

Product instruction manual Linea DH-650



lineaTM



The Linea has been designed to be user friendly, however we strongly recommend you take a few minutes to read through this manual to ensure correct operation.

Keep this manual safe for future reference.



SPECIFICATION

Model	DH-650	DH-460	DH-360
Max. laminating width	650mm	460mm	340mm
Max. laminating thickness	1mm		
Max. laminating temperature	140°C		
Max. laminating speed	1.6m/min	1.4m/min	
Recommended film	Up to 250 mic		
Diameter of heating roller	55mm	44mm	
Diameter of pull roller	45mm	30mm	
Power supply	AC220V/ 50Hz		
Power	1260W	700W	
Dimensions (L x W x H)	930X435X295mm	740X435X295mm	625X435X295mm
Weight	51KG	41KG	27KG

CONGRATULATIONS





















Thank you for purchasing and using our laminator.

You have purchased the finest laminator available in its service class. It was designed and manufactured to provide you with the utmost in utility. As with any device that combines power and movement in its use, there are dangers if improperly used. At the same time, there are easier and faster ways for getting the job done if certain precautions are taken first. Please read this manual carefully. It contains useful ideas in obtaining the most efficient operation from your laminator and safety procedures you need to know before beginning use. Save the manual for later use.

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SAFETY PRECAUTIONS

 WARNING	
 Please do not use broken, aging or self-made electrical wire and damaged supply cord. Please do not immoderately draw, twist or enlace the electrical wire, to avoid the fire or electric shock.	
 Please do not use the power supply that is not in accordance with the rated voltage, to avoid the fire or electric shock.	
 NO DISJOINT	 Don't disjoint, modify and repair the machine yourself.  If there are any problems on the machine, please do not use it, send it to the dealer for repairing.
 ENTANGLEMENT CAUTION	 Keep hands, long hair, loose clothing and articles such as ties or necklaces away from the front of the heating roller and pull roller to avoid entanglement.  In case some articles entangled, press the switch to REV right away; if not workable, cut off the power supply at once, and contact your dealer for settlement.
 ELECTRIC SHOCK CAUTION	 Do not make the electrical wire or plug or the machine bedewed by water or other liquids.  Do not operate the machine with wet hand.  Do not make the machine pressing on the electrical wire.  Do not cut off the power supply while moving the machine.  Do not operate the machine with the cover open.  The power socket must be properly grounded.
 HIGH TEMPERATURE CAUTION	 Do not put articles on the laminator while it is working, so that to disperse the heat.  Do not insert the easy-burnt or easy-softened material into the machine, in case they are melt and give rise to smoke.  Do not touch the cover, heating roller and heating parts while the machine is working, in case heat injury.

MAINTENANCE AND SERVICE

SOLUTION: The film is threaded improperly. If the adhesive side face to the roller, the film will be wrapped around the rollers. Thread the film in proper position.

The laminating temperature is too high, the film will be melted and wrapped around the roller. Decrease the laminating temperature.

Press the motor switch to stop position immediately. After the roller cool down, cut the film on the top and bottom, just in front of the stabilizer bars Reverse the roller at a very low speed and allow the machine to back out the film that is wrapped around the rolls, pull the film off the roller.

PROBLEM: Wrinkling of the plastic on a laminated material.

SOLUTION: Check the tension of the film, make sure the film is threaded properly (see film threading).

PROBLEM: Film is not properly adhered.

SOLUTION: The laminating temperature is too low, there is not enough heat for melting the adhesive. Increase the laminating temperature.

PROBLEM: The laminated material seems to have a irregular surface that does not match the texture of the paper being coated.

SOLUTION: This is usually caused by adhesive build-up or dirt on the rubber rollers. Inspect the rubber rollers and clean it.

Damages to the rubbers can also cause irregularities in the surface of the film.

PROBLEM: General haziness or cloudiness in the film after lamination.

SOLUTION: Increase the temperature or decrease the speed. That cloudiness is a function of incomplete adhesion. On a variable speed machine loaded with thicker film, it may be that the film is being run too fast.

For problems not listed here, contact your local dealer.

Service

If the service is required, please provide the following information:

- ☞ The detail of the problem
- ☞ Installation Date
- ☞ Serial number

MAINTENANCE AND SERVICE

Press LOAD button, the roller will run, cleans the roller. After cleaning, position the feed table and slide on the safety shield.

