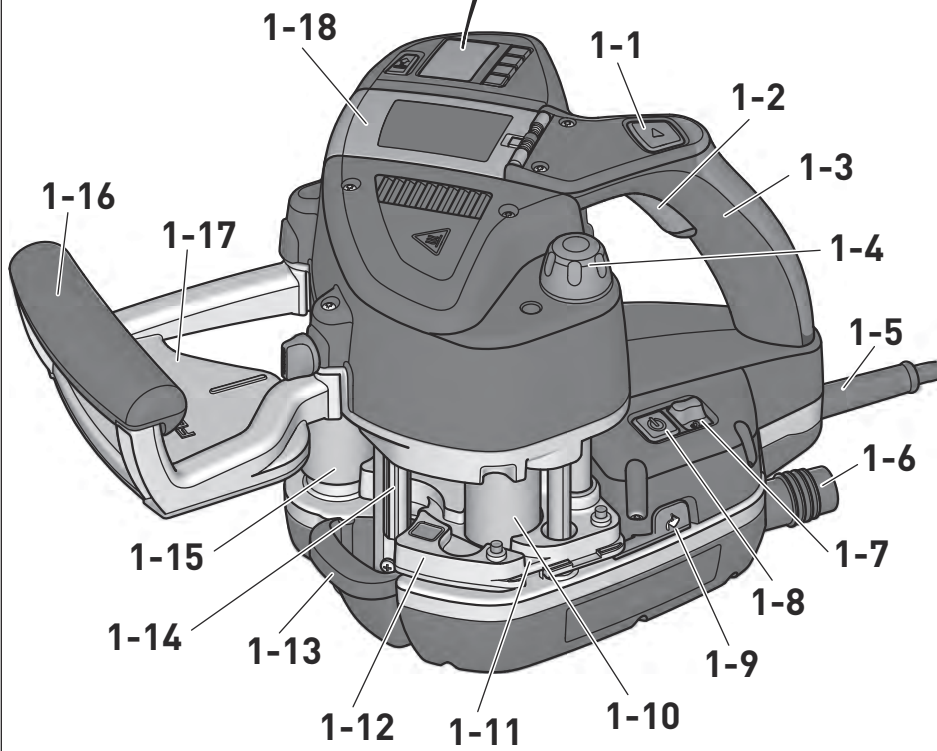
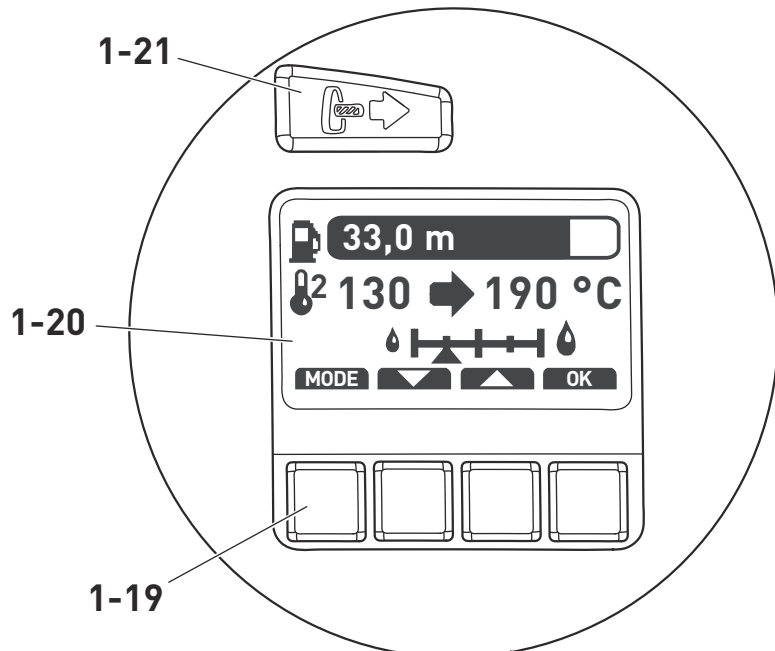


