READ ALL PRECAUTIONS & INSTRUCTIONS CAREFULLY
BEFORE OPERATING LAMINATOR

Setup
Instruction
Operation
Lamination
Maintenance

Premier Series Laminators

OPERATION MANUAL

June 1993

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1-1 INTRODUCTION

The Premier III is designed to provide quality lamination of a wide range of papers and materials up to 1/8 inch thick using film up to five mils thick. Common applications include but are not limited to awards, teaching aids, visuals, maps, posters, menus, place mats, signs, labels, packaging, certificates, dry-erase charts, presentation materials, photographs, copies (B&W or color), prints, flash cards, game pieces, instruction sheets, flyers, safety notices, promotional sheets and many other items.
Options include a variable speed control, footage counter, slitter, machine cover, and a pre-heater that allows pouch laminating, dry mounting or simultaneous lamination and dry mounting. These pre-heater uses are described in separate instructions that come with each pre-heater unit.
To assure you get the best performance from your new laminator, please follow the safety, installation, operation, and maintenance instructions in this manual. Read the manual before using the laminator, keep the manual with the machine, and periodically review the instructions. The manual also contains warranty and parts information. Additional copies are available from the manufacturer at $10.00 each including postage. Please send payment with your order.

The International "HOT" warning symbol will be placed on the appropriate areas of each laminator.

Le symbole de securite international "CHAULEUR EXTREME" sera appose aux endroits appropries sur les laminoirs thermiques.

El simbola internacional de advertencia o precaution "CALIENTE" ha sido colocado en cada una de las areas apropiadas de la laminadora.

We take this opportunity to thank you for selecting the Premier III laminator and to assure you of our continuing interest in your satisfaction with our products.
As you unpack your new laminator, please complete the following information. Always have this information ready when calling.

Dealer Where Purchased _____

Installation Date _____ Serial # _____ (located at the back of the laminator, next to the power connector)

WARNING: High temperatures are present and care should be exercised in operating the laminator.

AVERTISSEMENT: Degageant un tres haut degre de temperature, il est recommande d'utiliser beaucoup deprudence lurs du fonctionnement du laminoir.

ADVERTENCIA: Importante! Tome extrema precaucion cuando este haciendo el mantenimiento de limpieza, etc. A su maquina.

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WARNING: The laminator should not be operated without the plexiglass safety shield.

AVERTISSEMENT: Le laminoir ne devrait etre opere sans l'ecran protecteur en acrylique.

ADVERTENCIA: No opere la laminadora sin estar seguro de que el protector de "plexiglass" esta colocado en su lugar.

Ledco, Inc.
4265 North Main Street,
Hemlock, NY 14466
Phone 716-367-2392
Fax 716-367-2978

1-2 FEATURES & BENEFITS

Your new laminator has several standard features that set it apart from other models.

- **The clear safety shield** keeps fingers away from heat shoes and laminating rollers while allowing you to see your work.
- The easily accessible **heat control** permits the use of many different types of thermal laminating film from 1.5 to five mils thick.
- **The silicone rubber laminating rollers** are flexible enough to provide a good edge seal and firm enough to offer a good surface seal. A high silicone content insures a much longer average roller life.
- Very strong **steel cores** prevent roller flexing and insure uniform pressure across the width of the laminate, giving you the best quality lamination available in a light or medium-duty machine.
- **The built-in cutter bar** allows material to be taken off the laminator without cutting.
- **Tension control knobs** are built into both supply roll mandrels so that wrinkles and curling in the film can be eliminated.
- **Controls** to open and close the laminating rollers make threading easier and allow even heating of laminating rollers during warm-up.
- **Cooling fans** prevent wavy lamination or heat wrinkles and allow the use of films up to five mils thick.
- **Spring-loaded rubber rollers** accommodate poster board or other materials up to 1/8-inch thick.
- **The reverse drive switch** makes the machine easier to thread, helps avoid problems, and helps clear away jams.
- **The power cord is removeable** to prevent unauthorized usage without locking away the whaole machine.

1-3 OPTIONS

There are several options available to make the Premier III more versatile.

- Pre-heater to permit one-sided lamination, dry mounting, pouch lamination, and transparency creation. (Instructions for this option are included with the Pre-heater.)
- Footage counter to automatically record the amount of film for usage control and cost management.
- Variable speed control to permit lamination of many different materials using a wide range of film types and thickness.
- Slitters to automatically cut away side scrap, greatly reducing the amount of time needed to trim your work. Most Premier-class laminators do not have slitters available. The slitter knives can be completely retracted into their holders when not in use.
- Right side feed guide to go with the standard left side guide and feed one sheet at a time with greater accuracy or feed two sheets at a time in alignment with each other.
- Cleaning kit to make the difficult job of getting hardened adhesive off the rollers safer and easier.

1-4 CHARACTERISTICS

This chart compares the characteristics of the Premier III Series 12", 18", and 25" units:

Premier III Series

Characteristic	12"	18"	25"
Plastic Width	up to 12"	up to 18"	up to 25"
Speed	5 FPM	5 FPM	5 FPM
Speed with var. spd.	0-10 FPM	0-10 FPM	0-10 FPM
Depth	19"	19"	19"
Length	19"	25"	32"
Height	11"	11"	11"
Net Weight	46 lbs.	59 lbs.	75 lbs.
Power Consumed	1500 Watts	1500 Watts	1560 Watts
Power Supply	120v/60 cycle 220v/50 cycle	120v/60 cycle 220v/50 cycle	120v/60 cycle 220v/50 cycle
Tension	Preset/ Adjustable	Preset/ Adjustable	Preset/ Adjustable
Heat Setting	Adjustable	Adjustable	Adjustable
Plastic Length/ Thickness	Up to 500'/ 1.5 mils Up to 400'/ 3 mils Up to 250'/ 5 mils	Up to 500'/ 1.5 mils Up to 400'/ 3 mils Up to 250'/ 5 mils	Up to 500'/ 1.5 mils Up to 400'/ 3 mils Up to 250'/ 5 mils
Maximum Thickness of Material of Material & Film	115 mils 1/8 inch (125 mils)	115 mils 1/8 inch (125 mils)	115 mils 1/8 inch (125 mils)

1-5 PRINCIPLES OF OPERATION

The Premier series laminators operate by pulling film with a thermally-activated adhesive over a heat source and into a set of laminating rollers. Film from a film supply roll passes over heat shoes to activate a polyethylene adhesive layer on the film. It then passes through rubber rollers to apply pressure and bond the film to the item being laminated. The film will actually fuse into the item.

This may be checked by cutting a large "X" on the surface of a laminated sample with a sharp blade. Use the tip of the blade to pry up one corner of the "X." Grab that corner and pull up the film. If ink and/or paper fibers come up with the layer of film, a good lamination has been achieved. If the film comes up too easily, with no ink or paper, the lamination was probably done at too low a temperature. Check the instructions that may have come with your laminating film and/or the lamination temperature chart in section 5-5.

Please note that when doing an X-test on glossy paper, a good X-test will pull up ink only with the film, because the paper is coated to make it glossy. When laminating material that is not glossy, the paper is often more fibrous and a good X-test will yield ink and paper fibers coming up with the film.

1-6 LAMINATING FILM

Most thermal laminating film consists of two layers: a base layer of polyester and an adhesive layer of polyethylene. The polyester layer forms the harder outer surface of the film and does not melt at laminating temperature. It provides rigidity and protection for your laminated items. The greater the polyester content, the higher the level of protection, rigidity and luster. The polyethylene layer melts at laminating temperature and bonds the film onto the subject material under the pressure of the laminating rollers. As an X-test demonstrates, the adhesive is pressed into the paper and fills irregularities in the surface. The proportion of polyester and polyethylene in a film is usually described with numbers. For example, a "1-2" film consists of one mil of polyester and two mils of polyethylene. The first number refers to the base layer, which consists of polyester in the majority of thermal films. The second number refers to the adhesive layer, which is usually polyethylene. A mil is 1/1000 of an inch.

Since polyester is the more costly of the two types of plastic generally used in laminating film, a "2-1" film will cost more than a "1-2" film. Both are 3-mil films, but the "2-1" version will seem a little thicker on a piece of laminated material because it will be slightly stiffer.

In the U.S. laminating trade, the generally accepted practice is to describe two-sided lamination, or encapsulation, by the thickness of one layer of film. For example, "3-mil lamination" should refer to lamination with two layers of 3-mil film. If you are buying or selling laminating film or lamination services, please make sure both parties understand the film descriptions being used.

There is a huge variety of thermal laminating films available to suit many different kinds of application. Here are some of the more commonly used "special" film types or film additives:

- film with low-melt adhesives; these often have better clarity and are less likely to curl or ripple when laminating conditions are not ideal
- matte surfaces to eliminate glare, or matte surfaces that will accept printing or writing; many suppliers offer films with both glossy and matte (non-glare) finishes
- film with UV inhibitors to prevent film deterioration in sunlight and protect colors in the laminated material from fading
- thermal film that has a pressure-sensitive adhesive and a release liner on its outer side; for example, a poster with this material laminated on the back could easily be put up without fasteners or tape
- high clarity films; some of these have a protective liner for the top outer surface...after a piece of material has been laminated, trimmed, packed and shipped, the person using the material can remove the protective liner, revealing a surface perfectly free of dust, scratches or abrasion
- opaque or colored films for the back side of a lamination; these can form a border for a laminated piece
- iridescent clear films for special visual effects
- permanently waterproof films for outdoor, underwater or special applications; the most common thermal laminating films are made with water-based primers and will eventually de-laminate if continually exposed to water or weather; truly waterproof films are made with special primers

Rolls of film may be purchased in different widths. The size of the laminator is the only limitation to the width of the film rolls you can use. If you have a Premier 25-inch machine, you can use any width roll up to and including 25 inches. You could use 12 or 18-inch rolls, or even a 4-inch roll, for example. The same principle applies to the smaller machines: you can use any width roll up to the size of the laminator. Make sure the upper and lower roll widths are the same, and are aligned with each other.

When installing film, always center the rolls of film on the supply roll mandrels so the core grippers engage the cardboard core. Look for the score marks around the supply roll mandrels to aid in aligning the top and bottom rolls.

Rolls are also produced with different lengths of film on a roll (250', 500', 1000'). The Premier III series will easily accomodate rolls of 1.5 mil film up to 500", 3 mil film up to 400', and 5 mil film up to 250'.

Schools often use 1.5 mil film because it is least costly, but we recommend 3 mil film for most common applications, including teaching aids. The 3 mil film provides better protection, slightly more rigidity, and contributes to appearance. Three-mil film also provides much more consistency and quality of lamination than 1.5-mil film. Because it does not hold heat well, 1.5-mil is more likely to delaminate, while 3-mil rarely does. Five mil film is suggested for those applications that need the most protection and rigidity. Five mil film is best for making transparencies on your laminator (see section 5-7).

Rolls of film are sometimes spliced. Most film suppliers will mark a splice with colored tape. This way, you can see the splice as a "dash" of color on either end of the roll. If you spot a spliced roll in advance, you can put it on the top supply roll mandrel in order to see the splice coming more easily and avoid putting material under the splice. Or you could put it on the bottom roll if you plan to be laminating items that will never be seen from the back side.

1-7 WARRANTY

This laminator is guaranteed against defects in material and workmanship for a period of one year after date of shipment. Defective parts will be replaced without cost within the warranty period, provided the laminator has not been abused, altered or operated contrary to instructions. Ledco, Inc. shall not be liable for any alterations or repairs except those made with its written consent.
This obligation under warranty shall not extend to the following:

- The adjustment or replacement of parts which are the normal responsibility of the owner. For example, rubber rollers, heat shoe coatings, scratched or chipped paint, loose fasteners (screws, nuts, etc.), or other items that show wear under normal use; i.e. "normal wear parts."
- Normal operating adjustments to heat, speed, tension, etc.
- Parts that are not manufactured by Ledco, Inc. If these items are warranted by the individual manufacturer, their warranty is, in turn, passed on to the original purchaser of the laminator. Ledco, Inc. does nor incur any obligation or liability as a result of the warranties which are the sole responsibility of the appropriate individual manufacturer.

Any laminator which proves defective during the warranty period may be returned to Ledco, Inc. unless it is decided that the necessary repairs can be made during a service call. Notice of the defect should be submitted in writing or by phone to Ledco before any steps are taken to repair or return the machine. Phone: 716-367-2392 Fax: 716-367-2978

If the machine is returned, the following should accompany it.

- Customer name, address and phone number
- Written particulars regarding the malfunction
- Date of Installation
- Serial number of the machine.
- All returns must have a return authorization number on the outside of the shipping container. Send all returned equipment freight PREPAID to:

  Ledco, Inc., 4265 North Main Street, Hemlock, NY 14466

If your machine needs servicing after the warranty has expired please contact your dealer. Ledco, Inc. does offer technical support if your dealer is unable to assist.

This warranty is expressly in lieu of all other warranties expressed or implied, including the warranties of Merchantability and Fitness For Use and of all other obligation or liabilities of Ledco, Inc., and said company neither assumes nor authorizes any other person to assume it for any other obligation or liability in connection with the sale of this laminator except as provided for above.

Further, this warranty will not apply to any machine or part thereof which has been damaged as a result of an accident or as a result of the abuse, misuse, or neglect of the machine. The warranty is also void if the laminator has been altered or repaired by any other than an authorized repair facility or dealer. If you have any questions about this warranty, contact Ledco. Phone: 716-367-2392 Fax 716-367-2978

2-1 UNPACKING AND INVENTORY

Except for the supply roll mandrels, feed tray, and exit tray, each laminator is assembled at the factory. Upon arrival, inspect the unit immediately and thoroughly using the packing list that accompanies the shipment. Please follow these steps to correct any problem with your shipment. Ledco, Inc. cannot accept any responsibility for damage or loss unless you notify us within ten days of receipt of shipment and follow these procedures:

BREAKAGE OR DAMAGE

Report any damage and file a claim with the delivering carrier. The procedure for reporting damage depends on the method of shipment.

Freight, Express, of Truck Delivery

According to the contract terms and conditions of the carrier, the responsibility of the shipper ends at the time and place of shipment. The carrier then assumes full responsibility for the shipment.

