

SF-390A
Laminator

Operating Manual

Instructions of the operation manual:

- ★ Before operating the laminating machine, please read and understand the contents described in the manual carefully.
- ★ Please keep this instruction manual for future reference.
- ★ Please pay special attention to the sections marked with warning symbols in the manual, which are very important for the correct use and maintenance of the machine and the safety of users.
- ★ With the improvement of product function and software upgrade, the information of operation manual will be constantly changed and perfected without further notice. The description and image involved shall be subject to the actual contents in the packing box. The company reserves the right to modify and interpret this instruction manual. We strive to ensure the accuracy of the instructions and the product functions and features described, but we do not assume any responsibility for any differences between the user manual and the product.

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1. Safety Precautions



1.1 Before operation of this machine, please note if the supply voltage used matches the rated operating voltage of the machine. Use the supply voltage consistent with the rated operating voltage of this machine. Never misuse the supply voltage;

1.2 Please do not use damaged power cord or broken power socket;

1.3 The power supply should provide reliable grounding protection;

1.4 In order to avoid electric shock accident or machine failure, please do not spray water or other liquids on the machine;



1.5 Please do not touch the surface of the steel roller with your hands to avoid scalding skin;



1.6 Be aware not to entangle clothes, necktie, hair, necklace, cuffs and the like into the running machine during the operation, which may cause unnecessary damage to the machine;

1.7 In the process of film covering operation, please do not put any items other than the coating on the working panel or the boxes on both sides, so as to avoid accidental involvement of the articles and damage to the machine;

1.8 In case of fault, people other than professionals shall not attempt to dismantle the machine for repair. Repair shall be conducted by professionals or organized by local dealer. Dismantling and repair by unauthorized persons will adversely affect the normal service and maintenance of the machine;

1.9 The environment for the operation of the unit shall range 10°C—40°C. Ideal humidity: **55%**. The unit should stay away from locations with high

temperature (e.g. by air-conditioner), and damp and dusty locations;

1.10 When the machine is running, the operator should not leave his post;

1.11 Please prevent children from using or touching the machine;



1.12 When the machine is out of service for a long time, please cut off the power supply;

1.13 Please do not change the original configuration of this machine. If the user makes any changes, we will not take any responsibility for safety.

2. Application and characteristics of SF-390A

2.1 Application of SF-390A:

SF-390A fast laminator laminates printed matter, spray-drawing products, packing boxes, books and the like, allowing them to resist water, stain and damage, and providing durability. Featuring compact size, fast and continuous lamination, automatic parting cut, easy operation, economics and utility, this unit is ideal for the post production of various types of printed and packing products.

2.2 Main characteristics of SF-390A fast laminator:

2.2.1 Be suitable for lamination of BOPP pre-film-coating of rolls, For example: matte film, bright film, aluminum coating, laser film, tactile film, etc;

2.2.2 Mirror chrome plating roller, oil heating;

2.2.3 Touch screen human-computer interaction display system;

2.2.4 DC speed control system;

2.2.5 Electric hydraulic pressure system, film pressure adjustable;

2.2.6 Full automatic paper feeding control system, can overlap;

2.2.7 Pneumatic automatic cutting system;

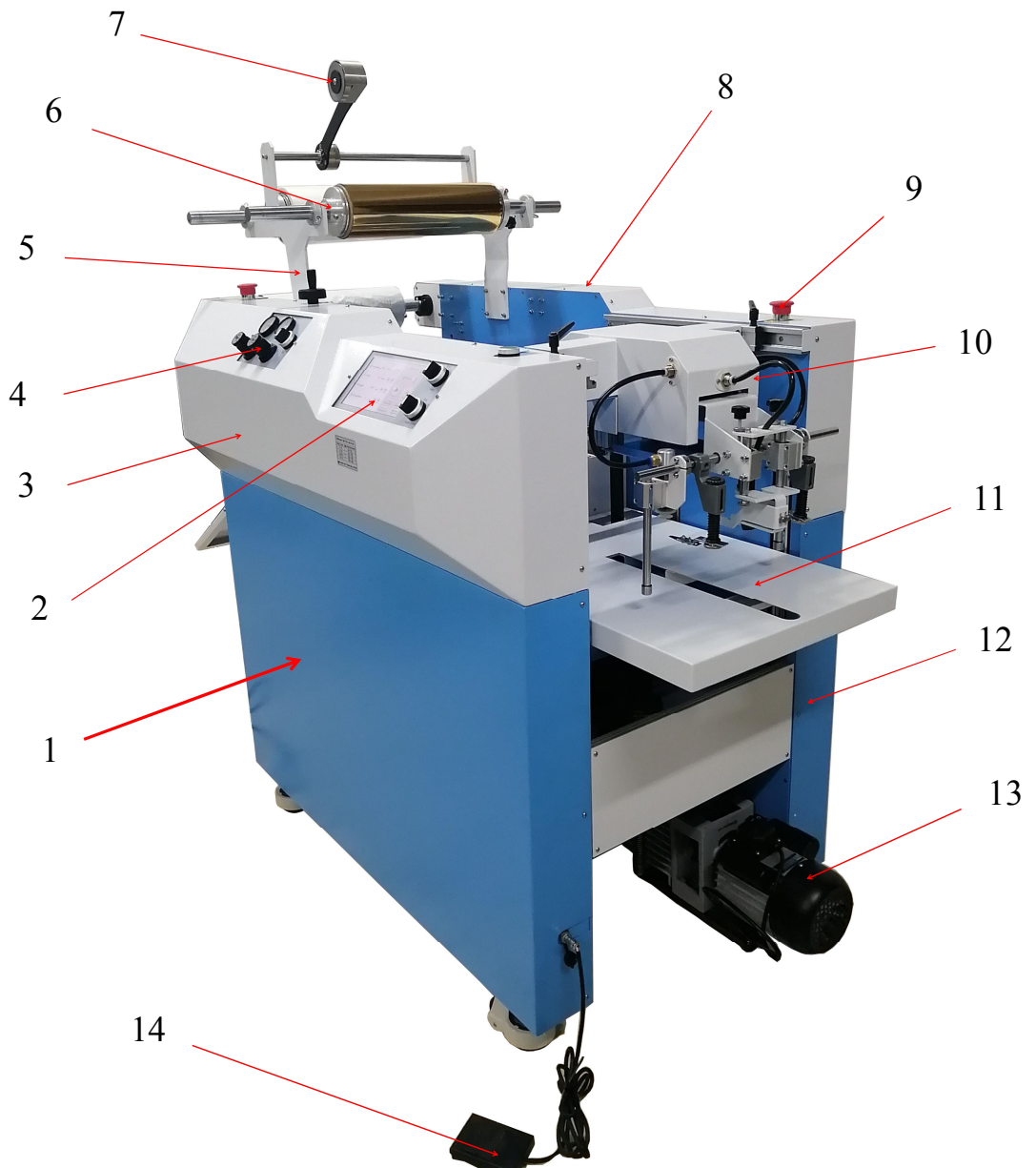
2.2.8 Curling-preventing device, preventing laminated paper from curling;