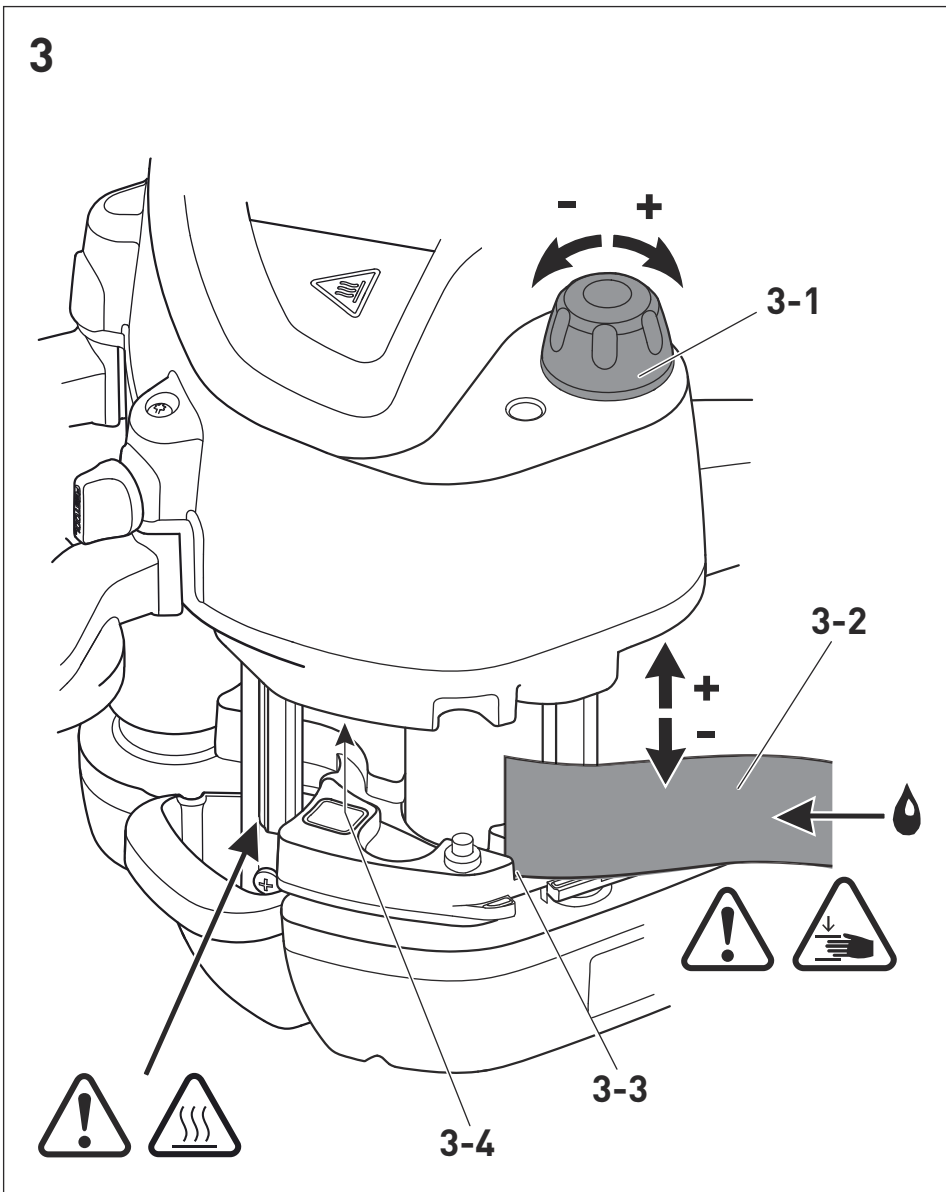
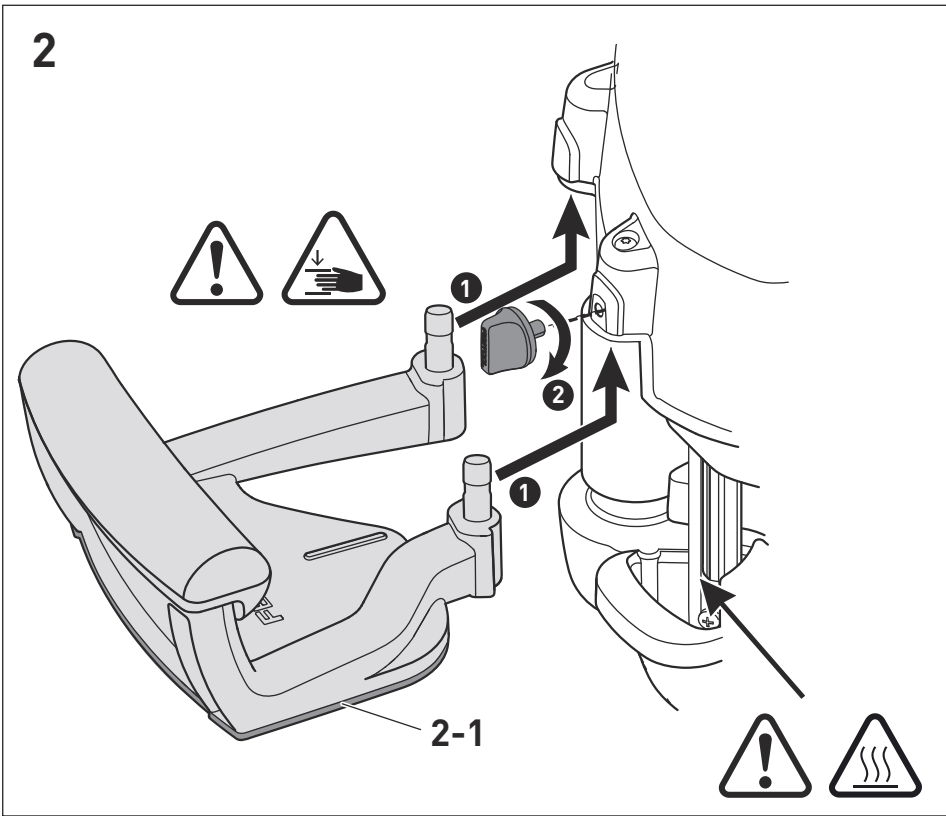
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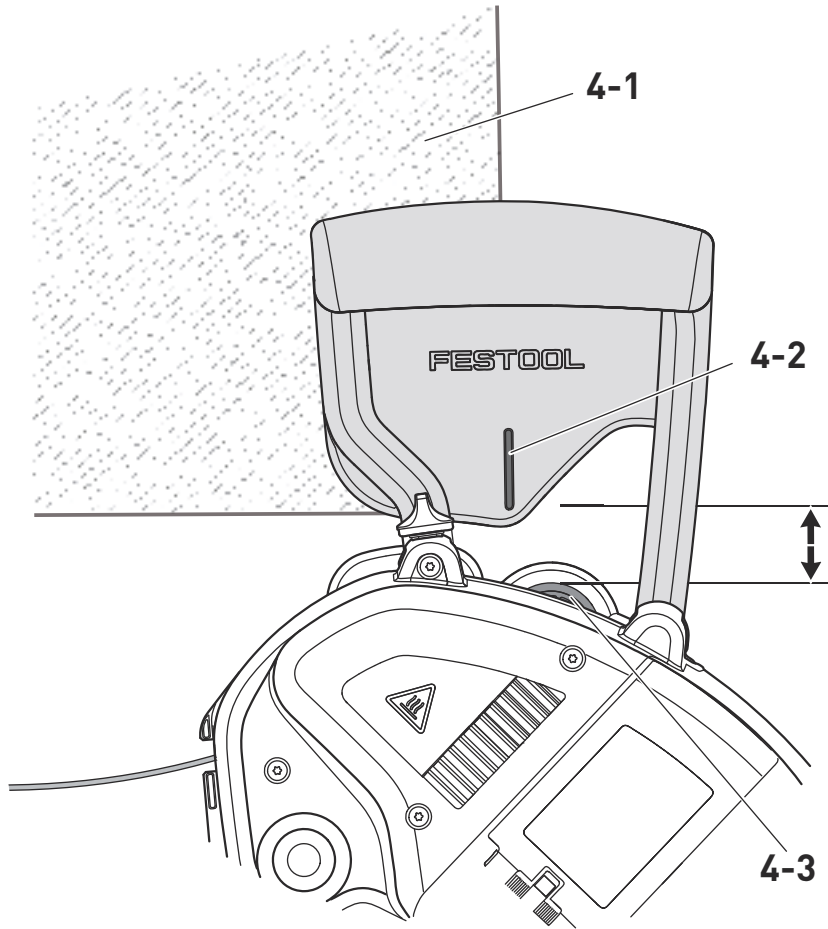