1. Notify the local agent of the transportation company immediately.
2. Hold damaged goods with container and packing for inspection by the examining agent. **DO NOT RETURN ANY GOODS TO LEDCO PRIOR TO INSPECTION AND AUTHORIZATION BY THE TRANSPORTATION COMPANY.**
3. File a claim against the transportation company. Substantiate your claim with the examining agent's report. A certified copy of your invoice is available upon request. The original bill of lading is attached to the original invoice. If the shipment was prepaid, write to Ledco for a receipted transportation bill.
4. Advise Ledco regarding your wish for a replacement.

Parcel Post

1. Notify us in writing at once, giving details of the loss or damage. **THIS INFORMATION IS REQUIRED FOR FILING A CLAIM WITH OUR INSURANCE COMPANY.**
2. Hold the damaged goods with container and packing for possible inspection by a shipping company representative.

United Parcel Service (UPS)

1. Contact your local UPS office regarding damage and insurance claims. UPS offices have different methods of handling claims and will advise you of their procedure.
2. Retain the container and packing.
3. Notify us at once for replacement.

SHORTAGE

1. Check the packing list notations. The apparent shortage may have been marked as an intentional short-shipped (back-ordered) item.
2. Reinspect the container and packing material, particularly for smaller items.
3. Make certain that the item was not removed by unauthorized personnel prior to complete unpacking and inventory.
4. Call us and send immediate, written notification of the shortage.

INCORRECT SHIPMENT

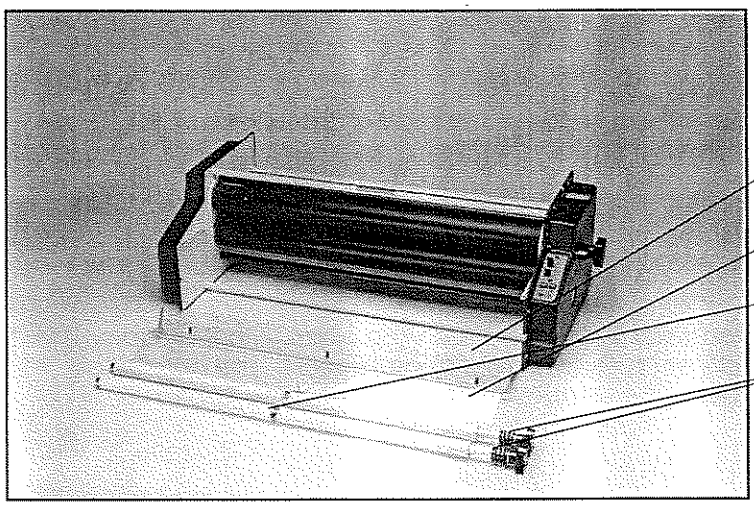
1. If the material you receive does not correspond with your order, notify Ledco immediately. Include the order number and item(s).
2. Hold items until return instructions are received.

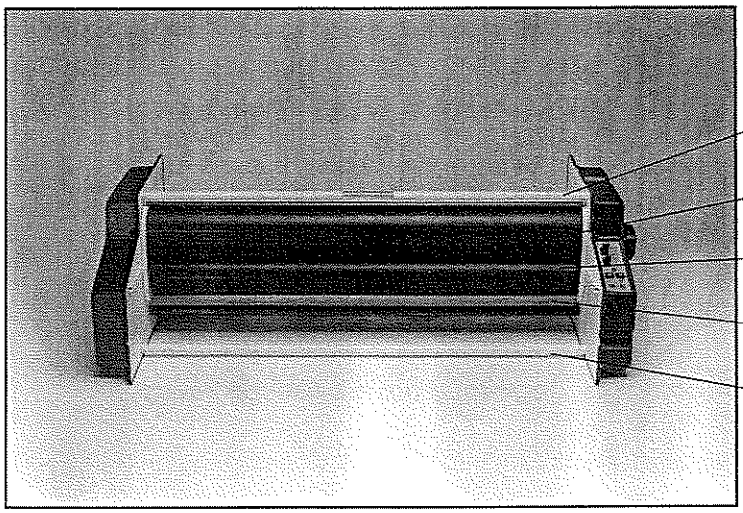
RETURNS

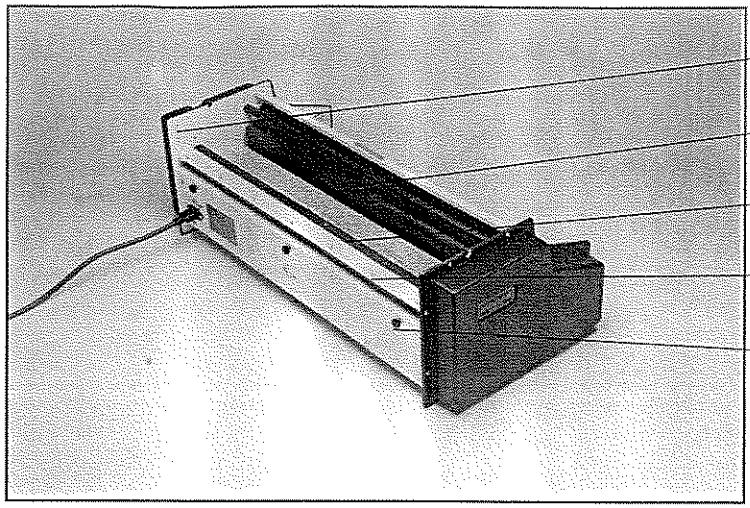
DO NOT RETURN DAMAGED OR INCORRECT ITEMS UNTIL YOU HAVE RECEIVED SHIPPING INSTRUCTIONS AND AN AUTHORIZATION NUMBER FROM LEDCO.

3-1 PRODUCT ILLUSTRATIONS & NAMES OF PARTS

The photos below and on the following page identify major components and operating controls. Refer to them as you study the installation, operating and maintenance procedures described in this manual.







Accessory Mounting Holes

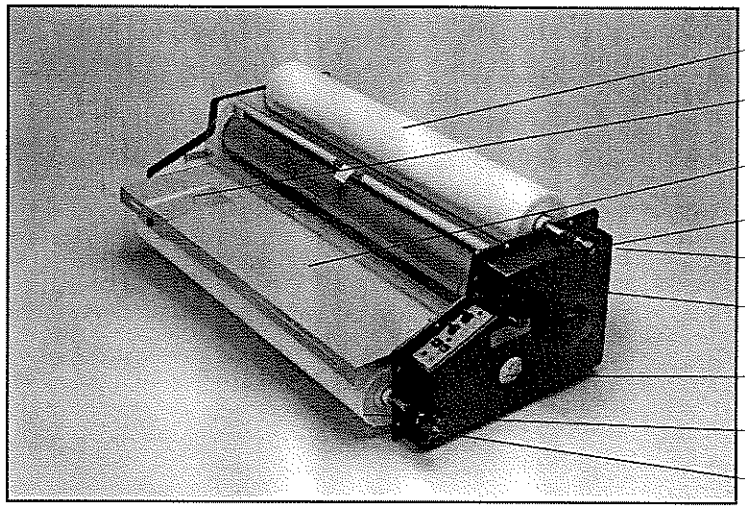
Laminating Rollers

Pull Rollers

Cutter Bar

Exit Tray Knobs

Laminating Rollers and Pull Rollers are collectively referred to as rubber rollers.



Top Film Supply Roll

Feed Guide

Feed Tray

Top Tension Control Knob

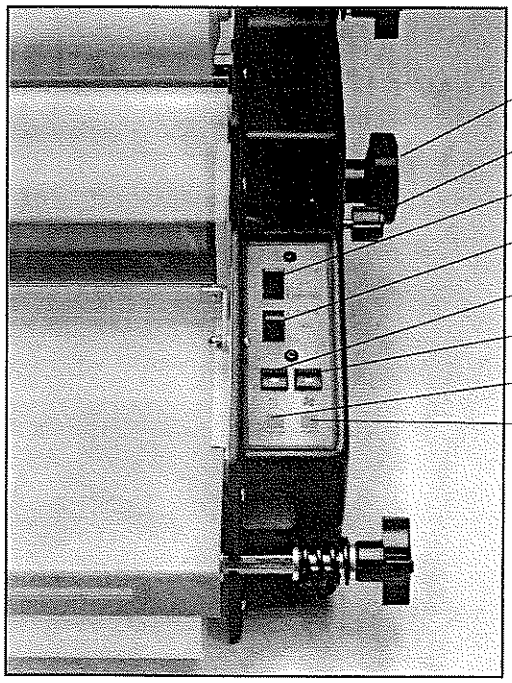
Exit Tray

Right Housing

Thermometer

Bottom Film Supply Roll

Bottom Tension Control Knob



Roll Pressure Control Knob

Temperature Control Knob

Drive Switch

Reverse Jog Switch

Heat Switch

Fan Switch

Heat Indicating Light

Power Indicating Light

4-1 SAFETY PRECAUTIONS

AVERTISSEMENT
ADVERTENCIA O PRECAUTION

1. High temperatures are present and care should be exercised in operating and maintaining the laminator. Even after the machine has been turned off it will remain hot for an extended period of time.

   La temperature elevee est presente et une attention speciale devrait etre apportee a l'utilisation de ces appareils. Meme apres que le courant electrique est enleve, la temperature elevee demeure pour un bon laps de temps.

   Observe la alta temperatura de la laminadora y ponga extremo cuidado al operar o limpiar la misma ya que la maquina conserva su calor aun despues de haber sido apagada por un periodo prolongada de tiempo.

2. Always make sure the power cord is not placed under the laminator where it might get over-heated from proximity to the bottom heat shoe.

   Avant de proceder au fonctionnement assurez-vous que le cordon l'alimentation n'est pas sous le laminoir, afin d'eveiter le surchauffement.

   Antes de comenzar a operar o funcionar la maquina, este seguro de que el cordon electrico no este debajo de la misma ya que podria sobre-calentarse.

3. The safety shield should remain attached to the machine and in position at all times. You may tip the safety shield forward while loading the film.

   Le protecteur de Plexi doit demeure attache au laminoir en tout temps. Vous pouvez le basculer pour changer les roulequz de film.

   El protector de seguridad debe permanecer siempre en su lugar, ud. Lo puede presionar ligeramente hacia abajo mientras coloca los rollos de plastico en la maquina.

4. Use caution when operating the laminator to prevent ties, jewelry, hair, and clothes from being caught in the machine.

   Lorsque l'appareil est en operation, une attention speciale devrait etre apportee afin que les objets tels que; cravate, cheveux, bijoux ou pieces de vetement, ne s'approchent pas des sabots chauffants.

   Tenga extremo cuidado mientras este operando la laminadora para evitar que cadenas (joyas), el cabello o la ropa queden atrapados o se enreden en los rodillos de la maquina.

5. Use caution when using the cutter bar as it is extremely sharp. Keep hands and clothing away from the cutter bar to avoid being cut or snagged on the sharp edges.

   Attention aussi, au couteau intefre, car les dents extrement pointues peuvent blesser.

   Mucho ciudado con sus manos y ropa cuando este usando la cortadora ya que esta extremadamente afilada.

5-1 SETUP & OPERATION

With the laminator on an unobstructed, level surface, perform the following checkout before threading the machine with film.

WARNING: Make sure the power supply cord is clear of the underside of the machine prior to operation to avoid overheating the cord.

AVERTISSEMENT: Avant de proceder au fonctionnement assurez-vous que le fil electrique n'est pas sous
le laminoir, afin d'eviter le surchauffement.

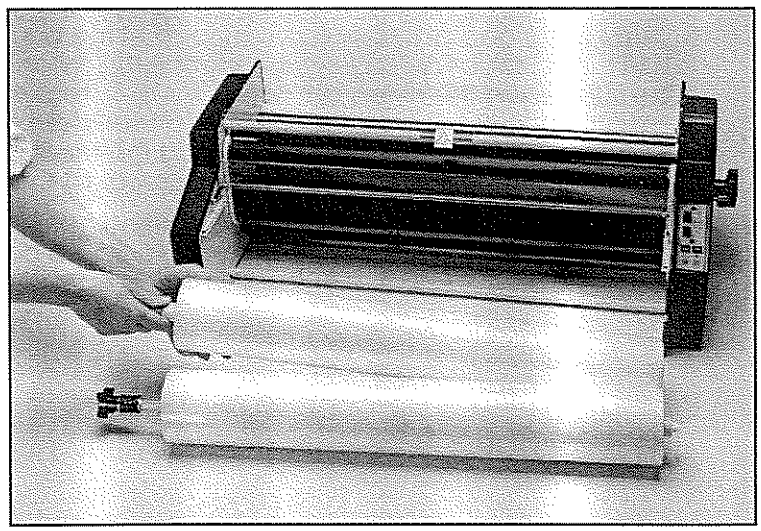
ADVERTENCIA: Antes de comenzar a operar o funcionar la maquina, este seguro de que el cordon electrico no este debajo de la misma ya que podria sobre-calentarse.

1. Remove the protective paper from the safety shield.
2. Turn the heat switch, fan switch, and the drive switch to the Off position.
3. Connect the machine to a power source. Make sure you have a working outlet of at least 15 amps so you can get adequate power.
4. Turn the heat switch to the ON position. The heat indicating light should go on, indicating power to the heat shoes.
5. Turn the fan switch to the ON position. You should hear the fans begin to operate.
6. The laminating and pull rollers are shipped in the open position. Turn the roll pressure control knob in either direction to engage (close) the rollers. Open and close the rollers several times. Notice that when the rollers are open, there is tension on the knob. When the knob turns freely, the rollers are closed. You can hear and feel them drop into the closed position. Leave the rollers open if you are not going to thread the machine now. Always ship the machine with the rollers open. Close the rollers if you are about to thread the machine.
7. Turn the drive switch to the FORWARD position. The pull rollers and the laminating rollers should rotate, causing the white threading card (packed between the rollers) to pass through the laminating and pull rollers. Let the threading card clear the laminator.
8. Turn the drive switch to the OFF position.
9. Turn the heat switch to the OFF position.
10. Turn the fan switch to the OFF position.