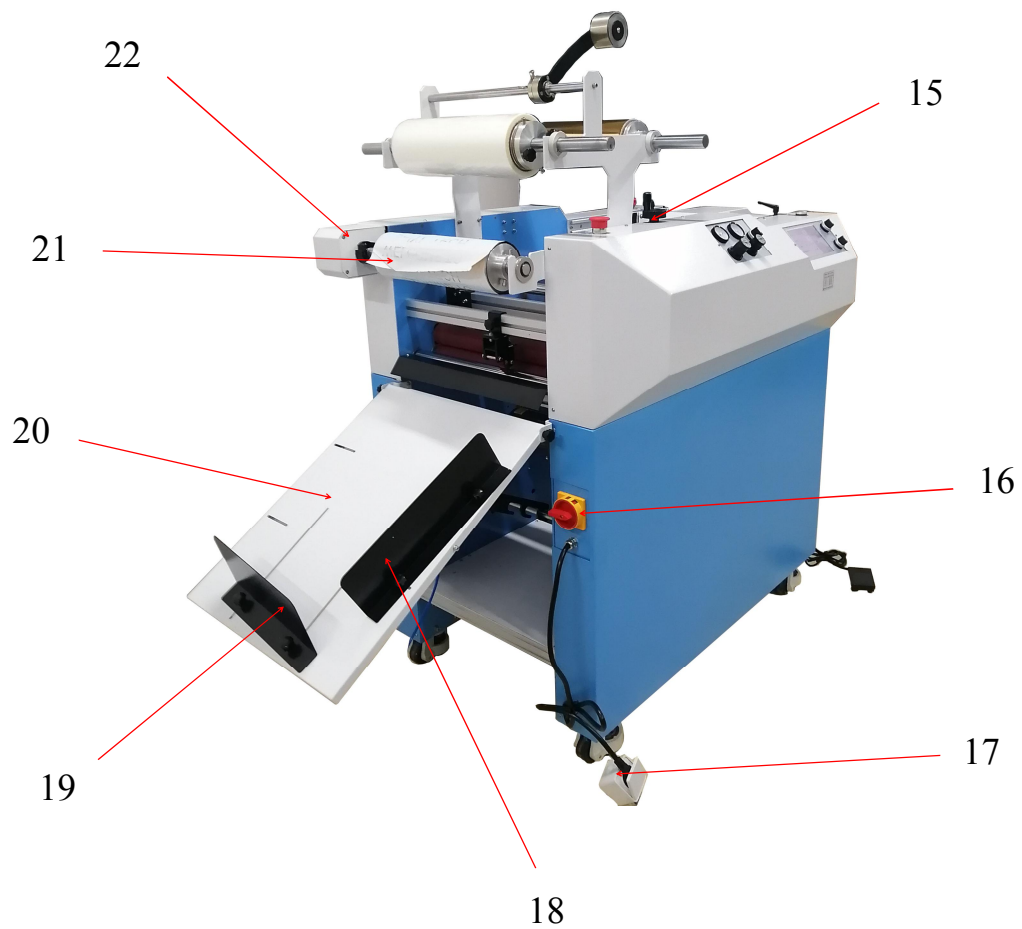
2.2.9 Film slitting device;

2.2.10 Bronzing winding device.

2.2.11 Automatic stop function for paper shortage.

3. Schematic diagram of the whole machine

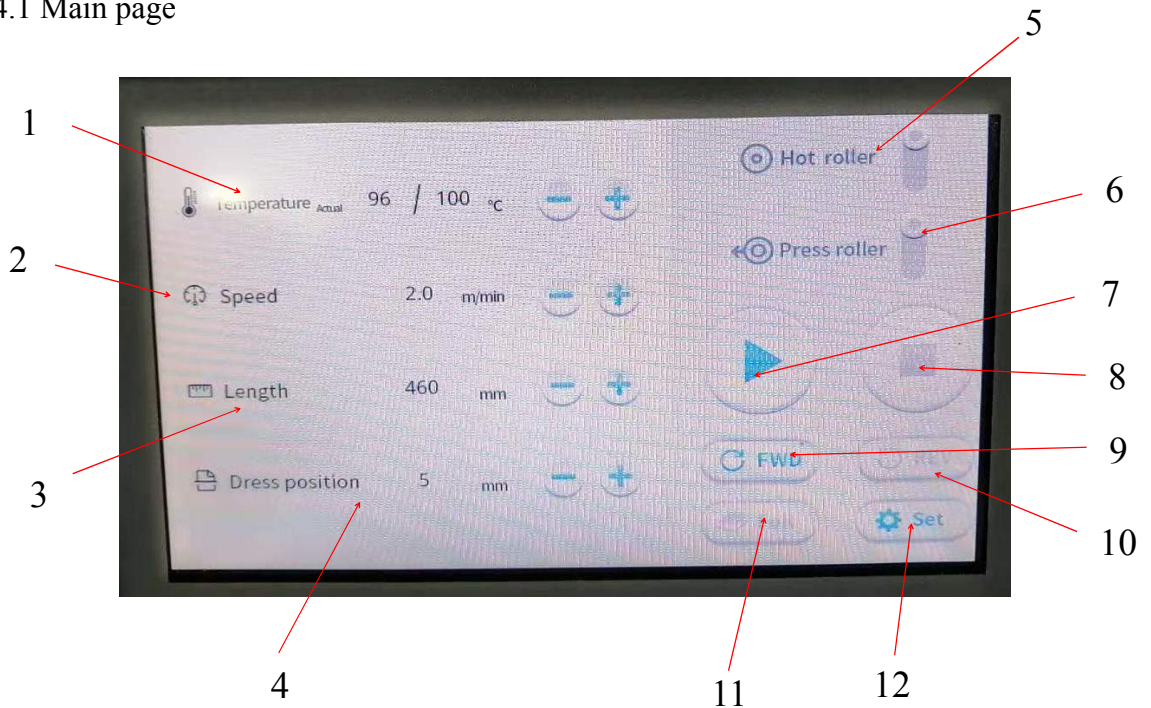




- 1. Lower left box
- 2. Operation display screen
- 3. Upper left box
- 4. Pressure regulating valve
- 5. Roller support
- 6. Roller device
- 7. Cutter mechanism
- 8. Upper right box
- 9. Emergency stop switch
- 10. Feeder
- 11. Paper placement platform
- 12. Lower right box
- 13. Negative pressure vacuum pump
- 14. Foot switch
- 15. Anti roll handwheel
- 16. Power switch
- 17. Power cord
- 18. Side baffle
- 19. Rear baffle
- 20. Back stacker
- 21. Take up roll
- 22. Winding mechanism

4. Operating instructions for operation panel

4.1 Main page



1. Temperature setting key 2. Speed setting area 3. Paper length setting key
 4. Setting area of cutting value adjustment 5. Laminating roller lifting button
 6. Lifting button of traction roller 7. Operation key 8. Stop key
 9. Pedal forward button 10. Pedal reverse button 11. Foil 12. Set

4.1.1 Temperature setting display

temperature value of the laminating roller; the set value adjustment range is "80 ~ 130 °C", and if it is lower than 80 °C, it will be displayed as "---"; when the button "+" is pressed, the value of 80 will appear, and the machine will start to heat up. Press "+" temperature setting value "+ 1" again, and press "+ 5" continuously; press "- 1" for temperature setting value and "- 5" for a long time. When the machine starts to heat up, the actual display temperature value changes with the actual temperature of the laminating roller surface.

Note: (1) laminating can be carried out when the actual surface temperature of the laminating roller reaches $\pm 5\text{ }^{\circ}\text{C}$;

(2) when the heating function needs to be turned off, the set temperature value should be reduced to $80\text{ }^{\circ}\text{C}$ first, and then press the button "-" again. When "-" appears, it means that the heating function of the machine has been turned off;

(3) The temperature overshoot will appear in the initial heating, and the overshoot is about $10\text{ }^{\circ}\text{C}$ and stable at the set value for about 15 minutes. Please wait until the temperature value is stable, so as not to affect the film quality.

4.1.2 Display of set speed value

The speed adjustment range of main roller is 1-15m / min, and the speed of each gear is 0.5m/min, increasing or decreasing. Press the icon "+" to increase the speed value, otherwise, press the icon "-" to decrease the speed value;

Note: the speed of slitting roller is not adjustable;

4.1.3 Paper length adjustment setting area

The adjustment range of paper length is 200-1200mm. Press the "+" or "-" button to change the value by one digit, increase or decrease by 1 mm, and press for a long time, and the value will increase or decrease in 20 units;

4.1.4 Setting area of cutting value adjustment

Press the "+" or "-" button to change the value by 1 bit, increase or decrease by 1 mm, and long press, the value will increase or decrease in 5 units;

4.1.5 Laminating roller lifting button

The icon is on, the icon is dark, and the roller is closed. When the icon is under, the roller is opened and the icon is on;

Note: when the laminating roller is not closed, the machine will not move after

pressing the operation button

4.1.6 Lifting button of traction roller

The icon is at the top, the icon is dark, the roller is closed, the icon is at the bottom, the roller is open, and the icon is on;

4.1.7 Run button

After pressing, the machine starts to work in linkage (i.e. both the cardboard baffle and the cutting roller can act); when pressed, the icon is dark in normal operation, while it is on in standby.

4.1.8 Stop button

This button controls the stop of the machine in the linkage state; after pressing the button, the machine stops working, the icon is dark, and the icon is on during the operation of the machine.

