

F350/F650 Roll Laminator Manual



HANGZHOU FUYANG HUIBO HANSWAY TRADING CO.,LTD.

ADD: NO.1216,GONGYUANXI ROAD, JINQIAO INDUSTRIAL PARK FUYANG,
HANGZHOU,CHINA

TEL: +86-571-63368676 +86-571-63168822

+86-571-61718035/8036/8980/8981

FAX: +86 20 28819702-25160

E-MAIL:boway@bowaychina.com

WEBSITE:www.bowaychina.com www.fullar.net

If any change, we won't make the notice, please make the object as the standard.

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Notice:

- Any differences between the manual and the products because of re-design the products are without notice, any doubts about the machine please consult with the local agent.
- Please save the packages and plastic bags for second transportation.

Forward

Thank you for your choosing our product. In order to correct use this product , kindly read this manual carefully. Take care every operate detail. Therefore it will help your operate skills and make the perfect production and improve the operate speed.

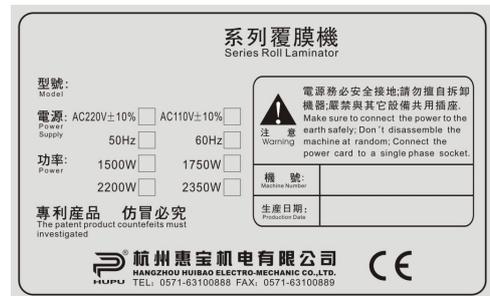
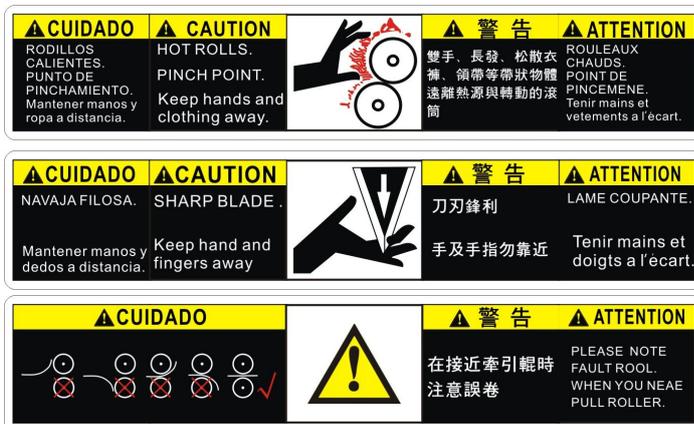
This machine is developed by rich experience, abundant economy and technology of corporation. There is serious quality control process which from design to material purchase and produce. Fully reflecting the corporation motto: “perfection pursuing, Customer satisfaction”

Safety caution:

Be care to use this machine, don't put the hand or another body to running part of the machine , which avoid any accident. Kindly see more using, maintenance caution as below.

1. Put the machine on the solid and air circulate place .
2. According the mechanical rear instruction to connect the power, If the voltage is too lower or higher ,the machine will run abnormally.
3. Ensure your safe, please use the earthed power socket.
4. Don't put several electric in one socket, because if overload will caused to fire or electric shock.
5. Before clean the machine, please take off the power .
6. Heating roller temp. is over 130°C, So don't touch the heating roller when using or power off in a short time.
7. Don't put irrelevant things into the laminator .
8. Don't touch the heating roll and film surface, or the film will be adhered to the roller and difficult to clean.
9. Don't repair the laminator by yourself. If problem, kindly connect the agent.

Following "warning" labels, you can find it from the machine:



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1、 Open box and check

Kindly check the accessory, after open the laminator box, any damage or miss, kindly contact the agent or head company.

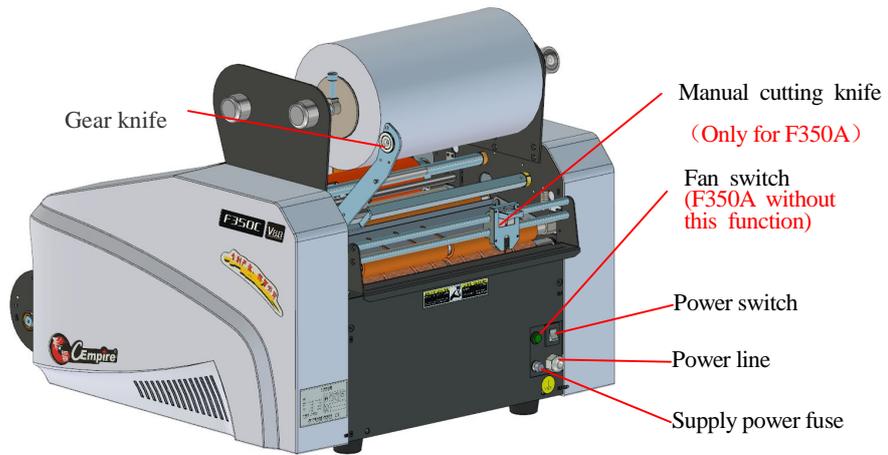
- 1.Machine.....1pc
- 2.CD Manual.....1pc
- 3.Warranty card.....1pc
- 4.Attachment Tools.....1pc
- 5.Film (Installed).....1pc

<p style="text-align: center;">F350A</p> 	<p style="text-align: center;">F350B</p> 	<p style="text-align: center;">F350C</p> 
<p style="text-align: center;">F350D</p> 	<p style="text-align: center;">F350E</p> 	<p style="text-align: center;">F650A</p> 
<p style="text-align: center;">F650B</p> 	<p style="text-align: center;">F650E</p> 	