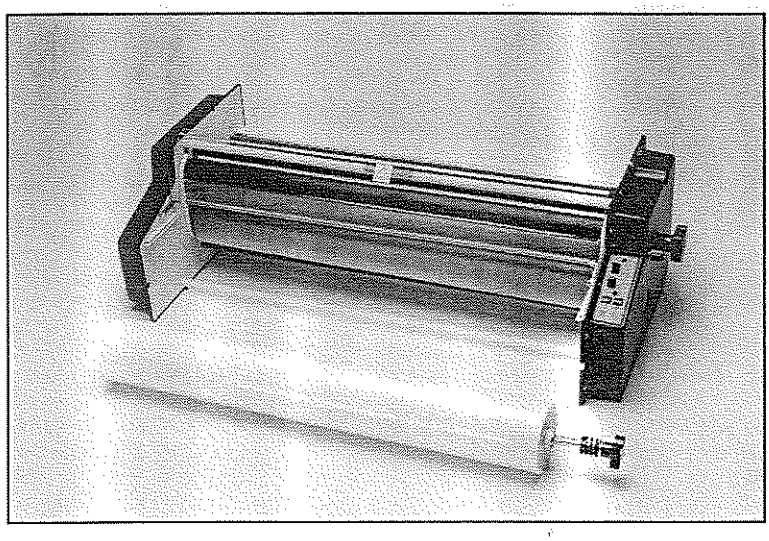
5-2 Threading the Laminator

1. For convenience and safety, we suggest threading the laminator while it is cold. Remove the supply roll mandrels and feed tray. The supply roll mandrels are now ready to accept loading of film rolls, wound with the polyester (shiny) side out. When viewed from the front of the machine, the core grippers on both top and bottom supply roll mandrels must point toward the heat shoes. The tension control knobs should be positioned on the right. Notice the knobs are labeled "Top Right" and "Bottom Right." If you have rolls of film on which the material is wound in the opposite direction (adhesive or dull side out) exchange the top and bottom supply roll mandrels so the core gripper positions are reversed.

2. Slide a roll of film onto the bottom supply roll mandrel, turning the roll slightly to slide the gripper inside the core. Center the roll. Make sure the dull side of the film is facing up and the shiny side is facing the heat shoes during the threading. Scored marks on the supply roll mandrels provide a guide for proper alignment. *NOTE*: The pointed metal piece protruding from the center of the supply roll mandrels grips the cardboard core of the film supply roll to prevent slippage. When placing a roll of film on the mandrel, twist the film supply roll in the direction away from the point on the gripper, or the gripper may break or become dislodged from its mounting.



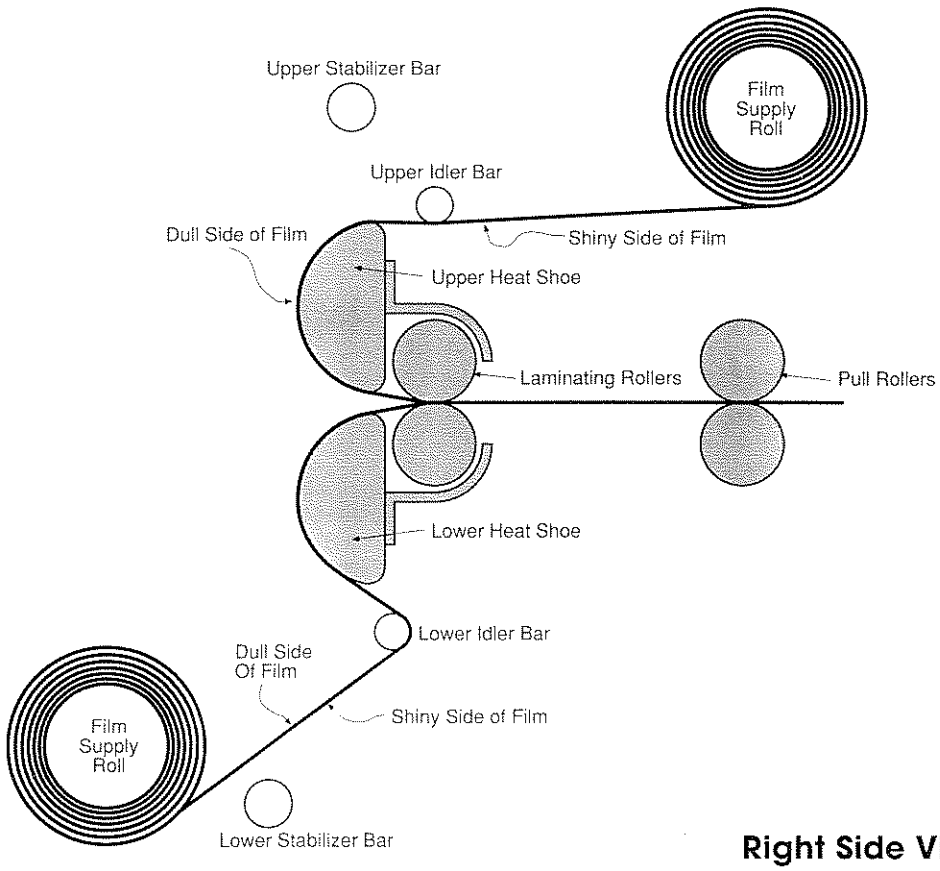
3. Review the threading diagram. With the bottom roll of film centered on the mandrel and the shiny side facing down, run the film over the bottom stabilizer bar (painted white) under the idler bar (right below the bottom heat shoe) and up and across the heat shoe.



4. With the roll aligned with the scored line on the right side of the mandrel, place it in the bottom bracket. Place the left side of the shaft first, then position the mandrel in the right side by turning the tension knob to the proper setting. FOLLOW THE RECOMMENDED LOADING PROCEDURES CAREFULLY WHEN THREADING FILM IN THE LAMINATOR. ACCURATE ALIGNMENT OF ROLLS WILL MINIMIZE WASTE.

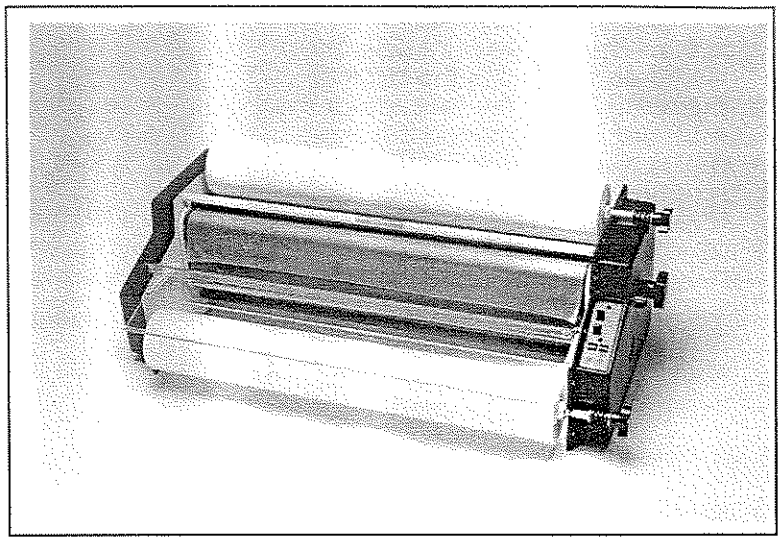
5. Load and thread the top roll of film in the same manner as the bottom roll. Refer to the threading diagram. The film should go under the idler bar and drape across the top heat shoe. Remember, the shiny side of the film must always go against the shoe. The dull (adhesive) side must face away from the shoe. The dull sides of each of the two webs of film must come together at the laminating rollers. The web of film from the top roll must never go over the upper stabilizer bar, which is directly over the top heat shoe. The stablizier bar is painted white or off-white.

5-3 Film Threading Diagram

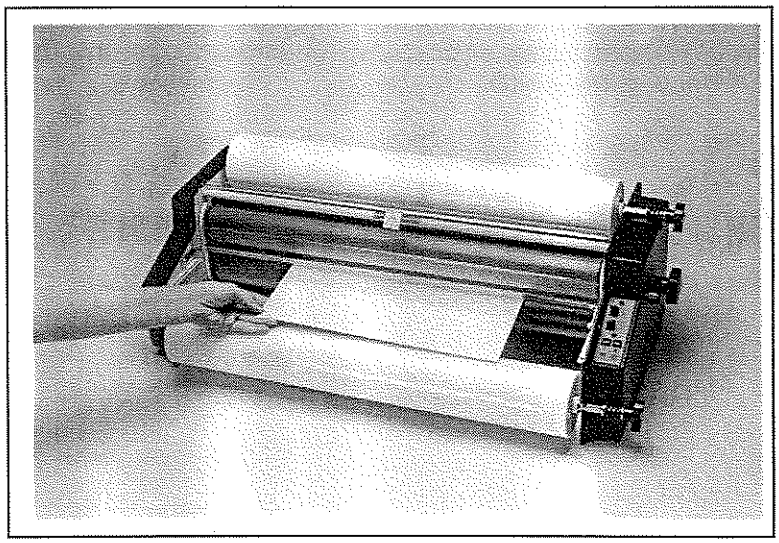


Right Side View

6. With both rolls threaded and installed in their respective brackets, unwind enough film from the top roll to reach the bottom of the bottom heat shoe. Next, unwind enough film from the bottom roll to reach the top of the top heat shoe.



7. Tip the safety shield up into the laminating position. With the film draped over the two heat shoes, push one edge of the threading card between the heat shoes so that the film is firmly positioned against the laminating rollers. Make sure the rubber rollers are in the closed position. If a threading card is not available, any piece of card stock or poster board will work.



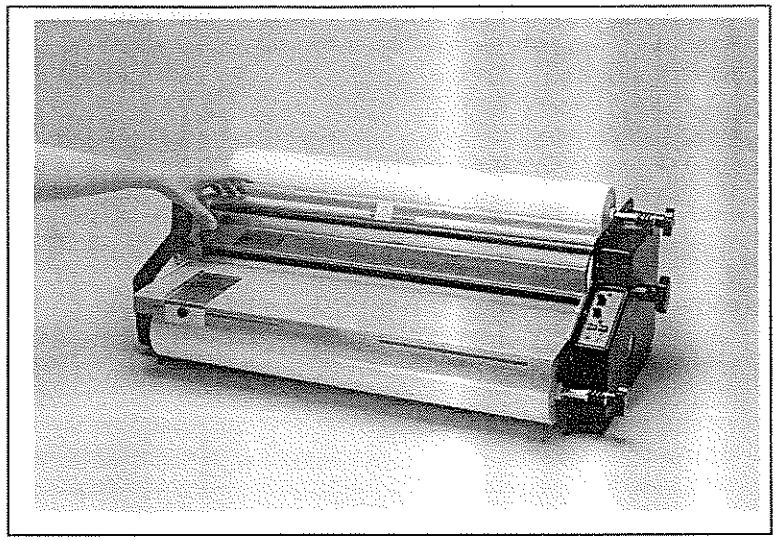
8. Allowing plenty of slack in the film supply rolls, turn the drive switch to FORWARD, permitting the film and feed board to pass through both sets of rubber rollers. When the threading card has cleared the back of the machine, turn the drive switch to the center position (off). Whenever you want to remove the film and/or laminated material from the back of the machine, lift the film up and pull it sharply and evenly against the cutter bar to remove it.

CAUTION: The edge of the cutter bar is extremely sharp!

AVERTISSEMENT: La bande coupante transversale est extremement affilee!

ADVERTENCIA: La cortadora esta extremadamente afilada!

9. Slide the feed tray into position in the front of the laminator.

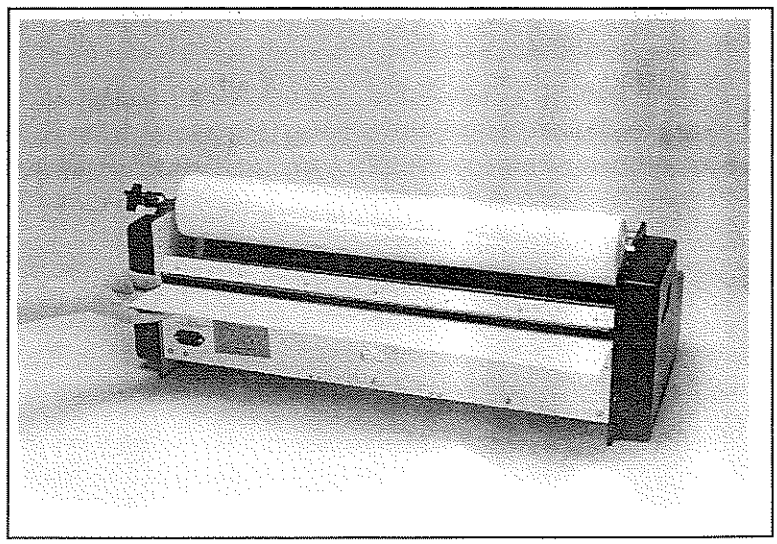


CAUTION: The laminator is designed to to be run with the operator directly facing the control panel and feed tray, not at an angle or from the side of the machine. For operator safety, the safety shield must be in position over the upper heat shoe when the machine is ON, or when the drive switch is in the forward position.

AVERTISSEMENT: Le laminoir est concu pour que l'operateur soit place directement en face du panneau de controle et du plateau d'alimentation. Pour la securite de l'operateur, l'ecran protecteur doit etre a sa position designee lorsque la temperature des sabots chauffants excede la temperature normale de la piece ou lorsque le commutateur est en position marche "AVANT."

ADVERTENCIA: Esta laminadora fue disenada para que el operador u operadora de la misma trabaje frente al panel de controles y a la plataforma por donde se insertan los articulos que van a ser laminados, y no en angulo o de lado. Para mas seguridad el protector debe de estar siempre colocado sobre los rodillos posteriores cuando el "SWITCH" de la maquina esta en posicion "ON" o el "DRIVE SWITCH" (switch que impulsa la maquina) en posicion "FORWARD."

10. Install the exit table by loosening the black knobs protruding from the back of the machine sufficiently to allow the exit table to slide down into position. Tighten the knobs to secure the table.



5-4 LAMINATING

1. Open the pull rollers.

   To open the pull rollers turn the roll pressure control knob counter-clockwise. It's the big knob on the right side of the machine (as you face the feed tray). Remember, the rollers are open when you feel tension on that knob. Open and close the rollers several times to get used to the feel of the mechanism. While the rollers are in the open position they will not pull film through the laminator.

2. With the pull rollers open, turn the drive switch to "Forward". This allows the laminating rollers to turn and get evenly heated while the machine is warming up. Evenly heated rollers contribute to the quality of the lamination.

3. Turn the heat switch to ON. The laminator will be ready to operate in about 10 minutes.

WARNING: Never permit the temperature to exceed 310 degrees Fahrenheit while film is threaded and the laminator is not running. The film could disintegrate and require cleaning and rethreading of the machine. When it is necessary to laminate at temperatures in excess of 310 degrees - such as for poster board - pull some excess film off the film supply rolls to provide slack so the film is not tight against the heat shoes while the machine is heating. This will keep the film from melting when the laminator is not advancing film.

