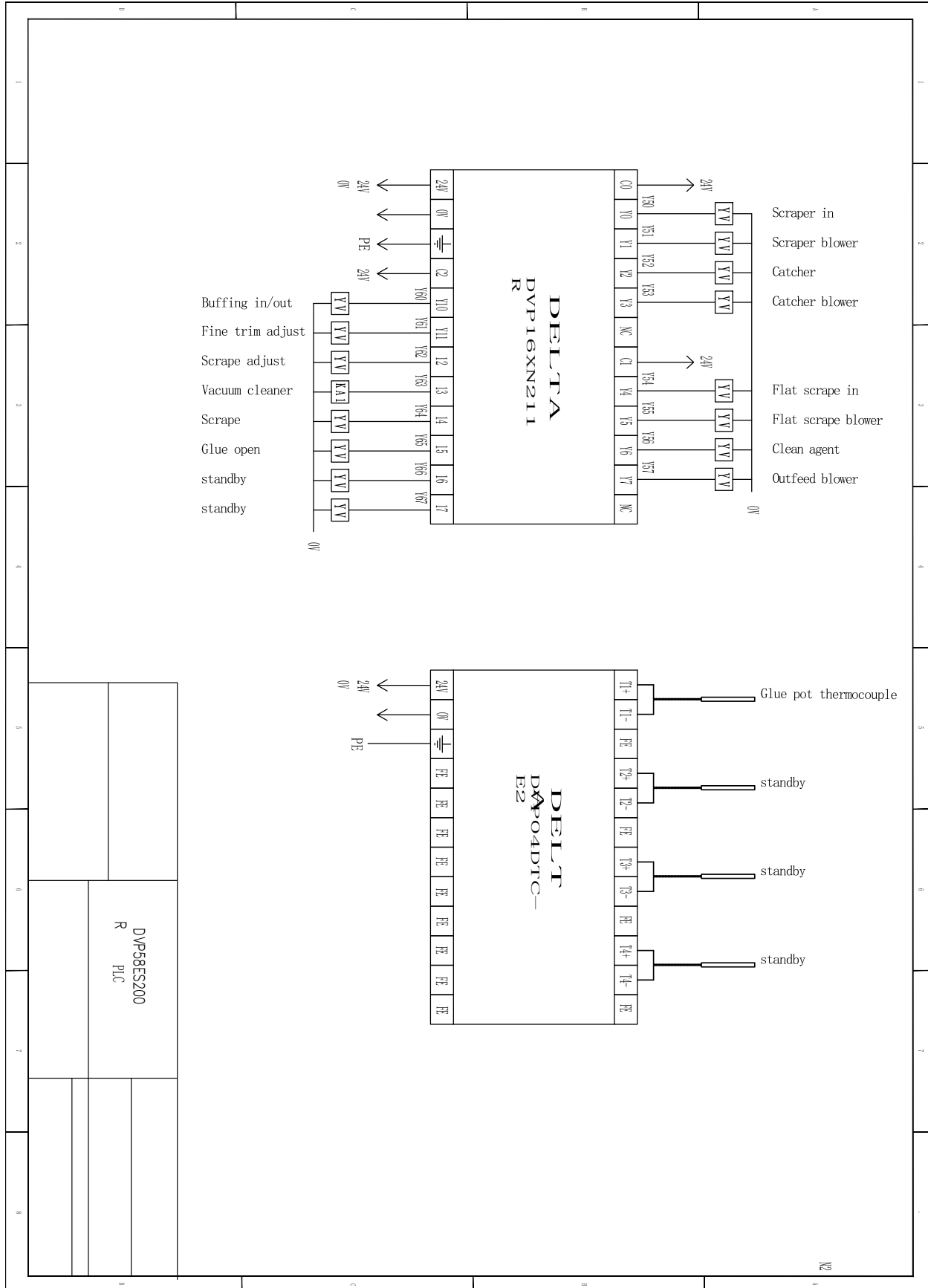