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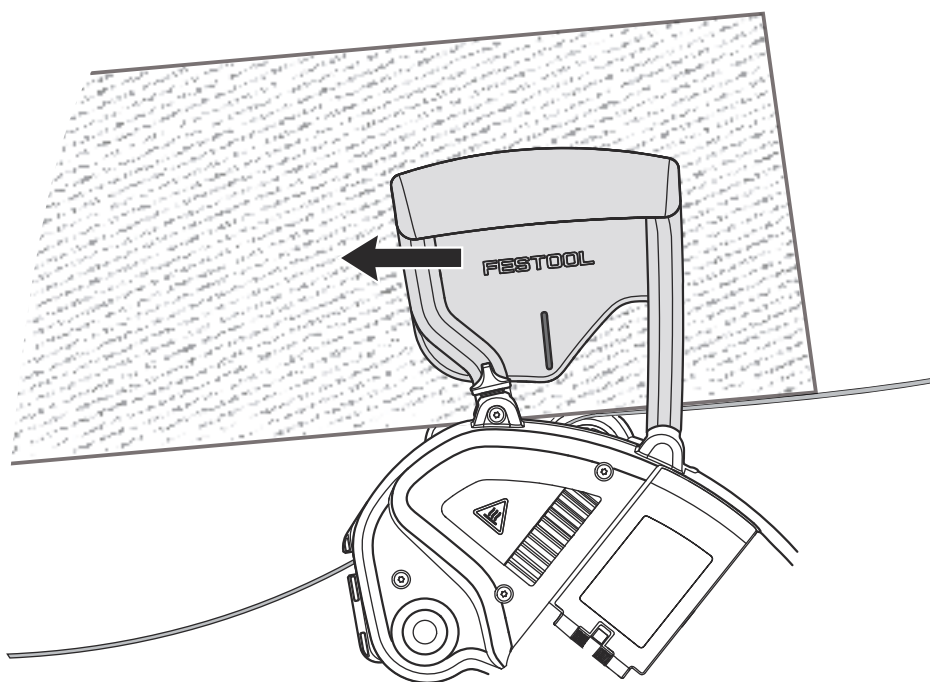




