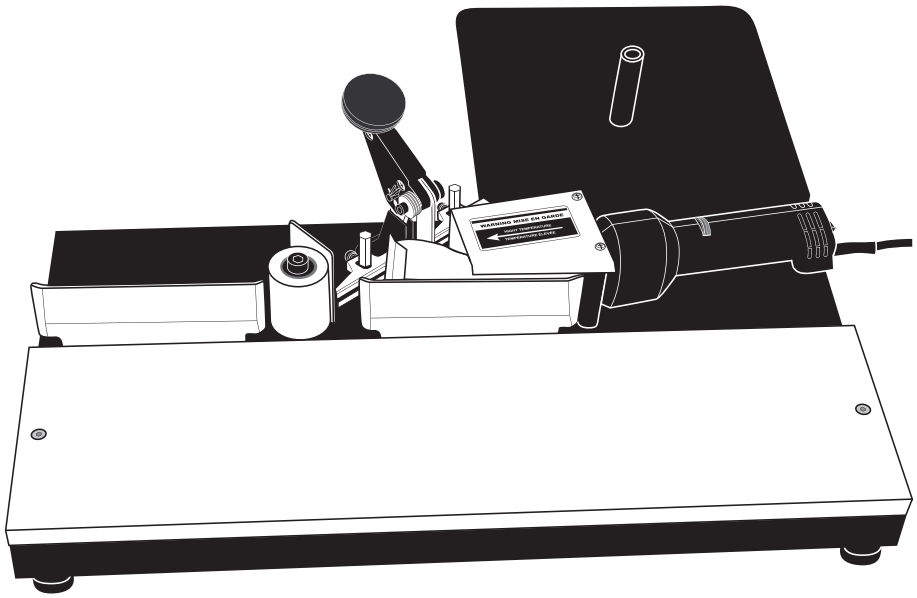
MAGNUM
INDUSTRIAL

MODEL NO.: MI-46150



OPERATING MANUAL

READ ALL INSTRUCTIONS

1. READ OWNER'S MANUAL THOROUGHLY – DO not discard these instructions as they are necessary to the safe operation of the tool and the teaching of other persons in the proper use of the tool.
2. KEEP WORK AREA CLEAN – Cluttered areas and benches invite injuries.
3. KEEP GUARDS IN PLACE and in working order.
4. GUARD AGAINST – electrical shock by preventing body contact with grounded surfaces. For example: pipes, radiators, range, refrigerator enclosures.
5. AVOID HAZARDOUS WORK AREA ENVIRONMENT – Keep area well lit. Do not use power tools in damp, wet or raining locations. Do not use tool in the presence of flammable liquids or gases.
6. KEEP CHILDREN AND VISITORS AWAY from the work area. Do not let them contact tools or extension cords.
7. STORE IDLE TOOLS – When not in use, tools should be stored securely in a dry place, locked up and out of the reach of children.
8. DON'T FORCE THE TOOL – It will do the job better and safer at the rate for which it was intended.
9. DRESS PROPERLY – Do not wear loose clothing or jewelry. They can be caught in moving parts. Rubber gloves and nonskid footwear are recommended when working out of doors. Wear protective hair covering to contain long hair.
10. USE RIGHT TOOL FOR THE JOB – Don't force a small tool or attachment to do the job of a heavy-duly tool.
11. ALWAYS USE SAFETY GLASSES with all tools. Also use face or dust mask if operation is dusty.
12. DON'T ABUSE CORD – Never carry the tool by the cord or yank the cord to disconnect it from the receptacle. Keep cords from heat, oil and sharp edges. When tools used outdoors, use only extension cords intended for use outdoors and are so marked.
13. DON'T OVER REACH – Keep proper footing and balance at all times.
14. MAINTAIN TOOLS WITH CARE – Keep tools sharp and clean for better and safer performance. Follow the instructions for lubricating and changing accessories. Inspect the cord periodically and, if damaged, have it repaired. Inspect extension cords periodically and replace them if damaged. Keep handles dry, clean, and free from oil and grease.
15. DISCONNECT TOOLS – When not in use, before servicing, and when changing accessories such as blades, bits, cutters grinding wheels, or sandpaper
16. AVOID ACCIDENTAL STARTING – by not carrying plugged in tools with a finger on the switch. Be sure switch is OFF when plugging in the tool.