2、 Name and function of parts

Before use and install this machine, Kindly know the name and function of parts by the below photo

F350 series General Parts

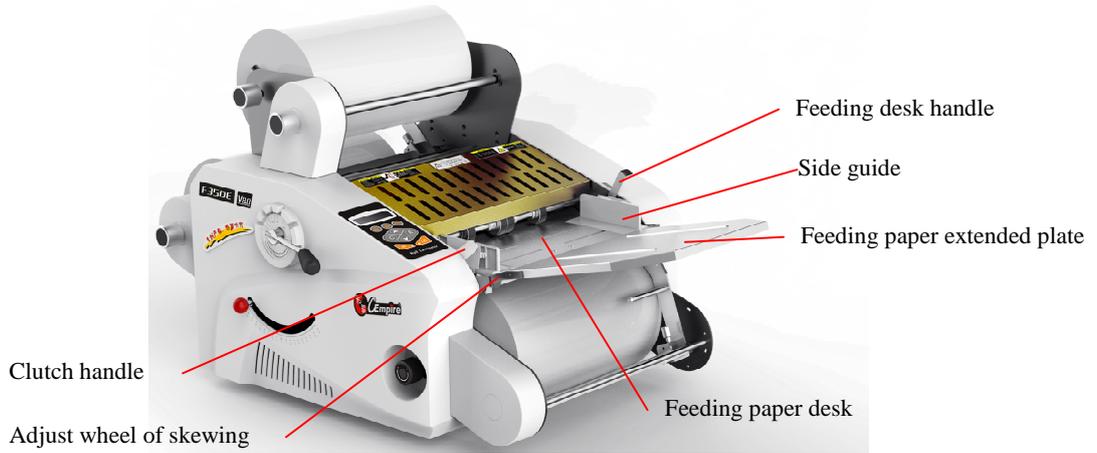


F350B/E Parts Name

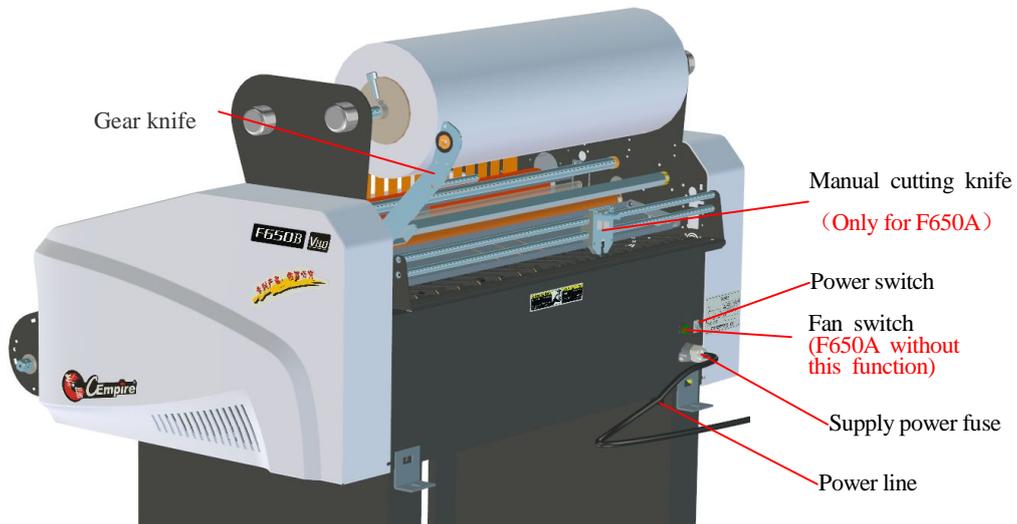


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F350D/E Parts Name



F650series General Parts

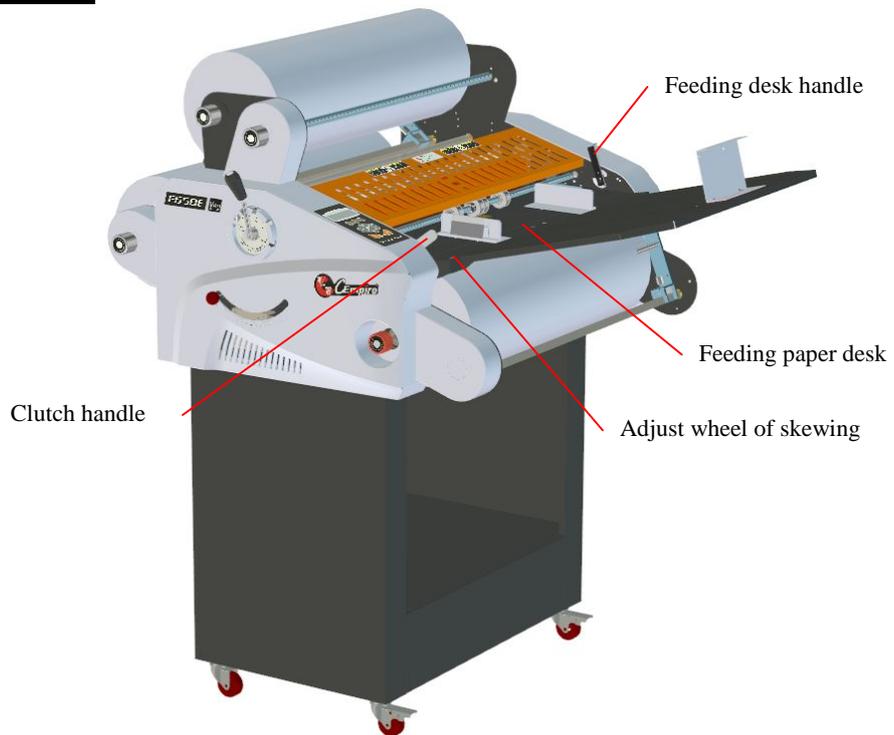


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F650B/E Parts Name



F650E Parts Name



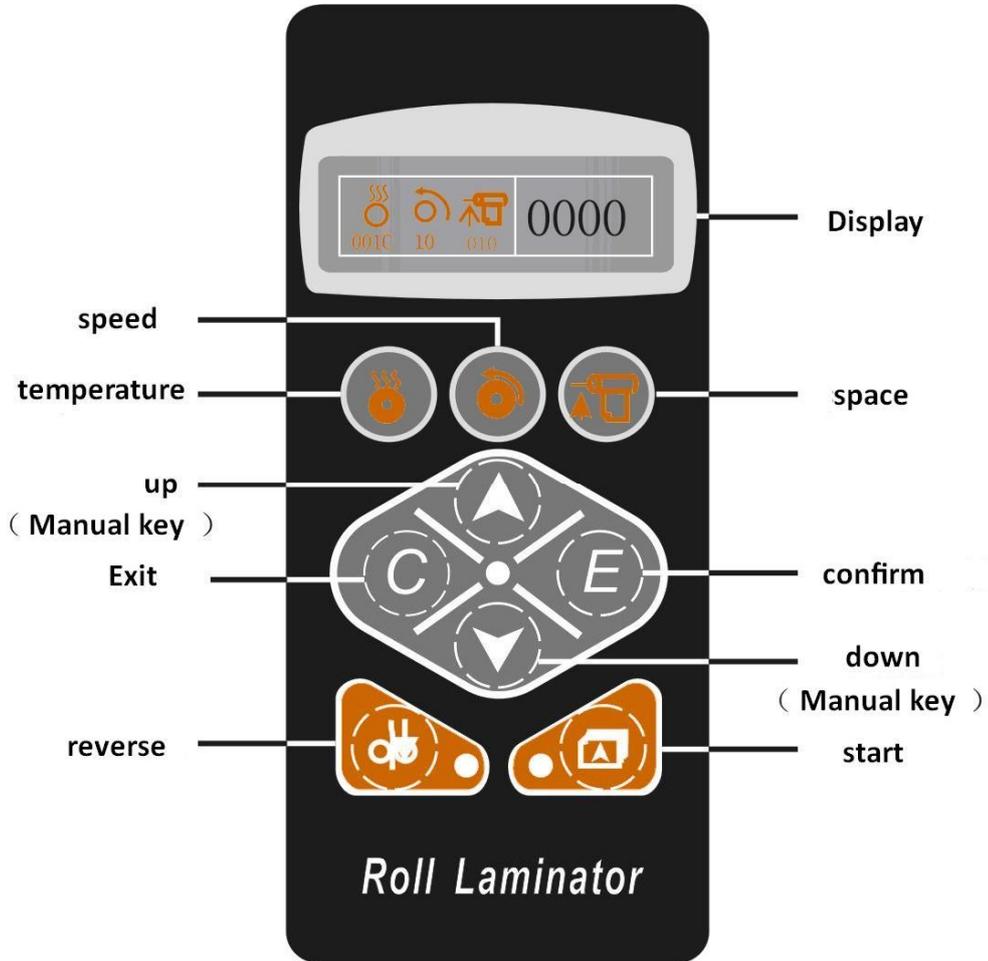
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3、Technical Parameter

Model	F350A	F350B	F350C	F350D	F350E	F650A	F650B	F650E
Paper width (mm)	130-350	130-350	130-350	130-330	130-330	130-650	130-650	130-640
paper length (mm)	110-700	110-700	110-700	150-700	150-700	110-700	110-700	150-700