4.1.9 Pedal forward button

This button is used with the foot switch. Press this button to turn dark. At this time, the machine starts to run when you step on the foot switch (only the main motor drives the rollers to run at the set speed). Release the foot switch and stop running. The icon will be on if you don't press the button. What is the speed setting value of forward rotation, the actual machine will operate according to this set speed;

Note: (1) this button is usually used when the machine is preheated or debugged;

(2) if the foot switch is used, the cutting roller of the machine will not work;

4.1.10 Pedal reverse button

This button is used with the foot switch. Press this button to turn dark. At this time, the machine starts to run when the foot switch is stepped on (only the rollers driven by the main motor run). After the foot switch is released, the icon will be on;

Note: there is no speed regulation for pedal reversal, and the maximum speed is 3m / min;

4.1.11 Foil

This button can be used when there is no need to cut the coated finished product or add the gilding device without the action of the slitting roller. If it is pressed down, it will turn dark and the cutting roller will not act; otherwise, it will be on, and the cutting roller will work normally;

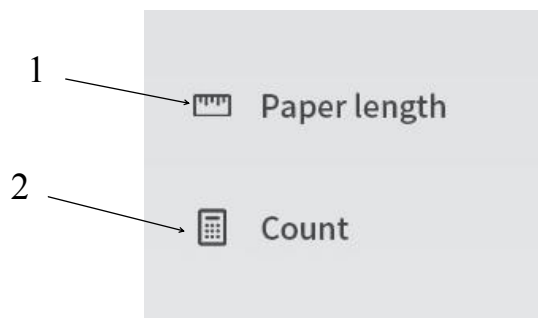
This button is used to enter the secondary interface. Click once to enter the secondary page;

Note: this key is invalid during normal operation of the machine. If there is no need to move the slitting roller, please press this key before running the machine.

4.1.12 Set

This button is used to enter the secondary interface. Click once to enter the secondary page;

4.2 Setup page



4.2.2 Paper length

It is used to adjust the error between the paper length value recognized by the system and the actual measured paper length value. The factory setting of this parameter has been completed, and the operator does not need to adjust it;

4.2.5 count

Record the total number of paper and the operator can read it;

4.2.6 home button



This button is used to return to the home page. Click to return;

5. Main technical parameters

Technical parameters \ Model	SF-390A	
Max. size of roll film	0.39m ×4000 m	
Film thickness range	17Mic~32Mic	
Applicable dimension of reel for roll film	φ75mm	
Max. O.D. dimension of roll film	Φ340mm	
Applicable thickness of paper core	Laser printing paper	135~350g/m ²
	Printing paper	157~350g/m ²
Max. applicable size of printed matter	390×520mm	
Min. applicable size of printed matter	200×300 mm	
Speed regulation range	1~15m/min	
Temperature regulation range	80~130℃	
Preheating time	20℃ At room temperature 25min (100℃)	
Operation and display system	touch screen	
Pressurization mode	hydraulic pressure	
Heating mode	Oil heating	
Laminating roll diameter	Upper roll	High gloss chromium plating 120mm
	Lower roll	silicon rubber 80mm
Paper overlap accuracy	±2mm	

Rated input power	3200W
Rated input voltage	220~240VAC, 50/60Hz
Allowable voltage fluctuation	+/-10%
Allowable frequency fluctuation	+/-10%
Net weight of complete machine	305Kg
Gross weight of machine	380Kg
Physical dimensions of machine (L×W×H)	1730×800×1480 mm
Machine transport dimensions (L × W × H)	1400×900×1360mm

※Recommended specifications of air pump: air storage tank volume: ≥ 50L, exhaust capacity: ≥ 80L / min, power: ≥ 1000kW

6. Operating cautions

6.1 The surface of the hot steel roll of the machine should be kept clean and frequently wiped in alcohol of high purity, thus eliminating the effect on the lamination.

6.2 When cleaning the machine, never wipe this machine with corrosive liquid to avoid damaging the machine body. Use soft dry cloth to wipe the machine.



6.3 After the lamination, cool the surface of the steel roll before stopping the machine, and lift the front steel roll and the rear rubber roll to avoid the deformation of the rubber roll surface.

6.4 Never use this machine for other purposes than film overlay. Otherwise, it may cause accidents or damage to the machine.

6.5 The pressure setting value of the pressure gauge of the laminating roller should not be over 0.4MPa;

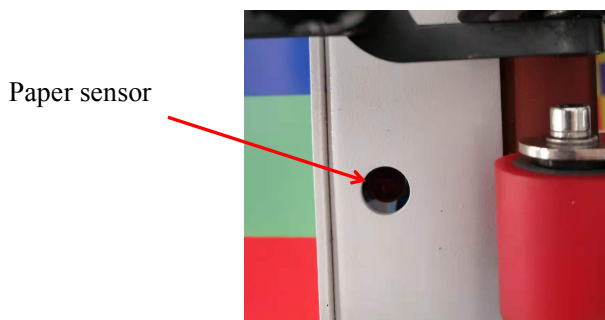
6.6When the machine is under 2m / min, the normal working speed should be higher than 2m / min;

6.7After laminating, please lower the laminating roller to avoid the deformation of COTS caused by long-term closure;

6.8High temperature lubricating oil should be applied at intervals between temperature sensor and steel roller.

6.9 the oil window of negative pressure vacuum pump should be observed regularly. When the oil level drops, vacuum oil should be added; (as shown in the figure)

6.10This machine is equipped with the function of automatic stop for paper shortage. The detection sensor is as shown in the following figure. If there is a stop during the paper feeding process, please check whether there is no paper here first;



7. Assembly of machines

7.1Packing box disassembly:

7.1.1Remove the baffle, upper cover and fixed wood strips around the packing box in turn;

7.1.2Open the plastic cover;

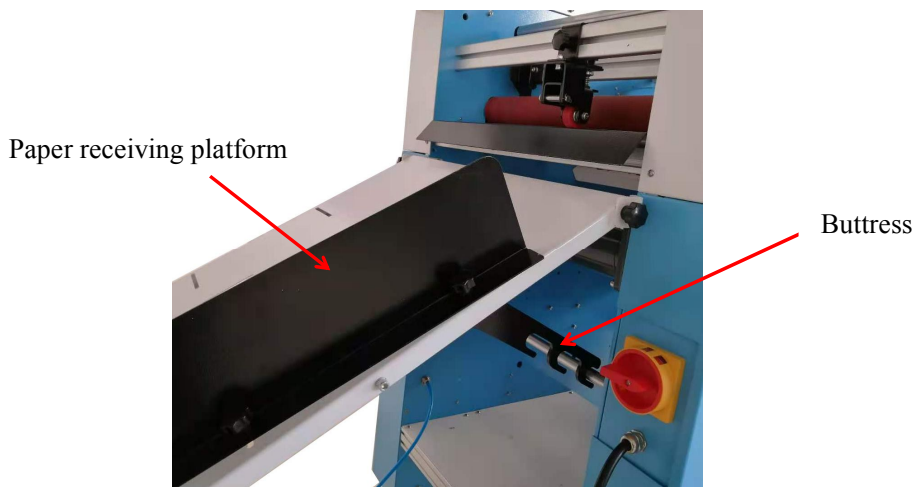
7.1.3Remove the pressing plate and wood strip fixing the fuselage;

7.1.4Remove the machine from the bottom bracket (use forklift, lifting screw and lifting belt);

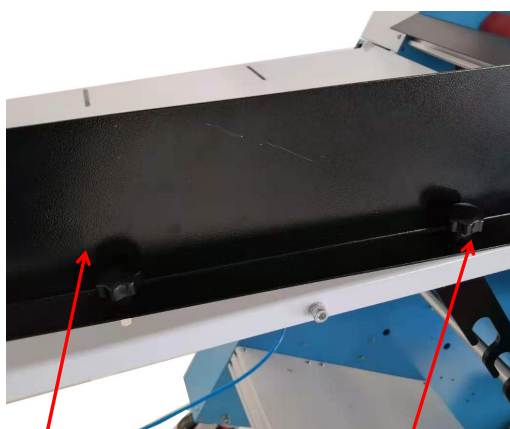
7.1.5 Place the machine on the flat ground and lock the caster;

7.2 Installation of rear paper receiving station

7.2.1 Turn the back paper receiving platform along the direction shown in the figure, and support the support plate on the support rod of the machine (the angle can be adjusted according to the needs)



7.2.2 As shown in the figure below, install the side baffle board on the paper receiving platform with M5 stainless steel hand screw and butterfly nut;



