

**TYPE KDFM-720、900、1200
QUICKLY LAMINATING MACHINE**

USER MANUAL



PREFACE

Dear users:

Welcome to use our products!

Do read installation and operation manual before make use of it.

Make sure normal operation and good working condition.



Fig.1 Overall Diagram of KDFM-720-900-1100-1200 High speed Laminating machine.

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1、 General Introduction

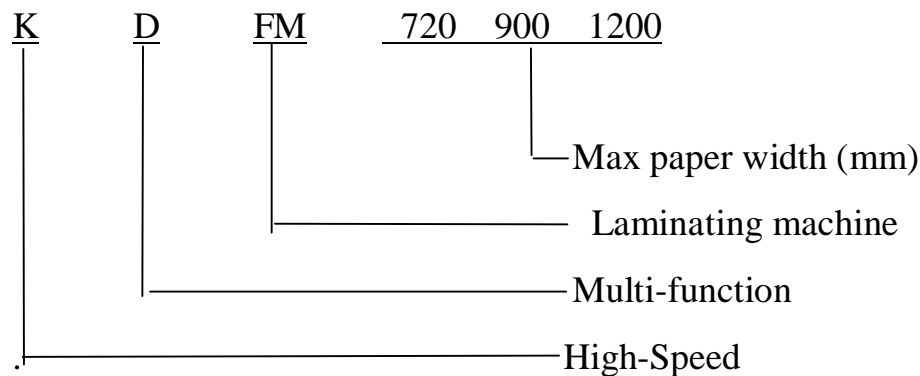
KDFM-720、920、1200 high-speed laminating machine is the newest product of our factory which is developed with advanced technology from abroad and in accordance with our national conditions.

This machine is advanced in design, compact in construction and convenient to use, it is mainly used to compounding automatically single or double sides of printed products by BOPP thermal film. After laminating, the printed products are smooth in appearance, bright in color and strong in intensity. It can widely apply to surface of laminating film for cover of books, packing box, food box, periodicals, drawing sheet, advertisement, document, radium glasses and etc.

2、 Main Technical Parameter

Item \ Type	KDFM720	KDFM900	KDFM1200
Max Laminating Width	620mm	820mm	1100mm
Max Laminating Speed	0-20m/min	0-20m/min	0-20m/min
Voltage	220V	380V	380V
Power of Motor	0.4KW	0.55KW	1.1KW
Power of Heating	2.4KW	3.6KW	5.4KW
Overall Dimensions	1150*1100*140mm	1450*1100*1400mm	1750*1250*1450mm
Weight	260Kg	380Kg	600 Kg

3、 Type Introduction



4、 Structure and Working Principle

This machine is consisted of machine stand, transmission mechanism, front & back rubber rollers, pressure adjustment mechanism, electrical system etc. Please see diagram 1 of its appearance picture.

Working principle: When single-side laminating, its working principle is that: Smeared film and the paper will be heated to a certain degree and pass through the front pressure roller 5 and 12, the smeared film's glue surface will melted and stucked to the paper because of heat compound, and will be passed out automatically after being pressed by back group rollers 15 and 16. Then it will be winded by receiving roller 17.

The working principle of double side laminating is the same as the single side, only the film's rotation position of is different. When double side laminating, there will install each film roll upper and under of the machine. The working routine of upper film is the same as the single side laminating. And the under film see the diagram 2, it will pass through film leading roller then enter into back group rollers 15 and 16 and press together, after pressing, it will be received by roller 17, and finish the double side laminating process.

5、 Use of machine

- 5.1 Check the spare parts of the machine before first use, the machine shall be placed evenly.
- 5.2 Connect well with the external power supply, and make the machine be connected to the ground in good condition.

5.3 Operation method

5.3.1 Single-side Lamination: Install the film roll on the film shaft 1, generally it will be put on the middle position of shaft. (Note: the film installation position should be decided the position of paper feeding.)

5.3.2 Put through the power. If the indication lamp is red, it shows that the machine has been electrification.

5.3.3 Press down the start button, the green light on, means that there is an instruction for the temperature controller.

5.3.4 Set the temperature to 80-100 cent degrees, specific should be according laminating speed and results (Generally, if the laminating speed is fast, the temperature also should be set higher, thus it will be beneficial to protect the quality of lamination.) The front heating begins to heat,

(Note: If it is single-side laminating, it only should set the temperature of front heating roll) and it will take about 20 minutes to rise to the set value.