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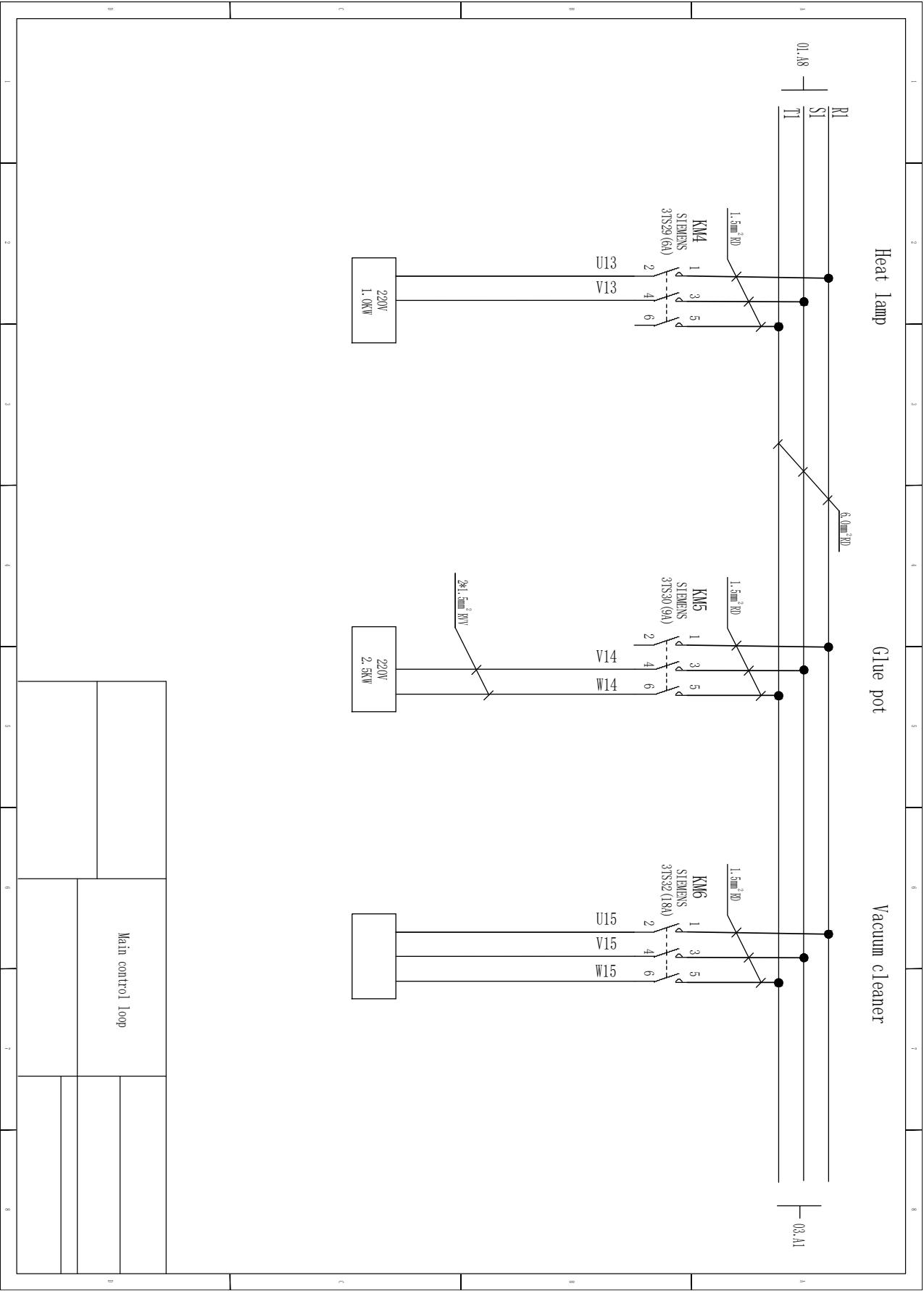