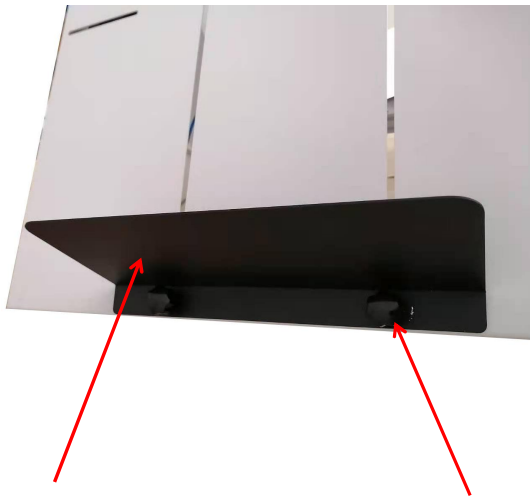
Cardboard side

M5 plastic hand screw



Butterfly nut

7.2.3As shown in the figure below, install the rear baffle board on the paper receiving platform with M5 plastic hand screw and baffle mounting rod;



Back board

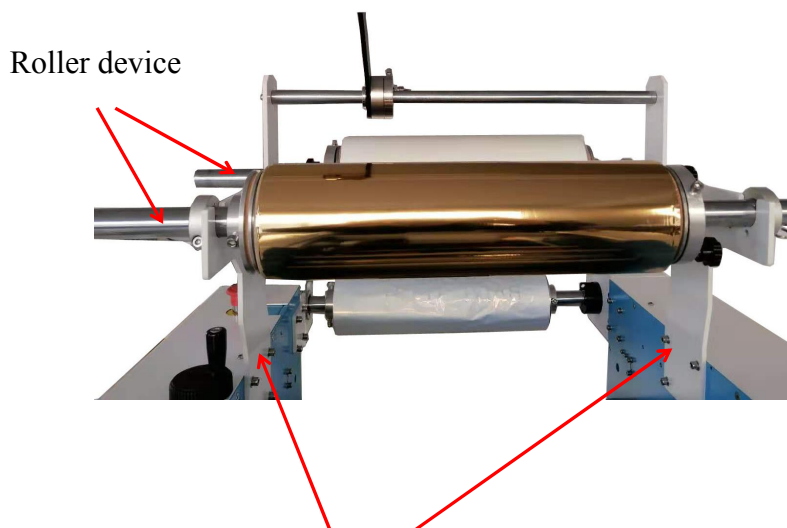
M5 plastic hand screw



Baffle mounting rod

7.3 Installation of material roller support plate and material roller

7.3.1 Install the roller support plates on the machine with M5 * 12 socket head screws according to the figure;



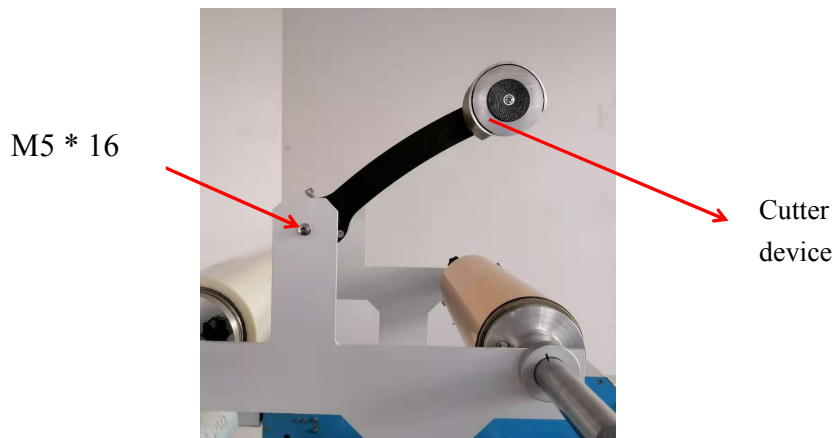
Roller device

Roller support

7.3.2 Place the material roller device on the bracket as shown in the figure;

7.4 Installation of cutter mechanism

7.4.1 Install and fasten the support rod of cutter mechanism with M5 * 16 hexagon
l screw as shown in the figure;



Note: two people are required for this installation

8. Operating procedure and method of machine

8.1 Connect the air source: insert the Φ 6mm gas pipe into the air source interface of the machine;

8.2 Connect the power and switch the power on. (The display is on) ;

8.3 First press the pedal forward button, and then step on the foot switch to make the machine run;

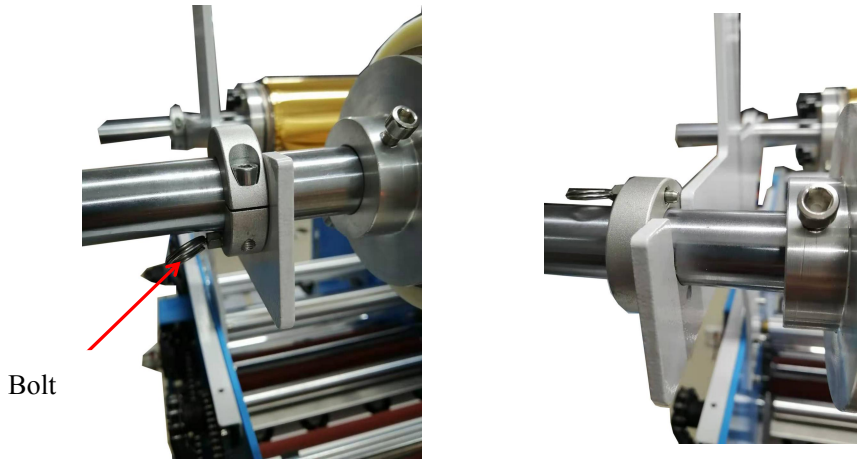
✘ Now, the speed shall be set below 2m/min.

8.4 Set the required temperature value for operation, and the machine will start to warm up.

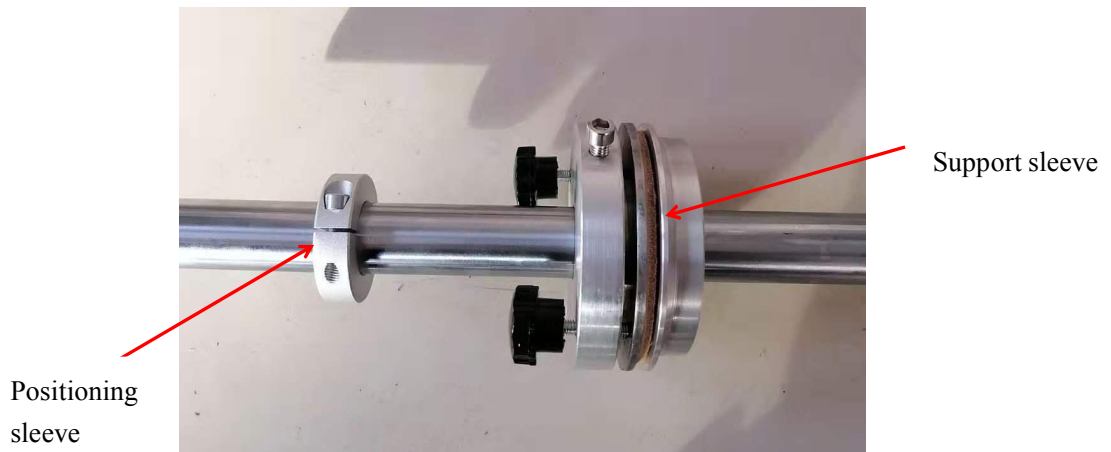
✘ The temperature value should be set according to the thickness of the coating, the color of the printed matter on the surface and the working speed. The setting value should not be too high at the beginning, so as not to affect the laminating effect.