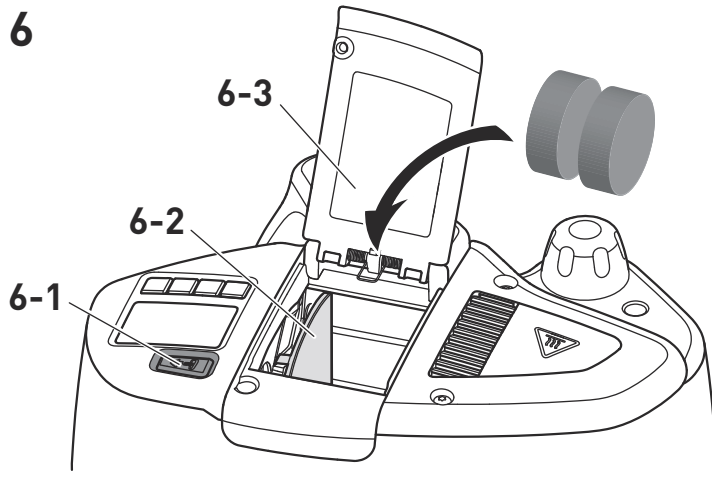
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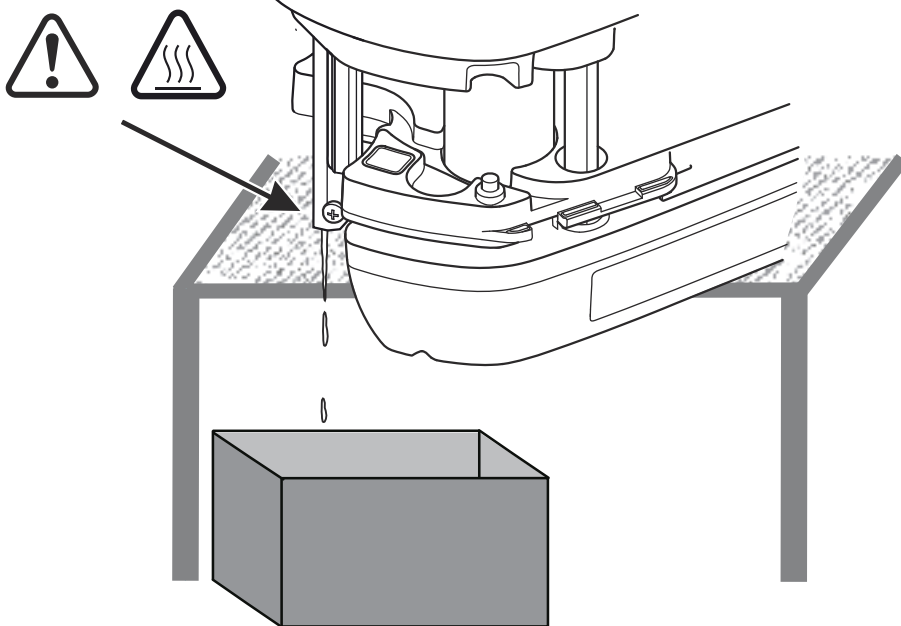
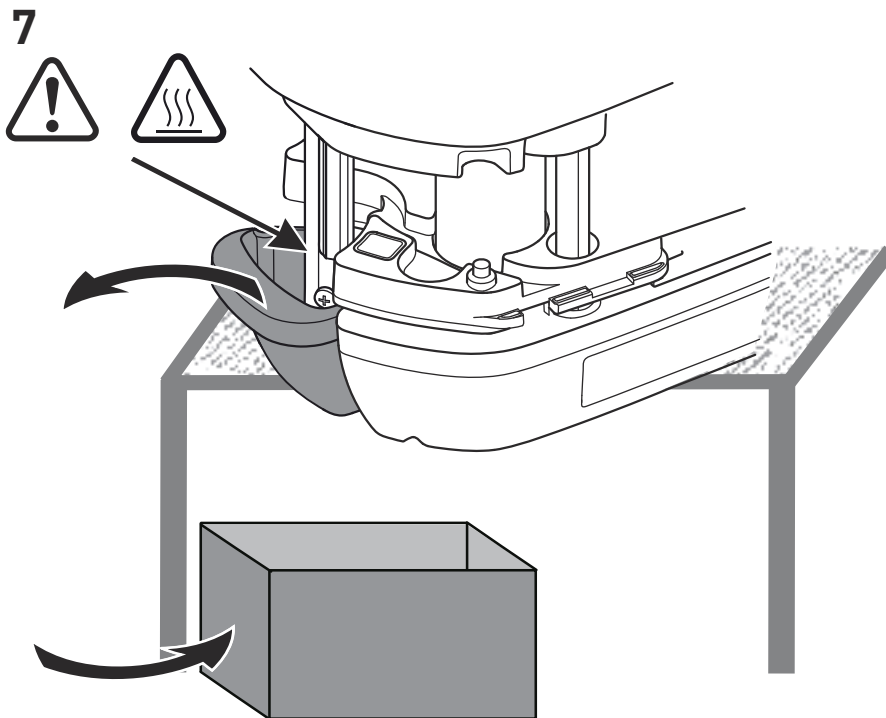
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6



