



MANUAL DE INSTRUCCIONES (E)

OPERATING INSTRUCTIONS (USA) (GB)

MODE D'EMPLOI (F)

GEBRAUCHSANWEISUNG (D)

MANUALE D'ISTRUZIONI (I)

MANUAL DE INSTRUÇÕES (P)



# EB15-2

Modelo • Model • Modèle • Modell • Modello • Modelo

Aplacadoras de Cantos Preencolados

Edgebander

Plaqueuse de Chants

Kantenleimmaschinen

Bordatrice

Orladora

# MANUAL DE INSTRUCCIONES

OPERATING INSTRUCTIONS

MODE D'EMPLOI

GEBRAUCHSANWEISUNG

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MANUAL DE INSTRUÇÕES



ESPAÑOL  
ENGLISH  
FRANÇAIS  
DEUTSCH  
ITALIANO  
PORTUGUÉS

**Aplacadora de Cantos Preencolados EB15-2**  
**EB15-2 Edgebander**  
**Plaqueuse de Chants EB15-2**  
**Kantenleimmaschinen EB15-2**  
**Bordatrice EB15-2**  
**Orladora EB15-2**

página/page  
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6  
9  
12  
16  
19  
22

Fig. 1

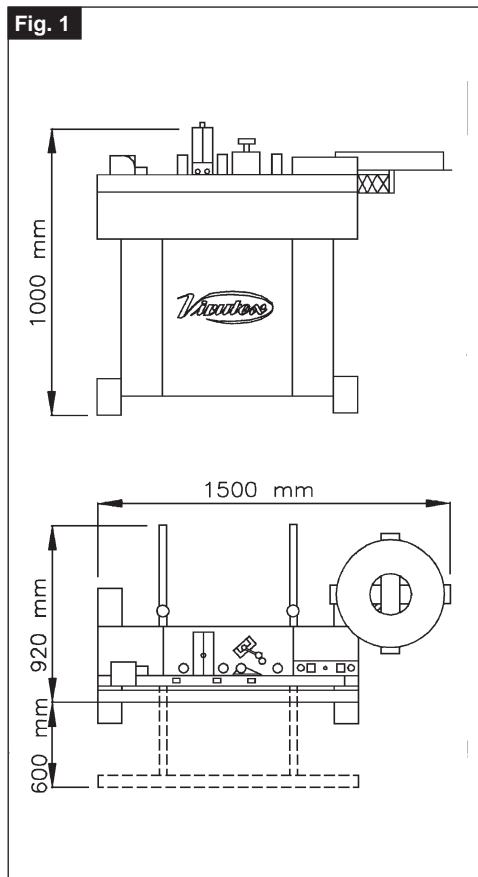


Fig. 2

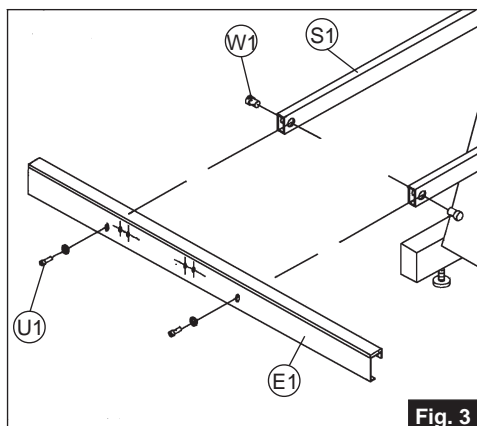
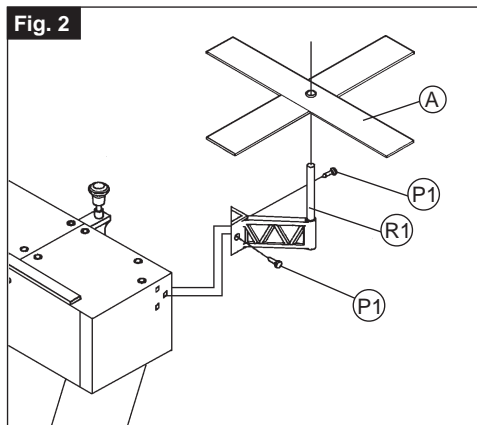
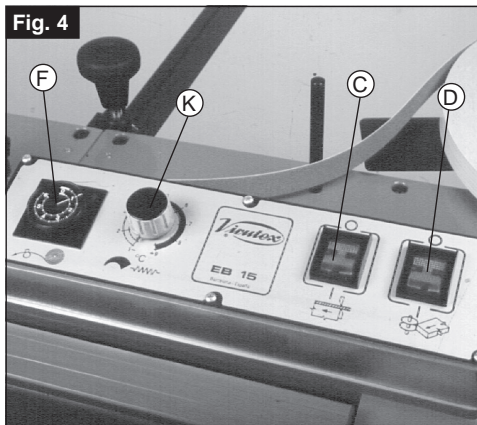
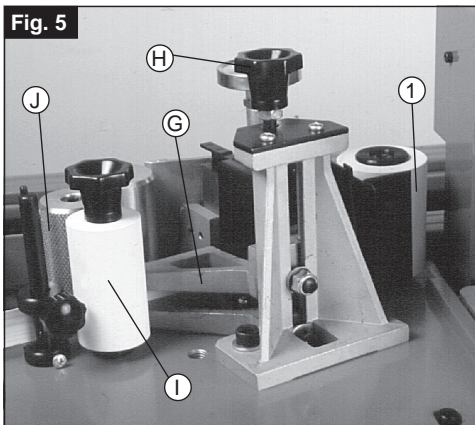