CAUTION: if the film gets wrapped around the roller, press the motor switch to stop position immediately. **WARNING:** do not use any cleaning solution to clean the roller, because some solutions may burn on the hot roller. After the roller cool down, cut the film on the top and bottom, just in front of the stabilizer bars. Reverse the roller at a very low speed and allow the machine to back out the film that is wrapped around the rolls, pull the film off the roller. Clean the adhesive on the roller.

PROBLEM SOLUTION

Please read this section before you have a problem

PROBLEM: No power is getting to the machine.

SOLUTION: Make sure there is power at the electrical outlet being used, and make sure both ends of the power cord are firmly engaged. The laminator equipped with three fuses (one is located next to the power switch, the other two are located under the bottom of laminator). Please check these fuses.

PROBLEM: Wrinkling of the film around the material being laminated.

















SOLUTION: This is normal and inevitable on any laminator, especially with thicker material. These wrinkles will be trimmed away with the scrap, so they do not affect appearance. Because the rollers are being held apart by the paper, they cannot pull equally on the plastic around the paper. This creates wrinkles that tend to look like the bow waves of a boat, radiating out through the clear part of the web from the sheet of material.

PROBLEM: When two pieces of material are laminated side by side, the plastic adhesive to one piece but not the other.

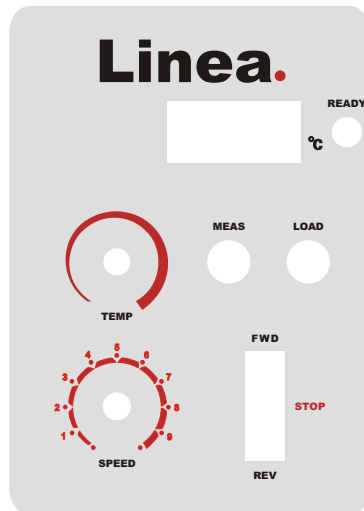
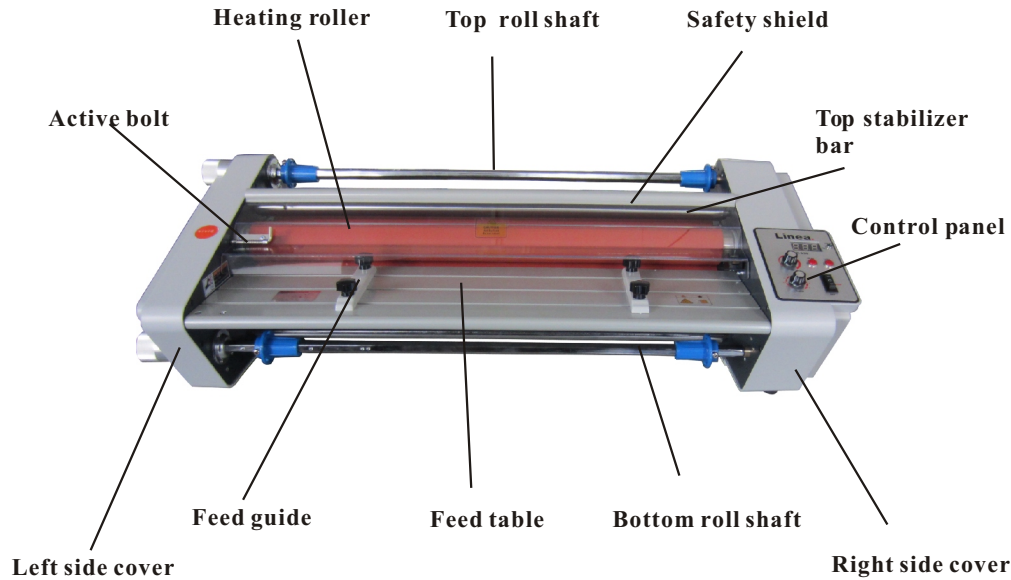
SOLUTION: To get maximum efficiency from the film rolls, you can feed several items into the laminator side by side. However, wrinkling can occur if these items are of unequal thickness, because the laminating rollers are lifted off the thinner items by the thicker items. When laminating items side by side, it is important to arrange them so that the thickness is the same.

PROBLEM: Film gets wrapped around the laminating rollers while hot laminating.

