

PREMIER 4 SERIES LAMINATOR

REPAIR PROCEDURES

31. Clear "wrap-around" by removing and cleaning or replacing rolls.

- a. Remove the rubber rollers
 - (1.) Remove drive chain and sprockets as described in 27 above.
 - (2.) Remove rubber roll gears as described in 24 above.
 - (3.) Remove the two 1/2" stop collars that secure the top front and rear rollers to the right hand side using a 1/8" allen wrench.
 - (4.) Use a 3/16" allen wrench to loosen and remove the pressure bolts and orange pressure springs (part # LC25 031.4) from the bottom bearing supports (part # 4285 028.4) and top bearing support (part # 4285 030.4b).
 - (5.) Use a 9/64" allen wrench and a phillips head screwdriver to remove the cap head screws and button head phillips screws with stainless steel spacers that hold the top bearing support/cam spring support bar and roller bearing assemblies in place.
 - (6.) Slide these top assemblies off the ends of their respective shafts.
 - (7.) Remove the top front and top rear rollers by sliding them thru the roll change openings on the side panels.
 - (8.) Use a phillips head screwdriver to loosen and remove the flat head phillips screws that secure the bottom bearing supports to the side panels, then slide the bottom bearing supports off their respective shaft ends.
 - (9.) Remove the bottom front and bottom rear rollers by sliding them thru the roll change openings on side panels.
- b. If the "wrap-around" prevents the roll from fitting through the opening, some of the film must be removed **being very careful not to damage the rolls.**
- c. After the rolls are removed, remove the remaining film and clean the rolls thoroughly.
- f. If the rolls are damaged, they must be replaced (part # 0500-040.4).

Reassemble in exact reverse order of disassembly noting the following:

- (1.) The 19 tooth sprocket is installed on the front laminating roll and the 18 tooth sprocket is installed on the rear pull roll.
 - (2.) When re-installing the rubber roll pressure springs, the optimal measurement setting for the springs is 31/32".
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32. Check fan switch position.

- a. Engage the green fan switch to the upper, "I", position. It should illuminate. Fans should operate.
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33. Check fan switch.

- a. Remove the right plastic housing as described in 3 above.
 - b. Check continuity of the fan switch with a multimeter.
 - (1.) Engage fan switch.
 - (2.) Place multimeter probes on two inner most switch terminals.
 - c. If there is no continuity, the switch is faulty and should be replaced (part # PRS310), and rewired exactly as shown in schematic.
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REPAIR PROCEDURES

38. Check rubber roll dwell line.

- a. Create a "dwell line". The "dwell line" is the imprint the front laminating rolls leave in the web of a threaded and heated laminating machine after being stationary for 90 seconds.
 - b. Thread the laminator with a good quality film.
 - c. Warm up the laminator.
 - d. After the laminator is warm, run a short length of film and stop the drive motor for at least 90 seconds.
 - e. Advance the film 12 to 15 inches and look at the impression the laminating rollers left on the film.
 - f. This impression, "dwell line" should be two parallel lines running the full width of the film measuring approximately 3/16" to 1/4" in width.
 - (1.) If the dwell line is very narrow, the rubber roll pressure may not be great enough to grip and pull the film taut, resulting in wrinkles in the web that can't be corrected with supply roll tension.
 - (2.) If the dwell line is over 1/4" wide, there is too much pressure resulting in shifting of the film towards the path of least resistance, adding wrinkling in the area with less pressure.
 - (3.) If the dwell line is narrow on one side and much wider on the other, the roll pressure is not adjusted correctly, contributing to wrinkling problems.
 - (4.) If the dwell line has an hour glass appearance (wide on both ends and much narrower in the middle), there is either too much pressure on both ends or the rubber rolls are worn excessively.
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39. Adjust rubber rolls.

- a. Remove both plastic housings as described in 3 above.
 - b. Using a 3/16" allen wrench, adjust the orange rubber roll pressure springs to the optimal measurement setting of 31/32", as specifically denoted in procedure 31 above.
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40. Replace rubber rolls.

- a. If the rubber rolls have been damaged or produce an unacceptable dwell line that can not be corrected with adjustments to the pressure as outlined in procedure 39, the rolls need to be replaced.
 - b. Replace rubber rolls as detailed in procedure 31.
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