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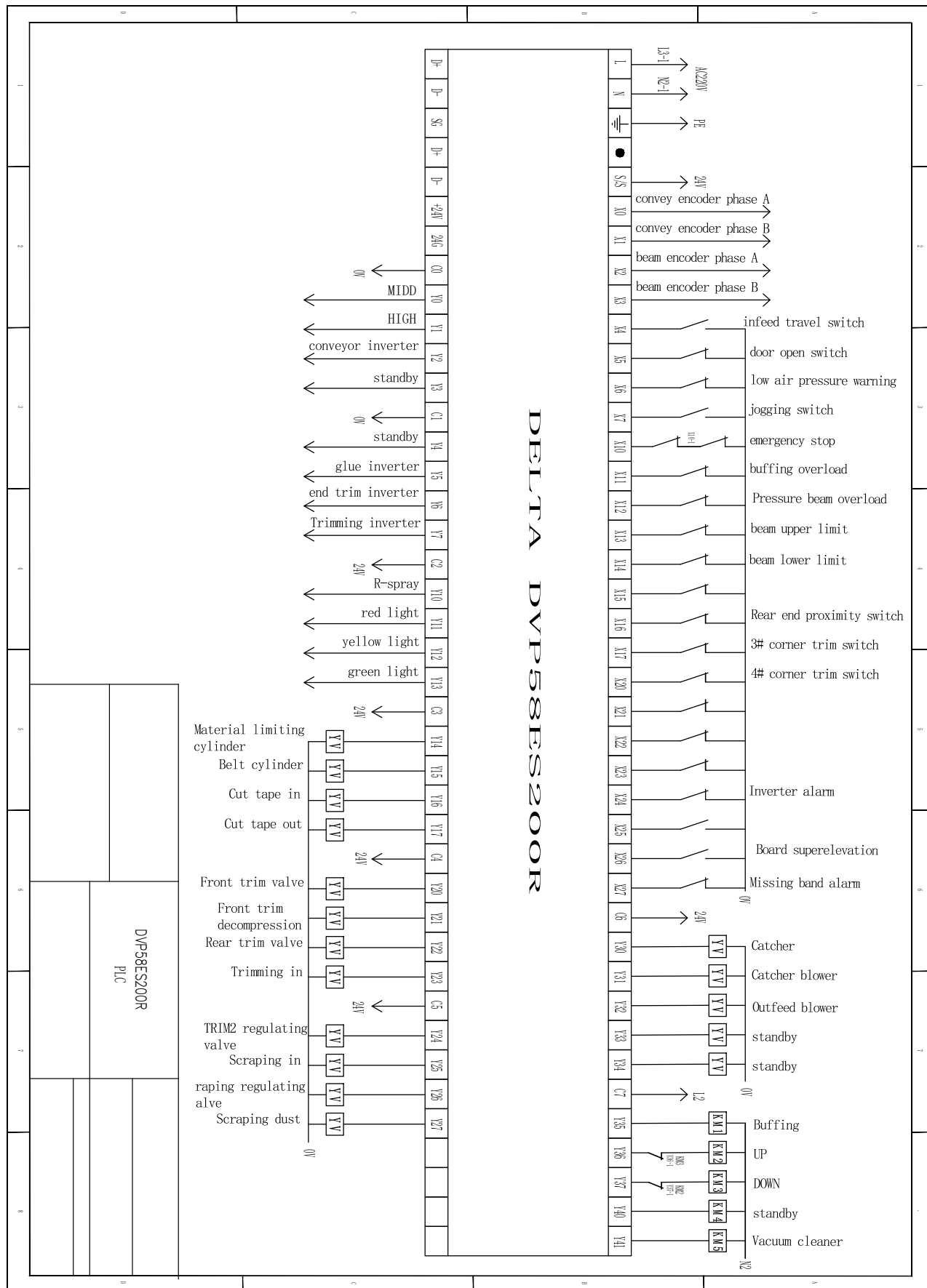


