

390A LAMINATION MACHINE

OPERATION MANUAL

390A is a small lamination machine with compact structure , easy to operate .The electrical system is centrally controlled by the programmable controller , which can be operated by one person .You need to input the paper size to be processed on the text screen to realize the two processes of laminating and slitting.

MAIN FEATURES

1. Man – Machine Interface system : color touch screen , simple and convenient operation.
The operator can view the machine work any time from the touch screen status.
2. The automatic air pressure system can provide stable coating pressure. The pressure sizes can be adjusted according to the needs.
3. The film slitting perforating knife can cut the width of the film to make it fit the width of the paper.
4. The perforating knife can punch holes on the edge of the film to smoothly realize automatic slitting.
5. The pneumatic slitting system can automatically slit the coated paper.

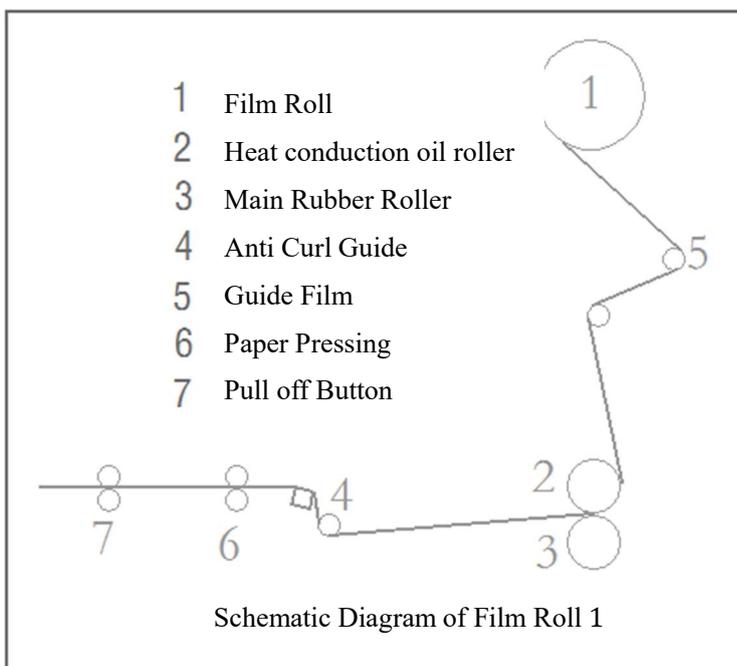
390A TECHNICAL PARAMETERS

- | | |
|-------------------------|-----------------|
| 1. Max Paper Width | 380mm |
| 2. Paper Thickness | 105g-500g |
| 3. Max Laminating Speed | 0-20m/min |
| 4. Gross Power | 2.9KW |
| 5. Total Weight | 450KG |
| 6. Overall Dimensions | 2200×780×1500mm |

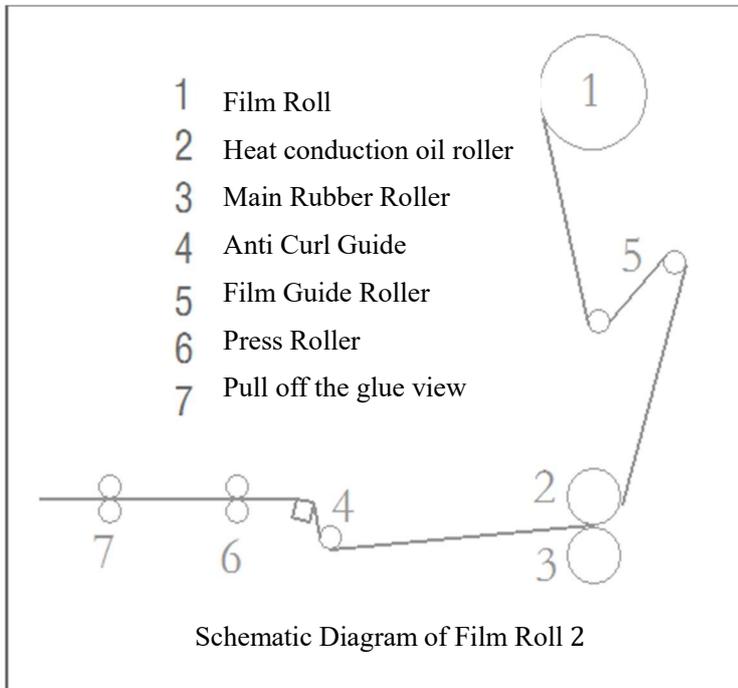
LAMINATING INSTALLATION INSTRUCTIONS

Film Installation

Type 1



Type 2



Note : When Installing , just pull the film between (2. thermal oil roller) and (3. main rubber roller)