Paper thickness (g/m ²)	80-400	80-400	80-400	100-300	100-300	80-400	80-400	100-300
Speed (m/h)	240	240	240	240	240	240	240	240
Feeder	Manual	Manual	Manual	Automatic	Automatic	Manual	Manual	Automatic
Display	LCD							
Max. film diameter	210	210	210	210	210	210	210	210
Auto. slitting	/	/	√	√	/	/	/	/
Auto. collecting	/	√	/	/	√	/	√	√
Manual cutting	√	/	/	/	/	√	/	/
Heating rollers	2	2	2	2	2	2	2	2
Double sides film	√	√	√	√	√	√	√	√
Gear knife	√	√	√	√	√	√	√	√
Anti curl	18	18	18	18	18	18	18	18
Cold laminator roller	/	√	√	√	√	/	√	√
Power	AC220V(110V) ±10% 50Hz (60Hz) 1450W	AC220V(110V) ±10% 50Hz (60Hz) 2050W	AC220V(110V) ±10% 50Hz (60Hz) 2050W	AC220V(110V) ±10% 50Hz (60Hz) 2050W				
Machine size (mm)	730×645×545	845×645×545	730×645×545	880×645×545	1020×645×54 5	730×965×122 0	845×965×1 220	1135×965× 1220
NW (kg)	48	52	53	62	57	93	99	107

PS:Auto slitting only for single laminating.