7



11 Problembesehung

Problem	Mögliche Ursachen	Abhilfen
Laufender Betrieb stoppt.	Klappe [1-18] ist offen. Beim Öffnen der Klappe während des Betriebes stoppt die Klebstoffzufuhr. Vorschub läuft jedoch weiter.	Klappe [1-18] schließen.
	Fehlermeldung (wird im Display [1-20] angezeigt): Kantenband ist noch eingelegt.	Kantenband entfernen.
Maschine schaltet ab.	Gerät befindet sich im Abkühlmodus < 50 °C	Gerät durch Drücken der Start-Taste [1-1] erneut einschalten.
Displaybeleuchtung wird rot.	Gerät schaltet nach 15 min ohne Bedienung in den Abkühlmodus.	Gerät durch Drücken der Start-Taste [1-1] erneut einschalten.
Einzug schaltet vor Einfuhr des Kantenbands ab.	Das Zeitfenster von 20 s wurde überschritten.	Antrieb durch Drücken der Start-Taste [1-1] erneut starten.
Einzug schaltet trotz durchgezogenem Kantenband nicht ab.	Lichtschanke [3-4] ist verschmutzt.	Lichtschanke [3-4] vorsichtig säubern.
Display zeigt die Aufforderung zum Entfernen des Kantenbandes an, obwohl kein Kantenband eingelegt ist.		
Kantenband klebt nicht.	Verunreinigung/Düsenlöcher sind verstopft.	Verunreinigung durch Spülvorgang beheben (Kapitel 8.3).
		Bei starker Verunreinigung die Mittelplatte ganz nach oben drehen und im Betriebszustand die unteren Düsenlöcher durchstoßen.
Klebstoff zu flüssig/zu fest, zu viel/ zu wenig	Falsche Temperatur, falsche Klebstoffmenge eingestellt.	Temperatur über die Menü-tasten [1-19] auf verwendete Klebstoffpatronen einstellen. – zu flüssiger Klebstoff: Temperatur -10°C – zu fester Klebstoff: Temperatur +10°C ggf. Klebstoffmenge anpassen mit [1-19] .

Problem	Mögliche Ursachen	Abhilfen
Mangelhafter Klebstoffauftrag bei dünnen Kantenbändern (materialbedingt bei ca. 0,5 - 0,8 mm) am Beginn der Leimung.	Fehlender Druck des Kantenbandes an der Klebstoffdüse.	Hinterlegung des Kantenbandes am Beginn der Leimung durch ein zusätzliches Stück Kantenband (ca. 20 cm) mit gleicher Kantenhöhe. Dieses Zusatzstück wird hinter dem Kantenband mit in den Kanteneinzug eingeführt.
Fehlersymbol erscheint im Display [1-20] .	Die Elektronik der Maschine hat einen schwerwiegenden Fehler erkannt.	<p>Gerät durch Drücken des Ein-/Ausschalters [1-8] ausschalten und einige Minuten abkühlen lassen.</p> <p>Gerät durch Drücken des Ein-/Ausschalters [1-8] erneut einschalten.</p> <p>Wird das Fehlersymbol erneut angezeigt, Verbindung mit dem Kundendienst aufnehmen.</p>

Original operating manual

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1 Safety instructions

1.1 General safety instructions



WARNING! Read all safety warnings, instructions, illustrations and specifications provided with this power tool. Failure to follow all instructions listed below may result in electric shock, fire and/or serious injury.

Save all warnings and instructions for future reference.

The term "power tool" in the warnings refers to your mains-operated (corded) power tool or battery-operated (cordless) power tool.

1.2 Machine-related safety instructions

- **Always hold the machine by the insulated handles because the heating unit and adhesive nozzle can become very hot. Risk of burns!**
- **Always use the machine in well-ventilated rooms.** Otherwise there is a risk that excessive quantities of vapour will develop during work.
- **Do not use the machine for overhead work.** When performing overhead work, there is a danger of hot liquid adhesive dripping on the machine operator.
- **Protect the machine from moisture.** Moisture can cause electric shocks.
- **Protect the cable from heat sources, oil and sharp edges and keep away from hot machine components.** Damage to the cable can cause electric shocks.
- **Check the plug and the cable regularly to avoid hazards and have them replaced by an authorised after-sales service workshop if they become damaged.** A defective plug or cable can cause electric shocks.

