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Operator Manual:

CASTLE EB-2 EDGE BANDER

Updated March, 2001

The main components of the EB-2 are:

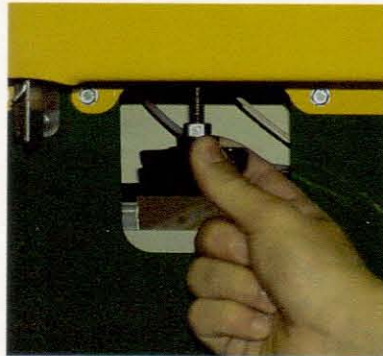
- 1) **Glue Pot:** Found in the middle of the yellow mechanical channel. The two main parts are the transfer wheel and the glue level sense tube.



The transfer wheel is located in the top of the glue pot. It applies glue as the board is pushed through the machine. The glue level sense tube is a black poly tube that is pressed firmly into the fitting on the control box.

TO REMOVE AND/OR REPLACE THE GLUE POT:

- 1) Loosen the star knob found under the glue pot.



- 2) Release the glue level sense tube by pushing in the ring on the control box fitting while simultaneously gently pulling on the poly tube.



- 3) With the tube released, use a pair of pliers to grab the lip of the glue pot, pull it out and place it on the galvanized shelf.



Reverse this procedure to install a glue pot, making sure it is installed all the way back onto the rear of the hot plate. Fill the empty glue pot with glue pellets to the top of the transfer wheel axle prior to installation.

IMPORTANT NOTE:

Do not mix glue pellet brands! Most do not mix with others!

- 2) **Guillotine:** Cuts the banding after a board is passed through. Pushing the red activator plate above the guillotine can also activate it.



The guillotine will come forward and block the banding process during warm up periods and when the machine is asleep.

- 3) **Glue Magazine:** Where the glue pellets are loaded and stored for transfer into the glue pot. To change pellet colors, pull on the glue magazine gate located near the top of the yellow mechanical channel.

The pellets will drop out the bottom of the machine at the red indicator on the bottom edge of the front case.



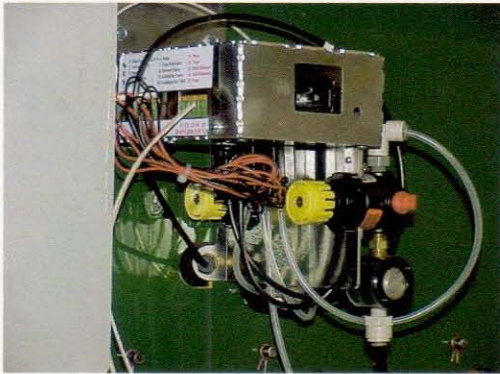
- 4) **Control Box:** Located on the right hand side of the machine. The portion visible in the front consists of three LED lights and two push buttons.



LED Chart

LOCATION	ACTION	MESSAGE
Left	<i>flashes green</i>	heating mode
Left	<i>solid green</i>	ready
Middle	<i>solid orange</i>	cool down mode
Right	<i>solid red</i>	temp increase mode

When the button on the left is depressed and held in, the guillotine will activate once and the orange light, signifying cool down, will come on. When the button on the right is depressed and held the guillotine will activate two times and on the third will stay out, thus turning on the solid red light and temperature heat up mode. Temperature changes are about 8 degrees Fahrenheit. Holding both temperature control buttons in at the same time will defeat the guillotine action. To reactivate, push both again. The control box is also visible from the rear near the power cord. When the rear door is open two air regulators are visible on the under side of the control box.



The regulator closest to the front of the machine sets how much air is sent through the pressure sense tube. The gauge next to it should be set at approximately 5 1/2 PSI. The regulator towards the rear should be at six full turns to the right from being completely off.

5) Band Reel: Found inside the machine when it is received. To remove it, you must open the rear door and cut the zip tie that is holding it in place. After it is removed, cut two small zip ties to release a 5/32" Allen wrench. Use the wrench to remove the collar from the shaft. Put the long end of shaft in the cutout located in the front bottom center of the machine until it goes through the rear cutout. To retain the reel, replace the collar and tighten. To install the banding, loosen the setscrew on the front sprocket and remove. Install the banding so the end is on the left facing up. Replace the sprocket and tighten the setscrew. To expand the center, turn the front and rear sprockets in opposite directions until tight.



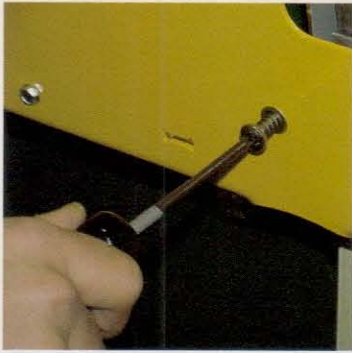
6) Hopper Extension: A special brown paper formed to fit the bottom of the aluminum chute to better guide glue pellets to the glue pot.