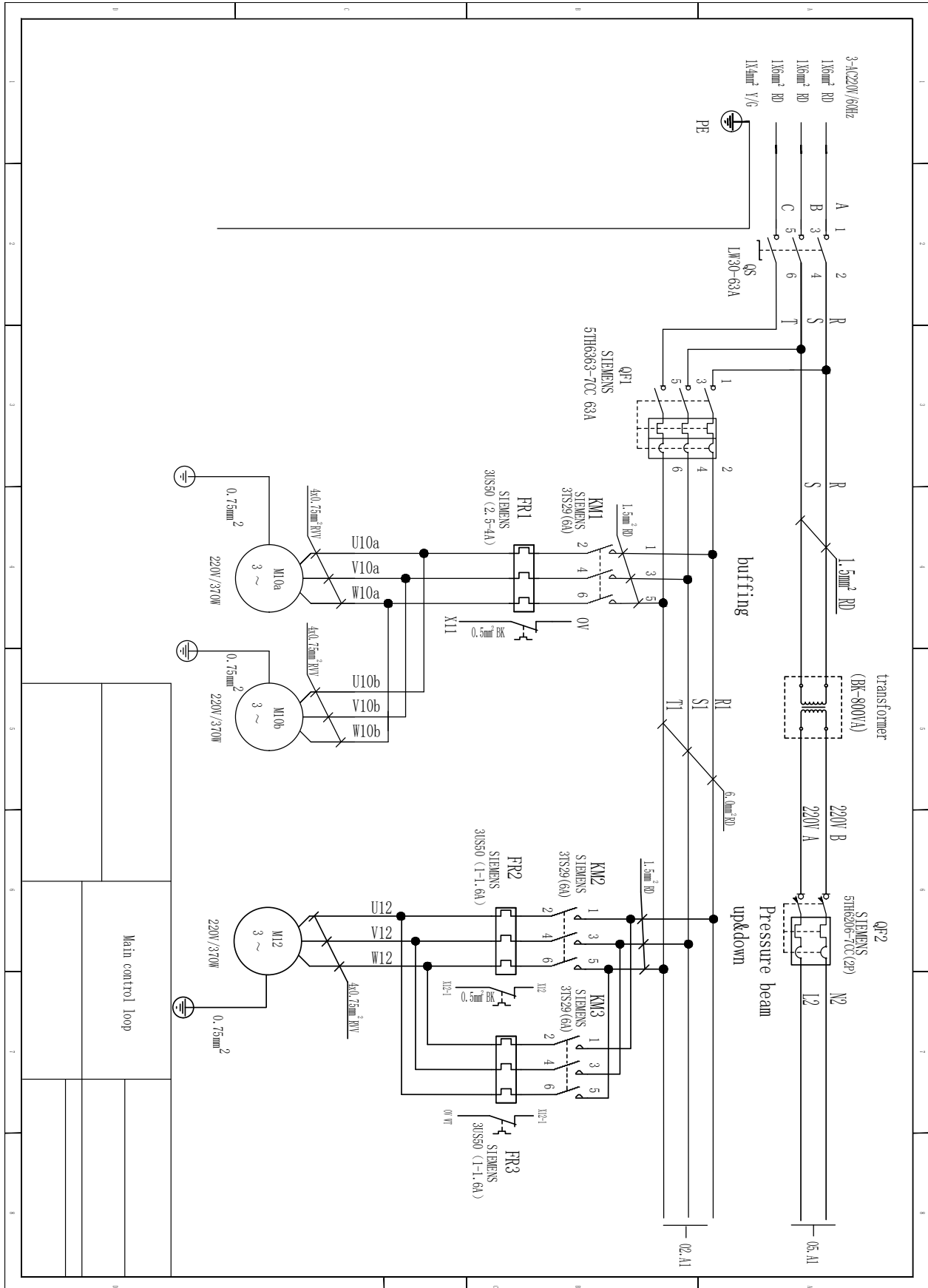
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