Fig. 3

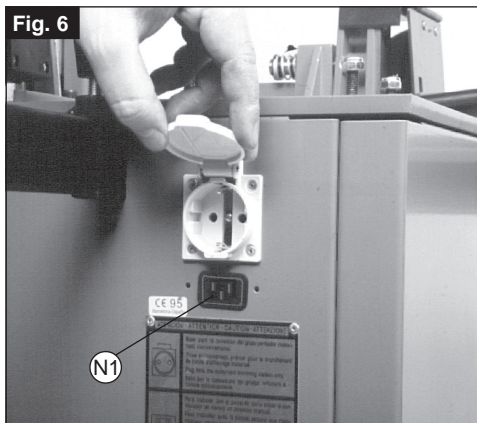
**Fig. 4**



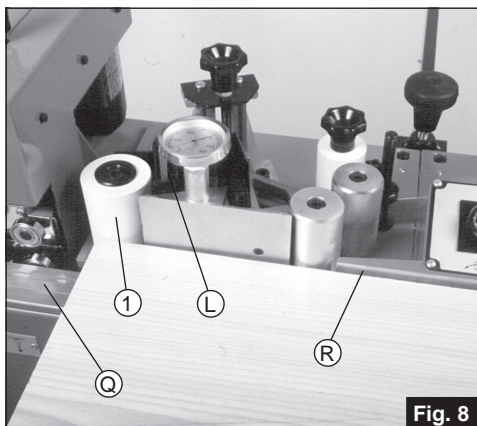
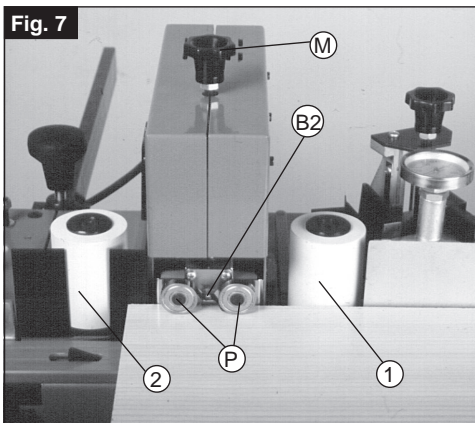
**Fig. 5**