5.3.5 When the temperature attains to the set value, press down the clockwise rotation button, and adjust the speed to suitable position, it means that have finished the preparation work for single-side lamination.

5.4 Double-side lamination

5.4.1 When double-side laminating,

It can adjust as the method of 5.3.1. The position of under film shaft with film roll should be coin with film shaft 1. So it can assure the compound precision.

5.4.2 Make the two temperature controller to be between 80-100, and make the front and back roller be in heating condition. Meanwhile, start the machine, when the temperature reaches the set value, it means that it has finished the preparation work for double-side laminating.

5.5 When single-side laminating, should put the thermal film (adhesive layer downward) and paper together to pass through front press rollers. When double-side laminating, it should place the paper between this two thermal films. So the adhesive surface of the under film shaft should be upward.

5.6 Separately press with the handle wheel of front and back pressure roller 11 and 13, make the pressure of front and back group roller even.

5.7 The laminated products will be sent out from back pressure roller, and can be received directly by receiving roller, and it also can be sent out

directly and tidy by manual.

5.8 The lamination for PVC is the same with papers', but it must use the adjusting wheel before laminating.

6、Maintenance

6.1 Add a little lubricating oil in chain wheel and bearing once half a month.

6.2 If the machine doesn't work for a long time, it should make the front and back two groups of pressure rollers loosen lest the roller will be deformed because of longtime being pressed.

6.3 Keep each roller clean. If dirty, you can use the cotton dipped with water less alcohol to clean it.

6.4 Common trouble and elimination

Fault	Cause	Method
Machine can't start	1. Fuse melts 2. Voltage abnormal	1. Exchange fuse 2. Check whether power and voltage is normal
Temperature rise too slowly or can't rise	1. Electrical heat pipe is damaged 2. Temperature controller is out of control	Exchange the electrical heat pipe and temperature controller
Wrinkles on the surface of laminated product	Adjustment for front and back pressure rollers is not improper.	Adjust the pressure roller to make the pressure even
Fog or white spot on the face of laminated product	Temperature set too low	Raise temperature
Sticking force between film and paper is not strong enough	Pressure of pressure roller is not enough	Adjust pressure
Too big difference between measured and set temperature	Temperature measuring couple not pressed on rolling pipe	Adjust setup position to make it pressed on the face of rolling pipe
Temperature out of control	Double-side control silicon is damaged	exchange

7 Electrical systems

7.1 Refer to the electric chart 3 and 4.

7.2 Attention notes:

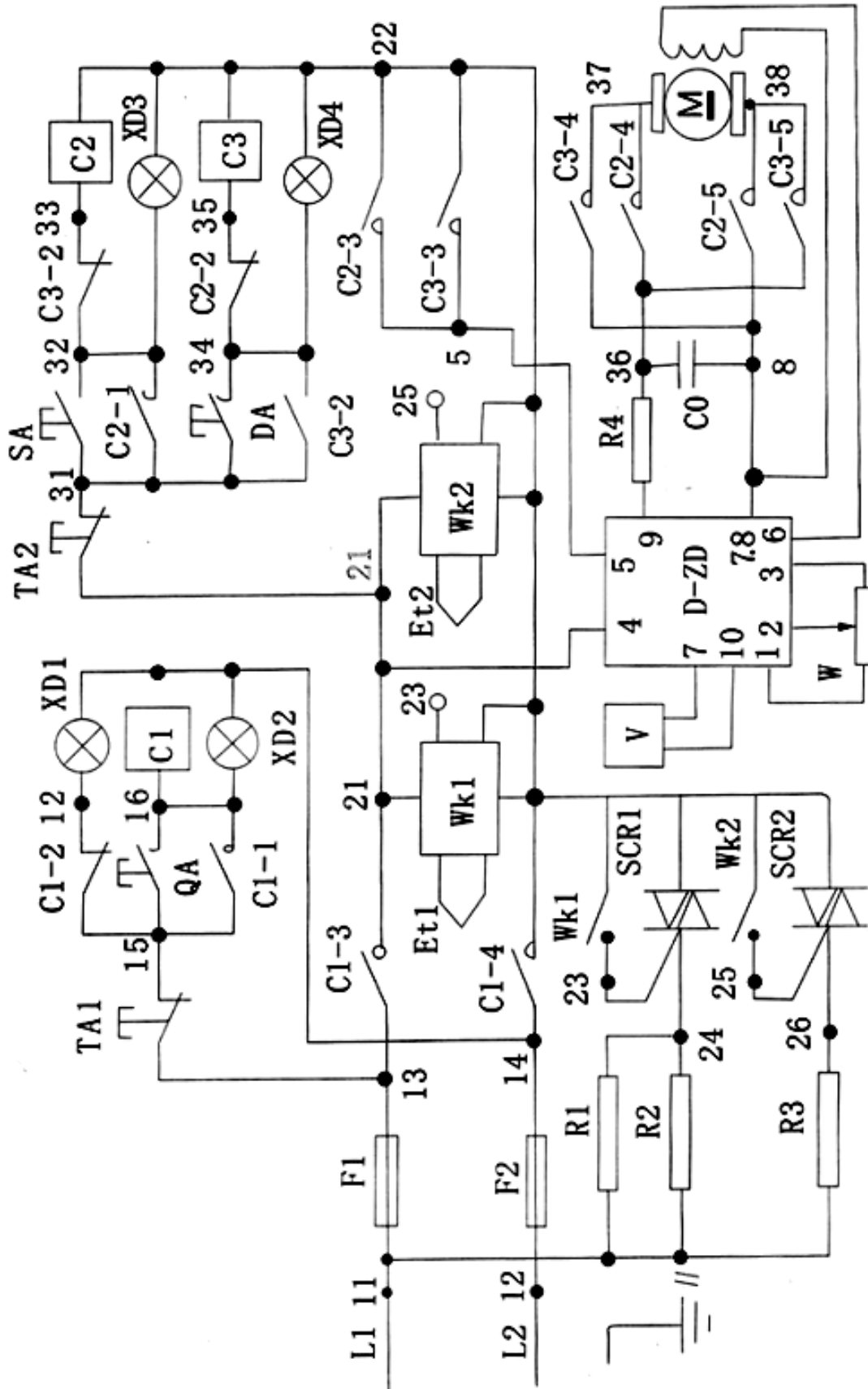
7.2.1 If start the machine for the first time, please must connect it to the grounding device to make the machine in good ground-connecting condition.