8.5 Install the roll film as follows:

8.5.1 Pull out the pin and rotate the roller about 180 degrees.



8.5.2 Take down the roller mechanism from the machine and take down the positioning sleeve and the support sleeve with adjusting screw according to the direction shown in the figure (as shown in the following figure);



8.5.3 The feeding roller is inserted into the paper cylinder, and the boss of the supporting sleeve of the feeding roller at the other end is inserted into the paper cylinder and is plugged as tightly as possible (as shown in the figure below);

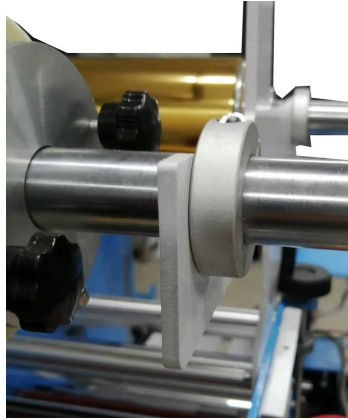


8.5.4 Insert the removed boss of the support sleeve into the paper cylinder and plug it as much as possible, and then tighten the locking screw (as shown in the figure below);

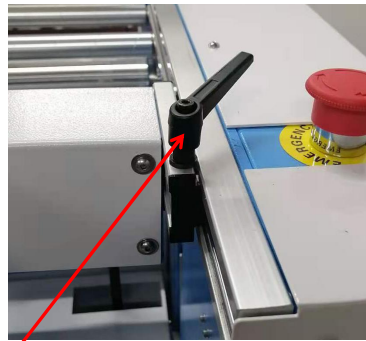
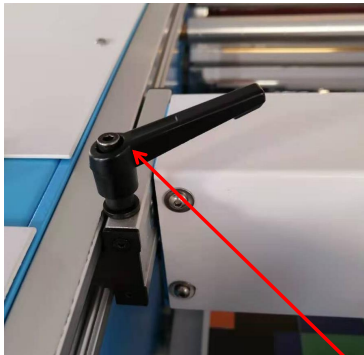


8.5.5 Place the roll with film rolling on the machine as shown in the figure, rotate it 180 degrees again, insert the pin into the positioning hole on the bracket, and then install the positioning sleeve;

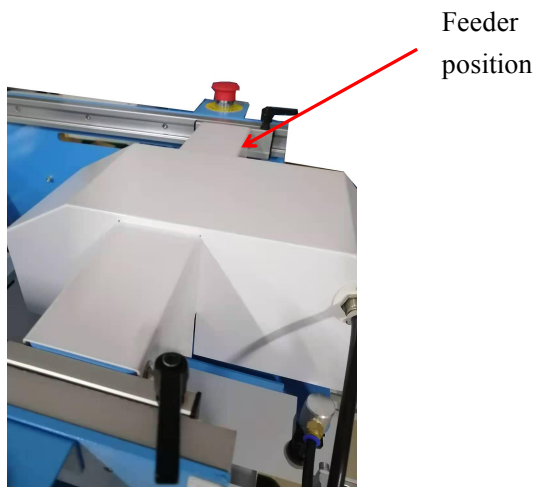
Note: there are bolt positioning holes on both sides of the support plate



8.6 Release the fixed handle of feeder to make it to the outermost position;



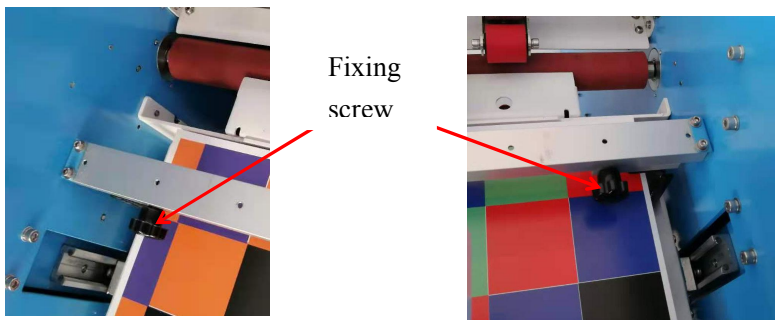
Feeder fixed handle



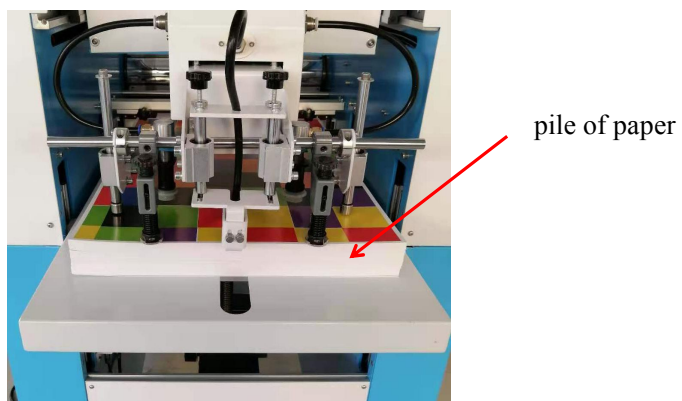
8.7 Turn the lifting switch of the paper table to “Down”, Feeder switch should be in "Stop" ” , lower the paper table to the bottom position, and then stack the coated paper on the paper table



8.7.1 Loosen the fixing screw and open the front side board;

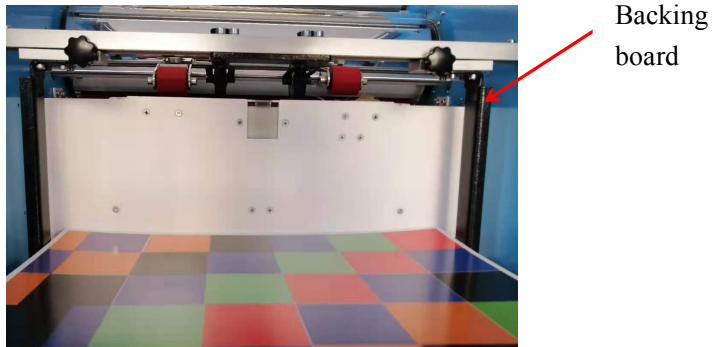


8.7.2 The paper to be covered with film is stacked on the paper table in turn;
Note: the stacking should be in the middle as far as possible, and the left and right sides and the back of the stack must be neat;



8.7.3 Use the side backup plate to hold the paper pile respectively, and then fasten it with screws;

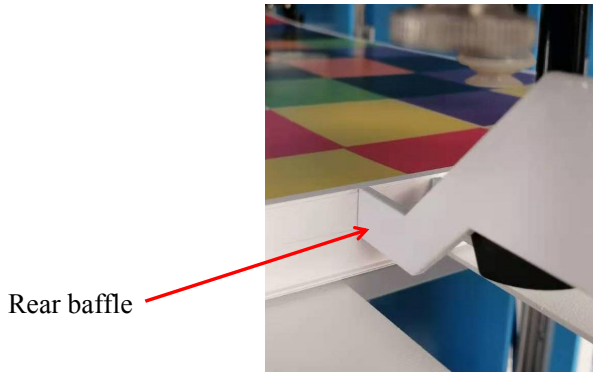
Note: the backing plate is not easy to stack too tightly against the paper, and there should be a gap of about 1 mm;



8.8 Turn the lifting switch of the paper table to “up” to make the paper table rise automatically, and it will stop automatically when it is in place,

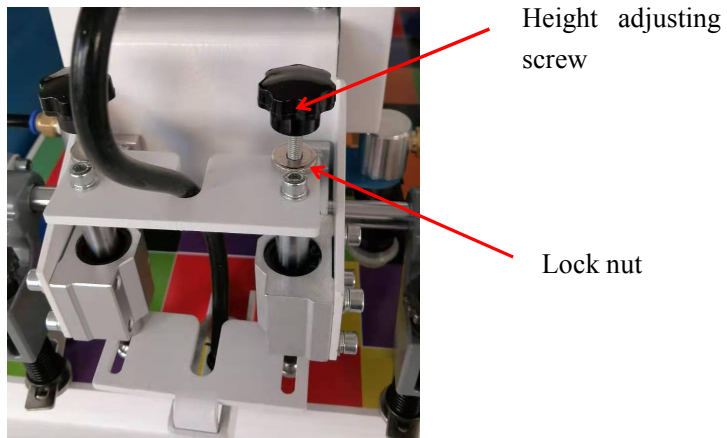


8.9 Push Feeder forward to make the rear baffle board lean against the back of the paper pile, and then lock the fixed handle of Feeder;

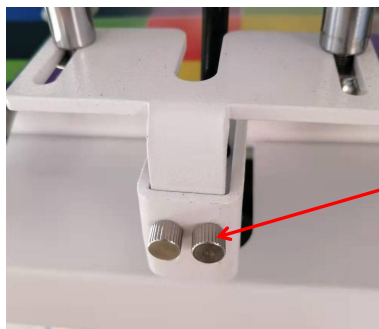


8.10 According to the thickness of the paper and the position of the paper stack, adjust the position of the air blower and the rear baffle, and the specific methods are as follows

8.10.1 Adjust the screw blowing nozzle clockwise as shown in the figure to rise and vice versa. Loosen the fastening nut before adjustment and lock it after adjustment.