The schematic diagram of the paper slicing with the film is guided to the 6. pressure roller by

hand , and the  pressure roller switch opens, let paper pass, close the inside

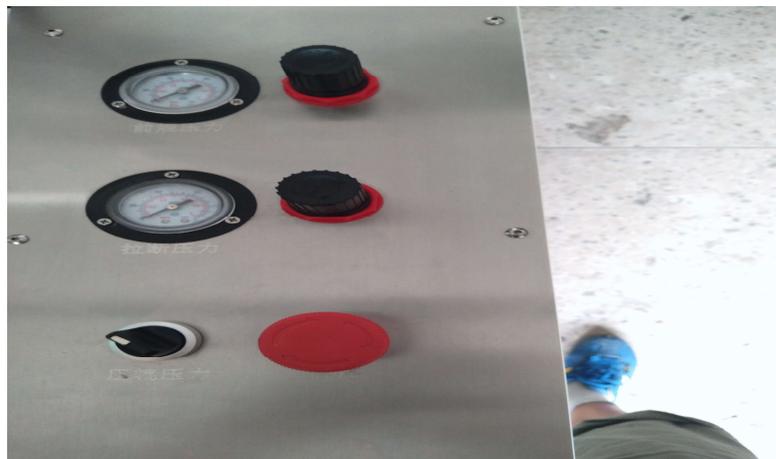
after paper passes  Maintain its traction. Then guide to {7 pull off the rubber roller}operate time, Pay attention to safety, so that the wearing film is completed , the operator only needs to put the paper on the paper table. .

OPERATION PROCESS DESCRIPTION

1. Plug the machine into AC220V power supply , the rated current of the socket is not less than 20A, and the installing wire is not less than 4mm² ,
And ensure that there is good grounding wire.
2. Check whether the compressed air is nuclear , and check that the inlet pressure should not be lower than 0.6MPa, if the pressure is not correct , please turn the knob to the correct pressure.



3. Check and adjust the pull – off pressure and front gauge pressure , keep it at 0.2MPa



4. Turn on the power switch , the machine is powered on , the power indicator light is on , the thermostat is powered on , the touch screen is selected as the initial state.