7.2.2 User can not randomly increase the capacity of electric system's fuse. Our factory won't be responsible for any quality accident resulted from Such act. Do not use copper wire instead of fuse.

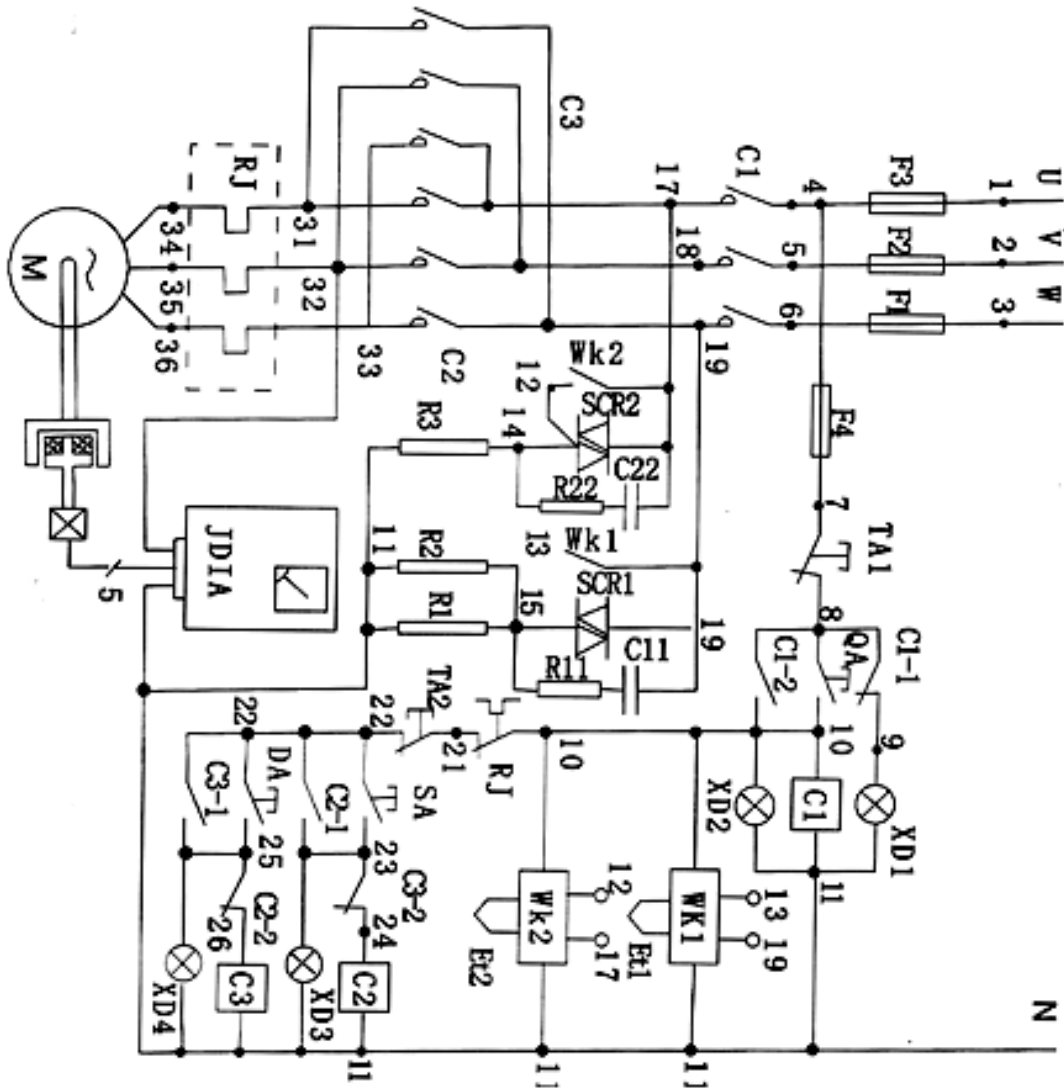
The wire connecting method of JDIA electromagnetism speed adjusting motor has been indicated in diagram 4. Wire connection method of temperature indicating regulator's ends has been indicated in diagram 5.