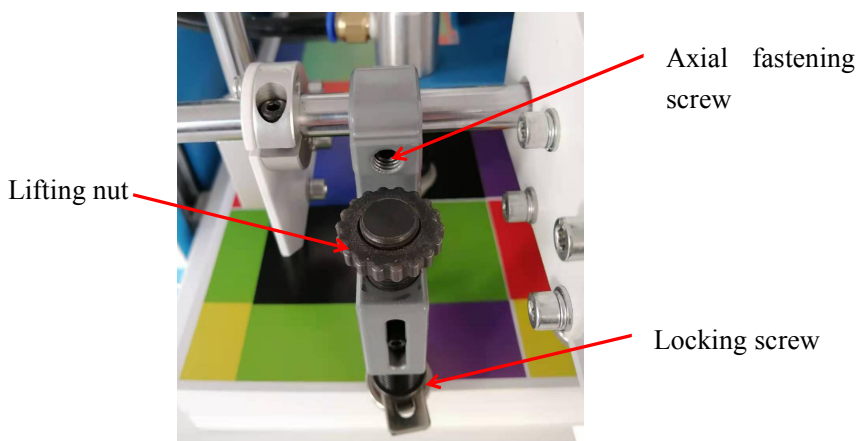
8.10.2 Loosen the fastening screw of the rear baffle and adjust the height of the rear baffle (the height of the rear baffle should be slightly higher than the paper stack by about 2mm);



Locking screw

Note: thin paper blowing nozzle can be properly high to ensure that five pieces of paper can be blown away;

8.11 According to the width of the paper, adjust the position of the pressing sheet, and the specific method is as follows:



Axial fastening screw

Lifting nut

Locking screw

8.11.1 Loosen the fastening screw, and the paper pressing device can move left and right;

8.11.2 Adjust the nut clockwise or anticlockwise, the pressboard can rise and fall;

8.11.3 After loosening the fastening screw, the paper can be moved back and forth;

8.12 According to the width of the paper, adjust the position of the pressure bar, loosen the fastening screw, the pressure bar can move left and right, which is

easy to place at the two corners of the paper pile;



8.13 According to the actual length of the coating, set the paper length value.

※ Example of adjustment method: the actual length of the covered object is 450 mm, and the display screen value is set to 450. At this time, the lap edge between the front and rear sheets should be 0. If the front and rear paper lap edges are required to be 2 mm, the display value can be adjusted to 448. (Note: to avoid the glue of the lower rubber roller, please do not allow the gap between the front and rear sheets)

8.14 Observe the actual temperature value in the display interface. When the actual temperature value is within $\pm 5\text{ }^{\circ}\text{C}$ of the set temperature value, the membrane penetrating operation can be carried out. The specific methods are as follows:

8.14.1 Make the machine stop rotating and ensure that the laminating roll and the back pressing roll are in the open state;

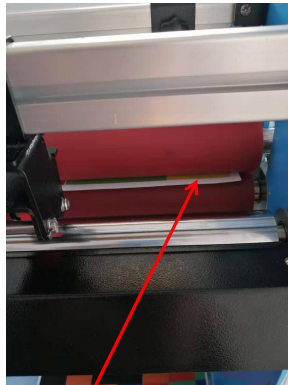
8.14.2 Feed the thicker paper (preferably 200g) with a length of 450mm or more from the front end of the front steel roller (as shown in the figure below).



8.14.3 The paper passes through the middle of the anti crimp device and passes through the rear traction roller to the position of the rear slitting roll;

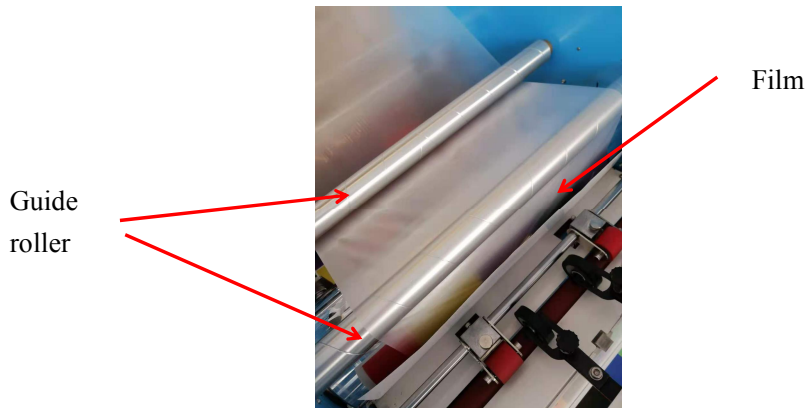


Anti roll
device



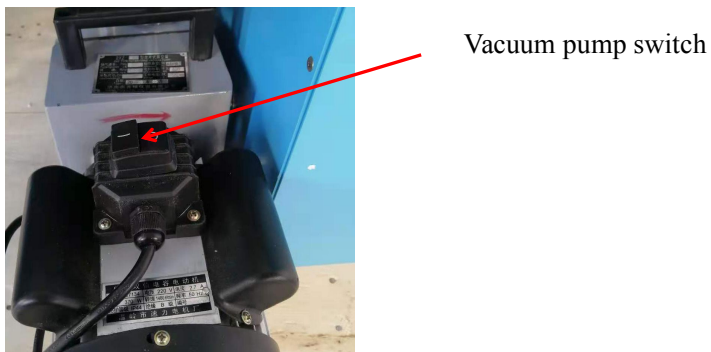
Paper

8.14.4 Put the film through the guide roll, put it on the front hot laminating roll, and then bond it with the end of the paper; (as shown in the figure below)

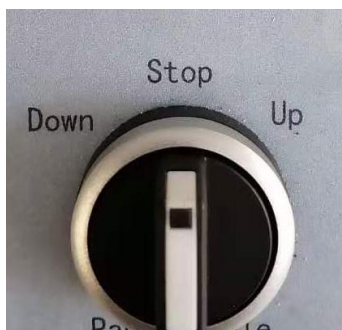


※ During this operation, do not glue the coated surface of the adhesive film on the steel roller. If there is glue, please remove it in time to avoid affecting the laminating effect.

8.15 Turn on the vacuum pump switch;



8.16 Turn the lifting switch of the paper dropping table to "stop";



8.17 Press the reset button to reset Feeder



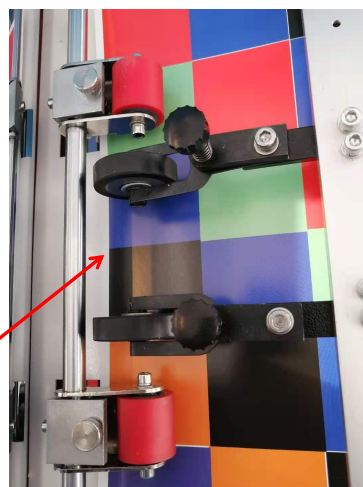
Note: this step is to prevent Feeder from being out of position during the last shutdown. If it is in the original position, the suction nozzle mechanism has no action. If it is no longer in the original position, the suction nozzle will move automatically (if there is jamming phenomenon in the reset process, please manually assist its reset);

8.18 Turn the Feeder control switch to "Auto" and the first sheet of paper is fed in.

Note: the first piece of paper fed by Feder may not be fully in place. Please hold the front end of the paper against the baffle manually;



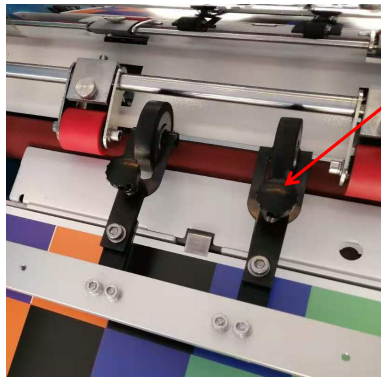
First piece of paper



8.19 The specific methods are as follows:

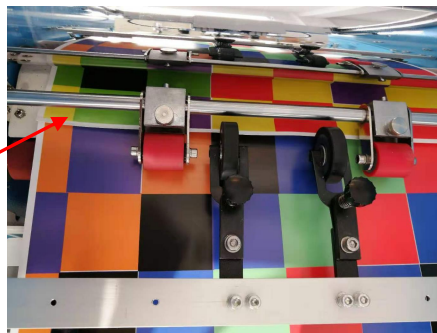
Adjust the adjusting screw clockwise to increase the preload, otherwise decrease.

