

## ProLam R27

Premium Roll Laminator



### OPERATION MANUAL

*Please read carefully before operation*

# CONGRATULATIONS

Congratulations on your purchase of the Akiles ProLam R27. This laminator was designed and manufactured to provide you with the utmost in utility. As with any device that combines power and movement in its use, improper usage can result in dangerous situations. Also, there are easier and faster ways for getting the job done if certain precautions are first taken. Please read this manual carefully. It contains useful ideas in obtaining the most efficient operation from your laminator and safety procedures you need to know before beginning use. Please save this manual for future use.

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# SAFETY PRECAUTIONS



## WARNING



Please do not use broken, aging or self-made electrical wire and damaged supply cord. Please do not immoderately draw, twist or enlace the electrical wire, to avoid the fire or electric shock.



Please do not use the power supply that is not in accordance with the rated voltage, to avoid the fire or electric shock.



NO DISJOINT



Don't disjoint, modify and repair the machine yourself. If there are any problems on the machine, please do not use it, send it to the dealer for repairing.



ENTANGLEMENT  
CAUTION



Keep hands, long hair, loose clothing and articles such as ties or necklaces away from the front of the heating roller and pull roller to avoid entanglement. In case some articles entangled, press the REV button right away; if not workable, cut off the power supply at once, and contact your dealer for settlement.



ELECTRIC SHOCK  
CAUTION



Do not make the electrical wire or plug or the machine bedewed by water or other liquids. Do not operate the machine with wet hand. Do not make the machine pressing on the electrical wire. Do cut off the power supply while moving the machine. Do not operate the machine with the cover open.



HIGH  
TEMPERATURE  
CAUTION



Do not put articles on the laminator while it is working, so that to disperse the heat. Do not insert the easy-burnt or easy-softened material into the machine, in case they are melt and give rise to smoke. Do not touch the cover, heating roller and heating parts while the machine is working, in case heat injury.



# SAFETY PRECAUTIONS



## CAUTION

<b>WORKING PLACE</b>	<ul style="list-style-type: none"> <li>⚠ This machine should be put at the dry and clean place, do not put it at the damp place or near the exit of cooling appliances.</li> <li>⚠ This machine should be put on the horizontal and firm place. In front and rear of the machine, there should be sufficient place for the document in and out.</li> <li>⚠ Do not put any articles on the machine.</li> </ul>
<b>LAMINATING FILM</b>	<ul style="list-style-type: none"> <li>⚠ Please use good quality laminating film, in order to show the lamination effect, and avoid the entanglement.</li> </ul>
<b>OBJECT</b>	<ul style="list-style-type: none"> <li>⚠ The laminating machine uses hot press technology. To avoid film entanglement or laminating failure, avoid using the following objects: <ul style="list-style-type: none"> <li>※ 1. Easy-burnt material, easy-softened material</li> <li>※ 2. The document printed by heat-sensitive paper, or any articles that can be faded or transformed after heating.</li> <li>3. Any articles that have drape, breakage, dampness or deformation before laminating.</li> <li>4. Coin or any other hard articles.</li> </ul> </li> <li>※ = <b>exceptions while in cold laminating operation.</b></li> <li>⚠ Do not attempt to laminate articles that exceed total recommended material thickness.</li> </ul>
<b>MACHINE OPERATION</b>	<ul style="list-style-type: none"> <li>⚠ Do not turn to other usages except the usage range stated in this operation manual.</li> <li>⚠ Do not use the machine outside the room. Before leaving, please cut off the power supply if the operation is over.</li> <li>⚠ If there are any problems on the machine, please do not use it, send it to the dealer for repairing.</li> </ul>