Three extra hopper extensions are located on the band reel when machine is first unwrapped. To change hopper extensions, remove the glue pot and place it on shelf. Loosen the lower Philips head screw in hopper and slide off the old extension. Put a new extension on so the Castle logo is visible from the front of the machine. Place the glue pot back into position, align the hopper extension with the hole in top of glue pot and retighten the screw.

7) Band Guide: A stainless steel pair of guides, adjustable for both thickness and width. The thickness is adjusted with the 5/16" head bolt to the left of the transfer wheel, going through the main front panel. Adjust it so there is just a slight drag when the tape is pulled through it.





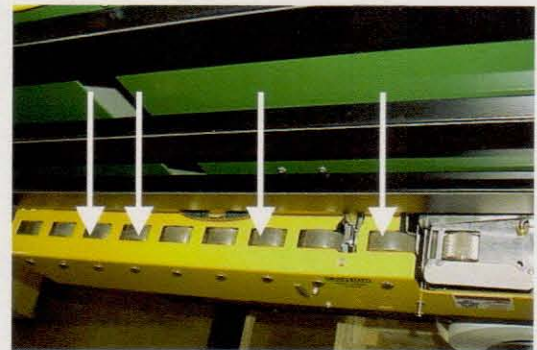
Adjust the width with the screw with a spring under the head. It should also be adjusted until the tape has a slight drag. The spring keeps the adjustment from changing with use.

8) **Outriggers:** Are to be used when longer panels are being banded. They are simply inserted until they run into the stop bolts.



When not in use, your outriggers can be stored on the legs of the EB-2.

9) **Sprung Wheels:** Four iron wheels after the transfer wheel that are spring loaded to help seal the edges of the banding in place. When using the EB-2, hold the panels down firmly to insure that the wheels are compressed to provide a finished edge on the banding.



**If you need technical assistance with your EB-2 or
have any questions, please call Castle
800-282-8338**

Edge Bander Quick Start Guide

Unpack:

Remove cardboard, wood skid materials. Discard. Save 2" x 2" **Outrigger spars**. Open the rear panel and remove **Glue Pot Shield, Power cord and Band Reel**. **Outrigger wheels** and **Glue pellets** are in bags inside the **Glue Magazine**.

Height Adjustment:

Loosen Leg **Locking Nuts**, then **Set Screws**. Raise Bander to working height one end at a time by tightening each **Set Screw** individually. Set angle with **Locking Nuts**.

Band Reel:

Insert **Axel** into working position and fix in place with **Retaining Collar** behind **Back Panel**. Rotate the inner and outer spokes in opposite directions to expand and close **Adjustable Center**.

To install banding onto the **Band Reel** remove **Outer Reel Plate**, place the banding over the **Adjustable Center** with the loose end to the right, banding should feed off in clock-wise direction. Replace **Outer Reel Plate** firmly over banding and tighten collar. By working inside and outside spokes in opposite directions, center band coil. Feed tape through **Band Guide**. Then set for width with the adjustment screw protruding through **Glue Pot Shield**, just finger tight to assure correct tracking. Leave 2 inches of tape exposed above contact wheel.

Outriggers:

Mount the **Wheels** and brackets to the **Outrigger Spars**, tall side of bracket to the rear. The outriggers should be mirror images of each other.

Start Up:

Dump glue pellets in to **Glue Magazine**.

Attach **Air Supply** and **Power Cord** at rear of machine. When plugged in with air supplied, the **Guillotine** should deploy 3 times. On the third cycle it will remain out, blocking the tape path. **Allow 1 hour for initial heat up**. **Green Power Indicator Light** will flash while heating up. Guillotine retracts when ready and the green light will stay on continuously.

Adjust the **Stock Guide** on **Glue Pot Shield** so that the stock to be banded will pass through without shifting or binding.

Prior to shipping, the machine is tested. **Glue pot** is filled and connected.

Adjusting Temperature:

Temperature Controls are on the right of the **Power Indicator light**. The left button will lower the temperature and will light the left **Temperature Indicator Light**. The far right **Temperature Control Button** will raise the temperature and light the right **Temperature Indicator Light**. Allow 20 minutes for temperature changes. Stringy glue is too cool, Smoking glue is too hot.

Changing Glue Pots:

Connect black hose to fitting below **Control Box**. Place Glue Pot onto **Heater Plate**. Slide all the way in and tighten **Star Knob** under pot to retain it. Priming information is shipped with extra **Glue Pots**.

For Assistance please call 800-282-8338