Note: the preload needs to be adjusted according to the different thickness of the paper. The general adjustment is as follows: one paper feeding wheel does not rotate, two papers are fed, and the paper can be rotated;



Paper feeding
auxiliary
wheel

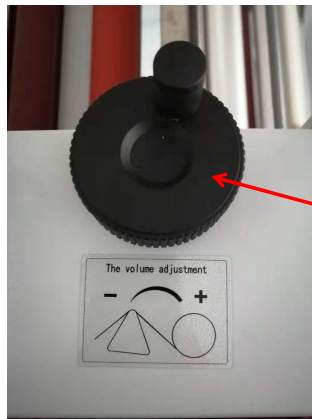
8.20 Close the laminating roller and traction roller, and then start the operation button. When the paper feeding wheel is lifted, place the second sheet of paper. When the end of the second sheet of paper reaches the position shown in the figure below, press the stop key to stop the machine.



Paper
position

Note: it is better to use waste paper with the same size and specification for the first few sheets of paper, so as to avoid waste due to improper adjustment of previous parameters;

8.21 Rotate the hand wheel according to the anti crimp schematic diagram to preset the anti crimp gear position;



Adjust the handwheel

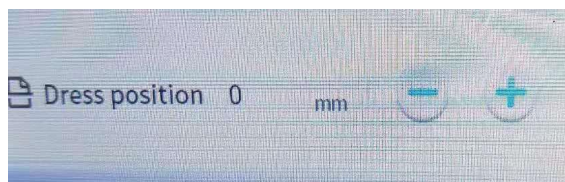
8.22 The reference table is set according to the anti crimp position and cutting value, and the cutting value is set on the display screen;



Anti rolling gear

Decurl scale	Range of splitting set-value
I-II	0~10
II-III	10~20
III-IV	20~30
IV-V	30~40

⚠ The median value of the above range is preferred

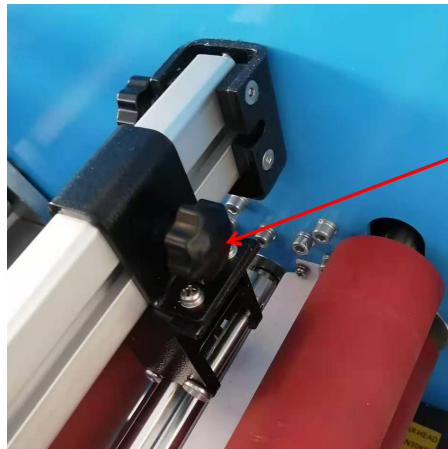


8.23 Adjust the position of the point line cutter and press it down:

8.23.1 Loosen the fastening screw of the point line cutter mechanism with an After

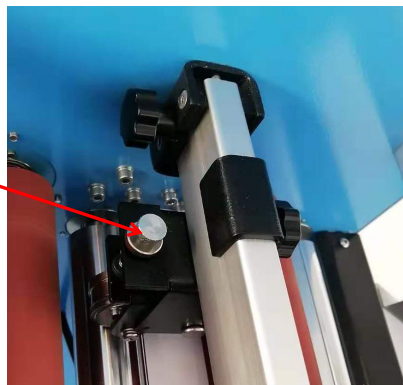
loosening the fixing screw, the point line cutter device can be moved left and right, and the screw is tightened after the position is determined;

Note: the point line cutter should be placed 10 mm away from the paper edge;



Fixing screw

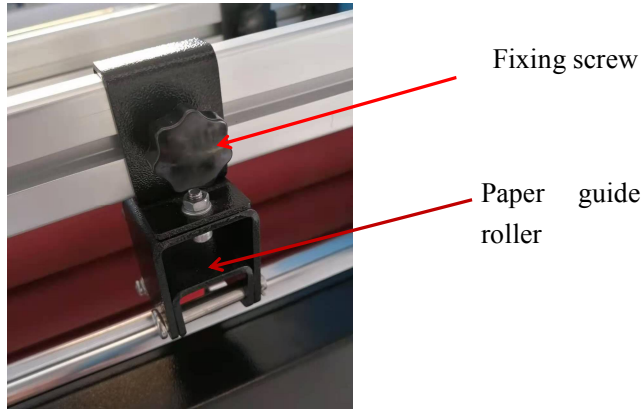
8.23.2 Adjust the screw to press down the point cutter



Adjusting screw

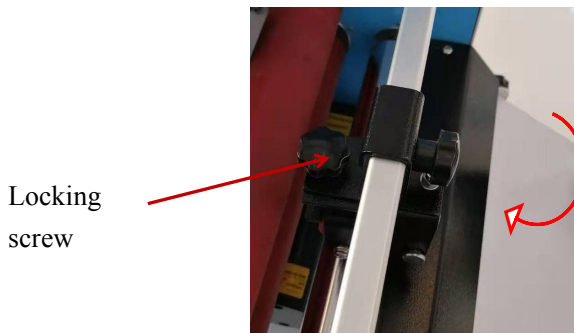
Note: adjust the knife clockwise to press down, otherwise the knife will lift up. After adjustment, please lock it with nut;

8.24 Adjust the position of the press wheel as shown in the figure. The specific method is as follows: rotate anticlockwise to loosen the fastening screw, and then move the paper feeding pressure wheel mechanism horizontally to lock it after confirming the position;



Note: The position of paper guide wheel should be about 150 mm away from the right paper edge;

8.25 The specific method is as follows: loosen the hand screw, then rotate the bracket along the direction shown in the figure to determine the tilt angle, and then lock it after determining the position;



Note: 1. The tilt angle of the guide roller should be adjusted according to the different thickness of the coating. The thinner the coating is, the smaller the angle is, otherwise, the larger the angle is;

8.26 Set the working speed of the machine and press the "Run button". At this time, Feida starts to feed paper automatically and starts to cover the film.

8.27 After several sheets of continuous film covering, the machine can be stopped (the stop position is the same as that in 7.9), and the laminating effect,

paper overlap size, cutting condition and flatness of the product after plastic coating can be observed; (Note: since there are many devices to be adjusted to avoid waste of paper in the early stage, this operation process should be carried out at a low speed);

8.28 According to the actual situation of the coated products, adjust the working parameters and fine tune the devices that need to be adjusted to achieve the best working effect;

8.29 After the parameters are adjusted and stabilized, the speed can be increased properly;

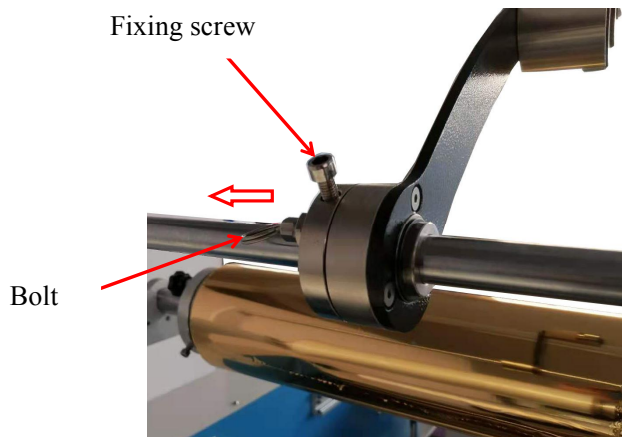
※Because speed, temperature, pressure and anti curling position are a group of matching factors, that is, the faster the speed, the higher the temperature and pressure required, and the higher the anti coiling gear. Therefore, if the speed needs to be changed during the operation, the temperature, pressure and anti rolling gear should be adjusted;

8.30 After working for a period of time, sort out and take out the products after laminating;

8.31 Now a film covering operation is completed, it is necessary to cover the film again in a short time, and repeat the above feeding steps. If you replace the film covering, you need to repeat all the above steps.

9. How to use the slitter mechanism

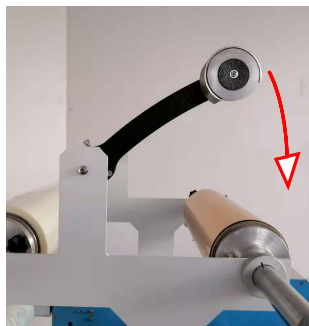
9.1 Loosen the fastening screw of the slitting mechanism with an internal hexagonal wrench, and then move the mechanism laterally along the supporting rod, and put the mechanism down and press on the roll film to determine the position of the slitting cutter;



Note: the position of slitting cutter should be determined according to the required film width.

9.2 After confirming the position, lift up the point line cutter mechanism and fasten it with screws;

9.3 Pull out the fixing pin along the direction shown in the figure, and then put down the slitting cutter. At this point, the adjustment is completed. If it is necessary to fine tune, operate according to this method.