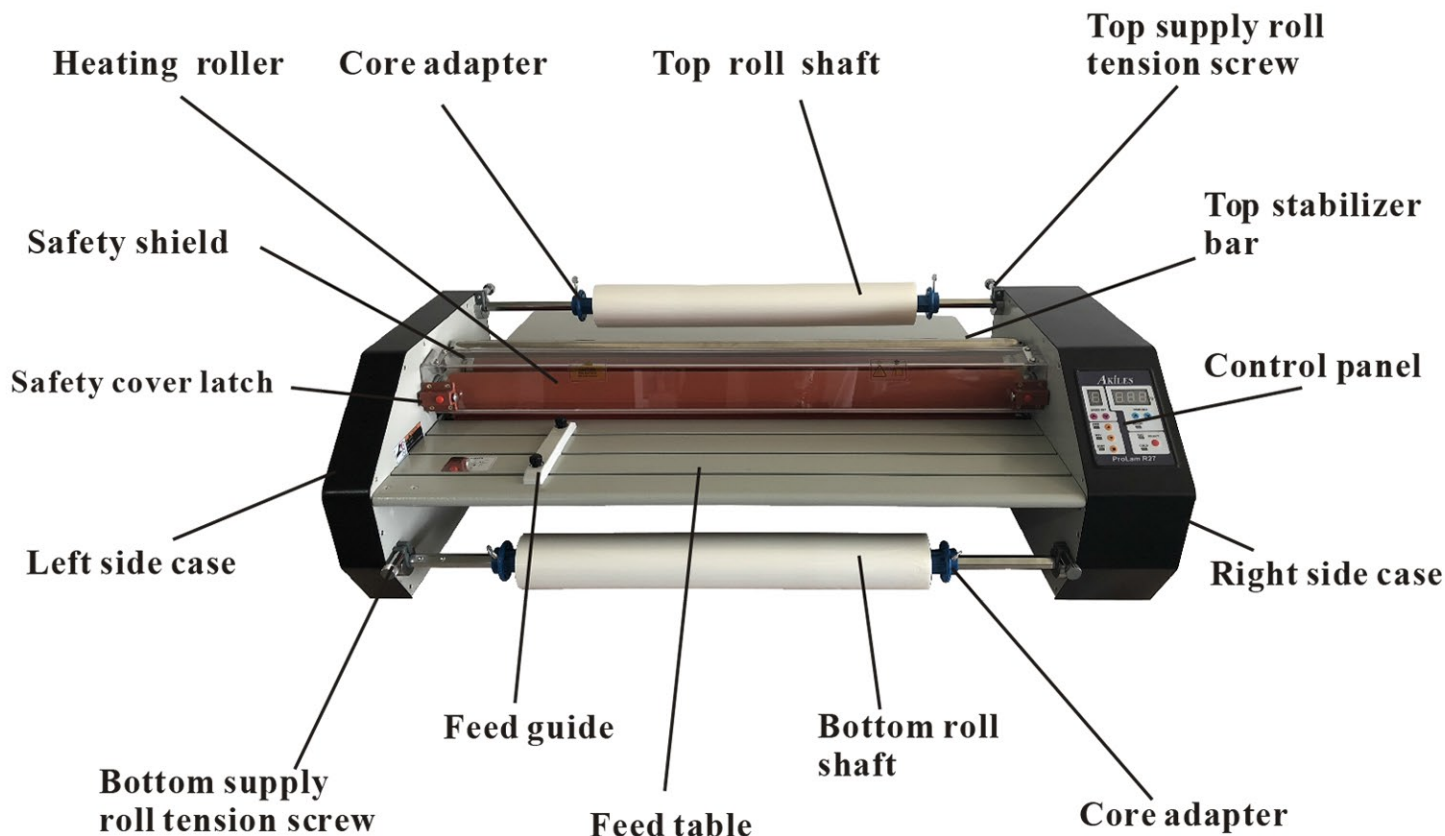


## ADVISES

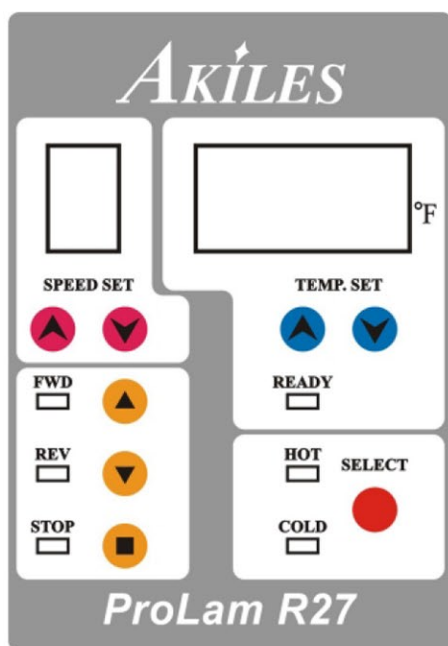
- ⚠ While operating the machine, mind the children nearby, in case any suddenness.
- ⚠ Do not suspend the electrical wire on the table or cabinet or any other places that the children can touch, or place easy stumble persons.
- ⚠ Using the accessory that not recommended or sold by the manufacturer, might cause damage on the machine.
- ⚠ The photo or document once is laminated, it will become permanent and will not be taken apart.
- ⚠ Please do not laminate the collected rare articles, or some articles might be taken out in the future.



# STRUCTURE AND CONTROL PANEL

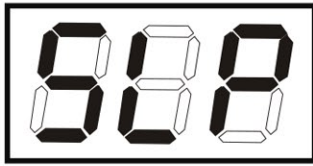


## CONTROL PANEL AND FUNCTIONS OF DIGITAL DISPLAY



## 1. Digital display and Functions

### 1) Sleeping function



SLP

A) When the motor does not run for about 120 minutes continuously, the machine will enter into sleeping function automatically.

**Note: I) While entering into sleeping function, the machine cut off heating power supply automatically.**

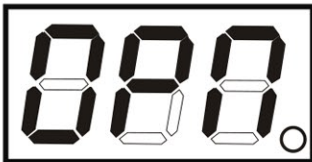
**II) The Temp display flash SLP.**

B) Waking up the sleeping function

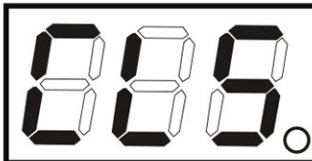
I) Press the STOP, REV or FWD button

II) Restart the power supply

