



OPERATING MANUAL Gfp 865DH-4



Please read this manual carefully before operating!

**Do NOT reproduce this manual or make changes to it
without express written consent from Gfp**

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1. Introduction

Thank you for choosing a Gfp laminator. It has been designed and manufactured to provide years of continuous service. Please read this manual thoroughly before operating. Please inspect the box and the laminator for shipping damage. Damage should be brought to the immediate attention of the delivering carrier. For a list of shipping components see “Packing List” on page 7.

Please preserve this operation manual for future reference. Pay special attention to the paragraphs with warning symbols which are vital to the proper uses and maintenance and the safety of the users. Please comply with the operation guides of this machine and warnings in this operation manual.

2. Important Safety Instructions

In this operating manual you will find important safety messages regarding the product. Read these instructions carefully, failure to comply with the following safety procedures could result in serious injury.



WARNING Do not attempt to service or repair the laminator. Only authorized maintenance and service technicians should make repairs.



WARNING Do not connect the laminator to an electrical supply or attempt to operate the laminator until you have completely read these instructions. Maintain these instructions in a convenient location for future reference.



WARNING To guard against injury, the following safety precautions must be observed in the installation and use of the laminator.



Warning Ensure the safety shield is in place before operating the laminator. Operating without the safety shield can result in serious injuries

3. Installation Safeguards

- Shipping damage should be brought to the immediate attention of the delivering carrier.
- Avoid locating the laminator near sources of heat or cold. Avoid locating the laminator in the direct path of forced, heated or cooled air.
- The receptacle must be located near the equipment and easily accessible.



Connect the electrical plug provided with the laminator to a suitably grounded outlet only. This machine must have reliable earth ground to ensure the safety of the machine during operations.

Contact an electrician should the electrical plug provided with the laminator not match the receptacles at your location.



Ensure that the voltages of the power supply you are using match the rated working voltages before operations. Do not use incorrect power supply.



Do not use damaged wires or outlets. If abnormal conditions occur, switch off the power supply first.



This machine must be grounded reliably to ensure safe operation.



Only a licensed electrician should install wiring and outlet for the laminator.



To ensure safe operation, do not defeat or remove electrical or mechanical safety devices such as interlocks, shields, guards and photo eyes.



This machine is equipped with a heating system; do NOT touch the surface of rollers during thermal operations to avoid burns.

4. General Safeguards

- Keep hands, long hair, loose clothing, and articles such as neckties and necklaces away from the rollers to avoid entanglement and entrapment. The rollers have pinch points that can trap body parts or clothing and cause serious injury.
- Do not use the machines for purposes other than lamination and mounting, otherwise damages to the machine or accidents may occur.
- Keep out of reach of children.
- Keep flammable and wet objects away from the machine.
- Do not use flammable sprays or materials when cleaning the machine.
- Do not leave the machine unattended during operations.
- Do not mount metal materials or other hard objects.
- Do not put burrs, sharp blade or rigid materials in between the two rubber rollers.
- Do not attempt to laminate items that exceed total recommended material thickness of the unit.
- Do not touch the rollers when they are hot or place foreign object inside the machine.
- Do not cut adhesive films directly on the surface of the rollers to avoid damaging the rubber coating.
- Shut down the machine after laminating to avoid misusing this machine by others.
- Shut down the power and unplug the power cord before moving the machine.
- Note the locations of the castors while moving or operating this machine to avoid injuries to your feet.



-  Disconnect from the power supply before repair or maintenance.



-  Disconnect from the power supply when the machine is not in use for a long time.
- When the machine lies idle for a long period of time, raise the top rubber roller to avoid flat spots on the rubber surface.
- Do not cover the surface of the machine until the machine has completely cooled.
- Perform only the routine maintenance procedures referred to in these instructions.

5. Operating Conditions

- Place machine on level surface
- Environment requirements :
 - Ambient temperature: 50⁰ F - 104⁰ F
 - Humidity : 30%—80% ; ideal humidity : 55%
- Due to the static on film rolls, you should try to keep the environment clean.
- Provide enough space around machine to ensure safe and effective operation. The minimum area covered is 8 ft. x 10 ft.
- Do not directly cut the films on the surfaces of the rubber rollers to avoid damages to the rollers.
- Do not put burrs, sharp knives or extra thick and hard materials in between the rollers. Do not leave objects like tools, rulers, knives, etc. on the working panels or the side cabinets to avoid their being pulled into the machine accidentally and damaging the rollers.
- For repairs and replacements, please contact your local dealer or distributor. Unauthorized repairs and dismantling will affect future maintenances of the machines.
- The machine can laminate continuously objects less than ½” thick.
 - For objects over ½” but less than 1” thick, use the pedal switch.
- Operator should be present while machine is in operation.



***Warning: Do not keep the machines in direct sunshine or near it.
Do not keep the machine in dusty place or places with strong vibrations.***

6. Electrical Requirements

- 220-240V 50/60 Hz Single Phase (NEMA 6-30R)
- 865DH-4 – 24 amp



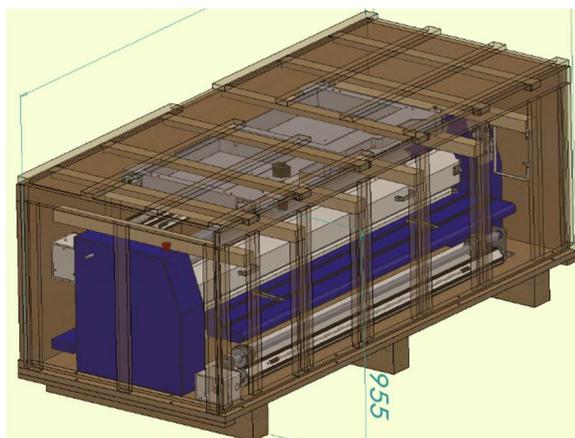
Connect the electrical plug, provided with the laminator, to a suitably grounded outlet only. This machine must have reliable earth ground to ensure the safety of the machine during operations.