4、Controllable parts and keys



 <p>Power switch</p>	<p>4.1. Power switch Shift to the upper (“ON”), power on Shift to the lower (“OFF”), power off</p>
 <p>Confirm key</p>	<p>4.2. Confirm key press “E” key to choice the menu functions ,press, when you choose someone function, press “^” “v” to select the parameters, and press “E”,parameters will flicker and press”E” to set, after it , press “E” to confirm.</p>
 <p>Exit (cancel)key</p>	<p>4.3.Exit (Cancel) key Press “C ”to exit menu select function after you have set well, Or you can eliminate, ignore the error, when there is a alarm, to keep former well working condition.</p>

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 <p>Up key</p>  <p>Down key</p>	<p>4.4.Up key、Down key “^” “v” up or down for the menu, increase or decrease for the parameters.</p>
 <p>Set temperature key</p>	<p>4.5.Set temperature key After press“setting temp.”, temp. display will flicker, means it’s can setting the temp. now.press“^”or“v”can modify the temp. parameter, after setting, pres “setting temp.”to confirm。There is cold operation mode if the temp. appear 0 degree. Note: Lowest temp.is 0 degree, highest tem. is 130 degree。There is best temp. about 110 degree as factory setting. Any adjust value, the machine have the memory.</p>
 <p>Speed key</p>	<p>4.6.Speed key After press “speed key” , speed key will flicker, means you can set the speed, press“^”or“v”can modify the temp., after setting, press“speed key” to confirm</p>
 <p>Paper distance key</p>	<p>4.7.Paper distance key 4.7.1 F350A、F350B、F350C、F650A、F650B Paper distance key’s functions: After press “Paper distance” , Paper distance will flicker, means you can setting. press“^”or “v”can modify the distance parameter, more bigger value means the distance is more bigger of two papers. less value means the two papers are lapped more. After setting, press “Paper distance” to confirm。 Note: Standard parameter is 45 as factory setting; space value is 0-250mm 4.7.2 F350D、F350E、F650E Paper distance key’s functions: After press “Paper distance” , Paper distance will flicker, means you can setting. press“^”or “v”can modify the distance parameter, more bigger value means two papers are lapped more.,less value means the two papers are lapped less. After setting, press “Paper distance” to confirm。 Note: Standard parameter is 10 as factory setting; space value is 0-20mm</p>
 <p>Reverse key</p>	<p>4.8.Reverse key Pressing the”Reverse key” when the indicator is not light, the motor rotate at low speed, for Troubleshooting, loose the key, it will stop.</p>
 <p>Start key</p> <p>PS:if any abnormal, press two times continuously to stop working forcibly (Only for F350D、F350E、F650E)</p>	<p>4.9.Start key 4.9.1、F350A、F350B、F350C、F650A、F650B ’s functions: ①when the indicator is not light, the motor rotate at low speed, for feeding film and troubleshooting, loose the start key, it will stop. ②Under manual mode, press”start key” the indicator is light and main motor running all the time, and press” start key” again, the motor stop running.</p>

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	<p>through the cover sensor.The main motor will stop when the paper is left the cover sensor, press” start key” again to quit from auto model.</p> <p>4.9.2、F350D、F350E、F650E “Start key” functions:</p> <p>①when the indicator is not light, the motor rotate at low speed, for feeding film and troubleshooting, loose the start key, it will stop.</p> <p>② Finish feeding film, press”Start key”, the paper feed automatically.Press”Start key”again,paper will stop the beginning position , ready for next time.</p> <p>③when the laminating with abnormal status, please press” start key” two times to shop working.</p>
<p>纸长设定: 700mm</p> <p>工作模式: 自动</p>	<p>4.10.paper length setting</p> <p>press“E”enter into menu, press“^”“√”key to choose “paper length setting” menu, press again“E”to confirm, paper length key is shinning, means can set the paper length now。press“^”“√”set the parameter which according the paper size, after setting ,press “E” to confirm.min value 110mm,max length 700mm.</p> <p>Note: ①when setting700mm, means no limited length.</p> <p>②For F350D, min value 128mm,max length 700mm. Paper length should set according to the actual paper length.</p>
<p>工作模式: 自动</p> <p>单位选择: mm</p>	<p>4.11.Operate mode</p> <p>press“E”enter into the menu, press“^”“√”key to choose “operate mode” menu, press again“E”to confirm, operate mode key is shinning, there is manual and auto mode in there. According your operate skills to choose the suitable operate mode by Press“^”“√”, after choose press “E” to confirm</p> <p>Note:①factory setting with auto. Operate mode.</p> <p>②F350D、F350E、F6350E without this function</p>
<p>纸长设定: 700mm</p> <p>送纸距离: 10</p>	<p>4.12. Paper feed space (only forF350D、F350E、F650E)</p> <p>press“E”enter into menu, press“^”“√”key to choose “paper feed space” menu, press again“E”to confirm, paper feed space is shinning, means can press“^”“√”set the parameter to set the paper feed space。More parameter more length of paper feeding,after setting ,press “E” to confirm.</p> <p>Note: factory setting at 10, space setting range:0-20.</p>
<p>单位选择: mm</p> <p>计数值: 0000</p>	<p>4.13Unit</p> <p>press“E”key enter menu, press “^”“√”key to choose “unit” menu. And press“E”to confirm, unit key is shinning, the unit can be shift between “mm”and” inch”.</p>
<p>计数值: 0000</p> <p>覆膜模式: 双覆</p>	<p>4.14.Counter</p> <p>Press“E”key to enter menu, press“^”“√”key to choose “counter” menu, press“E”to confirm, you can view the total count for laminating.</p>