AVERTISSEMENT: La temperature ne devrait jamais exceder 310 degres F. lorsque le plastique est enfile et que le laminoir n'est pas en marche. Le plastique peut se desintegrer et le laminoir devre etre nettoye et le film reenfile a nouveau. Lorsqu'il est necessaire de laminer a des temperatures excedant 310 degres (160 degres Celsius), comme les cartonsaffiches, pendant que le laminoir chauffe, tirez un excedant de plastique du distributeur du roule au afin de relacher la pression contre les sabots chauffants. Ceci devra emprecher le plastique de fondre lorsque le laminoir n'est pas en marche.

ADVERTENCIA: La temperatura nunca debe exceder los 160 grados Celsius cuando el plastico esta colocado en la laminadora y esta no este functionado ya que el plastico se puede derretir o desintegrar en los rodillos debido al calor, lo cual requeriria limpiar la maquina antes de volver a colocar los rolles nuevamente en posicion de trabajo. Cuando sea necesario laminar articulos excediendo los 160 grados Celsius, como cartulinas o carton ("POSTER BOARD") hale el plastico ligeramente de manera que no quede tenso y muy adherido o pegado a los rodillos mientras que la maquina este tomando el calor necesario, esto evitara que el plastico se derrita mientras que la laminadora noeste funcionando y los rollos sin avanzar.

When the heat indicating light is on, it means the thermostat is calling for more heat to maintain the laminating temperature. During normal operation, the light will go on and off periodically. After initial warm-up (but not before), there is enough heat for laminating to continue normally even if the light is on. The heat drop during lamination is too slight to affect operation.

4. Position the feed guide for the work to be performed. Adjust by loosening the black knob, sliding the guide to the desired position, and tightening the knob.

5. Check the tension on the film supply rolls to see if the top roll and the bottom roll have approximately the same tension. This may be done by gently rotating the rolls back and forth. If a roll moves too freely it is too loose. If a roll is difficult to move the tension will need to be decreased.

   Turn the tension control knobs counter-clockwise to decrease tension. These knobs are located on the right ends of the supply roll mandrels. Turn the tension control knobs clockwise to increase tension.

6. Once the machine has come up to temperature, as indicated by the heat indicating light going out for the first time, you are ready to laminate. Check the thermometer to make sure the machine is at the right temperature for the film you're using. With the heat switch ON, the motor in FORWARD, the Rollers CLOSED, and the safety shield UP, slide items over the feed tray, positioning them against the guide and into the laminating rollers.

   Once you start the film, watch the film as it passes over the heat shoes to let the wrinkling disappear before inserting material to be laminated. Each time you stop the film, slack will form in the web of film. It will take a few inches of film to get the slack and the resulting wrinkles past the shoes.

7. Examine the film as it exits the machine.

   If bubbles or wrinkles appear in the film, this may mean there is not enough tension to draw the film tightly and smoothly over the heat shoes. Turn the tension control knobs clockwise to increase the tension. If the film is tight and smooth as it goes over the heat shoes but then draws in towards the center of the machine or squeals, there may be too much tension on the supply roll mandrels. This can be corrected by turning the tension control knobs counter-clockwise to decrease the tension.

   The appearance of the film traveling over the shoes is a good indicator of correct tension. When the tension is ideal, both shoes will show some film wrinkling, sometimes called "waterfalling," on the top of the top shoe and the bottom of the bottom shoe. This "waterfalling" effect indicates that there is not too much tension. The best amount of supply roll tension is the least amount that will do the job. If the waterfalling has disappeared before the film goes into the laminating rollers, or nip, there is enough tension. On the other hand, if there is no waterfalling at all, there may be too much tension.

   The most frequently used film, 1.5 mils thick, requires very little tension. REMEMBER THAT IT IS IMPORTANT TO TURN BOTH THE TOP AND BOTTOM TENSION CONTROL KNOBS THE SAME AMOUNT TO KEEP THE RESISTANCE TO TURNING THE SAME ON TOP AND BOTTOM ROLLS. If the film curls up after it leaves the machine, loosen the top supply roll mandrel (turn counter-clockwise) and tighten the bottom supply roll mandrel (turn clockwise).

   If the film curls down after it leaves the machine, tighten the top supply roll mandrel (turn clockwise) and loosen the bottom supply roll mandrel (turn counter-clockwise). If the tension appears balanced, but you notice waves or ripples in the film as it comes out the back, the temperature may be too high or you may need to run the fans. These waves in the film are called "heat wrinkles." These heat wrinkles are formed when the film has not cooled enough before coming out the back of the machine. For the best results, the film should be cooled below melt temperature while it is pulled tight and perfectly flat between the laminating rollers and the pull rollers. If it gets out the back of the machine while still at or above melt temperature, heat wrinkles can form. The major reason for fans on most laminators is to cool the film, not to cool the machine.

5-5 RECOMMENDED TEMPERATURE SETTINGS

Your laminator is set at approximately 310 degrees Fahrenheit at the factory. This is the recommended temperature setting for 1.5 mil film. If you are laminating with a different thickness of film, refer to the following table for recommended temperature settings.

REMEMBER THAT YOU CANNOT LAMINATE FAX PAPER BECAUSE IT IS ACTIVATED BY HEAT AND WILL TURN BLACK. ALSO, REMOVE PAPER CLIPS AND STAPLES BECAUSE THEY CAN DAMAGE THE RUBBER ROLLERS. BE CAREFUL ABOUT LAMINATING ANYTHING THAT WILL BE AFFECTED BY HEAT. FOR EXAMPLE, CRAYON DRAWING COLORS MAY RUN TOGETHER OR BE SMEARED, ESPECIALLY IF THE CRAYON LAYER IS HEAVY. LIGHT CRAYON DRAWINGS MAY NOT BE AFFECTED, BUT TEST AN EXPENDABLE SAMPLE OF ANY ITEM THAT MAY NOT LAMINATE WELL.

DON'T LAMINATE ONE-OF-A-KIND DOCUMENTS BECAUSE LAMINATION CAN OCCASIONALY RUIN AN ITEM.

DON'T LAMINATE VALUABLE ITEMS SUCH AS STAMPS, BASEBALL CARDS, AUTOGRAPHS, OR OTHER COLLECTIBLES BECAUSE THE VALUE OF SUCH ITEMS CAN BE DESTROYED BY LAMINATION. COLLECTORS GENERALLY VALUE THESE KINDS OF ITEMS ONLY IN THEIR ORIGINAL STATE.

Film	Thickness	Temperature Setting	Fan Switch Position
1.5 mil	.0015 inch	300 to 315 degree range	OPTIONAL
3 mil	.003 inch	275 to 300 degree range	ON
"1-4" 5 mil	.005 inch	275 to 300 degree range	ON
"3-2" 5 mil	.005 inch	250 to 275 degree range	ON
1.5 mil on heavy poster or thicker paper	.0015 inch	320 to 350 degree range	OPTIONAL
3 or 5 mil (low-melt)	see above	240 to 260 degree range	ON

Note: It is quite possible that higher or lower variances from recommended temperature settings may be necessary due to subject construction, ambient temperatures, humidity or quality of laminating material.

To adjust the temperature, the laminator must be ON and the heat indicating light OUT. Move the temperature control knob counter-clockwise to increase and clockwise to decrease the temperature. One-quarter turn of the knob changes the temperature approximately 20 degrees. After adjusting the knob, the heat indicating light will come on; wait for it to go out before increasing the temperature any further.

Do not turn more than one revolution to the left until the heat indicator light has gone out. More than three revolutions of the temperature control knob to the left will disengage it.

Temperature may exceed 310 degrees when laminating poster board, etc. on a continuous basis, but when the machine is stopped, turn the heat off if the setting is in excess of 310 degrees. Never increase the heat beyond 350 degrees with film in the laminator.

Temperatures over 300 degrees are not needed except with 1.5 mil film. Film of 3 mils or more is generally run at 280 degrees or less.

Cooling Fans

The cooling fans on the Premier III are used during lamination with 3 mil or 5 mil plastic. The fans cool the plastic as it leaves the laminating rollers and before it enters the pull rollers. As mentioned earlier, the fans prevent heat wrinkling and help insure lamination that is smooth and flat.

5-6 SIMULTANEOUS LAMINATING AND DRY MOUNTING

Items may be simultaneously laminated and dry mounted using dry mount tissue. This is a tissue made of a heat-sensitive adhesive. This tissue may be purchased from laminating film suppliers and art or photo supply vendors.

1. With the heat switch on and the fan off, open the rubber rollers by turning the roll pressure control knob. Turn the drive switch to "Forward" to allow the rubber rollers to heat evenly.

2. Completely cover the back of the item to be mounted with a sheet of mounting tissue. There should be some excess.
3. To keep the tissue from slipping, tack it in place at the top edge with a glue stick. Trim the tissue to the size of the item.
4. Using the glue stick, tack the item to the mounting board, FACE SIDE UP.
5. Close the rubber rollers to allow the film to pass through the laminator. Allow the wrinkles from slack in the film to disappear.
6. Insert the mounting board into the laminator, placing the tacked edge into the rubber rollers first. If the mounting material is fairly thick, it may be necessary to adjust the heat to 350 degrees to ensure a good bond of the subject to the mounting material. When the item is fed into the rubber rollers, lamination is achieved at the same time the adhesive on the dry mount tissue is activated by the heat from the film and the laminating rollers.
7. Use of 3 mil or thicker film will give the best results, because thicker films will transfer more heat to the dry mount tissue. Some applications may require the use of a variable speed machine at lower speed to give the material longer exposure to the heat.

5-7 PREPARING TRANSPARENCY LIFTS

You can make full color or black and white transparencies with your laminator, using ordinary laminating film. Under heat and pressure, the adhesive captures much of the ink on clay-coated papers. This includes most glossy magazines or glossy printing on clay-coated stock. This is an extremely inexpensive and quick way to make long-lasting transparencies for overhead projectors or light boxes.

The film lifts the ink only from clay-coated paper. To determine whether the page is clay-coated, moisten a finger and rub it on an unprinted section of the magazine page. If a chalky substance remains on your finger, the paper is clay-coated.

NOTE: Be very careful about thumbprints or fingerprints when handling the page. Moisture from a heavy thumbprint will remove the clay coating and the area may show up blank or smudged.
It is necessary to produce two transparency lifts at a time. If you only have one picture you wish to prepare, use a scrap picture on the back side.

Using 3 mil or 5 mil film will produce a more rigid transparency with less tendency to curl. In any case, mounting the transparency in a cardboard mounting frame will make it easier to handle.

Materials:

Scissors; Warm, soapy water; Paper towel; Sponge or soft clean cloth; Glue stick

Procedure

1. With the heat switch ON, the fan switch Off and the rubber rollers in the opened position, turn the drive switch to the FORWARD position. This allows the rubber rollers to turn and heat evenly.
2. The proper heat setting is 310 degrees.
3. Place two pictures back to back, with the surfaces you want to lift on the outside. Leave a border on all four sides in excess of the image you want to project on the transparency.
4. Use a glue stick to lightly tack the top edges of the two pictures together to prevent them from slipping apart when they pass through the laminator.
5. Laminate the two back-to-back pictures.
6. Cut into the edges of the laminated pictures on all four sides just enough to permit the pictures to separate.
7. Place the pictures in a pan of lukewarm water to which you have added a liquid dishwashing detergent. Let the work soak for a few minutes to loosen the film from the page.
8. Peel the paper, which is now blank, from the plastic. The image is now embedded in the adhesive side of the plastic. In most cases the paper will simply fall away. If the page does not separate easily, rub the paper off gently with your fingers under the water.
9. Remove the excess clay residue from the transparency by wiping the plastic gently with a wet sponge or soft cloth. Always rub in one direction and hold one end while rubbing, or the film will wrinkle. Blot with a paper towel and allow to dry completely.
10. Place in a cardboard frame or laminate the transparency to give it added rigidity.

5-9 PREVENTING AND SOLVING PROBLEMS

Please read this section BEFORE you have a problem.

PROBLEM: Wrinkling of the material as it goes into the laminating rollers.

SOLUTION: It is always desirable and sometimes essential to smooth out the item as it passes over the feed table and through the rolls to ensure an even lamination without wrinkles. Smooth from the center of the item, back toward the tailing edges. When there is no longer sufficient surface to permit smoothing action, apply light pressure to the tailing edges with the index fingers in a back- and away direction.

If material has been rolled up, take the curl out of it on a table edge before laminating. If some curl remains, it may be helpful to insert the item with the curl down so the leading edge is pressed against the feed tray until just before the nip.

PROBLEM: Wrinkling of the film around the material being laminated.

SOLUTION: This is normal and inevitable on any laminator, especially with thicker material. These wrinkles will be trimmed away with the scrap, so they do not affect appearance. Because the rollers are being held apart by the paper or cardboard, they cannot pull equally on the plastic around the paper. This creates wrinkles that tend to look like the waves of a boat, radiating out through the clear part of the web from the sheet of material.

PROBLEM: When two pieces of material are laminated side by side, the plastic wrinkles, or adheres to one piece but not the other.

SOLUTION: To get maximum efficiency from the film rolls, you can feed several items into the laminator side by side. However, severe wrinkling can occur if these items are of unequal thickness, because the laminating roller are lifted off the thinner items by the thicker items. When laminating items side by side, it is important to arrange them so that thicknesses are the same.

PROBLEM: Wrinkling of the plastic on a laminated piece of material.

SOLUTIONS: Make sure you have enough supply roll tension to take the wrinkles out of the film before it gets past the heat shoes. (See Laminating, section 5-4)

Make sure the film is threaded properly (see Threading the Laminator, section 5-2). The most frequent operator error is threading the film under the bottom stabilizer bar.

PROBLEM: Wrinkling occurs in the film over the laminated item, AND the rolls of film move from side to side on the supply roll mandrels.

SOLUTION: Check the labels on the supply roll mandrel tension knobs. You'll probably find that the mandrels are reversed. Take the rolls of film off and switch the mandrels.

When the supply roll mandrels are reversed the core grippers point in the wrong direction to hold the rolls of film . Because the cardboard cores are turning on the mandrels, there is no supply roll tension control and the rolls of film are able to slide from side to side on the mandrel.

PROBLEM: Film gets wrapped around the pull rollers.