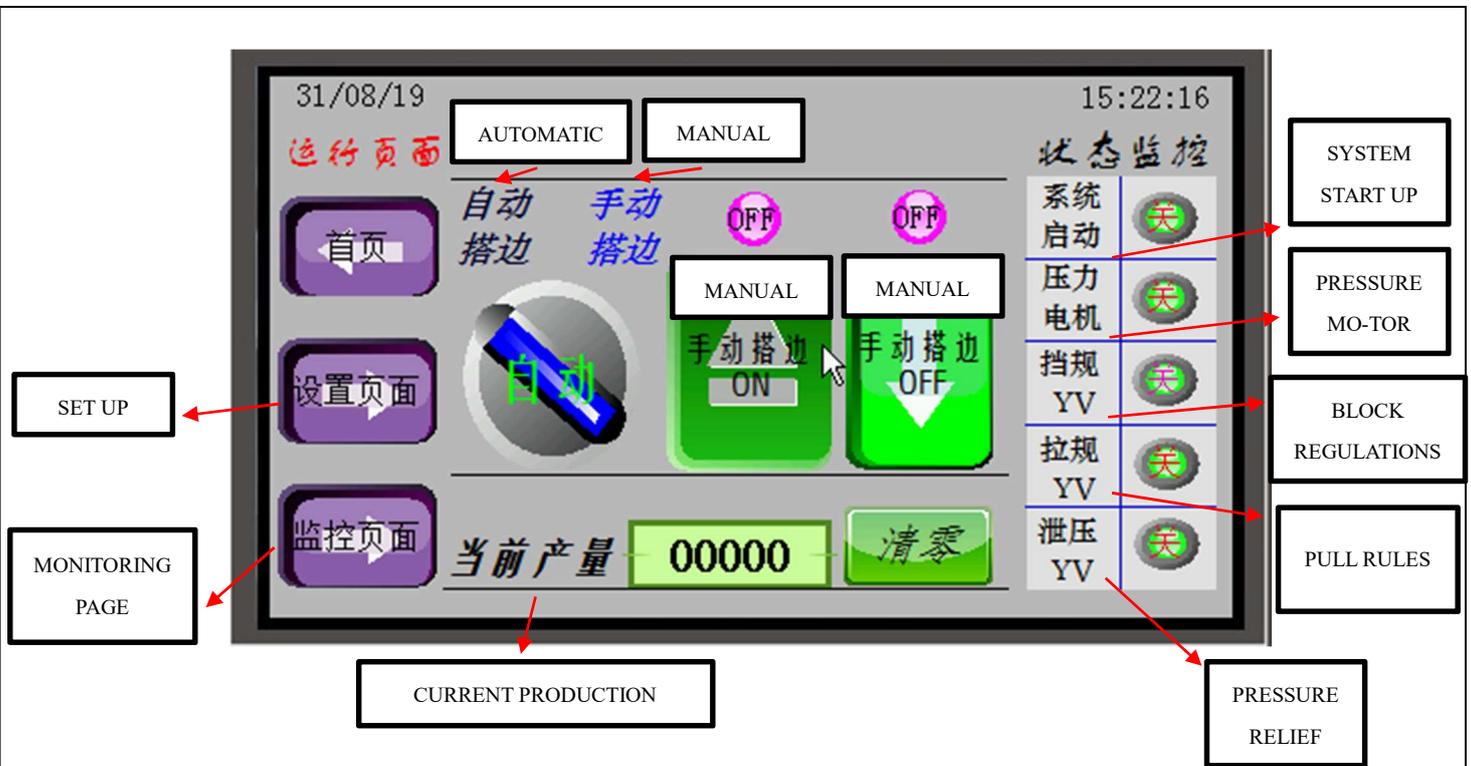
5. Regarding the thermostat , we have undergone rigorous testing before leaving the factory, the temperature has been adjusted, and the SV is set at 150 degree Fahrenheit.

When the value SV is equal to the value of PV , it can start normally

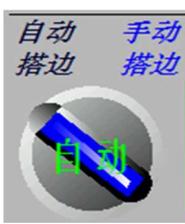
6. Settings of Touch Screen

Click to Enter

点击进入



A. MANUALLY



Click on



Hit

At this time the cylinder gauge rises , and the start button is connected



<Green>

Adjust Potentiometer



To the right speed

Put the film to the {2}{3} position “ Refer to the installation of the film” , then you can manually pull the film.

B. AUTOMATIC SIDE

Click to go to the settings page

The screenshot shows a settings page with a date of 31/08/19 and a time of 15:22:32. The page contains a table of settings and two main navigation buttons.

纸张长度	0	MM
搭接长度	0	MM
拉断长度设置	0	MM
挡规复位时间	0	MS
拉断运行时间	0	MS
延时泄压时间	0	MS

Navigation buttons: 运行页面 (RUN PAGE), 监控页面 (MONITOR PAGE).
 Additional display: 0 PP, 1MM/脉冲数 637.