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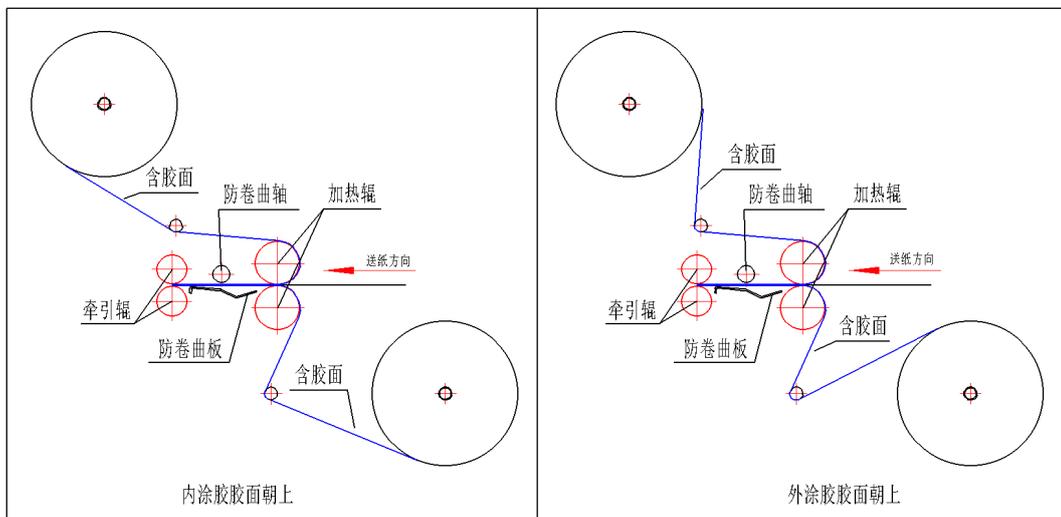
<p>覆膜模式: 双覆</p> <p>上辊补偿: 000</p>	<p>4.15.Laminating mode press “E” key into menu, press “^” “v” key to choose “laminating mode” menu, press “E” to confirm, laminating mode key is shinning, mode detail: double sides laminating、up laminating、down laminating。press “^” “v” according your demand to choose the laminating mode, press “E” to confirm.</p>
<p>上辊补偿: 000</p> <p>下辊补偿: 000</p>	<p>4.16.Up roll compensation press “E” key enter menu, press “^” “v” key to choose “up compensation” menu, press again “E” to confirm, ”up compensation” key is shinning, which means you can set the temp. compensation. According your needs to set the parameter which by Press “^” “v”, After setting,press “E” to confirm, compensation range: -15 ~ +15.</p>
<p>下辊补偿: 000</p> <p>纸长设定: 700mm</p>	<p>4.17.Down roll compensation press “E” into menu, and press “^” “v” key to choose “down roll compensation” menu, press again “E” to confirm, ”down roll compensation” key is shinning, Means you can set the temp. compensation value。According your needs to press “^” “v” to set the parameter, after setting ,press “E” to confirm, compensation range: -15 ~ +15.</p>

5、 How to use the machine

5.1、 start to work

- 5.1.1、 Check the shipping fixed screw and belting is removed or not;
- 5.1.2、 Switch on the plug,and power on, the machine is heating (same as pic-1), Means the machine is starting normally;
- 5.1.3、 Catch the film locating sleeve with hands when install the films, take our the film fixing wheel from right side. And take away the fixing screw of locating sleeve, take down the locating sleeve and put film in . finally screw up fixed position to finish;

Note: A、 Don't anti-installed the film; B、 left and right justification of up and down film ;



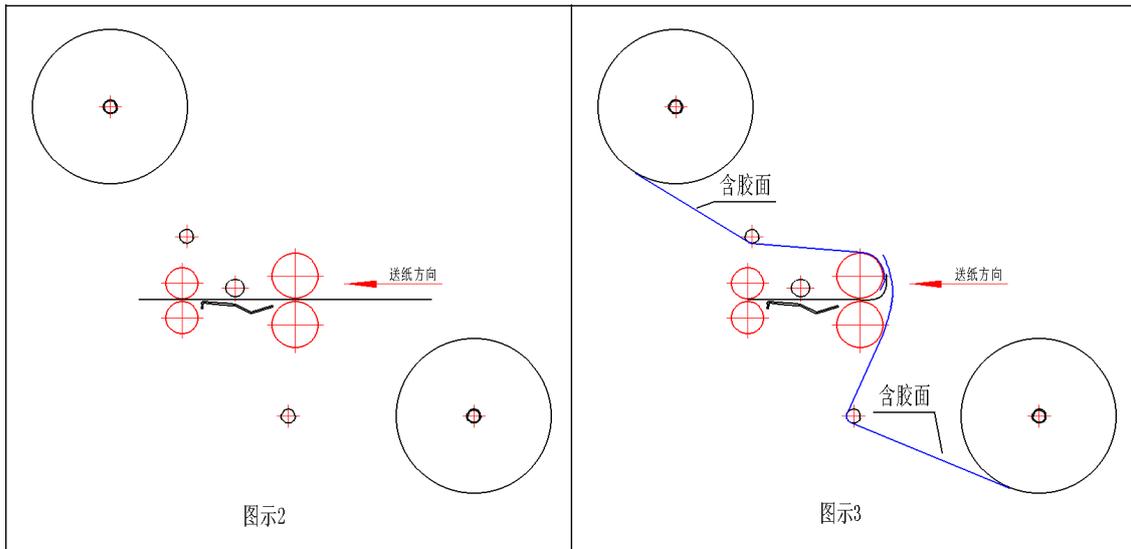
图示 1

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5. 1. 4、 Setting the gear knife position, keep it at the end of film about 2-4mm;
5. 1. 5、 Setting parameter of paper length ,speed,paper distance according the paper size;