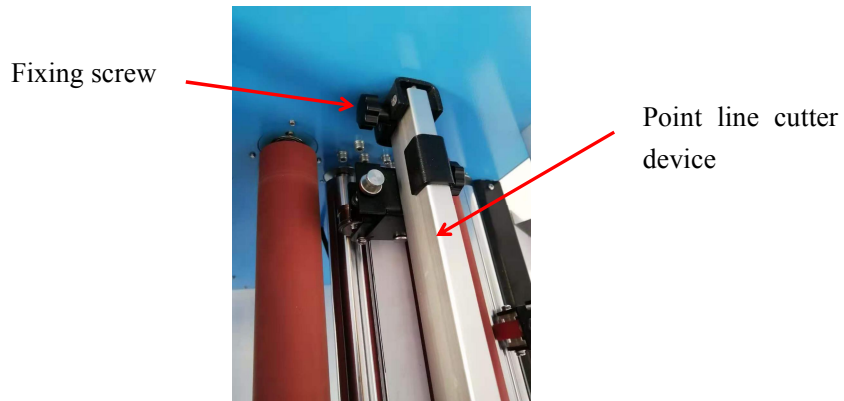


10. How to use aluminum foil mechanism

10.1 Heating, placing paper on the paper table, setting the paper length and speed according to the steps in item 8;

Note: the operating temperature of aluminum foil is generally not $110\text{ }^{\circ}\text{C}$. In addition, please operate at the speed lower than 5m / min ;

10.2 Remove the point line cutter mechanism as shown in the figure;

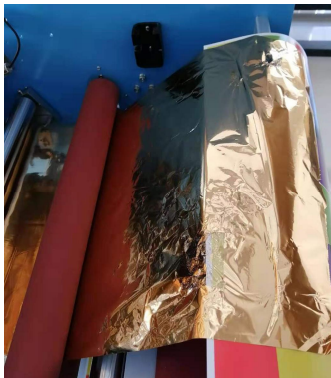


10.3 Wear a piece of paper as described in item 8;

10.4 Wrap the aluminum foil around the guide roll and lap it on the laminating roll and bond it with the paper with adhesive tape;



10.5 Pull the paper and film to the position of slitting roller, as shown in the figure;



10.6 Install the special aluminum foil guide roller mechanism at the position shown in the figure and lock it;

Aluminum foil
guide roller



10.7 Wrap the paper around the guide roller as shown in the figure and stick it on the winding paper drum;



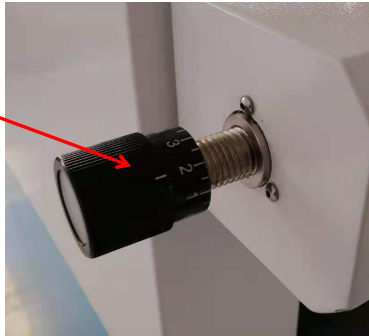
Take up paper
cylinder



Note:

1. please pay attention to the rotation direction of the paper cylinder when bonding;
2. The left side of the winding cylinder is equipped with a damping adjusting handle, which can increase the damping when it is turned clockwise and decrease on the contrary. As shown in the figure below:

Damping
adjustment
handle



10.8 Turn on the fan switch;



10.9 Press the aluminum foil switch;



10.10 Adjust the paper guide wheel angle, do not tilt;

10.11 Start the machine running switch, the machine aluminum foil work will start;

11 Work to be done after operation

11.1 After the operation is completed, if the machine is shut down for a short time, please adjust the temperature value of the display screen to 80 °C; if it is shut down for a long time, please set the temperature value of the display screen to "---";

11.2 Lift the point line cutter;

11.3 Set the machine to the pedal operation mode and step on the foot switch to make the machine run without load and send the remaining paper out of the machine;

11.4 Return the anti crimp device to the first gear position;

11.5 Wait till the temperature drops, and raise the front hot laminating roll and the top tractive roll.

11.6 Turn off the power switch of vacuum pump and machine and cut off the power supply;

11.7 Turn off the air source and the operation is finished.

12. Common problems in operation and solutions

Common phenomena	reason	resolvent
Low cutting efficiency or no cutting-off possible	1. Notched cutter is improperly located 2. Notched cutter is not depressed 3. Inclination angle of the inclined guide wheel is small 4. The pressure of the	1. Adjust the position of the notched cutter as required 2. Depress the notched cutter 3. Increase the inclination angle of the inclined guide wheel 4. Increase the pressure of the guide wheel 5. Adjust the position of the guide

	<p>inclined guide wheel is low</p> <p>5. The inclined guide wheel is improperly located</p> <p>6. The cutting position is improper</p>	<p>wheel</p> <p>6. Increase properly the fine-tune value for cutting</p>
The two edges of the roll film shrink	<p>1. High temperature</p> <p>2. Low speed</p>	<p>1. Lower the temperature</p> <p>2. Increase the speed</p>
The roll film slacks in operation	<p>1. Small damping of feed roll</p>	<p>1. Increase the damping of feed roll</p>
The roll film generates sound during operation	<p>1. Large damping of feed roll</p>	<p>1. Reduce the damping of feed roll</p>
The surface of laminated product is not clear and with white spots	<p>1. The pressure of laminating roller and traction roller is small</p> <p>2. Dust is present on the picture and text</p> <p>3. Film quality is poor</p> <p>4. Low temperature</p> <p>5. High speed</p>	<p>1. Increase the pressure according to the pressure regulation mode</p> <p>2. Wipe the surface of the picture and text clean</p> <p>3. Replace the film</p> <p>4. Raise the temperature</p> <p>5. Reduce the speed</p>
The surface of laminated product wrinkles and bubbles	<p>1. Glue found on the surface of hot laminating roll</p> <p>2. High temperature</p> <p>3. Low speed</p> <p>4. High pressure of laminating roller</p> <p>5. Pressure mismatch between laminating roller and traction roller</p> <p>6. The damping is not even</p>	<p>1. Clean the surface of steel roll</p> <p>2. Reduce the temperature</p> <p>3. Increase the speed</p> <p>4. Reduce the pressure according to the pressure regulation mode</p> <p>5. Adjust the pressure of the two rollers according to the pressure regulating mode</p> <p>6. Adjust the damping level</p>

	on the left and right sides of the roll film	
Impress found on the surface of laminated product	<ol style="list-style-type: none"> 1. Over-pressure from the inclined guide wheel 2. Excessive inclination angle of the inclined guide wheel 3. Picture and text are not flat during lamination 	<ol style="list-style-type: none"> 1. Reduce the pressure 2. Reduce the inclination angle 3. Improve the operating level
The laminated product is not flat and curling-up or down are found	<ol style="list-style-type: none"> 1. Position of the curling-preventing device is improper 2. High temperature 3. Low speed 	<ol style="list-style-type: none"> 1. Readjust the position of the curling-preventing device 2. Reduce the temperature 3. Increase the speed
Motor stalling	<ol style="list-style-type: none"> 1. Brush wear 	<ol style="list-style-type: none"> 1. Replace the carbon brush
Double sheet feed	<ol style="list-style-type: none"> 1. Improper position of blowing nozzle 2. There is electrostatic adsorption between the paper 	<ol style="list-style-type: none"> 1. Adjust the position of blowing nozzle 2. Shake the paper loose before stacking
No paper suction	<ol style="list-style-type: none"> 1. Positive empty pump switch not on 2. The air pipe of positive air pump interface is disconnected 	<ol style="list-style-type: none"> 1. Turn on the switch 2. Connect the trachea

13.packing list:

Serial	name	Specifications	number	remarks
1	Hexagon socket screw	M5*16	2	
2	Hexagon socket screw	M5*12	8	
3	Flat washer	φ 5	10	
4	Spring washer	φ 5	10	
5	inner hexagon spanner	S4	1	
6	inner hexagon spanner	S5	1	
7	Roller support plate	piece	2	
8	Roller mechanism	set	2	
9	Aluminum foil guide roller mechanism	set	1	
10	Cutter mechanism	set	1	
11	Back baffle	piece	2	
12	Back board	piece	1	
13	Rear baffle plate	piece	1	
14	Butterfly nut	M5	2	
15	Plum hand screw	M5*10	4	
16	an instruction manual	book	1	
17	Film cutter	individual	1	
18	desiccant	bag	2	
19	Coated sample	page	1	
20	Suction nozzle	piece	2	