Callouts on the left side:

- PAPER LENGTH
- OVERLAP LENGTH
- BROKEN LENGTH SETTING
- RESET TIME
- PULL OFF THE RUNNING TIME
- DELAYED PRESSURE RELIEF TIME

Set the following items separately

纸张长度	0	MM
搭接长度	0	MM
拉断长度设置	0	MM
挡规复位时间	0	MS
拉断运行时间	0	MS
延时泄压时间	0	MS

Note that 1MS = 0.1seconds. If you set 10MS, it means 1second. Length in millimeters <MM>

The B1 system automatically connects by default

B2 Press the start button <green>



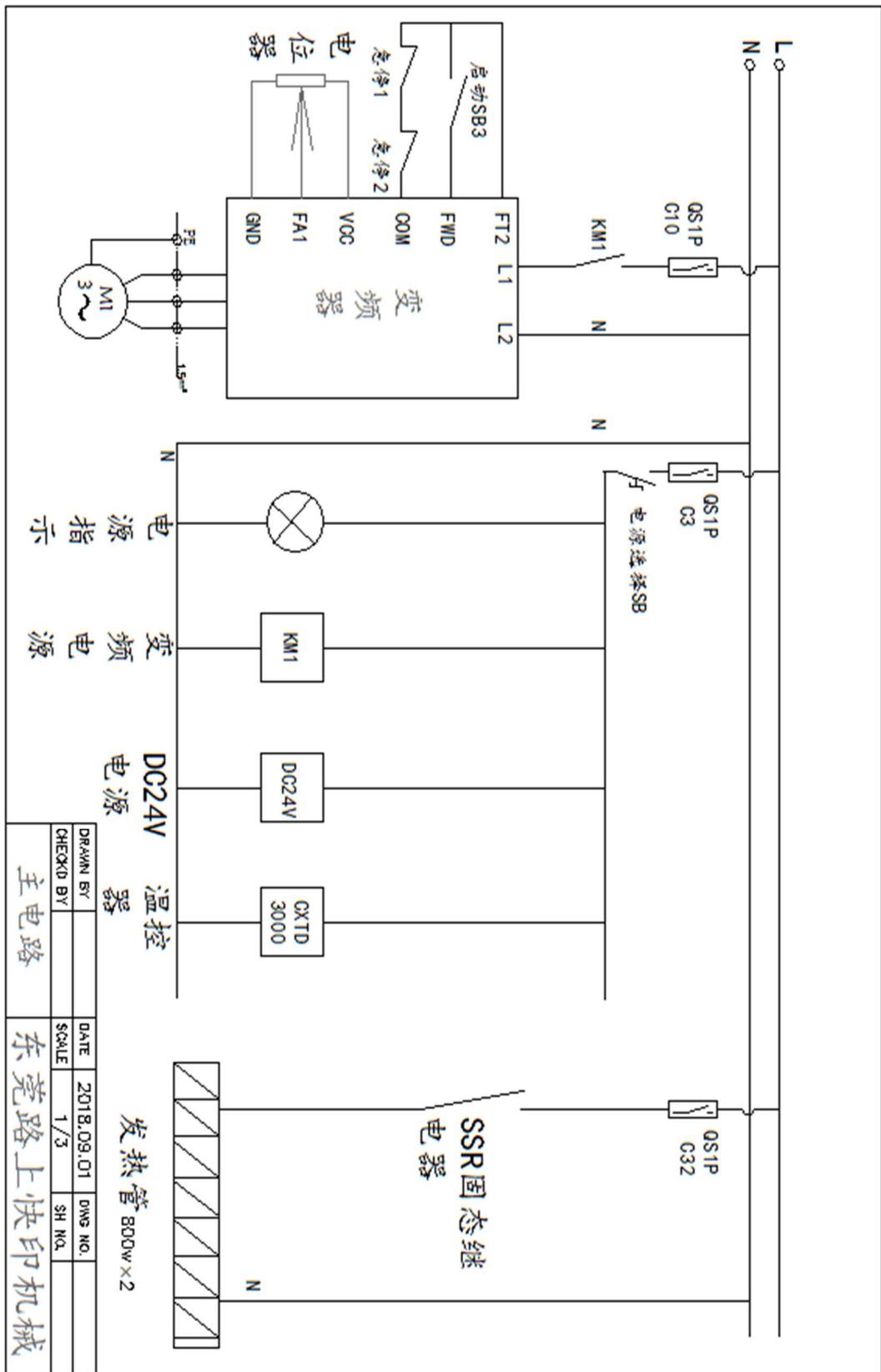
Adjust Potentiometer



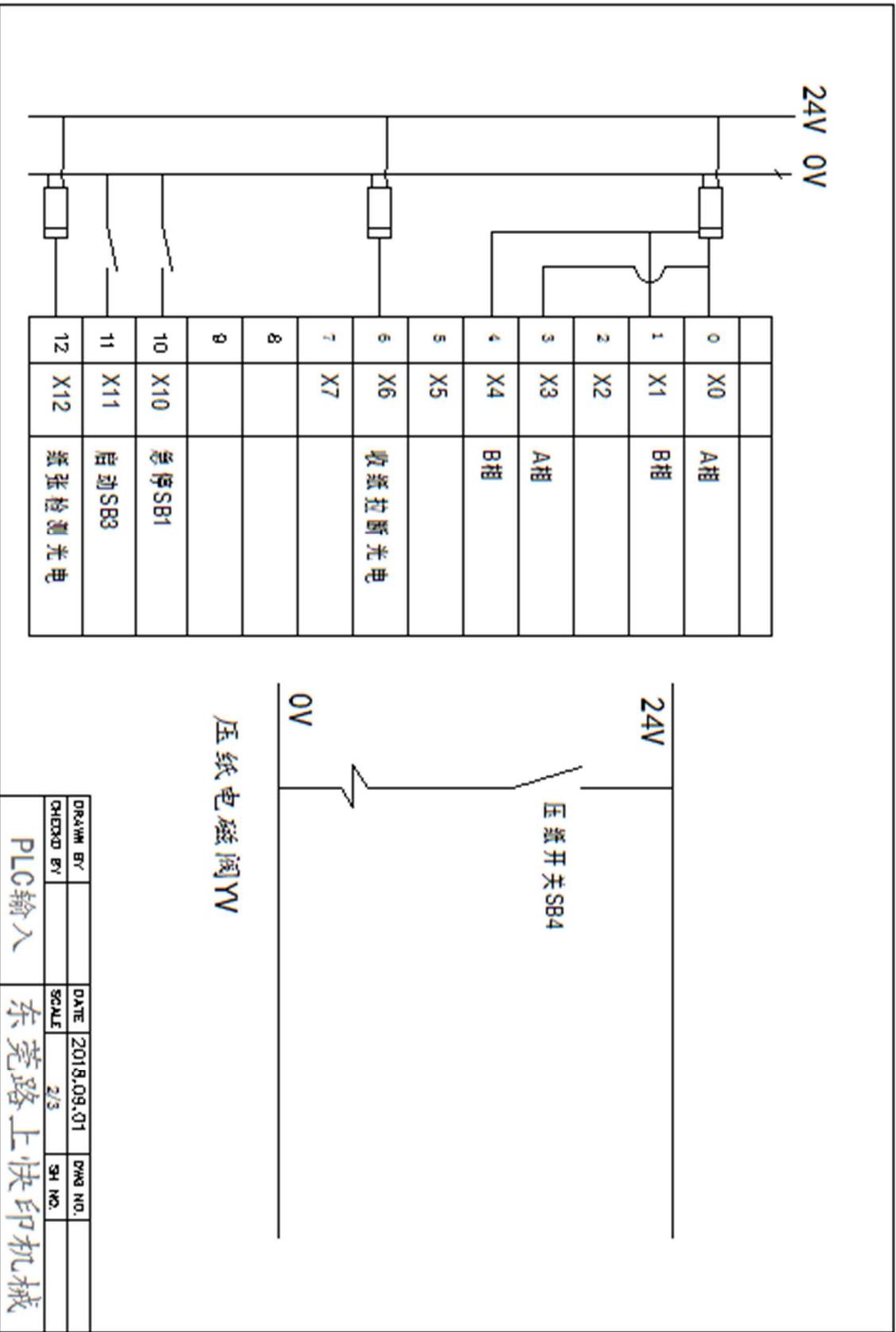
Up to this speed

Pull the roll film to the {2} {3} position “ Refer to the installation of the film”, then it can be carried out on the operating side.

The film is automatically covered.