SOLUTION: While threading the film, the loose ends of the unlaminated web are particularly susceptible to "wrap-around". To minimize this, pull the threading card after it emerges from the pull rollers until the film clears the exit table. Then cut off the excess film flush with the pull rollers prior to laminating. Use caution when first starting to laminate, being careful that the thin, unlaminated web does not get caught in pull rollers or laminating rollers.

If "wrap-around" does occur while the laminator is cold, you can easily correct it by reversing the direction of the rubber rolls, permitting the laminator to release the film from the rolls.

PROBLEM: Film gets wrapped around the laminating rollers while the machine is hot.

SOLUTION: Leaving the heat on so that the adhesive does not harden, follow the following steps.

WARNING: Be very careful not to touch the heat shoes when the machine is hot.

ATTENTION: Ne jamais toucher aux sabots-chuaffants lorsque le laminoir est chaud.
Nunca! Toque el area de calor cuando este la maquina caliente.

1. Remove the safety shield and feed tray.
2. Cut the film on the top and bottom, just in front of the idler bars.
3. Loosen the film from the heat shoes and grip the two loose ends, holding them together.
4. Turn the drive switch to the REVERSE position.
5. Briefly press the reverse drive switch and allow the laminator to back out the film that is wrapped around the rolls. Assist the operation by pulling lightly on the loose ends of the film.

WARNING: Continuing to press the reverse drive switch may cause reverse wrap-around. Press briefly, then release the switch and check the results. Press the switch again if additional backing is needed.

WARNING: Do not try to cut the plastic off the roller with a knife or other sharp instrument. You will end up cutting the rubber rollers and turn an inconvenience into a major repair bill not covered by warranty.

PROBLEM: Unequal amounts of film left on either top or bottom supply roll.

WARNING: If the film is run through the laminator without being matched to an opposing film, the adhesive exposed to the rubber rollers will stick to the laminating rollers and create a world-class wrap- around. This type of wrap-around is difficult to clear because the film adheres to the roller and to itself for the entire length of the accumulated film on the roller. It's best to clear this right away, before the adhesive hardens. Follow the steps above to clear.

SOLUTION: To avoid this problem, stop the laminator before either roll runs out, cut the webs of film, and remove the two near-empty rolls of film. Let the machine cool and then re-thread.

Experienced users may leave the pieces of film remaining over the shoes and in the rollers to help thread the new film. When the machine is warm, the ends of the new rolls can be easily tacked to the already threaded pieces because the adhesive layer facing outwards will be sticky. Be careful not to burn yourself on the heat shoes.

PROBLEM: Film is not properly adhered or starts to come off sometime after lamination.

SOLUTION: Unless there is something wrong with the film, this problem comes from film being run at too low a temperature. Check the heat setting on the laminator. (See Recommended Temperature Settings, section 5-5). If the film is not sticking to the item, it is likely that more heat is required.

If you are using a variable speed machine with 1.5 mil film, this problem can occur if you are running the machine too slowly. Because 1.5 mil film is thin and therefore loses heat easily, it can cool off too much between the heat shoes and the roller nip if it is run too slowly.

If you are running a variable speed machine with 5 mil film, you may have the problem if you try to go too fast. In this case, the thicker film may not have enough time on the heat shoes at high speed to reach its adhesive melt temperature. Thicker films may be run at low speeds with no problem.

When laminating poster board or other thick material with thinner film such as 1.5 mil, the paper itself can absorb enough of the heat from the film to drop the adhesive below melt temperature. The film may start to come off immediately or it may start to fall off after a few days. The solution here is to run the work at a higher temperature. About 350 degrees will usually do the job.

Sometimes you may see film detach from an item along one edge (the edge that was put in first). This happens when the material is put all the way into the nip before the machine is started. The area of film between the shoes and the nip can cool off too much while the machine is idle. The adhesive may not be hot enough to stick.

The way to prevent this is to let a few inches of film go though before putting in sheets to be laminated. This serves other purposes, besides ensuring the front edge of the piece will be properly sealed. It gives the machine a chance to take up the slack that develops in the film whenever the machine is stopped, and it prevents the following problem as well:

PROBLEM: A laminated item comes out with a large "oily" spot on or near the leading edge.

SOLUTION: It's not oil that causes this effect, but excess adhesive. When a machine is left heated but

idle for a few minutes or longer, the adhesive from the film over the shoes can form droplets that tend to accumulate near the center of the web. When the drive motor is started and a sheet of material is put in immediately, this excess adhesive saturates an area of paper, creating what looks like an oily spot. The solution, as mentioned above, is just to let a few inches of film go through before feeding in your work.

Anytime you are laminating unfamiliar or costly items, it is a good idea to start with an expendable sample or test piece. Laminating a test piece first gives you an indication of the results you'll get and also takes care of any pooled adhesive.

PROBLEM: A milky, hazy line about an inch wide appears periodically across the width of the web immediately after initial warm-up or after the machine has been sitting idle for a while.

SOLUTION: See LAMINATING, section 5-4, steps 1 & 2).

PROBLEM: The machine produces a continuous squealing noise when laminating.

SOLUTION: To a certain extent, it is normal for laminating film to squeal as it is pulled over the heat shoes under tension. This noise is produced via the same principles that make a violin squeal. Some of the compounds put on film to keep it from sticking to itself seem to act like rosin on the bow of the violin — they enhance the noise.

To minimize squealing, run the laminator with the least amount of supply roll tension that will do the job of removing wrinkles from the web of film. Make sure you are not using a higher temperature than needed. Also clean the heat shoes periodically (see section 7-2). If the noise gets really objectionable, use a different type or different brand of film.

PROBLEM: The laminated material seems to have a pitted surface or irregular surface that does not match the trexture of the paper being coated.

SOLUTION: This is usually caused by adhesive build-up on the rubber rollers, but may be caused by any matter stuck to the rollers, such a a piece of paper. Inspect the rubber rollers and if they need cleaning refer to section 7-3.

Irregularities in the surface of the film can also be caused by cuts or other damage to the rubber rollers, especially the laminating rollers. On some models, the pull rollers are identical to the laminating rollers and could be substituted if still in good condition.

PROBLEM: The film shrinks as it passes over the heat shoe (known as "necking" in the laminating trade).

SOLUTION: Reduce the heat and/or the supply roll tension. The film is not shrinking so much as it is being stretched by excess heat and tension, causing the web to get narrower as it is pulled over the shoes.

PROBLEM: No power is getting to the laminator.

SOLUTION: Make sure there is power at the electrical outlet being used, and make sure both ends of the power cord are firmly engaged. There are fuses inside the laminator, but dead outlets and loose power cord connections are the most common causes of this problem.

PROBLEM: Wavy or rippled sections in the laminate, especially toward the center of the web.

SOLUTION: These "heat wrinkles" are caused by excess temperature and/or forgetting to turn on the cooling fans (on some models the fans go on with the heaters). See section 5-5.

PROBLEM: General haziness or cloudiness in the film after lamination.

SOLUTION: Increase the temperature. That cloudiness is a function of incomplete adhesion. On a variable speed machine loaded with thicker film, it may be that the film is being run too fast and is not getting enough time on the heat shoes.

FOR PROBLEMS NOT LISTED HERE, CONTACT YOUR LEDCO DEALER. IF THE DEALER DOESN'T KNOW THE ANSWER, PLEASE ASK THE DEALER TO CONTACT LEDCO AND GET BACK TO YOU. YOU ARE ALSO WELCOME TO CONTACT US DIRECTLY WITH ANY PROBLEM AT 716-367-2392. BECAUSE OF THE POTENTIAL VOLUME OF SUPPORT CALLS, WE DO ENCOURAGE THE USE OF THE DEALER NETWORK AS MUCH AS POSSIBLE.

6-1 INSTRUCTIONS FOR OPTIONS

6-2 VARIABLE SPEED CONTROL

The variable speed control provides a higher top speed and more versatility for laminating a wider array of film thicknesses and materials. The speed range is zero to 10 feet per minute. The machine is set at the factory to "creep" very slowly when the control is set at zero. This helps extend the life of the control.

However, do not "stop" the laminator by turning the speed control knob to zero. The best way to start and stop the laminator is by closing and opening the rollers.

Heavier gauges of film require slower speeds. For example, 1.5 mil film can usually be run at top speed, while 5 mil film may not adhere well if run faster than 5 feet per minute. Because it is thicker, it needs more "dwell time" on the heat shoes to reach the desired temperature.

6-3 FOOTAGE COUNTER

The counter measures the amount of film used for an order or during a particular period.
To measure the use of film with the footage counter:

1. Set the wheel of the counter against the roll of film.
2. Press the reset button located next to the digital readout.
3. The counter will continue to measure the number of feet of film used unless the wheel is lifted off the roll of film.

NOTE: The footage counter and slitter cannot be installed together.

6-4 SLITTER

The slitter allows you to quickly and easily cut a laminated item, or group of items which maintain a constant vertical arrangement. For example, a series of identically sized posters may be cut as they exit the machine by positioning the blades on each side of the posters.

WARNING: The blades of the slitter are very sharp. Use extreme caution when using this attachment. Always remove the blades when attaching or detaching the slitter. Always retract the blades when they are not in use or when you are adjusting their position.

Installation

1. Remove the cutting blades from the plastic blade holders. This is done to prevent accidentally slicing the rubber rollers during installation of the slitter and for operator safety.
2. Turn the heat switch and the drive switch to the OFF position.
3. Remove the top supply roll mandrel from the laminator.
4. Locate the two accessory mounting holes on the inside of each housing. These are located above the cutter bar.
5. Lower the slitter into position between the housings.
6. Fasten the slitter between the housings using the four screws provided.
7. Slide the blade holders into the desired position by loosening the black plastic knobs.
8. Replace the blades in the plastic blade holders with the knife edge facing the FRONT of the machine.
9. Follow the normal laminating procedure to laminate.

NOTE: The footage counter and slitter cannot be installed together.

7-1 MAINTENANCE

Warning: Always use extreme caution when performing maintenance on your machine.

Always make sure the machine is unplugged and that there is NO power to the machine when working on any internal machine parts.

Use extreme caution to avoid Hot Surfaces which may remain hot for a period of time even if there is NO POWER to your machine.

Use extreme caution to avoid pinch points at the nip of rubber rollers. Never have rubber rollers turning while performing maintenance to your machine.

Never wear loose clothing, ties or jewelry (which may become entangled in gears or rubber rollers) while performing maintenance on your machine.

Avertissement: La prudence est de mise lorsque vous procedez a l'entretien de cet appareil.

Assurez-vous que le cordon d'alimentation est retire de la prise electrique, surtout lorsque vous avez a verifier les pieces internes.

Evitez de toucher aux surfaces chauffantes, qui demeurent dangereuses meme apres que vous avez enleve le courant.

Ne jamais faire tourner les rouleaux de caoutchouc alors que vous travaillex sur les pieces internes.

Ne jamais porter de vetements amples, cravate, etc...qui pourraient se prendre dans les rouleaux pendant que vous travaillex a l'entretien de cet appareil.

Importante! Tome extrema precaucion cuando este haciendo el mantenimiento de limpieza, etc. A su maquina.

Este seguro de que la misma esta desconectada y que no haya pase de electricidad ninguna a su maquina mientras este trabajando en cualquier parte interna de la misma.

Evite las superficias calientes las cuales mantienen calor por un periodo extenso de tiempo aun cuando la maquina este apagada.

Evite tocar los rodillos de goma. Nunca haga trabajo de mantenimiento con los rodillos de goma en movimiento.

Nunca tenga ropa suelta, corbatas o prendas que puedan engancharse en los rodillos de la maquina.

Nunca! Toque la aria de calor cuando este la maquina caliente.

GENERAL CLEANING

If you have a dusty work environment, cleaning the laminator every week helps prevent dirt build up on the rubber rollers and heat shoes.

7-2 CLEANING THE HEAT SHOES

During average use excess adhesive from the film will often cling to the heat shoes, especially near the edges.

Heat the machine to full laminating temperature to soften the adhesive. Put on oven mitts or heavy gloves to protect your hands. Using a clean, soft, dry cloth, gently rub the adhesive or other contaminants off the shoes. Never use any abrasive material or rub too hard on the shoes, because you may remove the teflon coating.

You may dampen your cleaning cloth with soapy water or a mild water-based cleaning solution, but make sure you carefully insulate your hands from possible steam burns if you do this. The steam formed when water hits the hot surface can penetrate both the cleaning cloth and your gloves.

7-3 CLEANING THE RUBBER ROLLERS

Both the laminating rollers and the pull rollers need occasional cleaning. Collectively these are referred to as the rubber rollers.

To clean the laminating rollers remove the five mounting screws from the back of the heat shoes. (These screws are located beneath the upper stabilizing bar.) Remove the metal shroud that surrounds the top laminating roller. This will expose the rollers so that you may clean them more easily. Use the reverse jog switch to slightly reposition the laminating rollers so that you may clean the entire surface on each roller.

Clean the rubber rollers with a mildly abrasive cleaning pad such as a white Scotch Brite Pad which may be purchased in the household section of your grocery store (the green pads are too abrasive). Use mildly soapy water to clean the rollers. Rub firmly but do not scrub the rollers vigorously as this might mar the surface. Do not use sharp metal objects or steel wool as these might also mar the rollers.
Be sure to replace the metal heat shroud and five screws before beginning to laminate.

7-4 LUBRICATION

Rubber Roller Bearings

Under normal laminating conditions, after 40 hours of use the rubber roller bearings should be lubricated. To lubricate the bearings, remove the plastic housings on each side of the machine and apply light oil (such as 3 in 1 Oil) on the felt washers located between the gear supports on the side panel. When you use the laminator continuously at temperatures of 325 degrees or more, it is advisable to lubricate the bearings after 20 hours of use. (See Section 8 -part #33 on the Left and Right Housing diagrams.)

