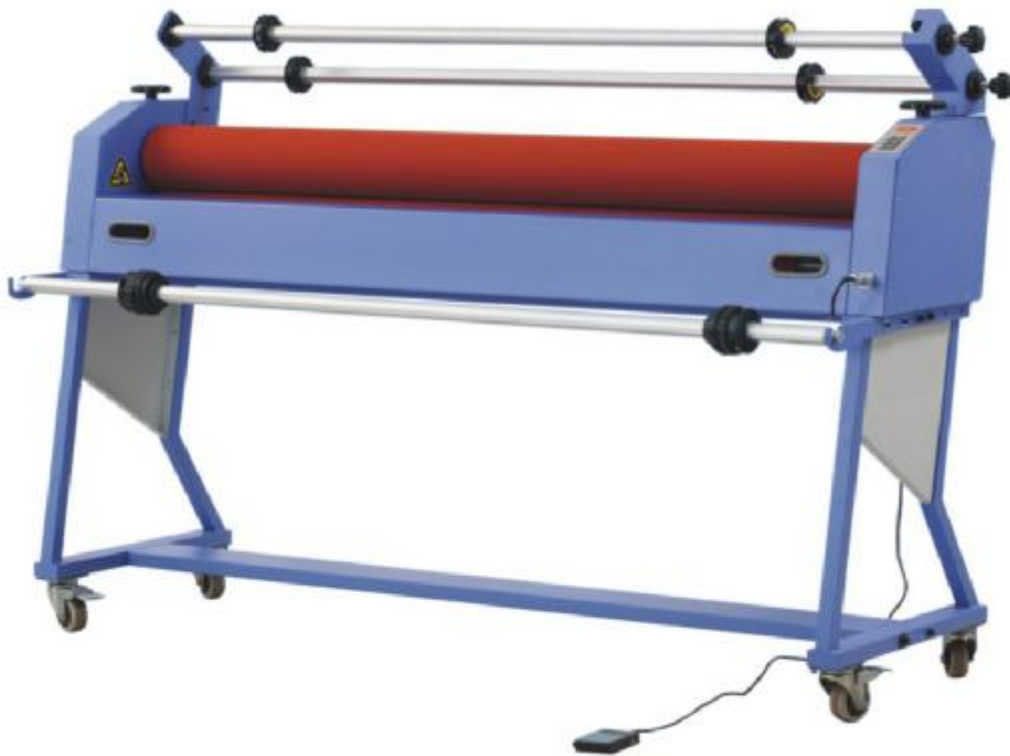


1400HEIV-L/1600HEIV-L Laminator

Operating Instruction



Please carefully read this instruction before operations!

Our respected customers:

We are very grateful for your patronage:

1400HEIV-L/1600HEIV-L cold pressing laminator, which, integrating simple operating method, reliable quality in refabrication and many other characteristics, offers satisfactory mounting effect and brings expected quality to you.

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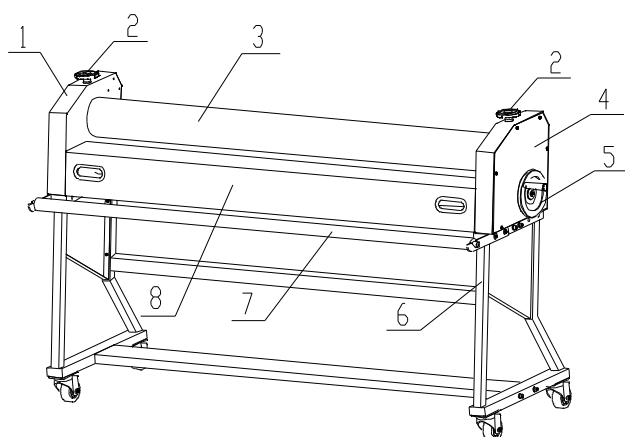
Application and characteristics

Instructions of series of cold laminators

Large cold press laminator is equipment for post-fabrication in printing, which meets your different requirements for overlaying film and is widely used in advertisement sector, exhibition sector, picture fabrication sector, photo studio and many other sectors and the most ideal supporting equipment for digital products.