SAFETY PRECAUTIONS

 CAUTION	
WORKING PLACE	<ul style="list-style-type: none">  This machine should be put at the dry and clean place, do not put it at the damp place or near the exit of cooling appliances.  This machine should be put on the horizontal and firm place. In front and rear of the machine, there should be sufficient place for the document in and out.  Do not put any articles on the machine.
LAMINATING FILM	<ul style="list-style-type: none">  Please use good quality laminating film, in order to show the lamination effect, and avoid the entanglement.
OBJECT	<ul style="list-style-type: none">  The laminating machine use the hot press technology, do not use the following objects in case laminating failure or laminating film entangle. <ul style="list-style-type: none"> ※ 1. Easy-burnt material, easy-softened material ※ 2. The document printed by heat-sensitive paper, or any articles that can be faded or transformed after heating. 3. Any articles that have drape, breakage, dampness or deformation before laminating. 4. Coin or any other hard articles. ※ means exception while cold laminating operation.  Do not attempt to laminate articles that exceed total recommend material thickness.
MACHINE OPERATION	<ul style="list-style-type: none">  Do not turn to other usages except the usage range stated in this operation manual.  Do not use the machine outside the room. Before leaving, please cut off the power supply if the operation is over.  If there are any problems on the machine, please do not use it, send it to the dealer for repairing.
 ADVICES	
<ul style="list-style-type: none">  While operating the machine, mind the children nearby, in case any suddenness.  Do not suspend the electrical wire on the table or cabinet or any other places that the children can touch, or place easy stumble persons.  Using the accessory that not recommended or sold by the manufacturer, might cause damage on the machine.  The photo or document once is laminated, it will become permanent and will not be taken apart.  Please do not laminate the collected rare articles, or some articles might be taken out in the future. 	

STRUCTURE AND CONTROL PANEL



OPERATION INSTRUCTIONS

Adjust the machine according to the above instructions until you have the perfect lamination result.

2) After the trial lamination has a satisfied result, position the feed guides according to the width of the item to be laminated, entering the item in the web of film.

Remind: keep clear and enough space behind the machine, so that the laminated item can come out easily, it will not wind onto the rubber roller. If the machine is stopped for a long period, set the temperature decreased by 5-10°C, this will prolong the work-life of the machine.

Stop the machine after the item to be laminated pass through the roller completely, otherwise there will be an imprint on the item.

Temperature setting

Normally, your film supplier should provide the information about the film application temperatures and operating characteristics. If you do not know the source of your film, or if the supplier cannot provide the information, please try the temperature and speed until you have the best result.

MAINTENANCE AND SERVICE

GENERAL MAINTENANCE

Do not laminate the metal or other hard items in case the damage of the rubber rollers.

Cleaning the machine timely will help prevent dirt or adhesive build-up on the rubber rollers and will improve the performance of the unit.

CLEANING THE RUBBER ROLLERS

During the normal lamination, excess adhesives from the film will often cling to the rubber rollers

To clean the rubber rollers, remove the film from the machine first, heat up the machine to 30-40°C. The warm roller enable it easier to remove the adhesive build-up on the rollers. Raise the safety shield and take out the feed table. Using a clean, soft, ethanol dampened cloth, gently rub the adhesive off the rollers.

CAUTION: Never use any abrasive or sharp metal material or rub too hard on the roller, because you may damage the rubber surface.

OPERATION INSTRUCTIONS

CAUTION: For hot laminating, the top and bottom roll film must have same width, besides, the top film and bottom film must be aligned. (If the film is not in alignment, loose the bolt on core adapter and align it.)

Step 4: With both roll films threaded and installed in their respective brackets, unwind the top and bottom supply rolls about half-turn each. This will provide enough slack in the web to allow the feed table to slide on easily.

Step5: Make sure there is still enough slack in the web. With the film draped over the two heating rollers, and melted or taped together, push one edge of the threading card between the heating rollers so that the film is firmly positioned. If a threading card is not available, any piece of card stock or poster board will work.(See FilmThreading Diagram.)

Step 6: Press the LOAD button. If the film and the card are in the nip (the point where the top and bottom roller meet), the film and the threading card will start into the laminator and will pass through both sets of rubber rollers. When the threading card has cleared the back of the machine, loose the LOAD button

Step 7: Slide the feed table into position

Step 8: Position the safety shield forward toward the roller and lock the active bolt.

Remark: The machine will not power on without the safety shield in the proper positions.

CAUTION: For operator safety, the safety shield must be in position over the upper heating roller when the machine is ON.

HOT LAMINATING

1. Turn on the power switch, turn the temperature knob to set the temperature for whatever film is being used. The temperature should be adjusted according to the film thickness and the item being laminated.