5. 2、 Install film

5. 2. 1、 Install glued film to guide the paper. open the safety cover, take down the working table, take a piece paper which same width of glued film, as guide and pass the front and back rolls, see pic.2
5. 2. 2、 when catch the setting temperature, Put the up film on heating roll, (see pic.3) Put the guide paper on the glue surface of film, and put the down film on the glue surface of film too, put on safety cover, install the working table, adjust the position guide and lock, adjust the pressure wheel according to thickness of paper and film too.



5. 3、 Laminating

5.3.1、 F350A、 F350B、 F350C、 F650A、 F650B

① Under manual mode, Press “start”,indicator is light, the motor will run all the time and press “start” again, it will stop.

② Under Automatic mode, Press “start”,indicator is light, machine will be ready for working, when paper passed cover sensor for 2 seconds, main motor runs, when the paper leave the cover sensor, main motor stops running. Press”start” again, exit from automatic mode.

5.3.2、 F350D、 F350E、 F650E

Press”Start key”, the paper feed automatically.Press”Start key”again,paper will stop the beginning position , ready for next time.

5.4、 To clean the jammed film

When the roller is heating, printed matter or glued film stick on the surface of roller, cyclic rotation maybe caused the roller is damaged and the machine is broken, don't use any clear liquid or solvent, avoiding rollers are burned.

Using the following solution to clean it:

5. 4. 1、 Stopping the machine and speed to slowest, Cut the involved printed matter or glued paper, start

“reverse key” , Take out the involved printed matter or glued film from front ;

5. 4. 2、 Put the up roller to highest position, take away the safety cover and working table;

5. 4. 3、 Setting the temp. 80—90℃ ;

5. 4. 4、 press on “reverse key” , Using a soft cloth to clean the up and down heating rollers which till the surface of the rolls are clean;

5. 4. 5、 Install the working table and safety cover;

5. 4. 6、 Re-stall the film;

Note: when clean the roller, don't touch any metal or something hard parts, avoid to hurt the surface of the roller, when clean, we should front-operate and keep roller reversal avoiding that cloth or hand into the roller.

6、 Adjustment skills of auto slitting

6.1、 Auto slitting machine should choose BOPP film, thickness 18-25mic is best;

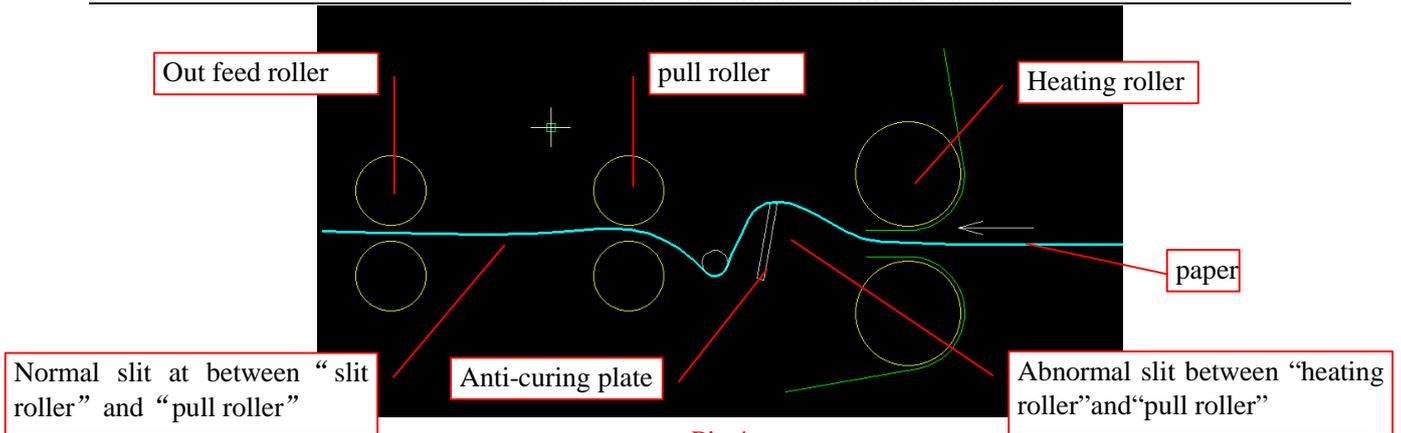
6.2、 Gear knife position at the end of film about 3-4mm is best, normal slitting should be between “paper out feed roller” and “pull roller”;

6.3、 If Gear knife position is too close to the edge, the coated paper is slit in advance between “heating roller” and “pull roller” (pic 4), or it can't normal laminate sequentially any more, and should increase the distance from gear knife to edge of film;