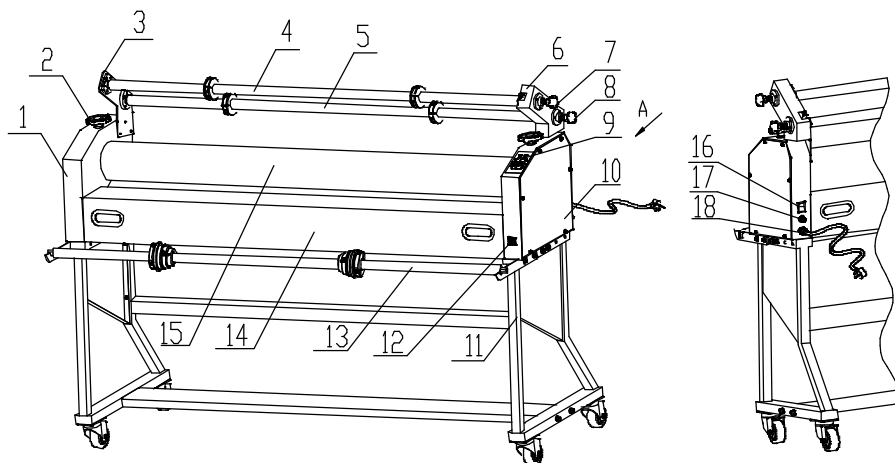
The cold mounting thickness is adjustable freely within the applicable scope. The machine features easy operation, wide range of application, simple construction, good operability, safe and reliable service and complete functions, and allows mounting of sheets and liner plates.

Sketch of machine: 1600HIV-L cold pressing cold laminator



1. Left case
2. Pressure regulating handwheel
3. Top rubber roll
4. Right case
5. Operating handwheel
6. Frame
7. Feed roll
8. Front operating panel

Sketch of machine: 1600EIV-L cold pressing cold laminator



- 1. Left case 2. Pressure regulating handwheel 3. Left windup support
- 4. Withdrawing backing paper roller 5. Feed roll 6. Right windup case
- 7. Pressure regulating handwheel for backing paper roller
- 8. Pressure regulating handwheel for feed roll 9. Control panel 10. Right case
- 11. Frame 13. Socket for foot switch 13. Feed roll 14. Front operating panel
- 15. Top rubber roll 16. Power switch 17. Fuse holder 18. Power lead

Operation of 1600EIV-L electric switch panel

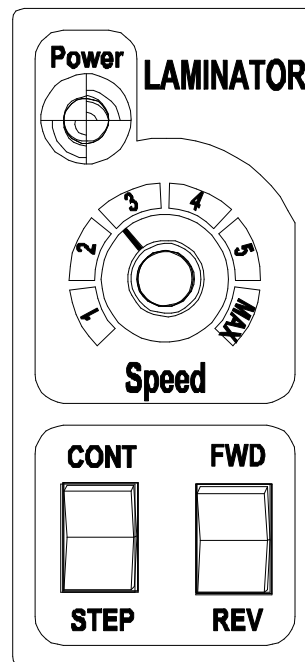
FWD press FWD/REV switch to this side, machine will turn to forward running (it can use when feed up film)

REV press the key to this side, machine will turn to reverse running (it can use when withdraw film)

Speed adjust this knob for speed of roller

CONT press this key to control machine from control by food pedal turn to continues operation

STEP press this key control machine from continues operation turn to control by foot pedal

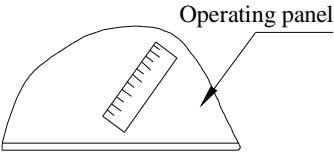

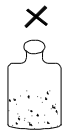
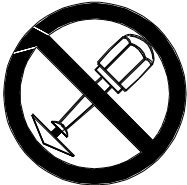
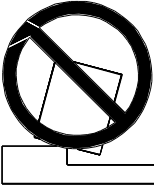


STEP key can be used as stop key when operation, it can step control operation when feed up film.