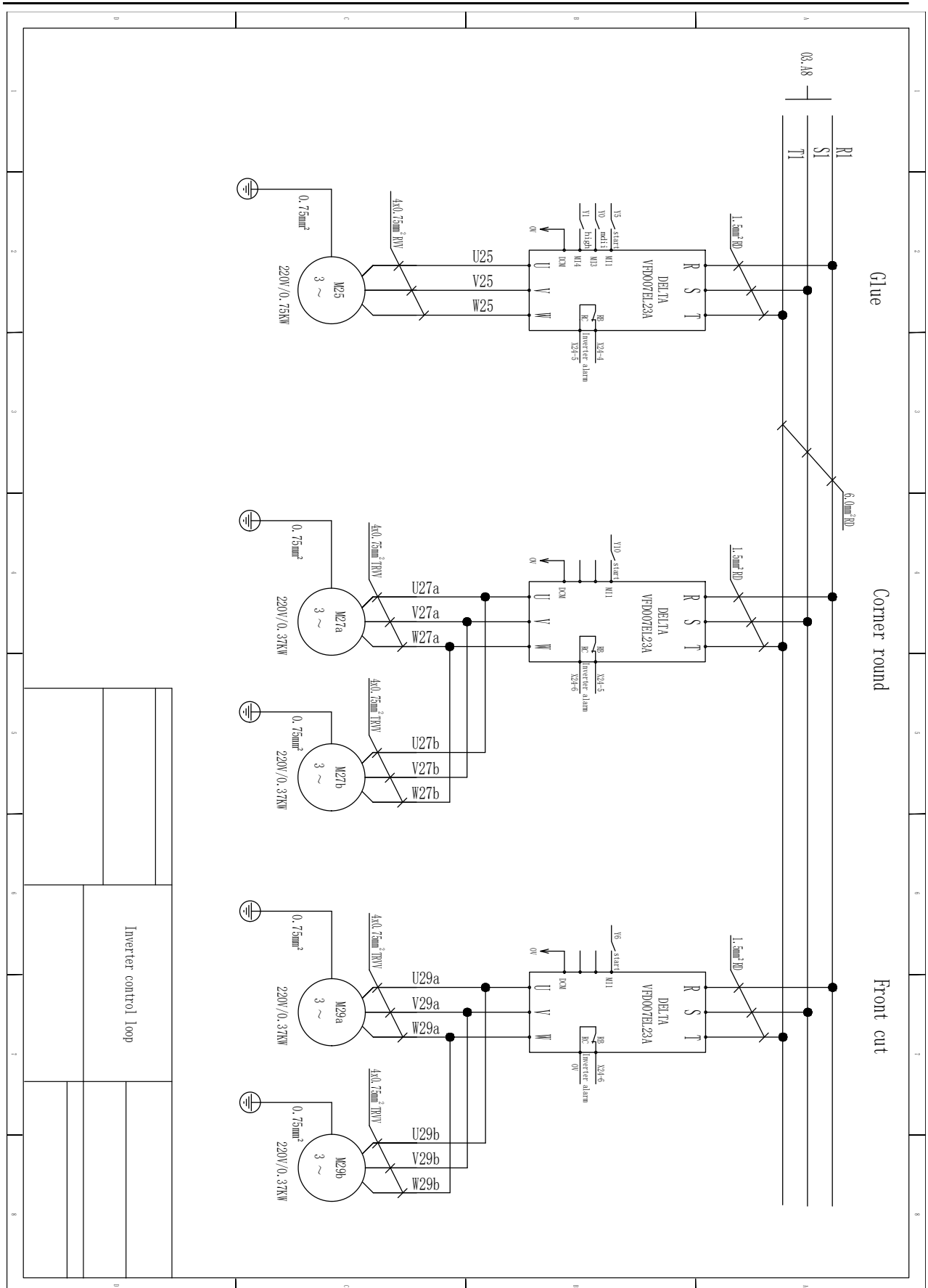