2. The laminator will be ready to operation in about 10 minutes.

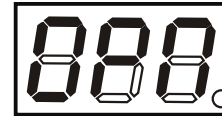
1) Trial lamination

If the roll film is the first time to be used, the trial lamination is required for perfect result. After the READY lamp is light, press the motor switch to FWD, let at least 250mm of film go through the rollers before inserting the items to be laminated. Examine the film coming out the back of machine.

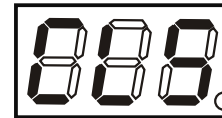
FUNCTIONS OF CONTROL PANEL

1. Digital display and Functions

Protecting function of temp sensor's open circuit and shot circuit



When the sensor is in open circuit, shows "OPN"

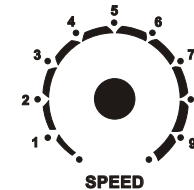


When the sensor is in short circuit, shows "CLS"

Note: No matter what problems happened, the machine will cut off the heating power supply automatically, and the motor will stop running.

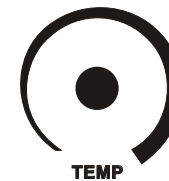
2. Functions of control panel

1) Speed setting knob



Turn the speed setting knob, you can select different laminating speed according to the different laminating temperature.

2) Temperature setting knob



Turn the temperature setting knob, you can choose different temperature knob setting, and read the temperature from the LED displays directly. This machine only display the setting temperature. Press the MEAS button, the true temperature will display on the LED display.

3) Ready indicator

READY



When the setting temperature is reached the READY indicator is light.

FUNCTIONS OF CONTROL PANEL

4) MEAS button



Press the MEAS button, the true temperature display on the LED display.

5) Film LOAD button



This button is used for threading film.

6) FWD/STOP/REV switch(Motor switch)



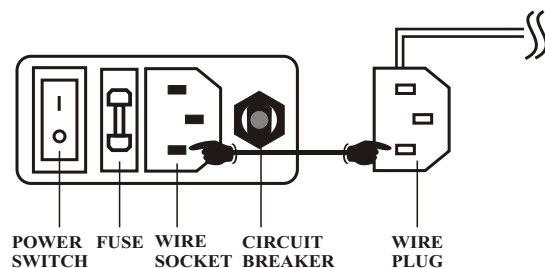
Press the switch to FWD position, the motor runs forward, the laminating film in, the machine works. Press the switch to STOP position, the motor stop. This function is used for pre-heating standby. Press the switch to REV position, the motor runs reverse, the laminating film out. This function is used for remove the object in setted by mistake.

OPERATION INSTRUCTIONS

PREPARATION

1. Connecting the power source

- 1) Checking the rated voltage on the machine, to insure it conform to the power source. Also, checking the plug to insure it conform to the socket.



OPERATION INSTRUCTIONS

- 2) Insert the plug into the power socket that is grounding correct.
- 3) Turn on the power switch, the display light, it indicates the power is connected.

2. Motor overload circuit breaker

This machine is equipped with motor overload circuit breaker (it is located behind the machine), in order to protect the motor working normally. When the motor is overload, the circuit breaker will jump and cut off the motor power. One minute later, when the overload is clear, press the circuit breaker button, the motor will start again.

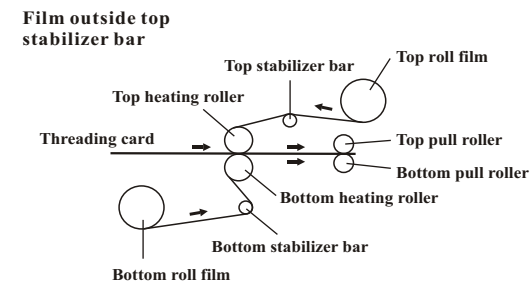
3. Film threading

Step 1: Raising the safety shield.

Remove the active bolt on the shield, raise the safety shield.

Step 2: Taking out the feed table.

Step 3: Follow the diagram to thread the film



Threading Diagram

Remark: Usually the shiny side is the polyester side, it contact the roller. The dull side is coated with adhesive. For the matte film, the two sides have minor difference, please especially be careful. Heat the film with lighter can easily tell the polyester side and adhesive side. The adhesive side must face away against to the roller.

Push the roll shaft to the right side, lift and then take out the shaft. Slide the roll film onto the roll shaft (follow the above instruction, do not load the film in wrong side). Hold the roll film on the core adapter, the core adapter can hold the core of the roll film, to prevent it rotating. Screwing the bolt on the core adapter. Put both hexagonal fittings into their respective brackets. Make sure they are both fully seated.