Warning: When the machine is in operation, never approach your hands to the rotating rubber rolls !

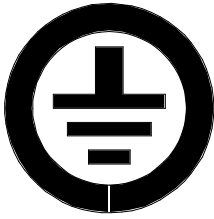
Warning and cautions

Warning

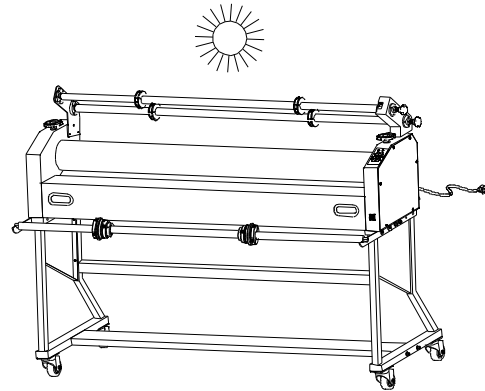
 <p>Never place the following articles on the operating panel to prevent the rubber rolls from damage by entanglement: tools, ruler, pen and other sharp objects. Never remove the glue remnant or foreign matter from the rubber rolls with sharp object (or nails) to avoid scratches on the surface of the rubber rolls.</p>	<p>When the rubber rolls require cleaning, wipe them clean with soft cloth dipped with alcohol to ensure the film-running effect. Never wipe with oils or ethanal or other liquid that solves the rubber rolls to prevent them from deformation.</p> <div style="display: flex; justify-content: space-around; align-items: center;"> <div style="text-align: center;">  <p>Alcohol</p> </div> <div style="text-align: center;">  <p>Oils</p> </div> </div>
<p>Never try to dismantle the machine for repair.</p> 	<p>Never place the machine at unstable locations.</p> 

Instructions of series of cold laminators

Make sure that the machine is reliably earthed.



Never place the equipment directly under the sunlight.

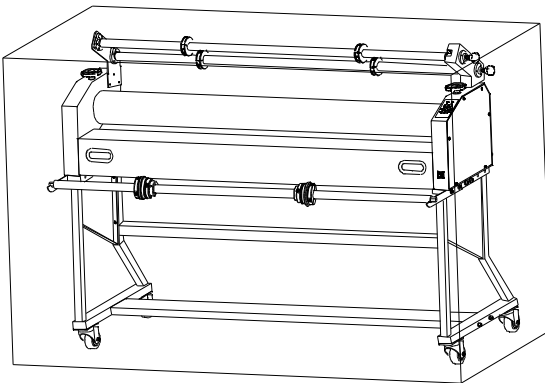


Select a well-ventilated and clean working environment free of direct sunlight.

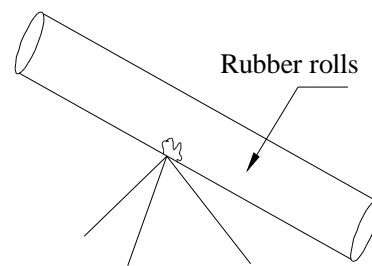
Cautions

Operating environment should be kept from high temperature and plenty of dust.

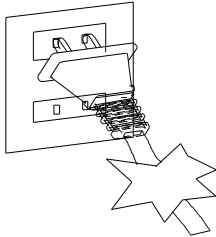
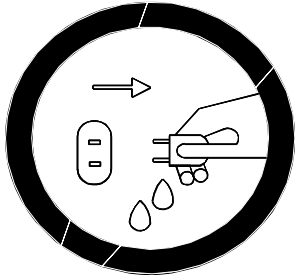
Dust protective cover
Main unit



To unpack, carefully take the machine out to avoid impact to the rubber rolls or losing of spare parts.