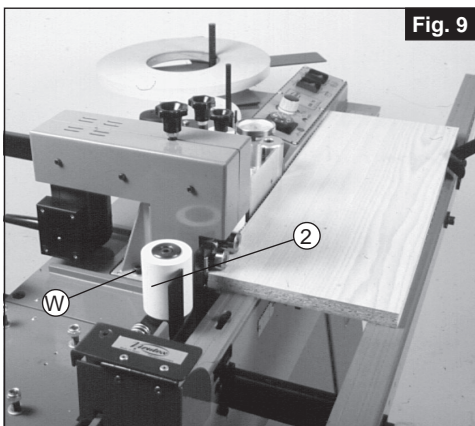
**Fig. 6**



**Fig. 7**



**Fig. 8**



**Fig. 9**

Fig. 10

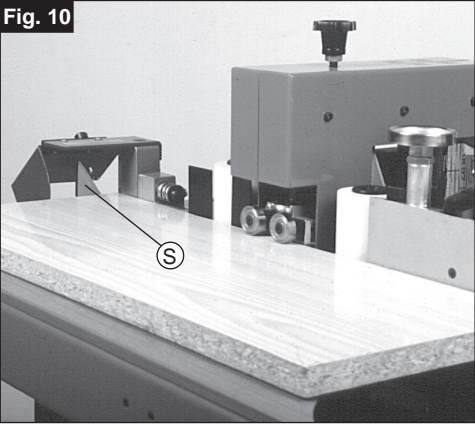


Fig. 11

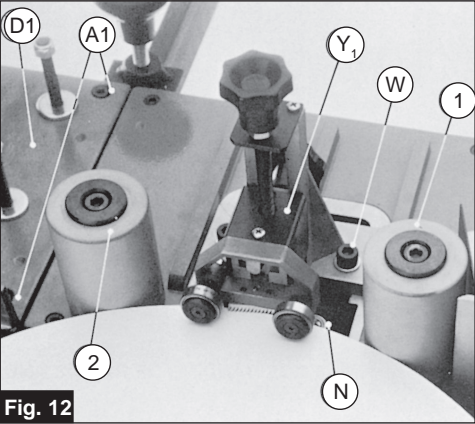
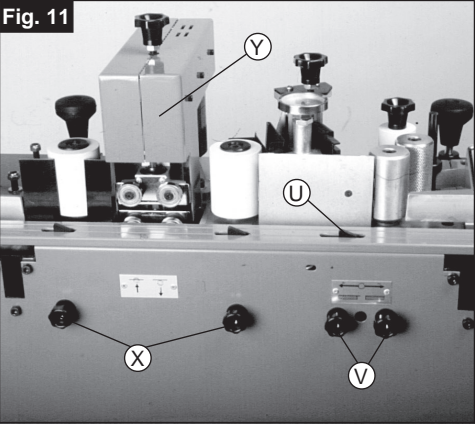