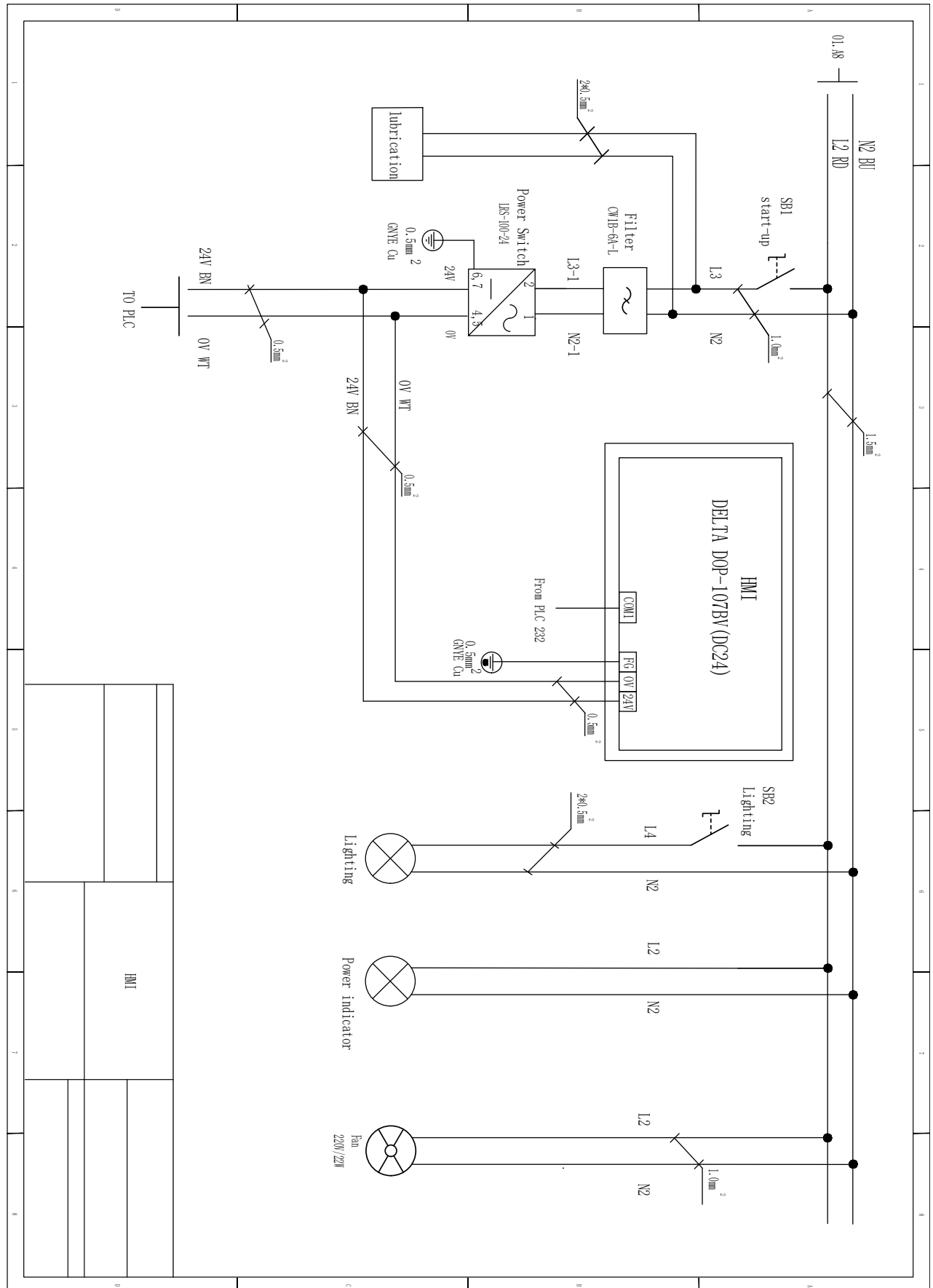
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15.0 Maintenance