- **Do not pull the plug from the socket by the cable.** The plug or cable may become damaged and cause electric shocks.
- **Always use an extension cable with protective earth conductor.** If an extension cable is used without a protective earth conductor, the machine's electrical system is no longer protected, which can cause electric shocks.
- **Always remove melted adhesive cartridges by purging.** Adhesive cartridges that are not melted can be removed by hand.
- **Caution! Clean the system no more than six hours after using PU adhesive.** If instructions in the operating manual or other documents accompanying individual machines relating to the connection, installation, commissioning, operation, use and maintenance of machines are not followed, any claim to warranty will be lost.
- **Wear suitable personal protective equipment:** dust mask for reducing the risk of inhaling hazardous vapours, protective gloves for handling hot machine components, safety goggles.
- **The Festool edge bander should always be mounted on work benches using the stationary fixture supplied by Festool.** The electric power tool may become unsafe and cause serious accidents if installed in benches from other manufacturers or self-manufactured work benches.
- **Always use original Festool accessories and adhesive cartridges.** Only products tested and approved by Festool are harmless to health and perfectly adapted to the machine and application. Please refer to the safety data sheet for additional specifications. See Festool catalogue or www.festool.com.
- **Observe national safety regulations!**

1.3 Emission levels

Levels determined in accordance with EN 60745 are typically:

Sound pressure level $L_{PA} \leq 65 \text{ dB(A)}$

Noise level $L_{WA} \leq 76 \text{ dB(A)}$

Uncertainty $K = 3 \text{ dB}$

Vibration emission level a_h (vector sum for three directions) and uncertainty K measured in accordance with 60745:

Vibration emission level (3 directions): $a_h < 2,5 \text{ m/s}^2$

Uncertainty $K = 1,5 \text{ m/s}^2$

The specified emission values (vibration, noise)


- are used to compare machines.
- They are also used for making preliminary estimates regarding vibration and noise loads during operation.
- They represent the primary applications of the power tool.

Increase possible for other applications, with other insertion tools or if not maintained adequately. Take note of idling and downtimes of machine!

2 Intended use

The edge bander is suitable for:

- Attaching edge bands made of wood, materials similar to wood and plastic using **Festool adhesives**.

 The user is liable for improper or non-intended use; this also includes continuous industrial operation.

3 Technical data

Edge bander		KA 65
Power		1200 W
Power supply		220 - 240 V~
Mains frequency		50/60 Hz
Edge height		18 - 65 mm *
Edge thickness		0,5 - 3,0 mm *
Inner radius		> 50 mm *
Heating time		approx. 8 min
Default melting temperature setting	Setting 1	190 °C
	Setting 2	200 °C
Melting temperature setting range	Setting 1/2	100 - 210 °C
Feed speed	1st gear	2 m/min
	2nd gear	4 m/min
Safety class		I
Weight (without adhesive cartridges and mains cable)		7,9 kg

* Depending on material

4 Symbols

Symbol Significance

-  Warning of general danger
-  Risk of electric shock
-  Warning: Hot surface!
-  Risk of pinching fingers and hands!
-  Read operating instructions and safety notices!
-  Wear protective gloves.
-  Wear a dust mask.
-  Wear protective goggles.
-  Do not dispose of with domestic waste.
-  Tip or advice
-  Handling instruction

5 Machine features

- [1-1] Start button
- [1-2] Feed speed button
- [1-3] Handle
- [1-4] Rotary knob for adjusting the edge height
- [1-5] Mains power cable
- [1-6] Extractor connector
- [1-7] Switch for temperature selection
- [1-8] On/Off switch
- [1-9] Safety lever for purging
- [1-10] Inlet roller
- [1-11] Edge inlet
- [1-12] Central plate
- [1-13] Drip catcher
- [1-14] Adhesive nozzle
- [1-15] Contact roller
- [1-16] Handle
- [1-17] Support base with start marking
- [1-18] Flap
- [1-19] Menu buttons

- [1-20] Display
- [1-21] Refill button

The specified illustrations appear at the beginning of the Operating Instructions.

6 Operation



WARNING


Unauthorised voltage or frequency!


Risk of accident

- ▶ The mains voltage and the frequency of the power source must correspond with the specifications on the machine's name plate.
- ▶ In North America, only Festool machines with the voltage specifications 120 V/60 Hz may be used.

6.1 Initial operation

- ▶ Remove protective foil from underneath the support base [1-17] and display [1-20].

 The machine may generate large quantities of smoke and a pungent odour when operated for the first time.

 Do not use the machine and working materials below 15 °C. Recommendation: room temperature.


6.2 Preparing for operation

- ▶ Install the support base [2].
- ▶ Insert the plug into an earthed socket.
- ▶ Insert a minimum of two adhesive cartridges in the magazine (chapter 8.2).
- ▶ Set the heating temperature for the relevant adhesive cartridges.

Temperature selection [1-7] according to the default setting:

Setting 1 = 190 °C

Setting 2 = 200 °C

 The temperature can be adjusted by pressing the menu buttons [1-19] (chapter 7.2). After independent changes are made, the last temperature used is automatically saved to the selected setting and replaces the default setting.

6.3 Switching on

- ▶ Press the on/off switch [1-8] once and hold until the Festool logo appears on the display [1-20].

The machine increases the temperature in heating mode until the setpoint temperature is reached (display [1-20] lights up red).

Machine switches to warming phase (display [1-20] flashes red/green).

Machine is ready for operation (display [1-20] lights up green).

NOTE

Do not leave the machine unattended!

- ▶ When taking a break of less than 15 minutes, switch the machine to cooling mode (chapter 6.4).
- ▶ When taking a longer break, switch off the machine completely.