Fig. 12

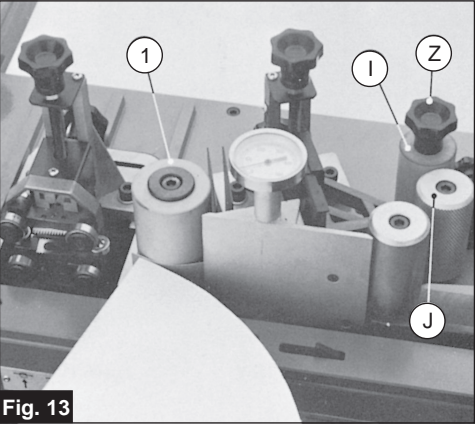


Fig. 13

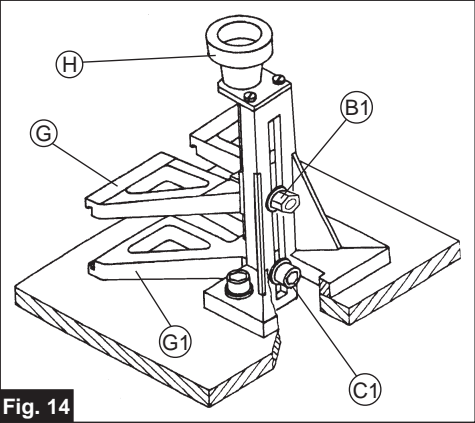


Fig. 14

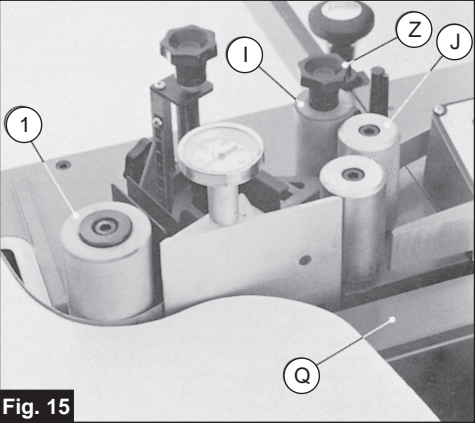


Fig. 15



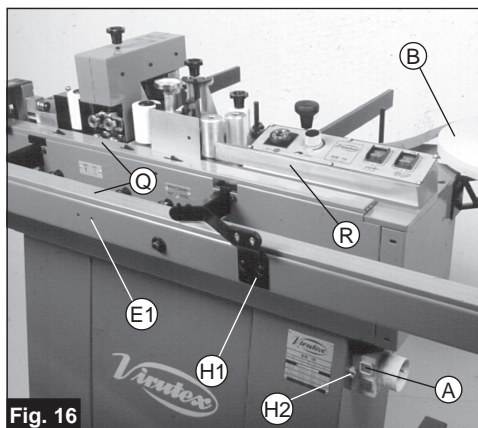


Fig. 16

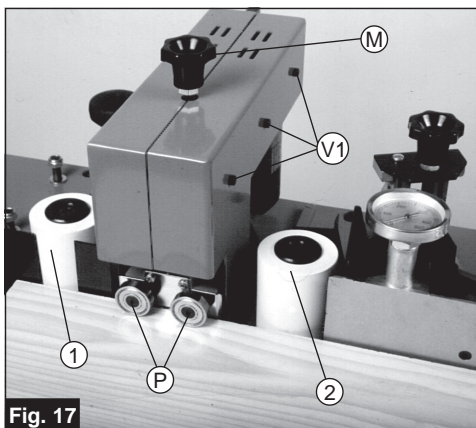


Fig. 17

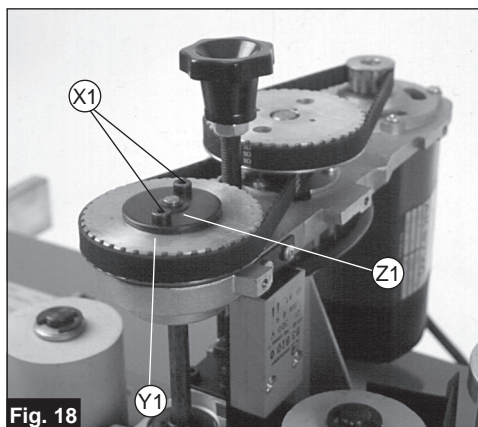


Fig. 18

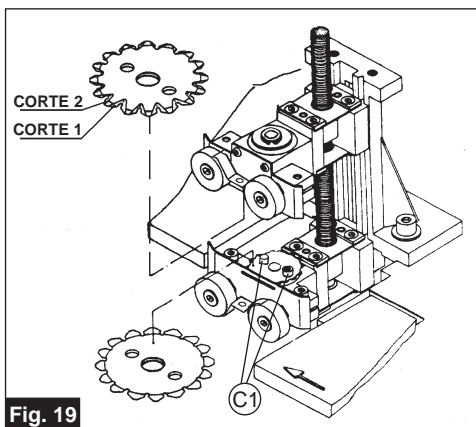


Fig. 19

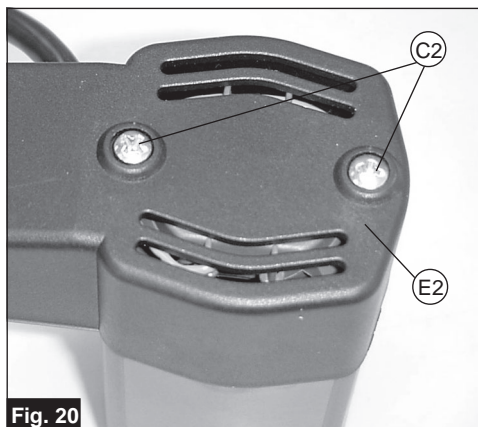


Fig. 20

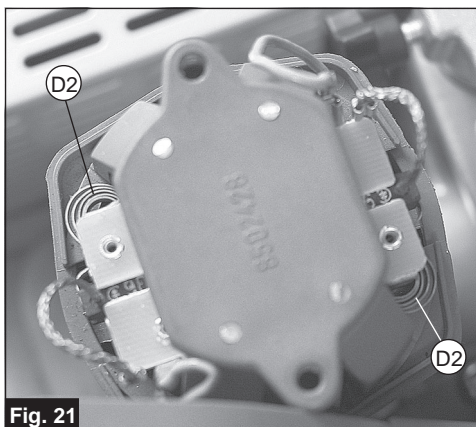


Fig. 21

VIRUTEX.  
Para esta operación no utilizar nunca papel esmeril.

15. ACCESORIOS OPCIONALES

4445003-PERFILADOR DE CUCHILLAS FIJAS  
Imprescindible para el perfilado de tableros circulares.

16. NIVEL DE RUIDO

El ruido de ésta herramienta eléctrica, está medido según ISO/DIS 230/5.  
El nivel de ruidos en el puesto de trabajo puede sobrepasar 85 dB(A). En este caso, es necesario tomar medidas de protección contra el ruido para el usuario de la herramienta.