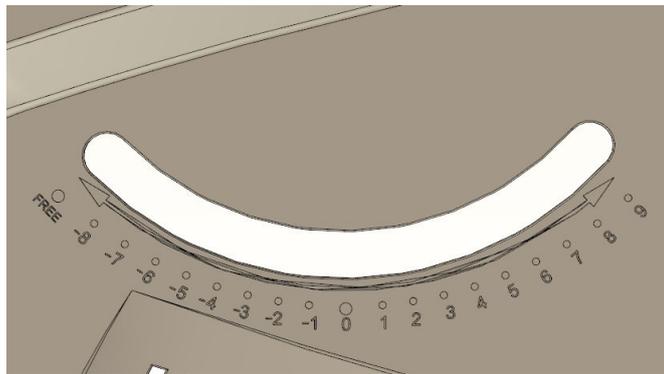
6.4、 If gear knife position is far from the edge, which will cause abnormal slitting;

The more thickness of the paper, the anti-curling level can't be too large, or it will be slit in advance between “heating roller” and “pull roller” and can't normal laminate sequentially any more, if the thickness is more than 157gms, the anti-curling level not be more than 8-0 level (pic 5)

6.5、 when the anti-curling level is on large level, increasing the distance from gear knife to edge of film will be better. If the distance is small, which will be slit at abnormal position.



Pic 4



Pic 5

6.6、 Experience :

6.6.1、 The thinner film be slit easily, the thicker film be slit not so easily. The best thickness is 18-25 mi BOPP film;

6.6.2、 More pressure of "pull roller" , film will be slit at abnormal position, but better for anti-curling.

6.6.3、 Less pressure of "pull roller" , film will be slit at abnormal position, and worse for anti-curling.

6.6.4、 Pressure of "pull roller" equal to or less than pressure of "heating roller" a little, Which is best setting.

6.6.5、 Smaller distance from gear knife to edge of film, film be slit more easily, and slit at abnormal position more easily. Larger distance from gear knife to edge of film, film can't be slit at normal position easily;

6.6.6、 The pressure of "out feed roller" , at the end of gear knife should larger than another end, which can be slit effectively;

6.6.7、 The pressure of "out feed roller" at the end of gear knife should not too large, or the coated paper and roller will be deformed easily.

6.6.8、 The pressure of "out feed roller" at opposite end of gear knife should not too small, or the coated paper will be crumpled easily.

6.6.9、 The pressure of "out feed roller" should not too large, or the coated paper and roller will be deformed easily.

6.6.10、 The more thickness of the paper, the anti-curling level can't be too large, which will be slit at abnormal position easily.

6.6.11、 The width of film should less than paper's, or can't be slit easily or involved in rollers;

7、 Laminating Technology and skills

To do the perfect laminating image, there are some important characters : temperature ,tension regulate and detection time of glued film on heating rolls. So, see the printed matte detail, choose the suitable film, temperature ,speed and tension。 In general, More thickness film or printed matte, we need more slow speed and more higher temperature , because we need more melt time for the thickness film; otherwise, thin film or printed matte, will be more faster speed and low temperature.

Under the glued film can be melted ,we can setting the temperature more lower , so that the film glue is melting as the best situation (the glue is melting from white color to transparent, means it start to have the toughness) . According the paper thickness to setting the temperature 80—120℃

Under no wrinkle and stick very well, we can set the tension more smaller. If the temperature is too higher or tension is more bigger, maybe the laminated paper will be curl.

If the film stop on rolls for some times, best take away that film before use, Because the down film will be expansion seriously, After cool and shrink, the paper will be easily curl on one side.

It's not suitable for more thin paper to laminating. Because If the paper is very thin , it will be curl caused by cooled film. If glue or something else stick on rolls, It will be affect laminating effect. Please clean it in time.

Suggestion: Overlapping the back of standby paper, do the double sides laminating, after this, we can cutting it and get the single laminating ,So that we can improve the work efficiency.

8、 Daily Maintenance

The stability and service life of machine are related to daily maintenance, Regularly to clean the laminator. Apply oil on activity parts , the machine service life will be more longer.

Clean heating roll, set the temperature about 80℃, then use soft cloth to clean the left glued liquid.

In order to keep clean the machine, we can clean the sundries, dust in regularly

If you have the Mechanical repair of common sense, You can regularly to check the screw is solid or not.

If happen any un-clear question, please contact the local agent or our company.

Warning: Not allowed from agent or our company, please don't disassemble the laminator, or you will loose the warranty.

9、Self -checking



Press on “E” key and turn on power to enter the checking situation..Checking the following in turn