6.4 Switching off

- ▶ Press the on/off switch [1-8] < 1 s

The machine reduces the temperature in cooling mode and then switches off.


Display [1-20] lights up red, fan symbol is displayed.

- ▶ Press the on/off switch [1-8] and hold > 1 s

The machine switches off immediately.

7 Settings

7.1 Adjusting the edge height [3]

 The edge height can only be adjusted **at operating temperature!** Ignoring this instruction may result in machine damage.

- ▶ Guide the edge band [3-2] into the edge inlet [3-3].
- ▶ Use the rotary knob [3-1] to adjust the height of the edge inlet [3-3] until the edge band [3-2] rests against the top and bottom of the inlet.
- ▶ Turn back the rotary knob by one locking position so that the edge band [3-2] can slide through smoothly without becoming caught.

7.2 Adapting the adhesive quantity

The necessary adhesive quantity is automatically adjusted to the current edge height.

Press the menu buttons [1-19] to adapt the adhesive quantity (layer thickness) to different workpiece materials (chapter 7.2).

7.3 Selecting the feed speed

The feed speed can be adjusted and adapted to the contour of the workpiece at any time by pressing the button [1-2].


1st gear = 2 m/min




2nd gear = 4 m/min

7.4 Menu buttons [1-19]

The following settings can be modified using the menu buttons [1-19]:


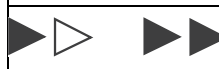
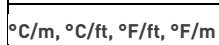
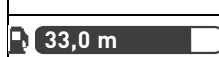
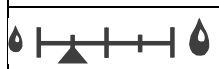

- Adhesive quantity
- Setpoint temperature
- Units of measurement







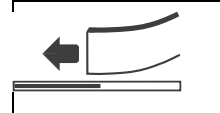



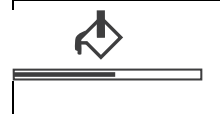
 If no menu buttons are pressed within 10 seconds, the menu is closed automatically and the changes are discarded.

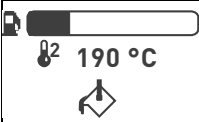


	Mode button Press the button to select the value you wish to change (flashes).
	Arrow buttons The selected value can be adjusted.
	OK Press <OK> to save any changes.

7.5 Display [1-20]

The current settings and information graphics are shown on the display [1-20].

	Temperature selection [1-7] Setting 1 (190 °C) / Setting 2 (200 °C)
	Feed speed [1-2] 1st gear (2 m/min) / 2nd gear (4 m/min)
	Units of measurement Select from °C/m, °C/ft, °F/ft or °F/m. °C = degrees Celsius m = metres °F = degrees Fahrenheit ft = feet
	Remaining edge length** Edge band length in relation to the remaining quantity of adhesive.
	Adhesive quantity Setting for the required adhesive quantity.
	Actual and setpoint temperature Display [1-20] lights up red during heating mode.

	Setpoint temperature Ready for operation, display [1-20] lights up green.
	Refill button [1-21] pressed Adhesive feed is reversed for refill process.
	Open flap [1-18] Adhesive feed was reversed for refill process. Flap [1-18] can be opened.
	Insert adhesive cartridges The magazine can be refilled with adhesive cartridges.
	Close the flap [1-18] Work can continue after the flap [1-18] is closed.
	Refill process complete Adhesive feed moves forward and pressure builds in the adhesive cartridges.
	Edge inlet ready Guide the edge band into the edge inlet [1-11] within 20 seconds. The remaining time is displayed. If the edge band is not inserted within the specified time, the start button [1-1] must be pressed again.
	Edge band to start position Now press the start button [1-1] to glue the edge band. The inlet starts up and transports the edge band through the machine.
	Remove the edge band An edge band was detected when the machine was switched on. Request for removal of the edge band. Press the start button [1-1] and hold until the edge band has passed through.
	Purging position reached Central plate [1-12] has been lowered completely and moved to purging position.
	Purging process starts Start button [1-1] was pressed. The purging process starts after one second.

	Purging process is carried out Adhesive nozzles are open, pressure has built in the adhesive cartridges. Display of the current status.
	Cooling mode The machine reduces the temperature in cooling mode and then switches off. Cooling mode is activated when: <ul style="list-style-type: none"> – on/off switch [1-8] is pressed < 1 s – no controls are actuated for more than 15 minutes The machine is switched on again by pressing the start button [1-1] or the on/off switch [1-8] .
	Fault symbol Troubleshooting (chapter 12).

** Automatic calculation of currently detected edge height

7.6 Dust extraction



CAUTION

Vapours emitted during the glueing process!

- ▶ Ensure there is good ventilation.
- ▶ Use an extractor.
- ▶ Always observe national regulations.

An extractor hose with a diameter of 27 mm can be attached to the extractor connector **[1-6]**.

8 Working with the machine



WARNING

High temperatures on the heating unit and adhesive nozzle!

Risk of burns when touched

- ▶ Wear suitable protective gloves.
- ▶ Always hold the machine by the insulated handles **[1-3]**, **[1-16]**!