### 2) Protecting function of temp sensor's open circuit and shot circuit



When the sensor is in open circuit, shows "OPN"



When the sensor is in short circuit, shows "CLS"

**Note: No matter what problems happened, the machine will cut off the heating power supply automatically, and the motor will stop running.**

**If motor running required, press the FWD or REV button continuously.**

### 3) Automatic memory function

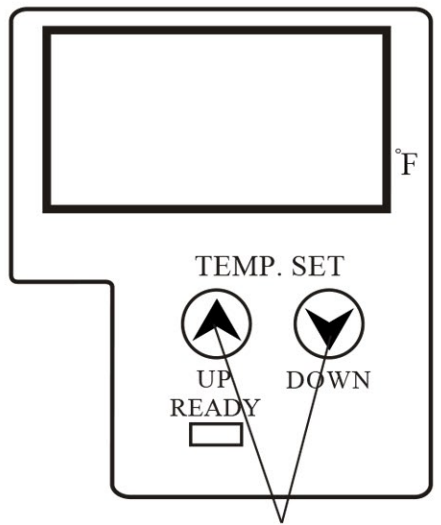
After pressing the control button, within 3 seconds, the machine can automatically save the setting data (speed, temperature, running mode), these data can be recovered for next operation.

**Note: Do not switch off the machine within 3 seconds after pressing the control button, in case the CPU might damaged.**



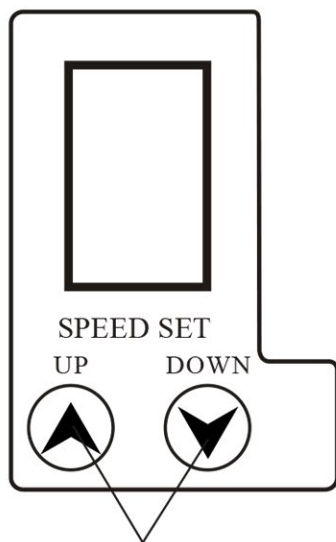
## 2. Button function of control panel

### 1) Temperature control



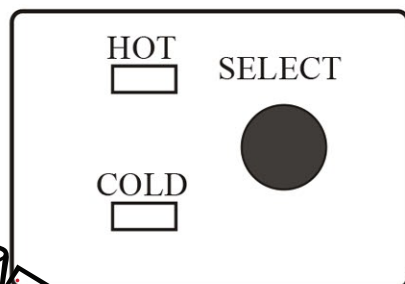
Temp control button

### 2) Speed control



Speed control button

### 3) Function selection



A) These can be used for increasing or decreasing Temp. manually. The temp can be increased or decreased by 1°F when these buttons are pressed. Pressing the button, the temp will be increased or decreased continuously until you loose the button.