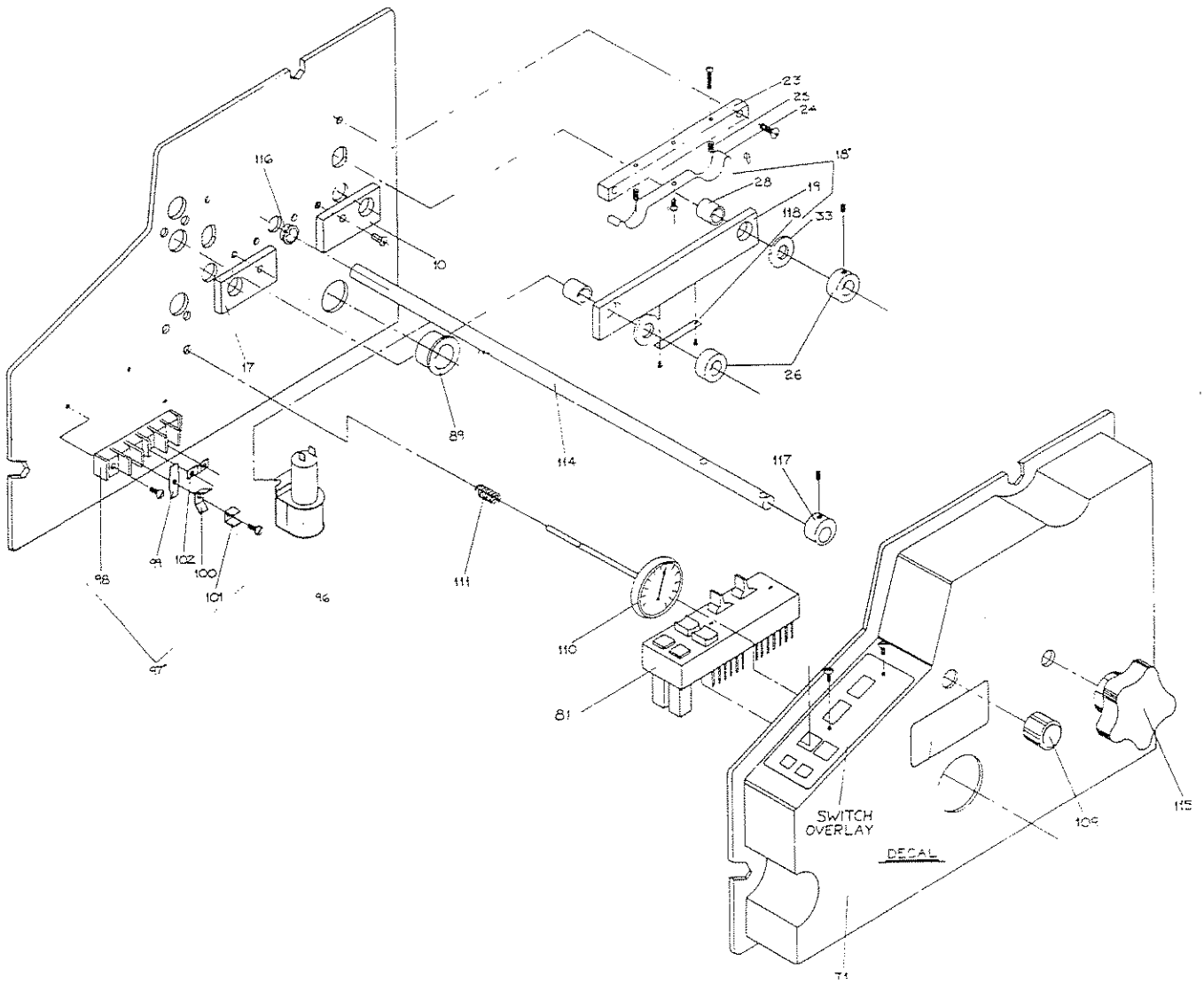
Drive Chain

Drive chain and sprockets on all models should receive a light coat of gear lube or heavy grease (lithium preferably) after each 1000 hours of operation. (See Section 8 part numbers 34 & 40 on the left and right housing diagrams.)

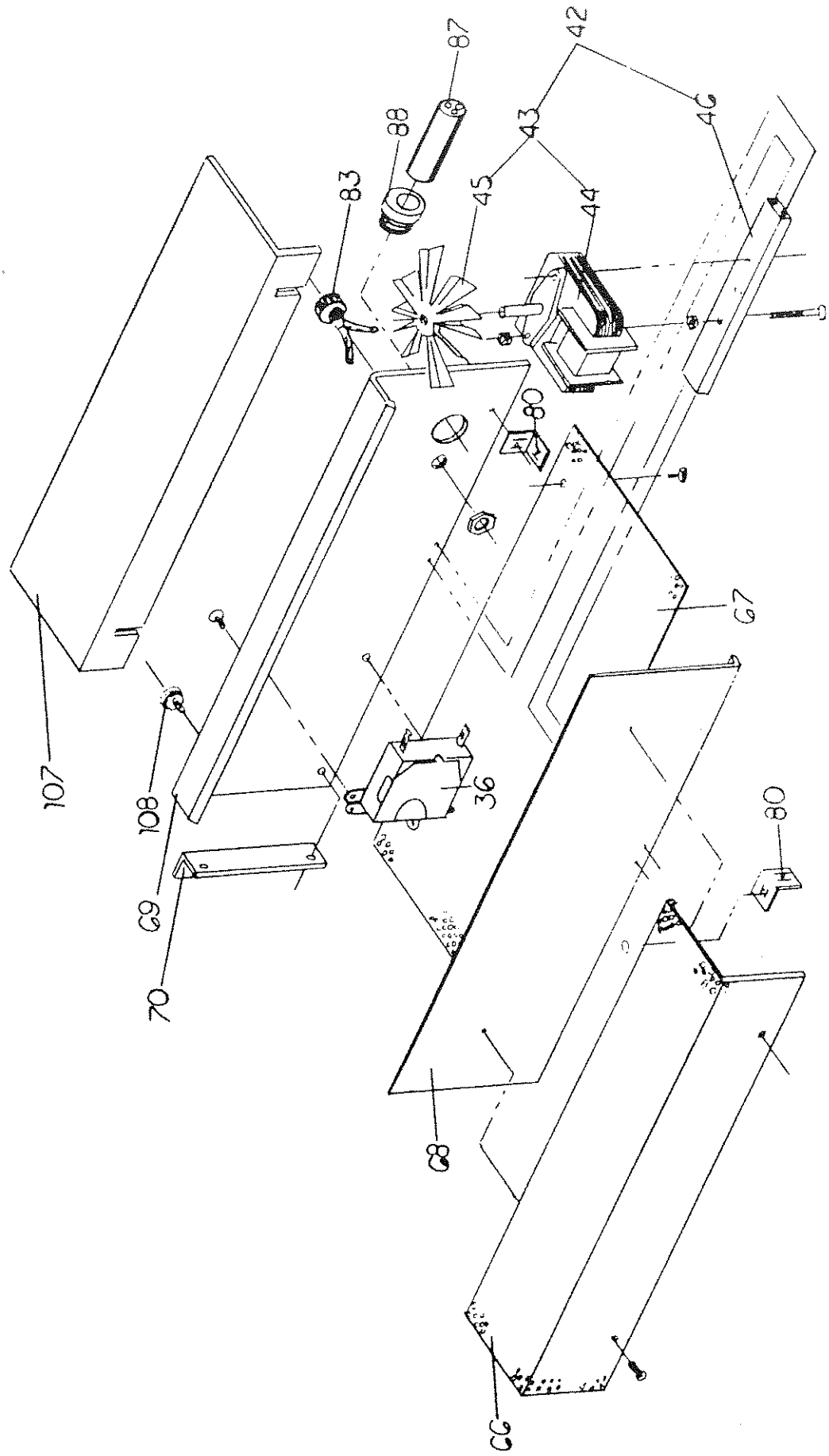
8-1 PARTS LIST AND DIAGRAMS

Diagrams on the following pages show the parts breakdown for each of the major subassemblies of the Premier III Laminator. Please use the Part Number (not the reference numbers) when ordering spare or replacement parts. Part numbers may be found on pages 34-35.