As with any machine, to ensure optimal performance you must conduct regular maintenance.

Failure to follow maintenance procedures will void the warranty.



WARNING

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

Table is based on 30 hours of use a week

	Daily	Weekly	Biweekly	Monthly	Biannually
Inspect Glue Pot glue level	X				
Inspect Glue Pot Health	X				
Inspect Buffing Pad	X				
Inspect Main Air Regulator for water and oil level	X				
Blow off all loose debris from inside and outside machine.	X				
Remove scrapping debris from catch box	X				
Inspect Guillotine Blade		X			
Inspect End Trim cutter.		X			
Inspect Corner Trimming blades. (if applicable)		X			
Inspect Scrapping Blades		X			
Inspect Oil Level				X	
Lubricate Linear Rods and Bearings				X	
Replace the Lubrication Oil with VG 32 heavy-duty gear oil					X
Clean Conveyor Pads and Rollers				X	
Grease glue pot fittings	X				
Inspect oil lines to ensure oil is flowing	X				
Clean excess glue residue from pressure rollers		X			
Purge glue from Glue Pot				X	
Note: Replace the lubrication oil every 3000 hours of use once the first biannual oil replacement is completed.					

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1. Automatic Oiler



- a.
- b. Fill with VG 32 heavy-duty gear oil to fill line on tank. This oil is for the motor gearbox on the conveyor belt

NOTE

The oiler runs when connected to power.

The oiler disperses oil every 437 minutes for 2 seconds.

2. Spindle and Conveyor

- a. T26419 or NLGL#2 Equivalent Grease
- b. This is a higher temperature grease.
- c. Use a grease gun to pump grease fittings.
- d. A service panel on the back side of the glue pot must be removed to expose the glue pot grease fitting.

3. Linear Rods on All Stations except End Cutting

- a. T26419 or NLGL#2 Equivalent Grease
- b. This is a higher temperature grease.
- c. Apply to cloth rag and wipe linear rods.

4. Main Air Regulator

- a. Fill with Pneumatic oil to recommended level indicated on device.

5. Removal and Replacement of Glue from Glue Pot

- a. Warning: Use caution and appropriate Personal Protective Equipment when performing this task.

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- b. Prepare a waste board at least 2x larger than the glue pot and 2 qty hardwood 1"x2"x15" sticks before proceeding. Some have found it to be easier to add a vertical hardwood stick vertically in the front of the glue pot in addition to the two longer sticks. This allows you to pull vertically on the front of the glue slug to help it over the rim of the glue pot.
- c. Heat the machine to operating temperature.
- d. Place two sticks made of hardwood into the melted glue.



*Image is for reference only; your machine may vary slightly, but all steps and concepts still apply.

- e. Allow the machine to cool completely.
- f. Heat up the glue pot while gently pulling on the hardwood sticks upward and outward. There will be a point in time when the glue becomes just soft enough to release from the glue spindle and sides of glue pot.

Generally this softening occurs at about 176 degrees Fahrenheit (80 degrees Celsius).

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- g. Place the melted glue “slug” onto a waste board. Allow to cool completely before disposing.



- h. Scrape remaining glue out of glue pot. Select tools that will not scratch or damage the Teflon coating.
- i. Refill glue pot with new approved glue.

16.0 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.

Symptom	Possible Cause(s)	Troubleshooting Step(s)	Possible Solution(s)
Sensor not responding.	1. Terminal ends could be bad 2. Wire has failed 3. Sensor has failed. 4. PLC is having communication issues.	1. Isolate one I/O sensor. The proximity sensor is the easiest for testing. The proximity sensor allows a single user to test the I/O functionality by themselves by pressurizing and depressurizing the edgebander. 2. Ensure that the rear end trimming station has decompressed. 3. Check the I/O screen of the monitor for "Proximity Sensor" 4. Check the I/O LED on the PLC 5. Reconnect air pressure to the machine. 6. Check the I/O screen of the monitor for "Proximity Sensor" 7. Check the I/O LED on the PLC 8. Did the box change from gray to green or vice versa? If so the PLC/HMI are working correctly.	1. Check all fuses 2. Check all resettable breakers 3. Replace sensor 4. Replace PLC
Glue not flowing regardless of glue flow adjustments	1) Clogged inlet or outlet ports on glue pot 2) Spindle motor not turning. 3) Glue shaft is loose on glue spindle	1. Observe glue spindle for rotation. 2. Check 24v solenoid on air valve. 3. Check pneumatic lines. 4. Open pressure beam to max and observe spindle for glue flow. 5. Open glue pot and observe if glue is "cycling" like a lazy river.	1. Check all fuses 2. Check all resettable breakers 3. Clean glue pot. 4. Re "center" the glue arm by rotating and loosening the arm until it is adjusted within the right range of travel 5. Replace 24v solenoid.