Instructions of series of cold laminators

<p>When power lead or plug is damaged or the plug does not firmly insert the socket, never use the machine.</p> 	<p>Never touch the power lead and plug with wet hands.</p> 
<p>During the mounting, make sure to introduce the cold pressed film into the rubber rolls for about 8mm before separating the rubber film from the backing paper. Never start with the separation.</p>	<p>During the mounting, place the glue-free side of the rubber film naturally and flatly against the rubber rolls and never tension it with force.</p>

General knowledge on machine maintenance: Bearings in the case should be subject to regular lubrication. For long idleness of the machine, lift the top roll and avoid plastic deformation resulting from the two rolls in long pressure state.

Prompt: There are no electrical parts but the fuse in the machine which can be repaired by the user.

Technical specification

Product model	1400HIV-L	1400EIV-L	1600HIV-L	1600EIV-L
Operating mode	Manual	Electric	Manual	Electric
Max. cold mounting width	1400mm	1400mm	1600mm	1600mm
Max. cold mounting thickness	20mm	20mm	20mm	20mm
Max. cold mounting length	Without limit	Without limit	Without limit	Without limit
Operating voltage		220V/50Hz		220V/50Hz
Linear speed range of rubber rolls		0~4m/min		0~4m/min

General operation

Method 1: Mounting of short sheet:

1. Mount the machine on special frame or on stable and firm bench.
2. The surrounding space should ensure an uninterrupted operation.
3. Setting of space between rubber rolls: Adjust the distance to cater to the needs for materials of different thicknesses so that the object passing the rubber rolls gets appropriate pressure, no damage is caused to the rubber rolls and the cold mounting quality is not affected due to insufficient pressure.

How to set the space:

- Check the thickness of the material you have
- Turn the left/right handwheels at the top of the machine according to the thickness of the object to be mounted. Turning counterclockwise increases the thickness and turning clockwise decreases the thickness.

Caution: To lift or lower the rubber rolls, do not try to adjust to the place unilaterally. Instead, regulate by the left/right handwheels alternately for gradual adjustment into the place.

4. Pressure regulation:

- To increase the pressure, turn clockwise the pressure regulating handwheels on the two sides. When the two rubber rolls meet, further turning the handwheels will lead to a process where the rubber rolls do not lower, which is the idle running of the handwheels. Now, slightly turn the handwheels on the two sides clockwise for the same angle so that the pressures on the left and right sides are consistent.

Caution: To increase the pressure, the turning angle should be appropriate. To decrease the pressure, turn the handwheel counterclockwise. Over-pressure will cause wrinkles or cockling on the mounted picture surface. In case of under-pressure, the mounted picture is not properly pressed and found vague and with white spots, thus affecting the mounting quality.

5. Cut the cold mounting film to the dimensions of the object to be mounted.

Caution: 15-20mm larger than the picture should be ensured lengthwise for the pre-feeding of the film.

The crosswise dimension of the rubber film should be 10-20mm larger than the picture.

1600EIV-L electric cold pressing laminator

I. Operating method in absence of backing-paper-receiving mechanism

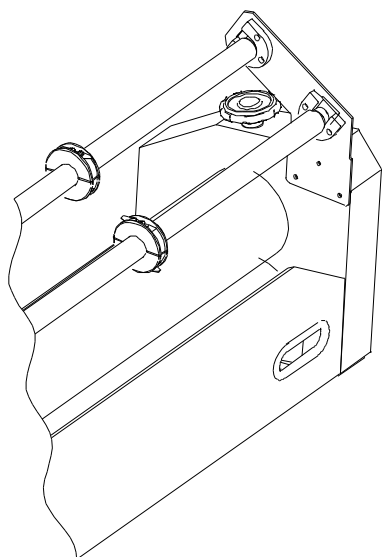
1. Before operating the electric cold pressing laminator, use three-plug outlet and ensure that the earth is reliably earthed.
2. Before switching on the power, place the plug of the foot switch in the outlet for it.
3. Connect the power.
4. Switch on the power and step on the foot switch and the rubber rolls rotate forwardly. Feed the cold mounting film flatly in between the rubber rolls for about 8mm and release the foot switch. (For feeding the rubber film, the distance from the centerline of the rubber film to the left/right

cases of the machine should be roughly equal.)