B) The range of temp that can be adjusted manually is 70°F–320°F.

C) When the temp reach 320°F , the over-heat protecting system will run automatically.

D) When pressing the temp control button, it indicates the setting temp. When losing the button for 3 seconds, it indicates the present temp. Automatically.

E) When the setting temp is reached, the READY lamp is light.

A) These can be used for increasing or decreasing speed manually. The speed can be increased or decreased by unit to 1 speed when these buttons are pressed.

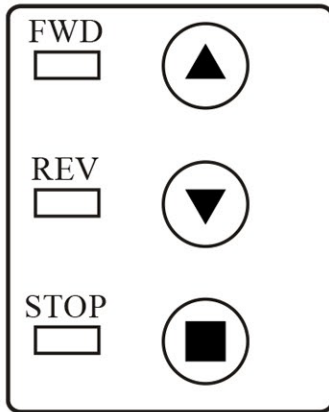
B) The range of speed that can be adjusted manually is speed 1-9.

A) Press the SELECT button to change the function of machine between hot and cold lamination.

B) While the HOT lamp is light, the machine is on hot laminating.

C) While the COLD lamp is light, the machine is on cold laminating.

#### 4) Forward, Reverse and Stop control



Press FWD or REV or STOP button can change the working condition of the machine.

A) Motor runs forward, the laminating film in, the machine works.

B) Motor runs reverse, the laminating film out. This function is used for remove the object inserted by mistake.

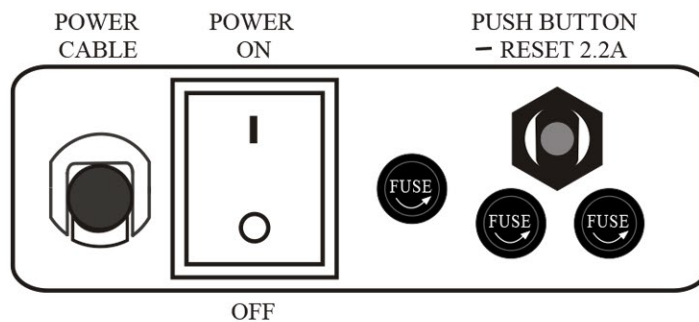
C) Motor stop. This function is used for pre-heating, standby.

## OPERATION INSTRUCTIONS

### PREPARATION

#### 1. Connecting the power source

- 1) Checking the rated voltage on the machine, to insure it conform to the power source. Also, checking the plug to insure it conform to the socket.
- 2) Insert the plug into the power socket that is grounding correct.



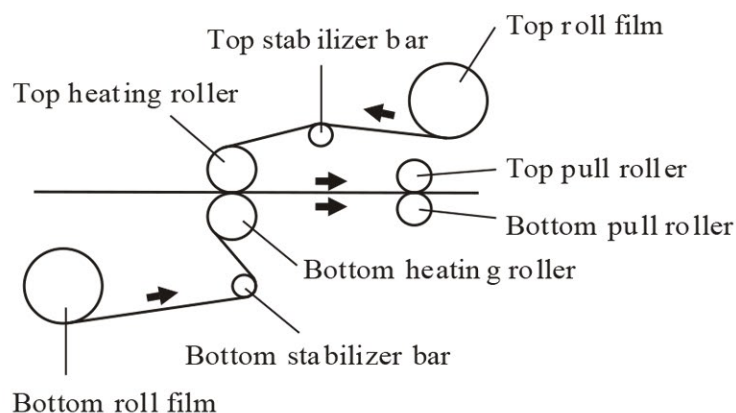
- 3) Turn on the power switch, the display light, it indicates the power is connected.