17. STAY ALERT – Watch what you are doing. Use common sense. Do not operate the tool when you are tired or while under the influence of drugs, alcohol or medication.
18. CHECK DAMAGED PARTS – before further use of the tool. A guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting and any other conditions that may effect its operation. A guard or other part that is damaged should be properly repaired. Have defective switches replaced. Do not use the tool if the switch does not turn it off and on.
19. REMOVE – adjusting keys and wrenches before turning on the tool. Be sure they are stored in their proper position on the tool.
20. FREQUENTLY CLEAN – air circulation vents on the tool.
21. NEVER TOUCH – moving parts while the tool is connected to a power source.
22. SAVE THESE INSTRUCTIONS.

WARNING: When using electric tools, basic safety precautions should be followed to reduce the risk of fire, electric shock, and personal injury. Some of these safety precautions are as follows:

EDGE BANDING is designed to give you maximum results when used with your banding system.

The genuine wood veneers are a generous 1/42 inch thick. They are finger jointed into continuous rolls which are end matched for color and grain continuity. It is bonded to a fleece backer, sanded and coated with high quality hot melt adhesive. Total band thickness is .030 inch.

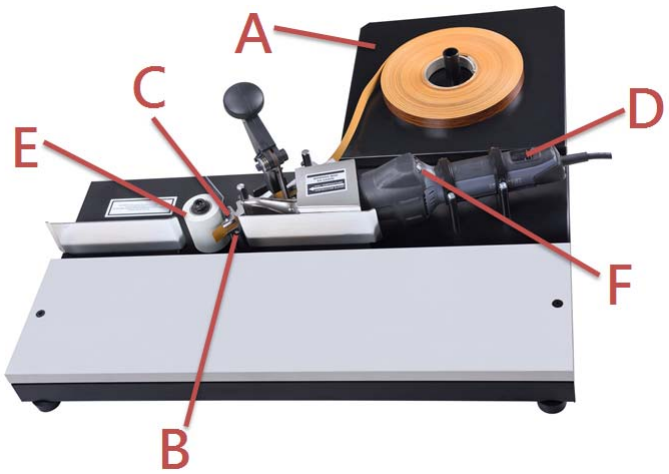
The laminate edge banding is available in many popular colors. The decorative papers are impregnated with polyester resins for strength. It is then laminated to a .010 inch thick backer sheet. The tape is coated with a high quality hot melt adhesive. Total band thickness is .016 inch.

Edge banding can SOLVE your edge veneer or laminate problems!!

INTRODUCTION

The banding system has been designed to handle wood and polyester edge banding materials. All edge banding materials must be backed with a hot melt glue. The heat gun prepares the glue for bonding to the substrate. The banding system will accommodate materials as wide as 2-1/4 inches. The edge band guides are completely adjustable. Any width of edge banding material can be fitted to the system by simply adjusting the upper edge band guides. The lower edge band guides are also adjustable, but once positioned slightly below the work table, they are rarely adjusted.

The width of the edge banding material you select is dependent on the thickness of the stock you are edge banding. The edge banding material is usually no more than 1/16 inch wider than the thickness of the work. This means that there is only 1/32 inch of excess to remove from either side of the work. This allows the excess to be removed with a laminate trimmer or laminate trimming bit in a router. The excess may also be removed by sanding. When the edge banding material is too wide, the clean up job becomes difficult and edge banding material is wasted.



SET UP

Pull down the outrigger support (Item A). This will keep the outrigger from tipping. Set the roll of edge banding material over the pin on the outrigger. Be sure the hot melt adhesive faces the heat gun. The lower edge band guides (Item B) will be set slightly below the work table. Adjust the upper edge guides (Item C) to the width of the edge banding material. The material must move freely through the guides after adjustment.

The heat gun has several settings. The heat setting is arbitrary. The hotter the gun, the faster you must feed the work. For best results, start with low heat and make adjustments according to your experience with the edge bander and the material you are using.

CAUTION: The heat gun generates sufficient heat to burn flesh and ignite combustibles. Work with extreme caution!!

OPERATING THE EDGE BANDING SYSTEM

To operate the edge banding system follow the steps listed below.