5. Separate the film from the backing paper by lifting them. Place the glue-free side of the film tightly against the rubber roll, and place the picture on the backing paper and align. (The lengthwise edge of the film should be almost normal to the rubber rolls.)
6. Step the foot switch and the rubber rolls rotate forwardly and feeds the picture in between the two rubber rolls. The front edge of the picture should enter the rubber rolls simultaneously to the greatest extent possible. Otherwise, bubbles, roughness and wrinkles will develop during the cold mounting.
7. Select appropriate speed, press the Continuous key and enter the continuous cold mounting state. (Caution: The cold mounting speed should not be too fast.)
8. As the cold mounting is coming to the end, make sure to prevent the cold mounting film from slippage off the rubber rolls and premature adherence to the picture, thus affecting the effect of the cold mounting.
9. Press the Crawl key and the motor stops.
10. Switch off the power.
11. Cut off the redundant film and you will get a satisfactory picture.

II. Operating method in presence of backing-paper-receiving mechanism

1. This mechanism is applicable to the cold mounting of rolls. For sheeting, the backing-paper-receiving mechanism is not required.
2. After receiving the machine, mount the left and right supports of the wind-up mechanism, the feed roll and supporting sleeve onto the main unit, and assemble the left and right supports of the wind-up mechanism in the direction as shown in the schematic for main unit. Mount the feed roll supporting sleeve on the feed roll and the feed roll on the left and right supports of the wind-up mechanism. The feed rolls should be so assembled that the feed roll support chips on the two feed roll supporting sleeves of the wind-up mechanism are opposite as shown in the figure below. Otherwise, no normal operation is possible.



3. Before operating the electric cold pressing laminator, use three-plug outlet and ensure that the

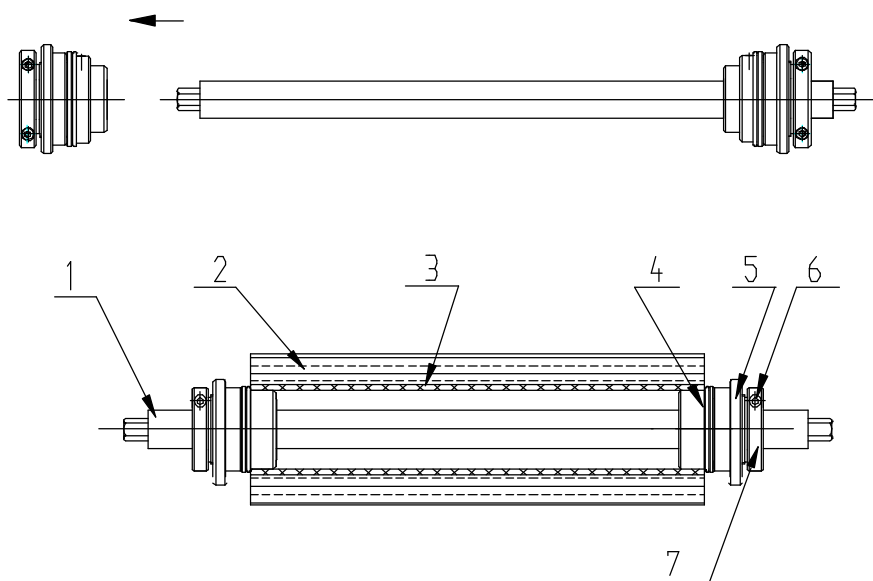
earth is reliably earthed.