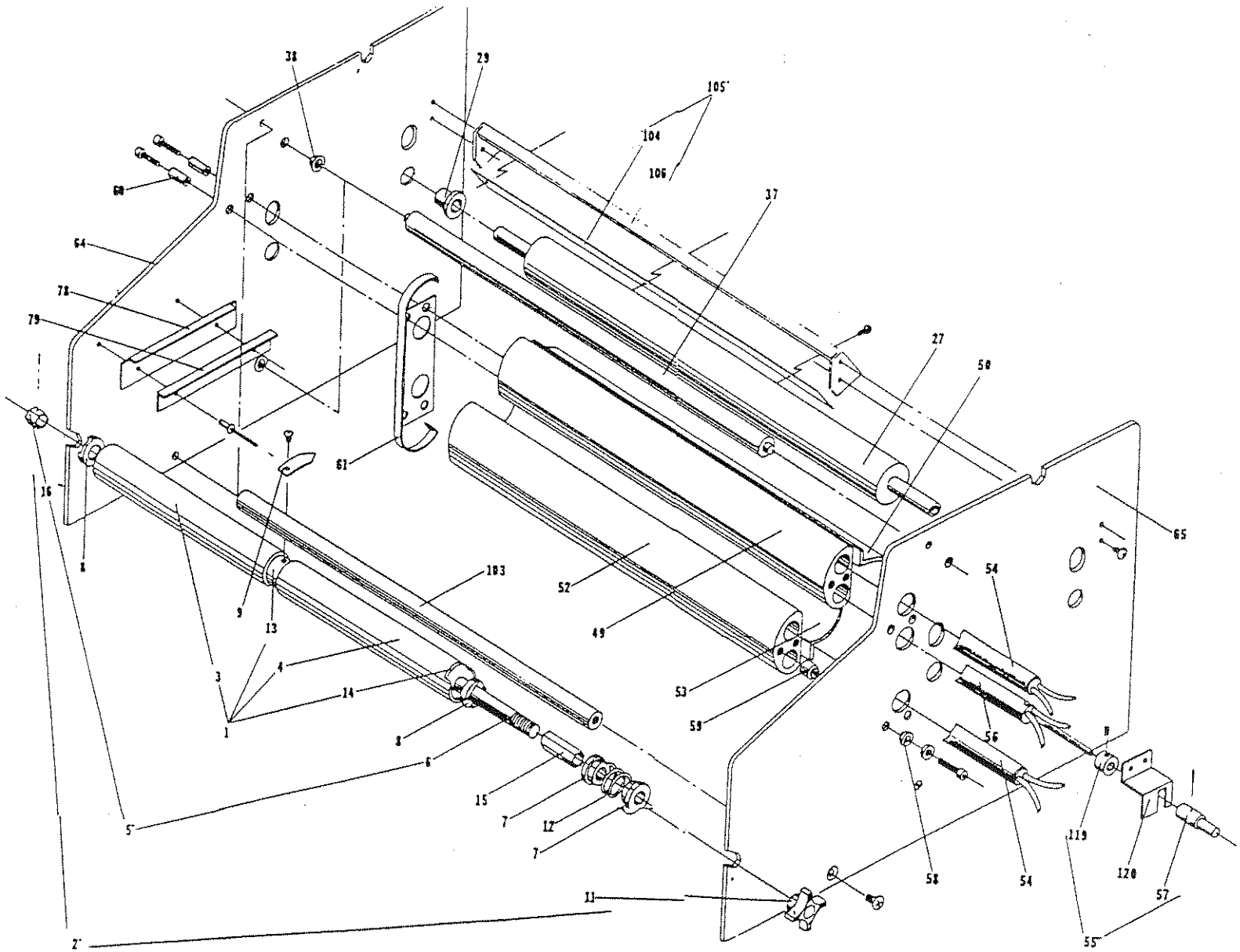
Right Housing



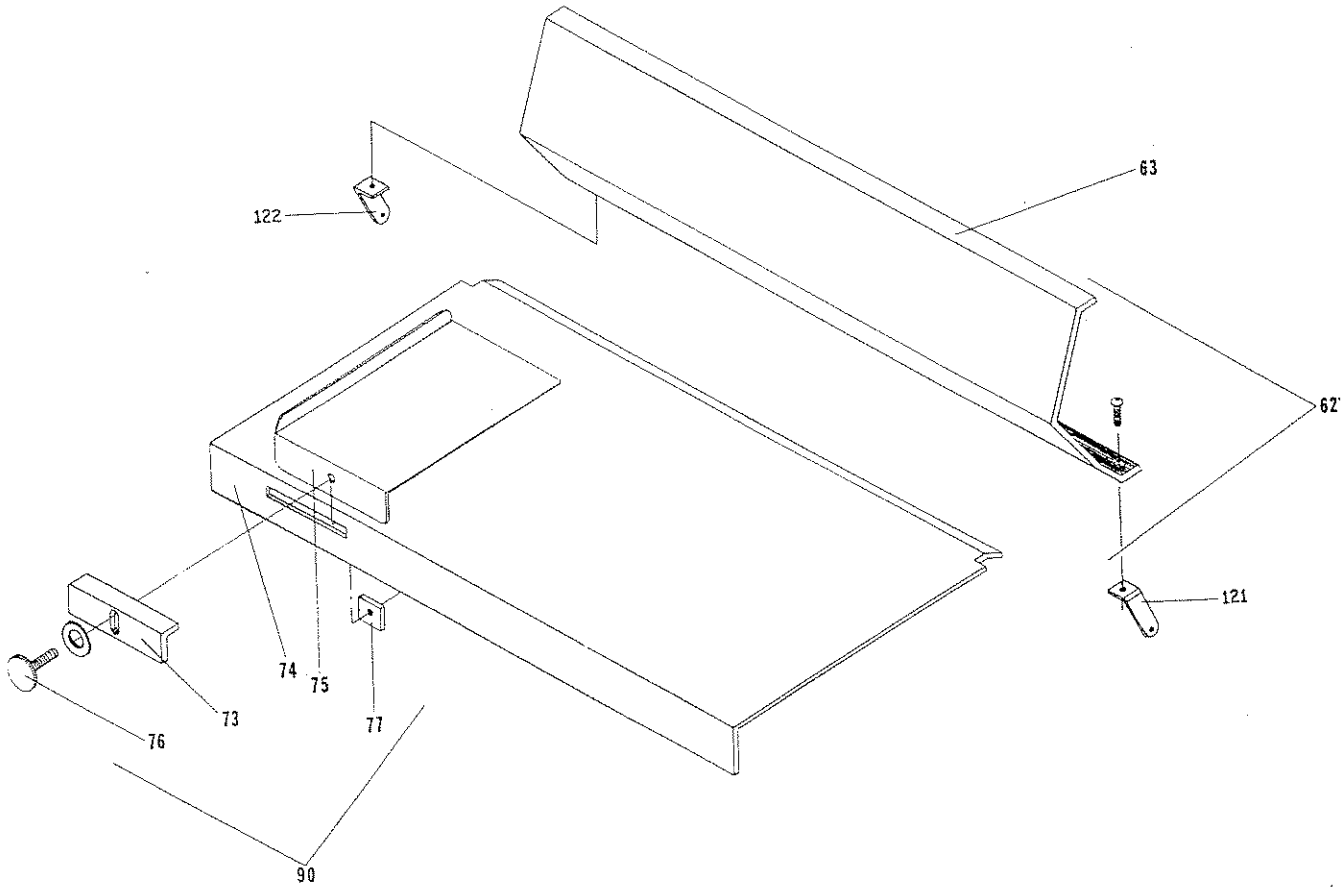
Motor Covers and Exit Tray



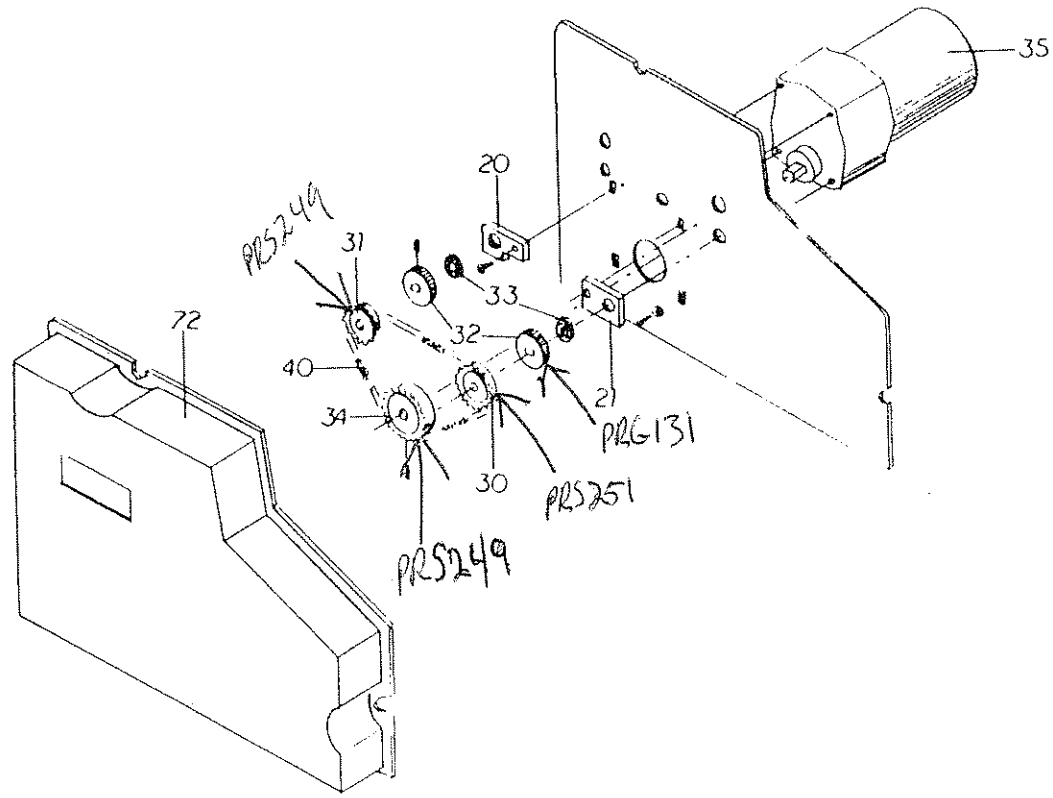
Supply Roll Mandrel, Heat Shoe, Rubber Roll Assembly



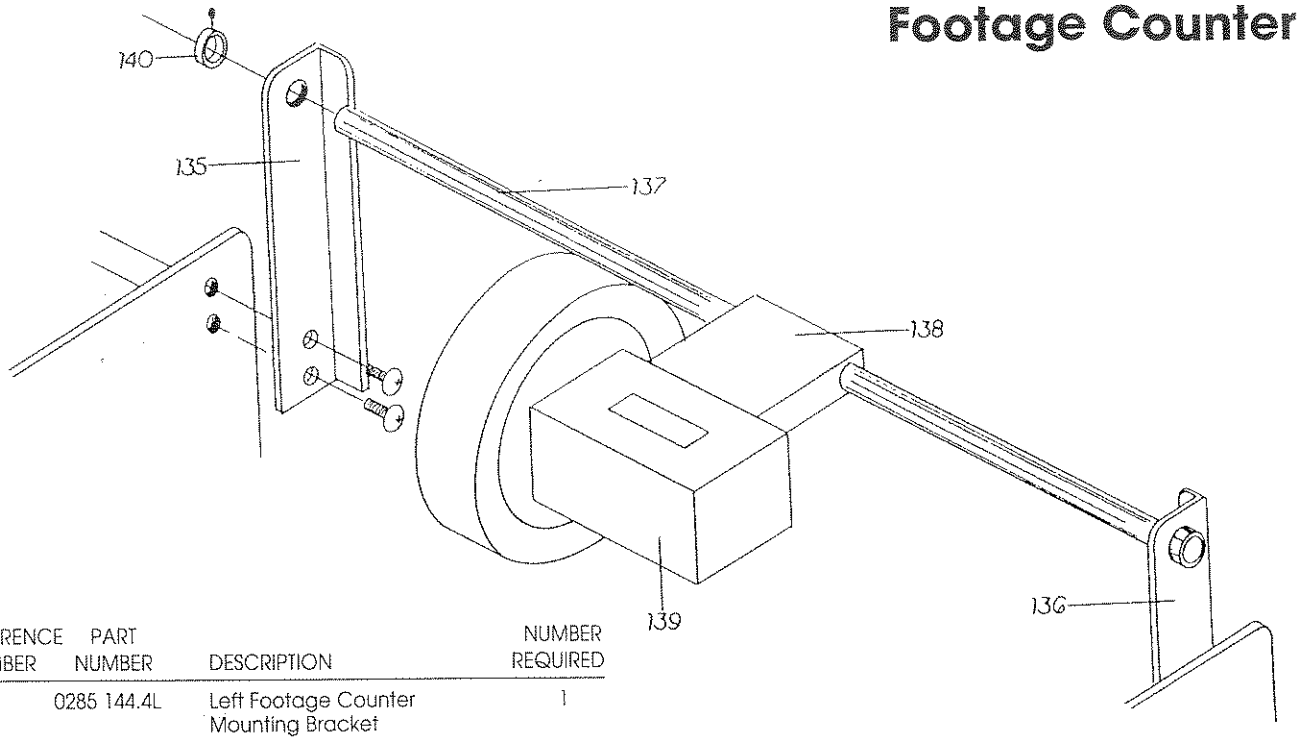
Feed Tray and Safety Shield



Left Housing

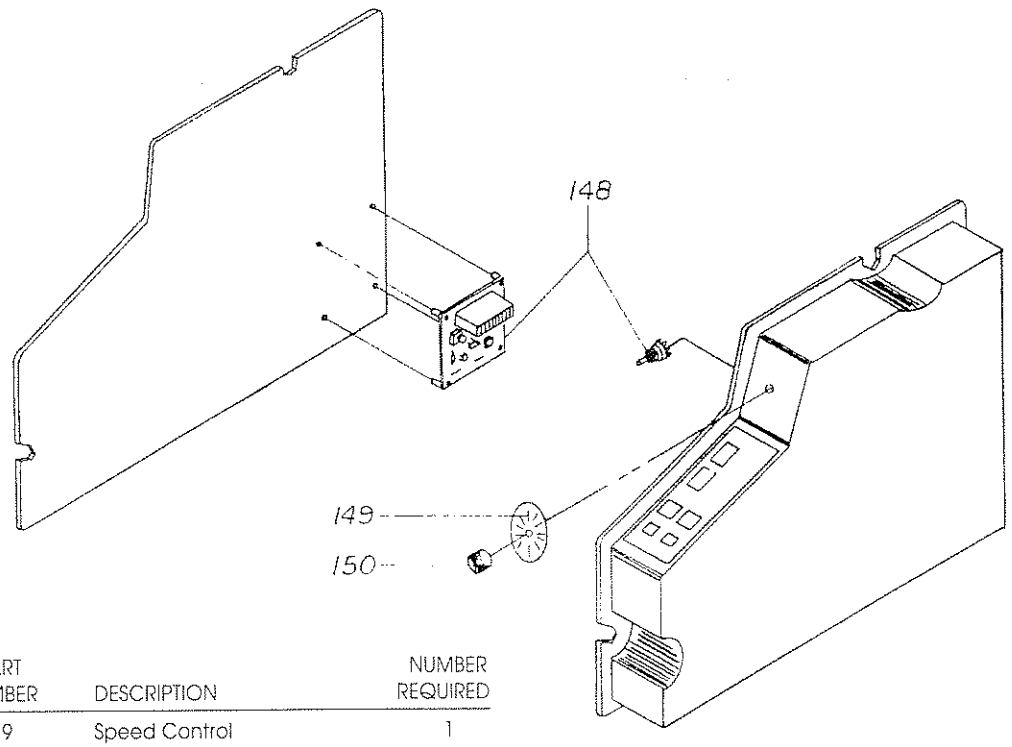


Footage Counter



REFERENCE NUMBER	PART NUMBER	DESCRIPTION	NUMBER REQUIRED
135	0285 144.4L	Left Footage Counter Mounting Bracket	1
136	0285 144.4R	Right Footage Counter Mounting Bracket	1
137	0200, 0800, 0500 145.4	Footage Counter Shaft	1
138	0285 142.4	Footage Counter Mounting Plate	1
139		Footage Counter Assembly	1
140	PRC095	Shaft Collar	2

Variable Speed Control



REFERENCE NUMBER	PART NUMBER	DESCRIPTION	NUMBER REQUIRED
148	PRM219	Speed Control	1
149	XS40	Dial Plate	1
140	PRK181	Speed Control Knob	1

Slitter

New option, drawing not available a time of printing.