17. RECOMENDACIONES

Para cualquier manipulación de mantenimiento en la máquina, desconectar ésta de la red eléctrica. Conservar el cable de alimentación y el enchufe en buenas condiciones.  
Para obtener un buen recorte de la cinta preencolada, debemos trabajar con las cuchillas limpias de cola y bien afiladas.  
También la máquina, debe encontrarse limpia de cola y recortes de cinta, para evitar posibles atascos en el desplazamiento efectuado por la cinta preencolada. La presión que efectúe el alimentador (accesorio opcional), sobre la superficie de los tableros, debe ser la necesaria para el arrastre de los mismos. Una presión en exceso, provoca un deterioro anticipado de la correa de arrastre.  
También es conveniente, que la superficie de la misma, esté limpia de restos de cola o de cuerpos extraños, con el fin de obtener un perfecto arrastre.  
Para la limpieza de las cuchillas, se recomienda la utilización de nuestro CANTSPRAY (spray antiadherente sin silicona). ref. 6399082

18. GARANTIA

Todas las máquinas VIRUTEX, tienen una garantía válida de 12 meses, a partir del día de su suministro, quedando excluidas todas las manipulaciones o daños ocasionados por manejos inadecuados o por desgaste natural de la máquina. Para cualquier reparación, dirigirse al Servicio Oficial de Asistencia Técnica VIRUTEX.

VIRUTEX se reserva el derecho de modificar sus productos sin previo aviso.

ENGLISH

EDGE BANDING MACHINE EB15-2

1. SAFETY INSTRUCTIONS FOR THE OPERATION OF THE EDGE BANDING MACHINE

• WARNING! Read carefully the GENERAL SAFETY INSTRUCTIONS BOOKLET, enclosed with the ma-

- chine documentation.
- Before connecting the machine to the mains, make sure that the supply voltage matches the one shown on the name plate.
  - Always keep your hands well away from the cutting areas and the temperature zones.
  - Always use genuine VIRUTEX replacement parts.
  - Never use faulty or blunt blades.

2. TECHNICAL FEATURES

Power consumption.....	2,850 W
Motor.....	50 or 60 Hz
Level of continuous acoustic pressure, weighed equivalent.....	83 dB (A)
Acoustic pressure level.....	96 dB (A)
Minimum thickness to band.....	11 mm
Maximum thickness to band.....	65 mm
Outside radius.....	unlimited (*)
Minimum inside radius.....	55 mm (*)
Electronic temperature adjustment.....	0 - 500°C
Operating speed.....	4.2 m/min
Approximate weight.....	77 kg
(*) To trim the the edge the use of the optional accessory 4445003-Trimming unit with fixed blades, is essential.	

3. STANDARD EQUIPMENT

- On opening the crating, you will find the following parts inside:
1. Edge banding machine EB15-2
  2. Sliding support assembly
  3. Box containing:
    - Band loader
    - Loader support
    - Top pressure assembly
    - Socket-outlet
    - Rear cutting pedal
    - Set of spanners
  4. Sundry documents.

4. EDGE BANDER MEASUREMENTS

The space occupied by the Edgebander is shown in (Fig. 1)

5. ASSEMBLY AND START UP

5.1 ASSEMBLING THE LOADER SUPPORT (Fig. 2)

- Loosen the P1 screws from their housing.
- Put the loader support R1 in place and secure it with the screws P1.
- Put the Band Loader A, checking that it turns freely.

5.2 ASSEMBLING THE SLIDING SUPPORT (Fig. 3)

- Remove from the sliding guide S1, the screw U1 that holds the trunnion W1 at one of its ends.
- Locate the sliding support E1 and reassemble it in its original position.
- Using a ruler, level the sliding support E1 in relation to the bench by means of the screw U1.
- Repeat the process in the same way with the other sliding support guide.

-Make sure that there is proper movement of the whole unit between the guides of the piece of furniture.

### 5.3 STARTING UP

The machine is fitted with a safety switch A, (start/stop) attached on the right hand side (Fig. 16).

This switch protects against any untimely starting of the machine, electrical overloads, and also as an outlet in connecting the machine to the mains. This connection should be carried out using an extension cable provided with an earth lead and live wires suitable for a nominal current of 16 A. Beside loader B (Fig. 16) is the control panel of the machine (Fig. 4), which has two switches (bandcutter C, and motorised profiler control D), button K to regulate the temperature, and timer F which regulates the outlet of the band to begin edgebanding.