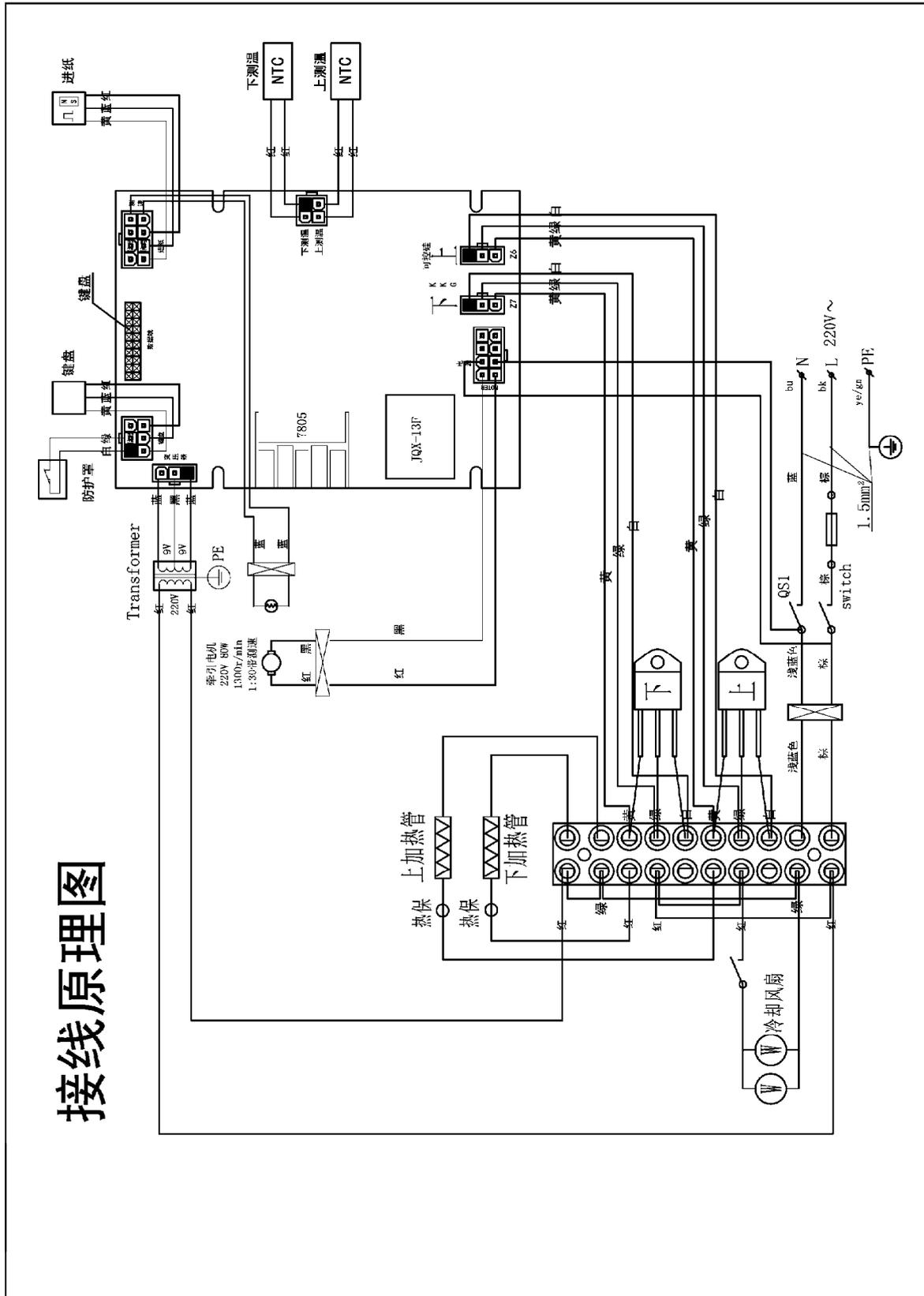
No	checking content	operating way	judgment method	solution
1.	Safety cover sensor (Protective cover)	Open the safety cover	LCD appear "0" for sensor is normal if appear"1" for feeder sensor is not well	If safety cover sensor "0" ,means the safety cover don't close or sensor is broken, we have to exchange the sensor.
2.	Infrared feeder sensor (Forinfcod sensor)	Put something cover the infrared feeder sensor	LCD appear "1" for feeder sensor is normal, If appear "0" for feeder sensor is not well.	If infrared cover sensor appear "0" for not well, we need to repair or exchange it.
3.	main motor (speed pulse)	Motor Positive and negative circulation running automatically	If Motor can Positive and negative circulation.run automatically, which means normal	

10、 Troubles and Troubleshooting

Nos	troubles	trouble reason	solution
1	safety cover error	Check the safety cover	Cover up the safety cover
2	Up temp. sensor error	Check up rolls temperature	1、 check up temp. sensor wire is well or not. 2、 change the main board or temp. sensor.
3	down temp. sensor error	Check down rolls temperature	1、 check up temp. sensor wire is well or not. 2、 change the main board or temp. sensor.
4	it's wrinkled after laminating	Film tension adjust is not well	Adjust the tension reference 6.4 wrinkle adjustment
		Pressure is too light	Appropriate increase the pressure of rolls
	Half side wrinkle	Pressure of setting bolt spring is not even	open the cover, using two sides rolls of setting bolt spring to adjust the rolls gap solution: more heavy the wrinkled side setting bolt spring or light non wrinkles side setting bolt spring.
	Middle or both sides wrinkle	Too heave of setting bolt spring	open the cover, using two sides rolls of setting bolt spring to adjust the rolls gap. solution: even ease the 8 pcs setting bolt spring pressure on right and left sides.
5	bubble after laminating	roll is not parallel	Adjust the parallelism of rolls
		Pressure is too light	Appropriate increase the pressure of rolls
	Middle or both sides bubble	Not Even pressure of spring	Reference the wrinkle solution
6	Rolls is curled up	roll is not parallel	Adjust the parallel of rolls
		setting bolt spring pressure is too heavy or not even	even ease the 2 sides of up rolls setting bolt spring pressure .

11.Electrical diagram

11.1 F350A、 F350B、 F350C、 F650A、 F650B Electrical diagram



11.2 F350D、F350E、F650E Electrical diagram

接线原理图