1. Position the end of the edge banding roll across from the nozzle of the heat gun. Be sure the material is threaded through the edge band guides. Note:The hot melt adhesive backing must face the heat gun.
2. Plug in the heat gun and turn on switch (Item D).
3. As the hot melt adhesive softens, hand feed the edge banding material up to the pinch roller (Item E).
4. Place the work on the work table and push the edge against the edge banding material. The edge banding material will be trapped between the pinch roller and the workpiece. The edge banding material will bond to workpiece.
5. Guide the workpiece toward the pinch roller at a moderate speed. The edge banding will bond to the edge of the work as it is pulled through the guides. Be sure the hot melt adhesive is bonding to the work. If the feed speed is too fast, or if the heat gun is set too low, the bond will be poor. Adjust the heat control (Item F) as needed to obtain a good bond.
6. As the work advances, the edge may rest against the out feed fence and the pinch roller. Always maintain pressure on the pinch roller while you are edge banding.
7. When the end of the workpiece is about 2-1/2 inches from the pinch roller, depress the veneer cutting knob to cut the edge banding process until the entire edge of the work has edge banded. The end of the edge banding material will extend beyond the edge of the work slightly. This will allow you to make a clean cut with some other cutting or sanding tool.
8. Shut off the heat gun and allow it to cool properly before storing the edge banding system. If you do not plan to use the system for a while, it is best to unplug the heat gun from its power source.

MAINTENANCE

Prolong use of the Edge Banding System may cause accumulation of hot melt adhesive on the edge banding guides.

REMOVING ADHESIVE

If hot melt adhesive accumulates on the edge banding guides it can make movement of the edge banding material difficult. Remove the edge banding material from the guides. Set the heat gun to a medium setting and turn it on. As the heat gun softens the melt adhesive, peel it from the guides with the putty knife. Be careful not to scratch the edge of the band guides. The guide must remain smooth for best results.

ADJUSTING FENCES

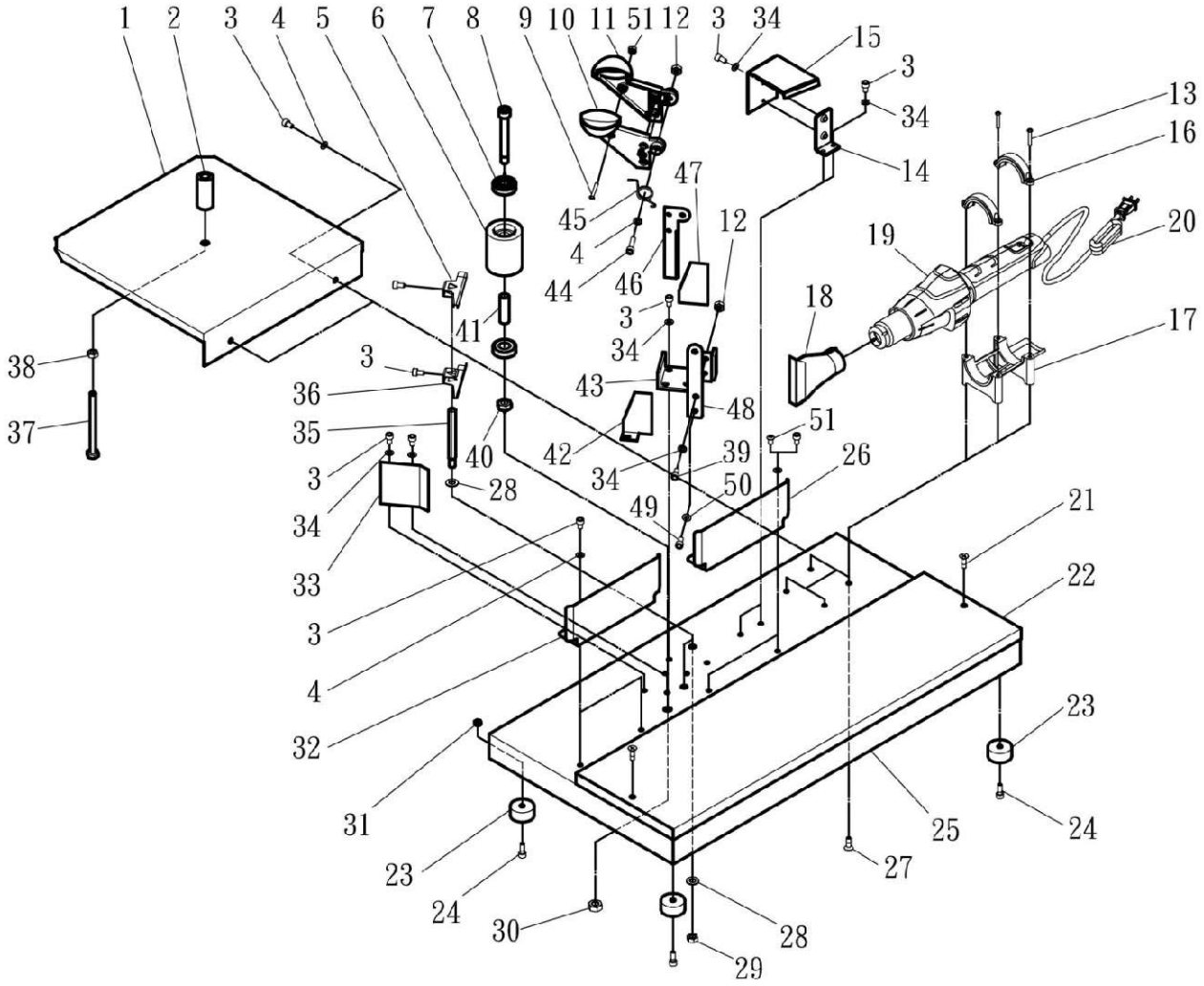
The infeed and outfeed fences are both adjusted so that they are recessed about 1/16 inch (1.5 mm) from the crown of the pinch roller. The infeed and outfeed fences are used only for support and do not have to line up with any reference point. The fence should be adjusted correctly when the edge banding system is delivered.