Upon introducing the pre-glued band, it is necessary to adjust the height of the guides G, (Fig. 5) to the width of the band, all of this by means of the knob H that makes the guide G go up or down, making sure that the band slides smoothly.

In order to start up the machine, press the green button on the stop/start switch A (Fig. 16) to supply power to the machine, and then put the bandcutter switch C in the manual position (0). Pass the band between the rollers I and J, (Fig. 5) of the band guide G until a length appears in front of the gluing roller (1): (Fig. 5 and Fig. 8).

Connect the pedal to the connector N1, (Fig. 6), situated at the rear of the machine and with this pedal cut off the protruding piece and remove it.

To start work, all we have to do is set the switch C, (Fig. 4), to the automatic cutting function (I) and adjust the temperature.

If the machine receives an electrical overload, switch H2 of the stop/start switch A (Fig. 16) will be deactivated, cutting off the electrical supply. In order to re-establish supply to the machine, it will first be necessary to flick thermal switch H2 and repeat the steps described above.

### 6. TEMPERATURE ADJUSTMENT

Before performing this operation, it is very important to ensure that the band is not in front of the air outlet L (Fig. 8) of the blower, to avoid overheating and the consequent deterioration of the preglued band.

To obtain more speed in raising the temperature, set the electronic control K, (Fig. 4) at number 9 on the adjustment scale, checking that the temperature rises fast. Once the temperature of 300°C has been reached, turn the button K to point 5 on the scale, and, once the needle has settled, adjust the temperature to the appropriate level for the preglued band being used.

When buying the pre-glued band roll, it is essential to ask the salesman for guidance about its working temperature, since this usually varies depending on the type of material of which the band is made (PVC, melamine, wood, etc) and of the glue with which it is

impregnated.

### 7. STRAIGHT, SHAPED AND SNIPPED EDGES

The machine leaves the factory ready to do this kind of work; it is only necessary to adjust the width of the preglued band and the passage between the shaper blades with relation to the thickness of the board to be edge-banded (the adjustment of the width of the band has already been explained in the section 5.3 Starting up).

To adjust the blades of the shaper and put them into their working position, it is necessary to follow the steps given in the section 12. Adjustment of the blades (Fig. 7).

The minimum size of boards for these edgebanding jobs is as follows:

**Minimum width 45 mm and minimum length 110 mm.**

Once the temperature has been adjusted, together with the band width and height of the blades, the machine is ready to begin work:

1. Open the machine's expandable guide E1, (Fig. 16), so that the board is well supported on the guides Q, (Fig. 8) and place it touching the front face R of the control box.
2. Bring the wood forward and stop just before it reaches the roller (1), (Fig. 8), and wait a few second until the band, now ready to be glued, emerges.
3. Upon observing that the band has stopped feeding, press the wood lightly against the roller (1).
4. Continue feeding the board, now with the band glued, which will enter between the blades for shaping. (Fig. 9).
5. When the end of the board emerges from inside the blades, support it on the second rubber roller (2) until the edge banding is completed.
6. The end of the board will touch against the blade S, (Fig. 10), of the snipping unit which, actuated automatically by the board itself, will cut off the overhanging edge from the end.

It is foreseen that the overhanging edge at the front will be 1 cm whereas at the rear it will be perfectly flush. If, for any reason, it is necessary to correct the overhanging edge at the front, this can be done by means of timer F situated on the control panel, (Fig. 4). If what we have to make flush is the overhanging edge band at the back, this is done by using limit switch U, (Fig. 11), situated in front of the heater. To do this, it is sufficient to loosen the knobs V and to move it in the same direction of the wood if the length of the overhanging edge is to be increased or in the opposite direction if it is to be shortened.

### 8. EDGE BANDING OF RADIUSSES AND SHAPES

For the edge banding of this kind of board, the machine can neither shape nor snip and it is necessary to carry out a series of adjustments to put it in working order:

1. Remove from the machine the shaper assembly Y, (Fig. 11) and (Fig. 12).

It is only necessary to loosen the screws W of the shaper that secure it to the base, until the whole assembly can be removed from its housing, together with its positioning pins.