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			Replace glue shaft motor.
3mm Banding does not fit in the tape feed spindle gap	Edgebanding spindle too small	Observe if 3mm edgebanding fits in between glue feed spindle and idle roller.	1. The gap for the tape feed needs to be increased. 2. Adjust the distance between the feed spindle and the idle spindle by loosening the 2 bolts that hold the idle spindle.
Tape is applied too short or long to material	1. Feed wheel may be slipping 2. Edge band surplus set is not set correctly	1. Check tension in feed roller and idle roller. 2. Verify that edge band surplus on control screen matches default screen in the guide. 3. Observe to make sure edgebanding Check for obstructions	Tape is applied too short or long to material
End Trim Station Roller Crushing Material	1. Excess air pressure is not allowing front cutter to travel the full length of the stroke.	1. Front cutter will appear to "bounce" when station activated manually. Material will crush as roller wheel rolls over material	1. Reduce overall pressure of stations using air regulators mounted on tower of station. 2. Adjust the trimming valves to bleed out excess air during downward travel.
Glue Pot Temperature is Erratic or Inaccurate	Glue Pot Thermistor is worn	Using a temperature gun, validate that temperatures are accurate to control screen reading.	Replace the thermistor in the gluepot.

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“EF” text followed by a number appears on VFD Display	1. Irregular voltage supplied to machine. 2. Debris or waste material has jammed motor shafts. 3. Seized Motor 4. Wire terminal failure. 5. Wire insulation failure 6. Wiring shortage 7. VFD is failing	1. Check all fuses and breakers. 2. Validate that supply voltage to machine is within spec. 3. With machine powered off try to manually turn blades of motors. 4. Measure continuity of connections for broken wire. 5. Temporarily change VFD addressing to test health of motors (advanced technique contact Laguna before proceeding) Measure health of 485 communication line. (advanced technique contact Laguna before proceeding)	1. Check all fuses and breakers. 2. Reset VFD pressing red button. 3. Power cycle equipment. 4. Replace loose terminals or broken wire. 5. Replace motor(s) 6. Replace VFD (Programming required) Replace PLC (Programming Required)
Pressure rollers do not move freely	Debris has built up under the pressure roller	Turn air off and push pressure rollers back and forth.	Remove pressure rollers and clear out debris.
Low Air Pressure Alarm	Air supply to equipment is too low and triggering alarm.	1. Verify air supply psi rating. 2. Ensure proper CFM is delivered to machine 3. Inspect machine for air leaks. 4. Temporarily by pass the main regulator to test functionality. Bypass the air pressure switch to test functionality	1. Repair air leak. 2. Replace main regulator. 3. Replace Pressure Switch.

17.0 Appendix

Parameter setting of Delta frequency converter

(This parameter is only used for 4 series models, Delta inverter)

Parameter Name	Parameter group	Conveyor	Follow the tracks of	Truing	End repair	Glueing	Pre-milling	Remarks
Maximum-frequency	01.00	200	200	200	200	200	200	Key description: ENTER (confirm), MODE (mode switching), Adventitia (increment plus) Admidia (incremental reduction)
Rated frequency of motor	01.01	50	200	200	200	50	200	
The motor is rated voltage	01.02	380	380	380	380	380	380	
Acceleration time	01.09	3				3	15	
deceleration time	01.10	1				1	15	
Terminal start and stop	00.01	1	1	1	1	1	1	
Multi-segment speed 2 (intermediate speed)	05.00	49				42.5		Velocity: Low-medium-high 16-20-24
Multi-segment speed 3 (high speed)	05.01	59				51		
Multi-segment speed 1 (low speed)	panel display	39.5	160	200	160	34	120	
failure warning	06.03	2	2	2	2	2	2	

Note: Other parameters are the factory setting of the frequency converter

manufacturer. When resuming the factory setting, set 00.02 to 9. Please refer to the

frequency manual for the use of the frequency converter.

18.0 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 and/or metalworking machine. The 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

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and all technical 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 and/or metalworking machine. The 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 and/or metalworking 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 woodworkers. 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 product, 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
www.lagunatools.com/why/customer-service/
8AM. To 5PM PSF. 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
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 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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