4. Before switching on the power, place the plug of the foot switch in the outlet for it.
5. Place a complete roll of cold mounting film onto the feed roll of the backing-paper-receiving mechanism. Certain friction should be made available on the feed roll so that certain tension is provided in mounting the film. Simply adjust the right pressure-regulating handwheel of the feed roll on the backing-paper-receiving mechanism. Place the picture to be mounted on the feed roll of the frame, pull down the cold mounting film and align it with the picture to be mounted.
6. Switch on the power and step on the foot switch and the rubber rolls rotate forwardly. Feed the cold mounting film flatly in between the rubber rolls for about 8mm and release the foot switch. (For feeding the rubber film, the distance from the centerline of the rubber film to the left/right cases of the machine should be roughly equal.)
7. Separate the backing paper of the cold mounting film from the cold mounting film at 20mm from the engagement line of the rubber rolls by using the film cutter, pull up the backing paper and firmly stick it to the paper core of the backing paper roll on the wind-up mechanism.
8. Place the object to be mounted and feed it flatly in the engagement line of the rubber rolls.
9. Step the foot switch, select appropriate speed, press the Continuous key and enter the continuous cold mounting state. (Caution: The cold mounting speed should not be too fast.)
10. Now, the wind-up mechanism should wind up the backing paper onto the backing paper roll. In case of abnormality in the winding-up, the pressure-regulating handwheel of the backing paper on the right wind-up case of the machine should be adjusted till a normal wind-up is possible.
11. As the cold mounting is coming to the end, make sure to prevent the cold mounting film from slippage off the rubber rolls and premature adherence to the picture, thus affecting the effect of the cold mounting.
12. Press the Crawl key and the motor stops.
13. Switch off the power.
14. Cut off the redundant film and you will get a satisfactory picture.

III. Operating method for frame feed roll

1. Mount the roll of picture and text on the feed roll;
2. Mount the removed feed roll supporting sleeves (parts) on one end of the picture and text paper core;
3. Adjust the distance between the two feed roll supporting sleeves (parts) in accordance with the actual width of the used consumable so that the picture and text is in the middle of the feed rolls.
4. Fasten the screws for positioning sleeve of material mandrels (Note: there should be 3~5mm clearance between the positioning and the adjusting sleeves of mandrels to make transverse adjustment easier),
5. Adjust the friction forces by turning the adjusting sleeve of the mandrels (Note: the friction forces should not be too big).

6. In case of deviation during the lamination of picture and text, the picture and text can be kept aligned to the rubber film by adjusting the feed roll supporting sleeves.

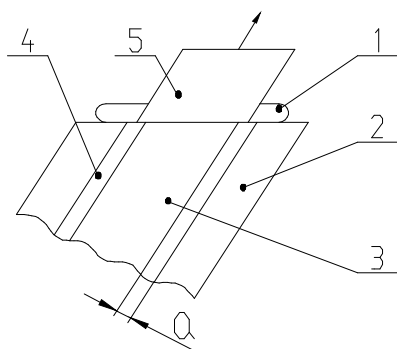


1. Axles of the material mandrel 2. Picture 3. Paper tube 4. Positioning sleeve for material mandrel
5. Adjusting sleeve 6. Fastening screws for the positioning sleeve 7. Positioning sleeve

Caution: During the mounting, in case of rolled picture or problem in the mounting quality, you can fast set the touch switch in a reverse state to withdraw the picture.

1600HIV-L manual cold pressing laminator

1. Turn the right operating handwheel of the machine clockwise and feed the film flatly in between the two rubber rolls for about 8mm.
2. Separate the film from the backing paper by lifting them. Place the glue-free side of the film tightly against the rubber roll, and place the picture on the backing paper and align. (The lengthwise edge of the film should be almost normal to the rubber rolls.)