2. Remove the gluing roller (2). To do so, loosen and remove the screw on the top so that the roller comes loose.

3. Remove the snipping unit D1. Before carrying out this operation, it is VERY IMPORTANT to disconnect the machine from the mains in order to avoid any possible risk of accidents with the blade. To remove the snipping unit, take out the four screws A1 that secure it to the bench of the machine, together with its locating pins; then disconnect it from the electrical installation, separating the multiple connector.

4. Adjust the lower band guide G1 (Fig. 14), so that the band emerges to touch the support guide Q, (Fig. 15), of the board. To carry out this adjustment, (Fig. 14), turn the adjustment knob H, raising the upper band guide G until the screw C1 that holds the lower band guide G1 becomes accessible. Then loosen this screw and tighten the nut B1. Using the adjustment knob H, raise the lower band guide until the pre-glued band emerges to touch the guide Q, (Fig. 15), of the machine. Then tighten again the screw C1, (Fig. 14), that secures the lower band guide. Loosen the nut B1 only to the necessary extent to allow the upper band guide G to slide forward until the pre-glued band slides smoothly inside it.

5. Set the band cutter switch C, (Fig. 4), to the manual position (O) and proceed to adjust the temperature.

6. Place the wood facing the gluing roller (1), (Fig. 15). Move the pre-glued band forward on the guides G and G1, (Fig. 14), using the knob Z, until the band appears in front of the gluing roller (1).

7. Press the wood against the band in the roller, following the shape of its contours, (Fig. 15). The cutting of the band is carried out manually with the pedal button as and when the operator wishes.

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## 9. PROFILED CIRCULAR EDGE BANDING

To be able to work with circular pieces with the machine, we must use the optional part 4445003, fixed band profiler and Y<sub>1</sub> (Fig. 12); it is also necessary to carry out some minor adjustments:

1. Loosen the knobs X, (Fig. 11), that hold the limit switch block on the left of the machine, lowering it until the levers are completely hidden.

2. Remove the motor-driven profiler (see Chapter 8. Edge Banding of radiuses and shapes) and place the optional accessory 4445003 in its housing.

3. Support the circular board on the rollers (1 and 2), (Fig. 12), and then move the profiler assembly Y towards the board until the inside rollers N make light contact; then check that the blades will profile the board.

It is necessary to lift the upper blade if access to the rollers N is hindered.

Once the profiler accessory has been fixed in its correct place, secure it with the screws W.

4. Make sure that the band cutter switch C, (Fig. 4), is in the manual position (O). For edge banding circular pieces, the band cutting process is carried out by using the pedal button, by means of which the machine's entire automatic process being cancelled. Once these adjustments have been made, place the circle of wood facing the band outlet of the gluing roller (1), (Fig. 13). Feed the band by pressing the pressure roller I against the feeder roller J, using the knob Z. When the band appears in front of the gluing roller (1), release the knob Z and press the wood against the band in the roller (1).

Then slide the circular board, introducing it between the blades until it comes into contact with the rollers N and the roller support (2).

Rotate the board maintaining the pressure constant on the rollers (1 and 2) until it is completely edge-banded, (Fig. 12). The band cutting is done with the pedal button at the operator's will.

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## 10. PRESSURE ASSEMBLY

The machine has a built-in pressure assembly H1, (Fig. 16), fixed to the expandible guide E1; this produces lateral pressure of the board against the pulling rollers.

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## 11. CHANGING THE BLADES OF THE MOTOR-DRIVEN PROFILER AK97

Remove all the protection elements that cover the assembly by taking out the three screws V1 on each side, (Fig. 17).

Remove the screws X1 that secure the driving assembly Z1 to the pulley Y1 and then remove it (Fig. 18).

Remove the screws A2 that secure the blades (Fig. 19), and then remove the blades themselves.

The blades have a cutting edge on both sides of the tooth (cuts 1 and 2) and therefore it is possible to use the second cut before replacing them with new ones by assembling the lower blade in the upper support and vice-versa.

**WARNING!** After any maintenance operation carried out inside the profiler assembly, always replace the protection elements provided in their normal position.

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## 12. ADJUSTMENT OF THE BLADES OF THE MOTOR-DRIVEN PROFILER AK97

Using the knob M, (Fig. 7), raise the upper blade holder until it allows the free passage of the board. Place the board between the four support rollers P so that contact is made with the slide B2 of the blade holder.

It is possible to see how the rollers of the lower blade holder raise the board slightly from the guides Q (Fig. 8).

By means of the knob M, (Fig. 7), lower the upper blade holder until the board is seated on the guides Q and the profiler is then ready to work.