PARTS LIST

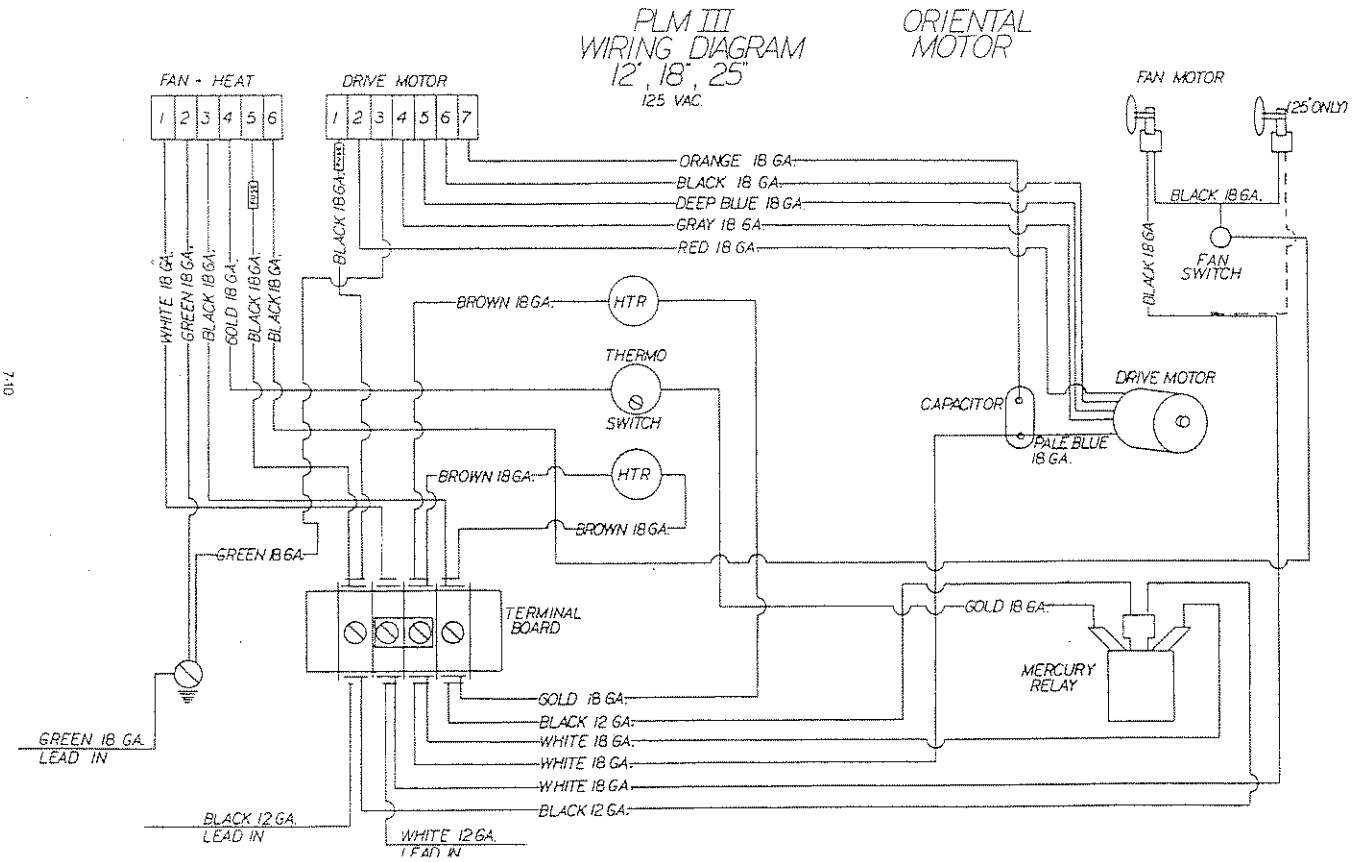
Description and Part Numbers

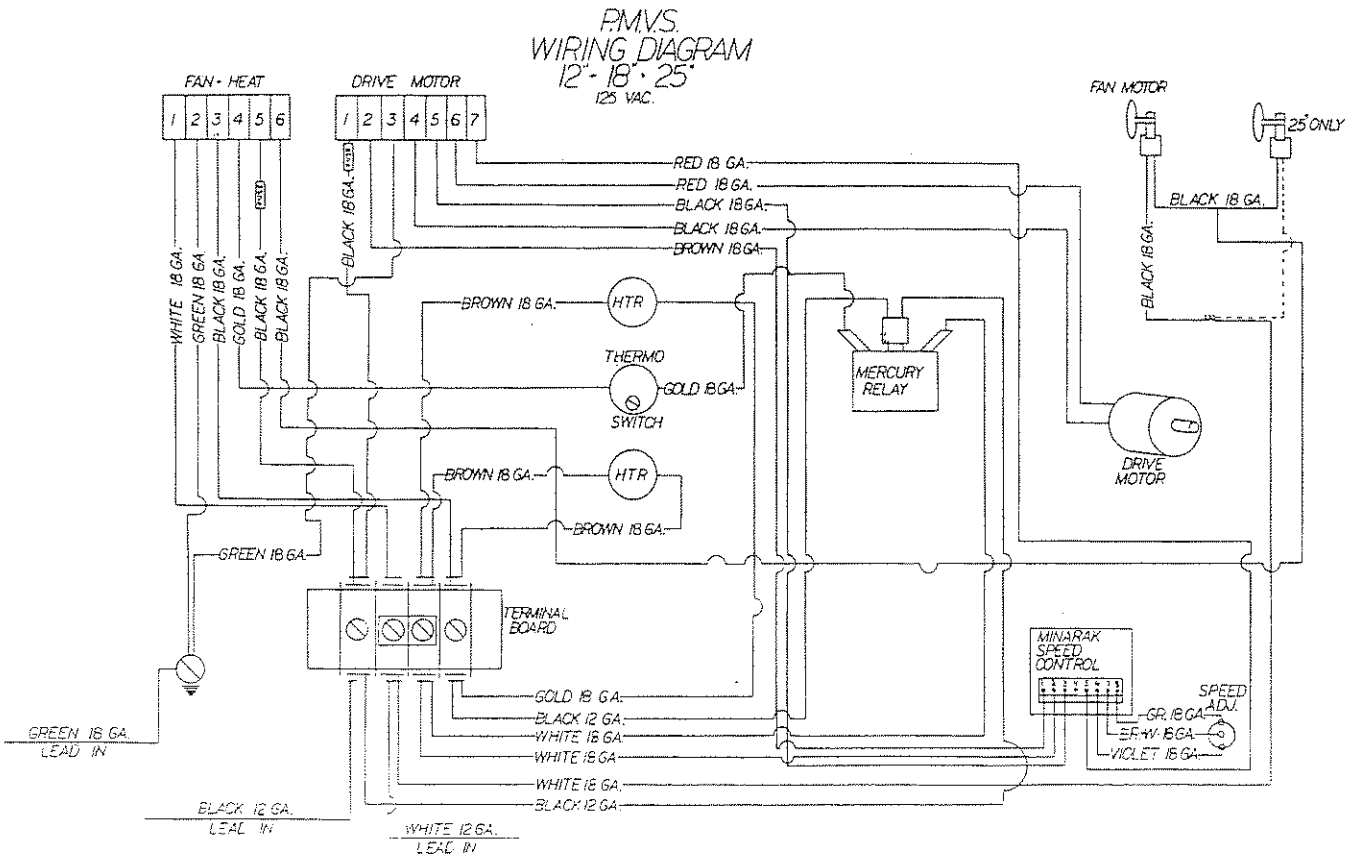
0200 = 12" Machines - 0800 = 18" Machines - 0500 = 25" Machines

REFERENCE NUMBER	PART NUMBER	DESCRIPTION	NUMBER REQUIRED
1	0200, 0800, 0500 002.4	.969 O.D. Supply Roll Mandrel Includes Numbers 3, 4, 13, 14	2
2	0200, 0800, 0500 002.5	Supply Roll Assembly Includes Numbers 1, 5, 7, 8, 9, 11, 12, 15 (Specify Top or Bottom)	2
3	0200, 0800, 0500 002.2L	Left Supply Roll Tube	2
4	0200, 0800, 0500 002.R	Right Supply Roll Tube	2
5	0200, 0800, 0500 011.4	Supply Roll Shaft With Hex Includes Numbers 6 and 16	2
6	0200, 0800, 0500 011.4	Supply Roll Without Hex (Use your old hex)	0
7	0285 026.4	Supply Roll Hex Bushing	4
8	0285 025.4	Supply Roll Friction Plate	4
9	0285 015.4	Supply Roll Dog (Core Gripper)	2
10	3285 028.4R	Rubber Roll Bottom Right Rear Bearing Support	1
11	PRK170	Supply Roll Tension Knob	2
12	PRS234	Supply Roll Tension Spring	2
13	0285 019.4	Supply Roll Joiner	2
14	0285 020.4	Supply Roll Friction Plug	4
15	0285 027.4	Supply Roll Hex Bushing	2
16	0285 023.4	Supply Roll Hex Adaptor	2
17	0285 028.4R	Bottom Right Front Rubber Roll Bearing	1
18	3285 030.5	Rubber Roll Bearing Assembly, Top Includes Numbers 19, 28, 118	2
19	3285 030.4	Top Rubber Roll Bearing Support	1
20	3285 028.4LR	Bottom Left Rear Roll Bearing Support	1
21	3285 028.4LF	Bottom Left Front Rubber Roll Bearing Support	1
22	3285 033.5	Pressure Bar Assembly Includes Numbers 23 and 24	2
23	3285 033.4	Pressure Bar	2
24	PRS233	Pressure Bar Leaf Spring	2
25	PRS240	Pressure Bar Coil Spring	4 6 on25"
26	PRC092	Retaining Collar	2
27	0200, 0800, 0500, 040.4	Rubber Roll	4
28	PRB043	Top Roll Oilite Bearing	4
29	PRB048	Bottom Roll Oilite Bearing	4
30	PRS251	Laminating Roll Sprocket	1
31	PRS249	Pull Roll Sprocket	1
32	PRG131	Rubber Roll Gear	4
33	PRW331	Gear Felt Washer	6
34	PRS249	Drive Sprocket	1
35	PRM215	Motor	1
36	PRM215B	Motor Capacitor	1
37	0200, 0800, 0500 052.4	Idler Shaft	2
38	PRB057	Idler Shaft Bushing	4
39		Not Assigned	
40	PRC083B	Chain	1
41	PRC084	Chain Kit: Includes Numbers 40, 41 & 1 Offset Link	1
42		Cooling System: Includes Numbers 43, 44, 45, 46	1 2 on 25"
43	PRF117.5A	Fan Motor and Blade	1 2 on 25"
44	PRF117	Fan Motor	1 2 on 25"
45	PRF113	Fan Blade	1 2 on 25"
46	3285 057.4	Fan Motor Bracket	1 2 on 25"
47, 48		Not Assigned	
49	0200, 0800, 0500 060.4T	Top Heat Shoe	1
	0200, 0800, 0500 060.5T	Top Heat Shoe Assembly: Includes Numbers 49, 50, 54, 56, 119	1
50	0200, 0800, 0500 061.4	Rubber Roll Heater	2
51		Not Assigned	
52	0200, 0800, 0500 060.4B	Bottom Heat Shoe	1
	0200, 0800, 0500 060.5B	Bottom Heat Shoe Assembly: Includes Numbers 52, 54	1

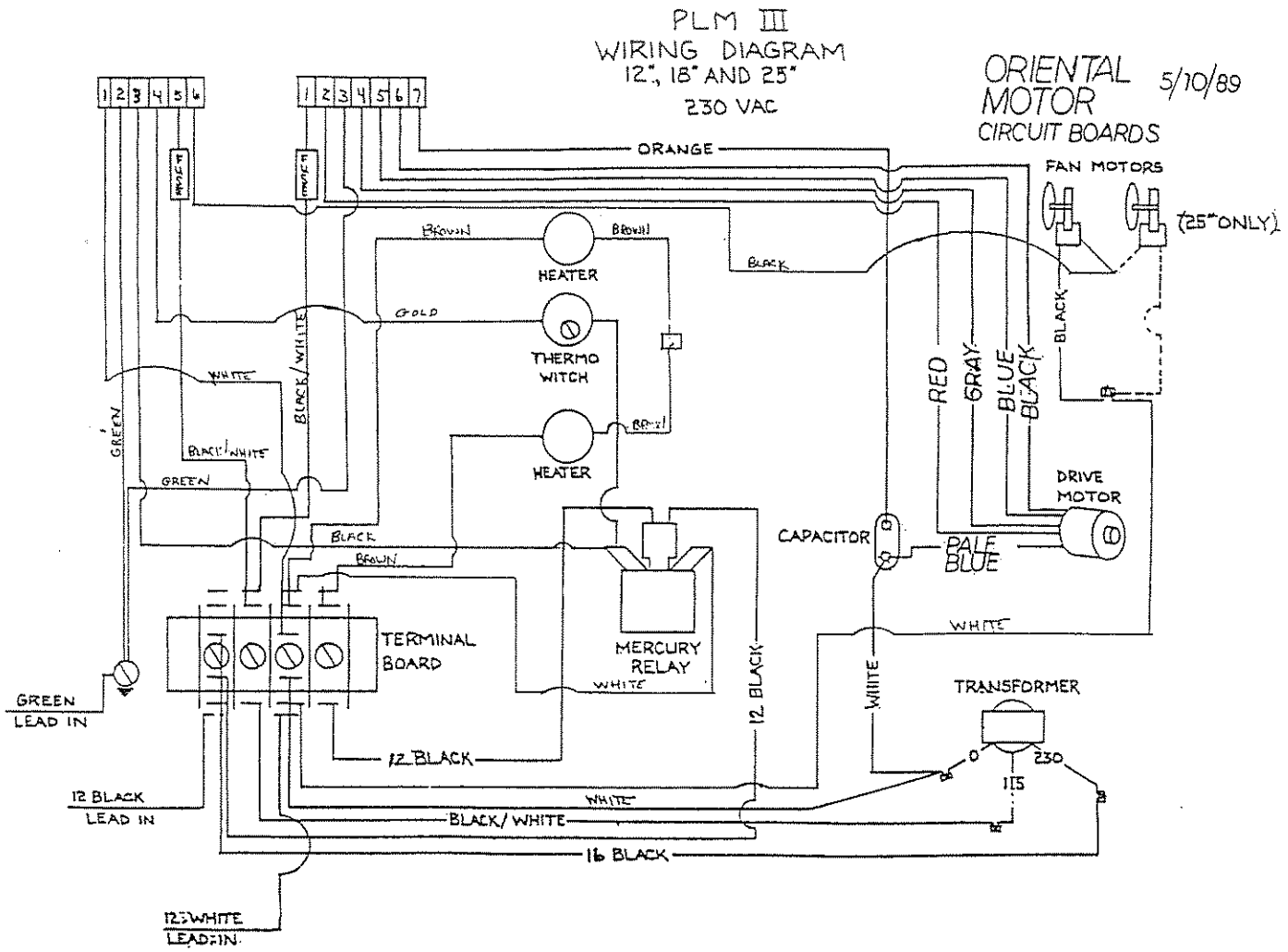
REFERENCE NUMBER	PART NUMBER	DESCRIPTION	NUMBER REQUIRED
53		Same as Number 50	
54	PRH144-12; PRH145-18" PRH146-25"	Cartridge Heater	2
55		Thermoswitch Assembly Includes Numbers 56, 119	1
56	PRT316	Thermoswitch	1
57		Not Assigned	
58	PRW332	Fibre Heat Shoe Washer	4
59	PRS231	Fibre Heat Shoe Spacer	4
60	PRS230	Brass Heat Shoe Spacer	4
61	0285 071.4	Heat Shield	1
62	0200, 0800, 0500 074.5	Safety Shiels Assembly Includes #62 and Fasteners	1
63	0200, 0800, 0500 074.4	Safety Shield	1
64	0285 090.4L	Left Side Panel	1
65	0285 090.4R	Right Side Panel	1
66	3200, 3800, 3500 092.4T	Top Motor Cover	1
67	3200, 3800, 3500 092.4BT	Bottom Motor Cover	1
68	3200, 3800, 3500 093.4FT	Front Motor Cover	1
69	3200, 3800, 3500 093.4BT	Back Motor Cover	1
70	0285 091.4	Back Motor Cover Bracket	2
71	0285 094.4R	Right Housing	1
72	0285 094.4L	Left Housing	1
73	0285 097.4S	Feed Table Guide Stabilizer	1
74	0200, 0800, 0500 096.4	Feed Table	1
75	0285 097.4L	Left Feed Table Guide	1
76	PRK177	Feed Table Guide Knob	1
77	0285 099.4	Feed Table Guide Nut	1
78	0285 098.4T	Top Feed Table Bracket	2
79	0285 098.4B	Bottom Feed Table Bracket	2
80	PRT319	Top & Bottom Motor Cover Bracket	6 7 on 25"
81	PRC116.5	Switch and Light Assembly	1
82-85		Not Assigned	
86	PRT318	Light Mounting Bracket	1
87	PRC102	Power Cord	1
88	PRB066	Strain Relief Bushing	1
89	PRB064	Large Snap Bushing	1
90	0200, 0800, 0500 096.5	Feed Table Assembly Includes 73, 74, 75, 76, 77	1
91-95		Not Assigned	
96	PRR222	Relay	1
97	PRT303.5	Terminal Block Assembly Includes 98, 99, 100, 101, 102	1
98	PRT300	Terminal Block	1
99	PRT306	180° Terminal	4
100	PRT307	45° Terminal	4
101	PRT308	90° Terminal	1
102	PRT309	Terminal Block Jumper	1
103	0200, 0800, 0500 110.4	Stabilizer	2
104	0200, 0800, 0500 111.4	Cut Off Blade	1
105	0200, 0800, 0500 112.5	Cut Off Assembly Includes Numbers 104, 106	1
106	0200, 0800, 0500 112.4	Cut Off Bracket	1
107	3200, 3800, 3500 113.4	Exit Table	1
108	PRK177	Exit Table Knob	2 3 on 25"
109	PRK180	Thermoswitch Knob	1
110	PRT311	Thermometer	1
111	PRS238	Thermometer Spring	1
112		Not Assigned	
113	3285 121.4	Control Panel Plate	1
114	3200, 3800, 3500 130.4	Cam Shaft	1
115	PRK175	Cam Shaft Handle	1
116	PRB058	Cam Shaft Bushing	2
117	3285 133.4	Cam	2
118	3285 134.4	Cam Wear Plate	2
119	0285 139.4A	Thermoswitch Stop Collar	1
120	0285 139.4	Thermoswitch Stop	1
121	0285 190.4L	Safety Shield Bracket	1
122	0285 190.4R	Safety Shield Bracket	1

8-10 Wiring Diagram





Wiring Diagram - 220 volt



9-1 USER NOTES