1. Rubber roll
2. Front operating panel
3. Picture
4. Backing paper
5. Film
 $a \geq 5\text{mm}$

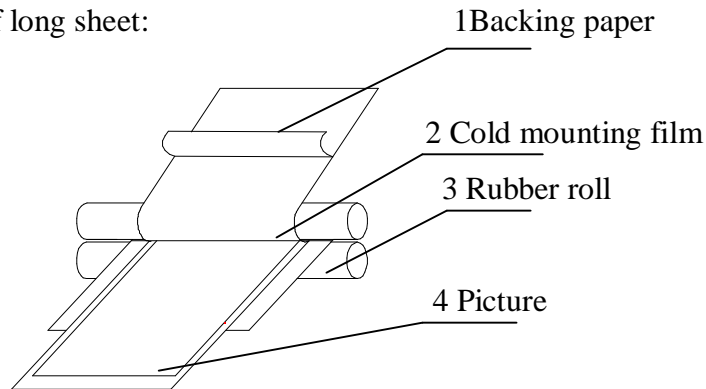
3. Rotate the operating handwheel at ever speed and feed the picture flatly in between the two rubber rolls. The front edge of the picture should enter the rubber rolls simultaneously to the greatest extent possible. Otherwise, bubbles, roughness and wrinkles will easily develop during the mounting. (Caution: The mounting speed should not be too fast.)

4. As the cold mounting is coming to the end, make sure to prevent the cold mounting film from slippage off the rubber rolls, thus affecting the effect of the cold mounting.
5. Cut off the redundant film and you will get a satisfactory picture

Caution: For the manual type, during the mounting, in case of rolled picture or problem in the mounting quality, you can turn the operating handwheel counterclockwise to withdraw the picture.

Tip: Use cold mounting film with good quality.

Method 2 Mounting of long sheet:



1. Adjust the pressure-regulating handwheels on the two sides to lift the rubber rolls.
2. Flatly feed in the rubber rolls the picture with the side to be mounted facing up and let it pass out of the rubber rolls by about 100mm.
3. Flatly feed in the rubber rolls the cold mounting film with the side with backing paper facing the picture and let it pass out of the rubber rolls by about 100mm.
4. Adjust the picture to be mounted and the cold mounting film so that they are aligned.
5. Adjust the pressure-regulating handwheels on the two sides, lower the top rubber roll and adjust it to the idle running position.
6. Cut the front end of the backing paper on the cold mounting film passing out of the rubber rolls by about 50-80mm.

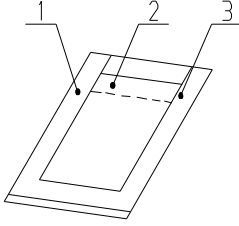
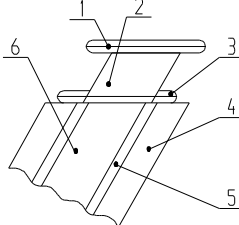
Flatly place the cold mounting film with cut backing paper so that the film is flatly stuck to the picture to be mounted.

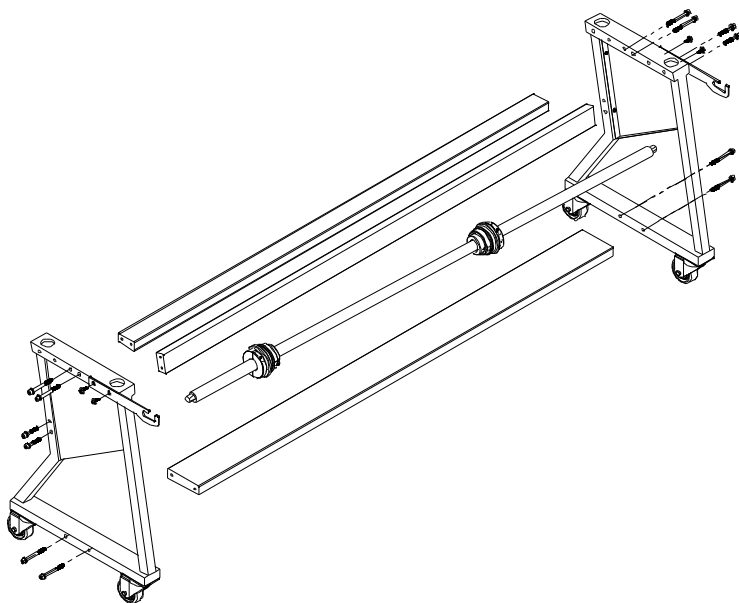
7. Turn the rubber rolls backward (i.e. reverse turning of the rubber rolls), return the picture mounted with cold mounting film to about 50mm before the roll to an extent that the portion of the cold mounting film with the backing paper remaining returns to the front panel.
8. Now, adjust the pressure of the rubber rolls and adjust the handwheel to a position where a slight pressure is applied after the idle running.
9. Move the complete cold mounting film over to the rear side of the rubber rolls and slowly peel off the cold mounting film from the position where the backing paper is removed. Now, turn the rubber rolls and cause the rubber rolls to rotate forward. Slowly remove the backing paper as the rubber rolls rotate till the cold mounting process ends.