#### 2. Motor overload circuit breaker

This machine is equipped with motor overload circuit breaker (it is located next to the power switch), in order to protect the motor working normally. When the motor is overload, the circuit breaker will jump and cut off the motor power. One minute later, when the overload is clear, press the circuit breaker button, the motor will start again.



## 4. Film loading & threading



### Film Threading Diagram

- 1) Take out the top roll shaft.
- 2) Loose the tension screw and then take out the holding piece. (See picture 1)
- 3) Loosen the fixing screw on the core adaptor (left side), then take out the core adaptor. (See Picture 2)
- 4) Slide the roll film onto the roll shaft .
- 5) Push the core adaptor into the roll film core tightly, then fix it. (See picture3)
- 6) Put the holding piece on the shaft. (See picture 4)



Picture 1



Picture 2



Picture 3



Picture 4

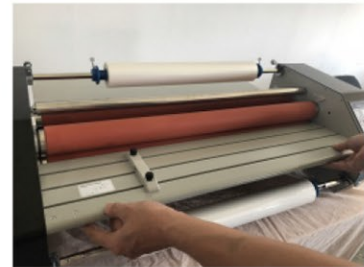
7) Put the roll film on the holder. Make sure they are both fully seated.

8) Press the red button on the locking latch of safety shield, then take out the safety shield. (See picture 5)



Picture 5

9) Remove the active bolt under the feeding table. Take out the feeding table. (See Picture 6)



Picture 6

10) Repeat Step 1-7 to load the bottom roll film.

11) Move the bottom stabilizer bar to the lower Position. (See picture 7)

**Warning: Threading the film while the bottom stabilizer bar is at the higher position may damage the temperature sensor.**



Picture 7

12) Pull the bottom roll film under the bottom stabilizer bar. (See picture 8)



Picture 8

13) Pull the top roll film over the top stabilizer bar, then align with the bottom film. If needed, move the top roll to adjust. (See picture 9)



Picture 9

- 14) Insert and push a threading card or similar stiff cardboard into the hot rollers. (see picture 10)



Picture 10

- 15) Set the speed to 1, press and hold the FWD button, the laminating roller will run forward slowly. When the threading card has come out from the back of the machine, release the FWD button. (See picture 11)



Picture 11

- 16) Move the bottom stabilizer bar to the upper position. (See picture 12)



Picture 12

- 17) Put the feeding table on the machine and lock the active bolt. (See picture 13)

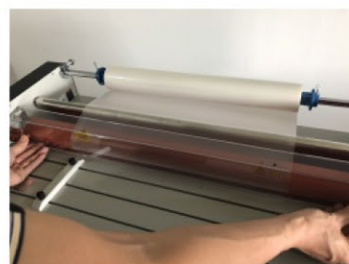


Picture 13

- 18) Put on the safety shield, and lock the latch. (See picture 14)

**Note: If the safety cover latch is not in the proper position, the machine will neither run nor heat.**

**CAUTION: For operator safety, the safety shield must be in position over the upper heating roller when the machine is ON.**



Picture 14



## HOT LAMINATING

Turn on the power switch. Press the SELECT button until the HOT lamp light is turned on. The machine will begin heating. Set the recommended temperature that correlates to the thickness of film being used. The temperature will be reached in around 10 minutes.

### Trial lamination

If the roll film is the first time to be used, a trial lamination is required for perfect result. After the READY lamp is light, press FWD button, let at least 10 inches of film go through the rollers before inserting the items to be laminated. Examine the film coming out the back of machine.

If the laminated film is clear and flat, it indicates the temperature and speed are suitable.

If there is cloudy part on the laminated film, you need either increase the temperature or decrease the speed. If the laminated film is clear but has waves on it, you need either decrease the temperature or increase the speed. After the trial lamination has a satisfied result, insert the item into the rolls. Reminder: Keep space behind the machine so that the laminated item can come out easily and prevent the laminating from winding back into the rollers. If the machine is stopped for a long period, lower the temperature by 5-10 F to prolong the work-life of the machine.

Stop the machine after the item to be laminated pass through the roller completely, otherwise there will be an imprint on the item.