**13. CHANGING THE BELTS OF THE MOTOR-DRIVEN PROFILER AK97**

Remove the protection elements that cover the whole assembly, by taking out the three screws V1 on each side (Fig. 17).

Remove the toothed belt that is in poor condition and replace it with another new VIRUTEX belt, grasping it correctly with the pulley teeth without forcing it (Fig. 18).

**14. CHANGING THE BRUSHES OF THE MOTOR-DRIVEN PROFILER AK97**

Disconnect the connection cable of the motorized trimmer.

Remove the motorized trimmer from its housing in the machine, by removing the screws W (Fig. 9)

Remove the screws C2 from the protector E2, taking it out of its housing (Fig. 20).

Raise the springs D2 (Fig. 21) that press on the brushes, and replace them with new original VIRUTEX ones, making sure that they slide freely inside the guides.

Replace the protector E2 in its housing.

It is recommended that the profiler be kept running for ten minutes, without any load, in order to ensure the proper seating of the brushes.

If any burns or roughness are observed on the collector, we recommend you have it repaired at a VIRUTEX service point.

Never use sandpaper for this operation.

**15. OPTIONAL ACCESSORIES  
FIXED BLADE PROFILER (4445003)**

This accessory is essential for profiling circular boards.

**16. NOISE LEVEL**

The noise of this electric tool is measured to ISO/DIS 230/5.

The noise level in the work place may exceed 85dB(A). In this case, it is necessary for the tool operator to take protective measures against noise.

**17. RECOMMENDATIONS**

Before performing any maintenance operations on the machine, disconnect it from the mains.

Always keep the cable and socket in good repair.

In order to ensure good cutting of the preglued band, always work with clean, glue-free and well-sharpened blades.

The machine must also be free of glue and pieces of cut band, in order to avoid any blockages in the movement of the preglued band.

The pressure the feeder (optional accessory) exerts on the surface of the boards must be sufficient for feeding of the same. Excess pressure causes early deterioration of the feed belt.

It is also recommended that the surface of the same should be free of glue and foreign bodies, in order to ensure perfect feeding. For cleaning the blades, we

recommend use of our CANTSPRAY (nonadherent silicone-free spray).ref.6399082

**18. GUARANTEE**

All VIRUTEX machines are fully guaranteed for 12 months as from the day of purchase, excluding any tampering or damage cause by improper handling or natural wear and tear of the machine. For any type of repair, always contact VIRUTEX Official Technical Assistance Service.

VIRUTEX reserves the right to make technical changes in its products without prior notice.

**FRANÇAIS**

**PLAQUEUSE DE CHANTS EB15-2**

**1. INSTRUCTIONS DE  
SECURITE POUR LE MANIEMENT  
DE LA MACHINE A PLAQUER SU CHANT**

• ATTENTION! Lire attentivement LA BROCHURE D'INSTRUCTIONS GENERALES DE SECURITE jointe à la documentation de la machine.

• Avant de brancher la machine, veiller à ce que la tension d'alimentation corresponde à celle indiquée sur la plaque des caractéristiques.

• Maintenir toujours les mains éloignées des zones de coupe et des surfaces chaudes.

• Utiliser toujours des pièces de rechange d'origine VIRUTEX.

• Ne jamais utiliser des lames défectueuses ou en mauvais état.

**2. CARACTERISTIQUES TECHNIQUES**

Puissance absorbée.....	2.850 W
Moteur.....	50 ou 60 Hz
Niveau de pression acoustique continue équivalent pondéré.....	83 dB (A)
Niveau de puissance acoustique.....	96 dB (A)
Epaisseur minimale à plaquer sur chant.....	11mm
Epaisseur maximale à plaquer sur chant.....	66mm
Rayons extérieurs.....	illimités(*)
Rayons intérieurs minimaux.....	55mm(*)
Réglage électronique de la température.....	0-500°C
Vitesse de travail.....	4,2 m/min
Poids approx.....	77Kg
(*) Pour profiler le chant, il est indispensable d'utiliser l'accessoire en option 4445003 Outil de profilage à lames fixes.	

**3. EQUIPEMENT STANDARD**

Lorsqu'on ouvrira la caisse d'emballage, on trouvera à l'intérieur les pièces suivantes:

1. Machine à plaquer sur chant EB15-2
2. Ensemble support mobile
3. Caisse contenant:
  - Chargeur de bande
  - Support du chargeur