Warning: When an electrical type machine switches between the forward and reverse

states, it is recommended that the machine be set in the Crawl state before the switching.

Special operation: When a picture is to be mounted over a liner plate of min. 5mm in thickness,

<p>—The liner plate should be flat, free of flashes and smooth at the front end.</p> <p>—Cut off about 50mm of the backing paper from the front of the cold mounting film to expose the glued face and attach it to the plate.</p>	 <p>1. Plate 2. Rubber film 3. Backing paper</p>
<p>—Lift the top roll, place the plate between the top and bottom rolls, lower the top roll, press the liner plate and adjust the pressure.</p>	 <p>1. Backing paper 2. Rubber film 3. Rubber roll 4. Front operating panel 5. Liner plate 6. Picture</p>
<p>—Lift the backing paper and the film from the plate, place the picture and properly locate it.</p>	
<p>—Start this machine, and separate the backing paper from the film while the film is running. When the film is running, it should attach flatly to the top rubber roll and the tensions at the two ends should be equal.</p>	
<p>—If the liner plate has a glued face, flatly and firmly stick the front end of the picture to the liner plate before feeding the front end in between the top and bottom rubber rolls. Lift the picture so that it is against the top rubber roll. Start the operation of the rubber rolls at proper pressure to drive the liner plate forward, thus the picture is evenly and flatly stuck to the liner plate. Repeat the cutting and mounting procedure on the liner plate and complete the complete mounting process.</p>	



Installation instruction of the frame

Maintenance service

We will provide you with refined after-sales service.

When you need us, directly contact our head office of sales or our local dealers.

Problems and solutions

Problems	Solutions
Cockling in the overlaid film	Appropriately reduce the pressure on the two sides of the rubber rolls.
Splayed wrinkles during film overlaying	Appropriately increase the pressure on the two sides of the rubber rolls.
Deviation of object to be mounted in the case of a long film	Make sure to align for feeding the film and maintain consistent pressure on the two sides.
Machine does not run when the button is pressed	Check if the fuse is blown and plug in firm contact.
Motor does not run at even speed in operation	Outlet must have proper earth.
Machine slips in position during its operation	Check if the casters are in locking state.

Prompt: In one of the following cases, the warranty does not apply and repair will be charged.

The period of validity for warranty has expired, the reference form of warranty is altered without authorization, product is damaged resulting from improper operation, maintenance and care due to failure in following the Operating Instruction, the number on the reference form of warranty does not match the practicality, and effective invoice can not be produced.

A Packing List of 1400HEIV-L/1600HEIV-L

Designations	Unit	Qty	Remarks
Main machine	pc	1	
Upright column of machine frame	set	2	Including caster wheels
Material roller	pc	1	
Supporting beam	pc	3	
Support of roller	pc	2	
Inner hexagon spanner	pc	1	S=4
Inner hexagon spanner	pc	1	S=5
Inner hexagon spanner	pc	1	S=6
Socket screw M8×80	pc	8	
Socket screw M8×55	pc	4	
Socket screw M5×20	pc	4	
Plain cushion ϕ 8	pc	12	
Elastic cushion ϕ 8	pc	12	
Elastic cushion ϕ 5	pc	4	
Gasket	pc	4	
Hand wheel crank	pc	1	Hand-driven type
Foot switch	pc	1	Motor-driven type
Cutter	pc	1	
Instruction	pc	1	