Recommended Temperature Settings\*

Laminating Film Thickness	Laminating temperature	Laminating speed
1.5 MIL	225	6
3 MIL	230	6
5 MIL	235	5
7 MIL	240	5
10 MIL	245	4

\*May change depending on different films. Please adjust accordingly as necessary

## COLD LAMINATING

Press the SELECT button until the COLD lamp is light, set the speed at level 4 or 5. Load the cold film as the same procedures of hot film; or insert the cold film and the item to be laminated into the roller simultaneously.

CAUTION: The adhesive side must face away from the roller.



# MAINTENANCE AND SERVICE

## GENERAL MAINTENANCE

Do not laminate the metal or other hard items in case the damage of the rubber rollers.

Cleaning the machine timely will help prevent dirt or adhesive build-up on the rubber rollers and will improve the performance of the unit.

## CLEANING THE RUBBER ROLLERS

During the normal lamination, excess adhesives from the film will often cling to the rubber rollers.

To clean the rubber rollers, remove the film from the machine first, heat up the machine to 85-105°F. The warm roller enable it easier to remove the adhesive built-up on the rollers. Raise the safety shield and take out the feed table. Using a clean, soft, ethanol dampened cloth, gently rub the adhesive off the rollers.

**CAUTION:** Never use any abrasive or sharp metal material or rub too hard on the roller, because you may damage the rubber surface.

Set the SPEED to 1. Press FWD or REV button, the roller will run, cleans the roller. After cleaning, position the feed table and put on the safety shield.

**CAUTION:** if the film gets wrapped around the roller, press STOP button and press the SELECT button to COLD (stop heating) immediately.

**WARNING:** do not use any cleaning solution to clean the roller, because some solutions may burn on the hot roller. After the roller cool down, cut the film on the top and bottom, just in front of the stabilizer bars. Reverse the roller at a very low speed and allow the machine to back out the film that is wrapped around the rolls, pull the film off the roller. Clean the adhesive on the roller.

## TROUBLESHOOTING

Please read this section entirely, in case problems arise.

**PROBLEM:** No power is getting to the machine.

**SOLUTION:** Make sure there is power at the electrical outlet being used, and make sure both ends of the power cord are firmly engaged.  
The laminator equipped with three fuses ( they are located back of laminator). Please check these fuses.

**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, they cannot pull equally on the plastic around the paper. This creates wrinkles that tend to look like the bow 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 adhesive 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, wrinkling can occur if these items are of unequal thickness, because the laminating rollers are lifted off the thinner items by the thicker items. When laminating items side by side, it is important to arrange them so that the thickness is the same.

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

**SOLUTION:** The film is threaded improperly. If the adhesive side face to the roller, the film will be wrapped around the rollers. Thread the film in proper position.

The laminating temperature is too high, the film will be melted and wrapped around the roller. Decrease the laminating temperature.

Press the STOP button immediately. After the roller cool down, cut the film on the top and bottom, just in front of the stabilizer bars Reverse the roller at a very low speed and allow the machine to back out the film that is wrapped around the rolls, pull the film off the roller.

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

**SOLUTION:** Check the tension of the film, make sure the film is threaded properly (see film threading).

**PROBLEM:** Film is not properly adhered.

**SOLUTION:** The laminating temperature is too low; there is not enough heat to melt the adhesive. Increase the laminating temperature.

**PROBLEM:** The laminated material seems to have an irregular surface that does not match the texture of the paper being coated.

**SOLUTION:** This is usually caused by adhesive build-up or dirt on the rubber rollers. Inspect the rubber rollers and clean as necessary . Damage to the rubber can also cause irregularities in the surface of the film.

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

**SOLUTION:** Increase the temperature or decrease the speed. 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.

SPECIFICATIONS	
Warm Up Time	20 min
Adjustable Temperature	320°F Max
Laminating Speed	9 settings (Up to 3.6 ft / min)
Max Film Thickness	10 mil
Max Film Width	27"
Max Laminating Thickness	1 mm
Core Size	1"
Heated Roller Size	2.17" (55 mm)
Sleep Mode	Yes, after 2 hours
Reverse Switch	Yes
Machine Dimensions	36.25" W x 12" H x 16" D
Weight	93 lbs
Power Consumption	1250 watts, 11.4amp
Warranty	1 Year