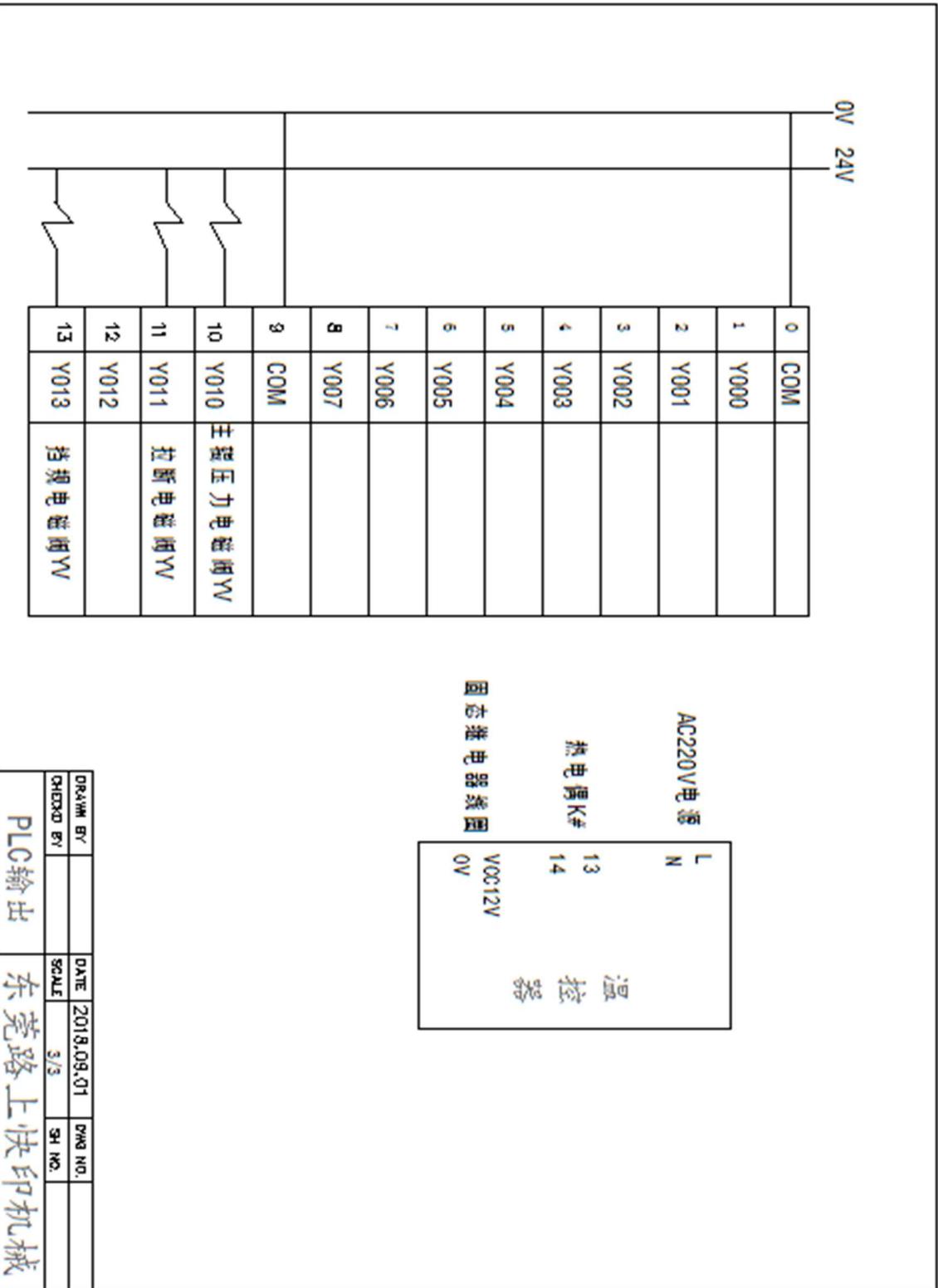


THE MAIN CIRCUIT



DRAWN BY		DATE	2018.09.01	DWG NO.	
CHECKED BY		SCALE	2/3	SH NO.	
PLC输入		东莞路上快印机械			

INPUT CIRCUIT



OUTPUT CIRCUIT