8、Accessories list

-shape screwdriver	1
+shape screwdriver	1
14-17 hand wheel	1
Inner 5\6\8 angle hand wheel	1



KDFM-650、720型复膜机电气系统接线原理图



Electric chart of KDFM-900、1200

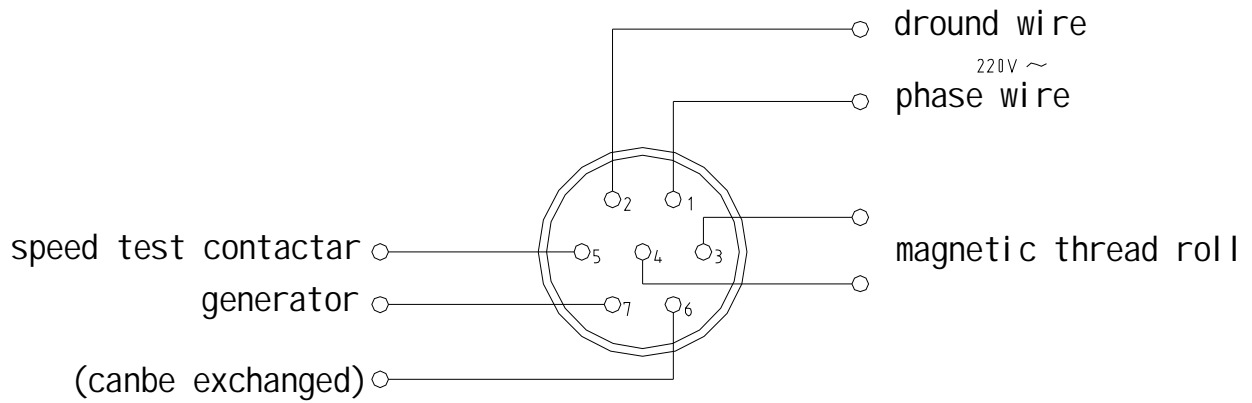


Diagram 4:
wire connecting of electromagnetism speed adjusting motor

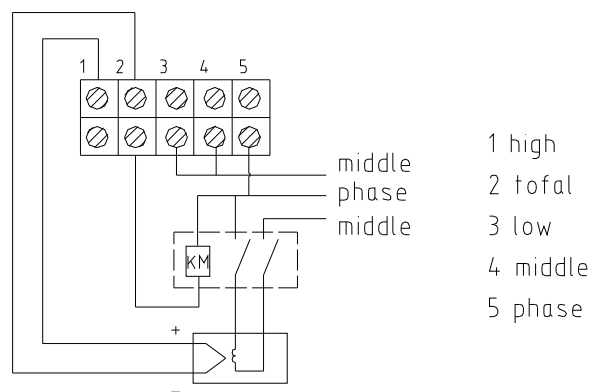


Diagram 5:
wire connecting of temperature indicating regulator's ends