REPLACING FRONT TABLE

The front table may become scuffed with use. It may be replaced with any smooth faced sheet stock. Remove the old table and use it as a pattern. A plastic laminate face may be glued to the new front table. This will increase its durability and reduce friction between the table and the original work. Be sure the new table is the same thickness as the original. Make an allowance for the plastic laminate if you plan to laminate your new work table.

TROUBLESHOOTING

When the edge banding does not adhere to the work, the heat gun may not be hot enough. It is also possible that the feed speed is too fast for the heat level of the heat gun. Reduce the feed speed or increase the heat level.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PARTS LIST FOR MI-46150

PARTS #	DESCRIPTION	QTY
MI-46150-01	Outrigger support	1
MI-46150-02	Stud	1
MI-46150-03	Hex screw (M6X10)	19
MI-46150-04	Eyelet washer (M6 x 21)	7
MI-46150-05	Upper edge guide	2
MI-46150-06	Pinch roller	1
MI-46150-07	Ball bearing	2
MI-46150-08	Hex screw (M10X80)	1
MI-46150-09	Tapping screw (M5 X 15)	3
MI-46150-10	Handle (right)	1
MI-46150-11	Handle (left)	1
MI-46150-12	Hex nut (M6)	2
MI-46150-13N	Retaining screw (M5X25)	4
MI-46150-14N	Flxed Shield	1
MI-46150-15N	Heat shield	1
MI-46150-16N	Top retaining clamp	1
MI-46150-17N	Bottom retaining clamp	1
MI-46150-18	Nozzle	1
MI-46150-19N	Hot-air gun	1
MI-46150-20	Electric cord	1
MI-46150-21	Flat head screw (M6X25)	2
MI-46150-22	Work table	1
MI-46150-23	Rubber boot	4
MI-46150-24	Hex screw (M6X16)	4
MI-46150-25N	Base	1

PARTS #	DESCRIPTION	QTY
MI-46150-26	Fence	1
MI-46150-27	Tapping screw (3/16'X5/8'')	4
MI-46150-28	Eyelet washer (5/16''X7/8''X2)	4
MI-46150-29	Hex nut (M8)	2
MI-46150-30	Hex nut (M10) .	1
MI-46150-31	Hex nut (M6)	4
MI-46150-32	Fence	1
MI-46150-33	Heat shield	1
MI-46150-34	Eyelet washer (M6 x 13)	11
MI-46150-35	Stud	2
MI-46150-36	Lower edge guide	2
MI-46150-37	Cap screw	1
MI-46150-38	Hex nut (M8) .	1
MI-46150-39	Hex screw (M6X16)	1
MI-46150-40	Hex nut (M10)	1
MI-46150-41	Plastic tube	1
MI-46150-42	Knife guard (right)	1
MI-46150-43	Knife base	1
MI-46150-44	Hex screw (M6X35)	1
MI-46150-45	Spring	1
MI-46150-46	Upper knife	1
MI-46150-47	Knife guard (left)	1
MI-46150-48	Bottom knife	1
MI-46150-49	Hex Socket Cap Screw (M6X12)	1
MI-46150-50	Eyelet Washer(1/4''X5/8''X2)	1
MI-46150-51	HEX SOCKET COP SCREW	1