WARNING

Moving workpiece!

Risk of injury from sliding workpiece

- ▶ Always secure the workpiece in such a manner that it cannot move.



CAUTION

Hardened PU adhesive has settled inside the machine.

Risk of damage to the machine – loss of warranty

- ▶ Clean the system no more than six hours after using PU adhesive (**see section 8.5**).

8.1 Glueing the edge band

- ▶ Cut the edge band down to size, leaving an allowance of approximately 10 cm.
- ▶ Switch on the machine **[1-8]**.
- ▶ Select the temperature setting **[1-7]**.

*Display **[1-20]** lights up red = actual and setpoint temperature are displayed. Machine is not yet ready for operation.*

*Display **[1-20]** lights up green = operating temperature reached. Setpoint temperature is displayed.*

Machine is now ready for operation.

- ▶ Adjust the relevant settings (**chapter 7**).
- ▶ Press the start button **[1-1]** once.
Edge inlet mechanism starts up.
- ▶ Guide the edge band into the edge inlet within 20 seconds **[1-11]**.
*The time remaining is shown on the display **[1-20]**.*

*The edge band is drawn in automatically up to the light barrier **[3-4]**.*

Inlet stops.

- ▶ Position the machine on the workpiece **[4-1]** approx. 2 cm away from the contact roller **[4-3]** with reference to the start marking **[4-2]** **[4]**. The start marking **[4-2]** and edge of the workpiece must be flush with one another.
- ▶ Press the start button **[1-1]** again.
Inlet starts.
Wait until the edge band with adhesive is visible.
- ▶ Push the machine down onto the workpiece and guide lengthways from right to left **[5]**. Exert pressure on the support base and against the

workpiece. Applying pressure in the feed direction is not necessary.

The edge feed mechanism moves the machine forwards automatically.


Once the edge band has passed through the feed completely, the mechanism stops automatically after a short delay.

8.2 Refilling an adhesive cartridge [6]

- ▶ Press the refill button [6-1].
Adhesive feed [6-2] moves back.
- ▶ Open the flap [6-3].
- ▶ Insert adhesive cartridges in the magazine.
- ▶ Close the flap [6-3].
- ▶ Wait until the adhesive feed [6-2] mechanism has moved forward and pressure has built up in the adhesive cartridges.

The refill process is complete, machine operation can resume.

8.3 Purging of adhesive cartridges




WARNING


Adhesive may escape immediately after actuating the safety lever [1-8] and simultaneously lowering the central plate [1-12] (purging position)! Risk of burns, damage to property from hot adhesive

- ▶ Remove the drop catcher and place a larger container such as a cardboard box under the machine.

Adhesive is pressed through the system without an edge band present when:

- The colour of adhesive cartridges is changed
- Changing from EVA to PU adhesive
- Purging PU adhesive from the machine using cleaning cartridges

 Approximately three adhesive cartridge are required to purge the machine completely.


 If necessary, press the refill button [1-21] for other adhesive cartridges and repeat the procedure.

- ▶ Position the machine at the edge of the bench [7].
- ▶ Remove the drop catcher [1-13].
- ▶ Place the container for catching hot adhesive into position.

- ▶ Press the refill button [1-21].
Adhesive feed moves back.
- ▶ Open the flap [1-18].
- ▶ Remove all the adhesive cartridges.
- ▶ Insert new adhesive cartridges.
- ▶ Close the flap [1-18].
- ▶ Set the edge height to maximum using the rotary knob for adjusting the edge height [1-4].
- ▶ Actuate the safety lever for purging the machine [1-9] while simultaneously turning the rotary knob for adjusting the edge height [1-4] clockwise until the central plate [1-12] rests against the bottom of the machine.
Purge position is reached.
- ▶ Press the start button [1-1] and hold > 1 s.
The purging preparation symbol appears on the display [1-20]. The process starts after 1 s.
- ▶ Continue purging until new adhesive appears in the adhesive nozzle [1-14].
Adhesive nozzles are open, pressure has built in the adhesive cartridges.
The purging symbol appears on the display [1-20] together with a status indicator.
- ▶ Interrupt purging: press the start button [1-1] again.
Adhesive nozzles are open, pressure stops building in the adhesive cartridges.
- ▶ Stop purging and leave purging position: turn the rotary knob for adjusting the edge height [1-4] clockwise.
Central plate moves upwards, adhesive nozzles are closed, pressure stops building in adhesive cartridges. Display [1-20] indicates normal standby status.
- ▶ Insert the drop catcher [1-13] again.

8.4 Special instructions on working with PU adhesive

- ▶ Pre-program the temperature settings to 140 °C and 190 °C (see section 6.2).
- ▶ Set the temperature to 140 °C.
- ▶ Open the tin of PU adhesive using a tin opener and remove the adhesive cartridge.
- ▶ Remove the paper liner surrounding it.
- ▶ Insert the cartridge as normal and glue the edges.

 The PU adhesive cartridge must be pressed completely through the system in order to entirely fill the system with PU adhesive.