- Contact an electrician should the electrical plug provided with the laminator not match the receptacles at your location.
- Ensure that the voltages of the power supply you are using match the rated working voltages before operations. Do not use an incorrect power supply.
- Do not use damaged wires or outlets. If abnormal conditions occur, switch off the power supply.

7. Packing list

Remove all parts from shipping crate and boxes. Inspect parts and the machine carefully. Any missing parts should be reported to your dealer or distributor.

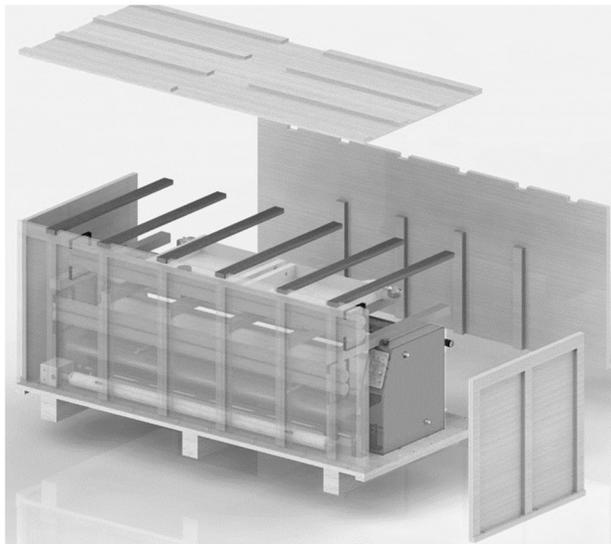
Main Machine Crate		Stand Box	
Part	Quantity	Part	Quantity
Main Machine	1	Cross beams	2
Swing out shaft assembly	1	Middle beam	1
Rewind tube	1	Left side stand	1
Foot Pedal	1	Right side stand	1
Heat tube	2	8 x100 hex screw	8
Media support brackets	3	Alignment bracket	2
Leveling Feet	4	5 x 8 hex screw	4
Stand anchor bolts (M10)	4	# 5 flat washer	8
Allen wrench 5mm	1	# 5 spring spacer	8
Film cutter (Zippy Knife)	1	Anchor bolts (M8)	2
Operation Manual	1	#8 Nut	2
8 x 20 hex screw	10	Allen wrench 4mm	1
# 8 flat washer	20	Allen wrench 6mm	1
# 8 spring spacer	20	5X16 hex screw	4
4X8 Combination screw	4	Spanner Wrench	1



8. Installation

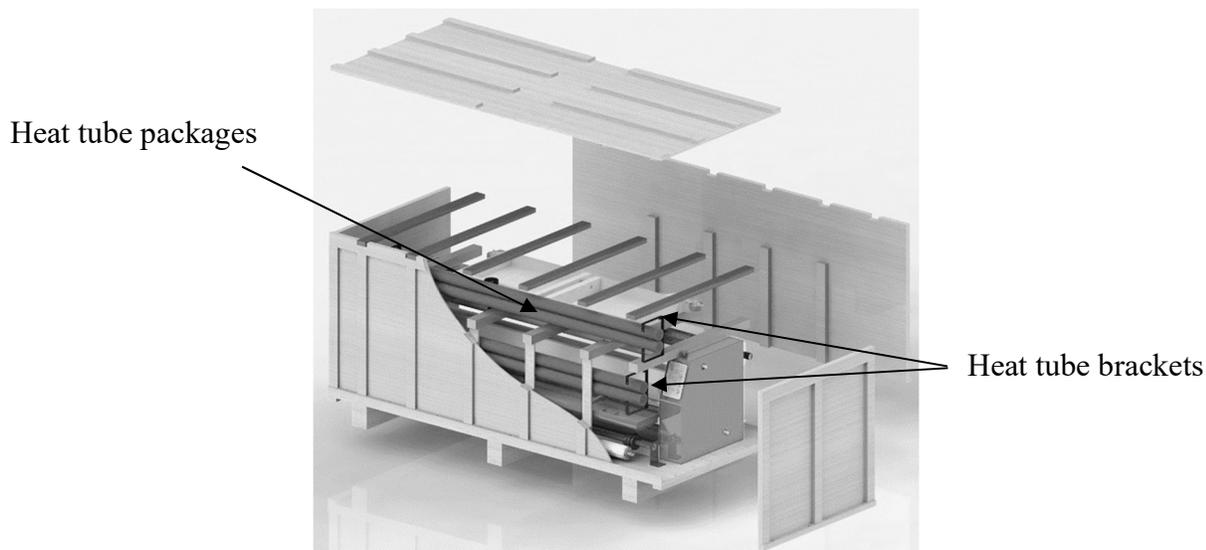
8 A. Uncrating the machine

1. Remove bolts around the base of the crate.
2. Lift crate top straight up and off the skid.



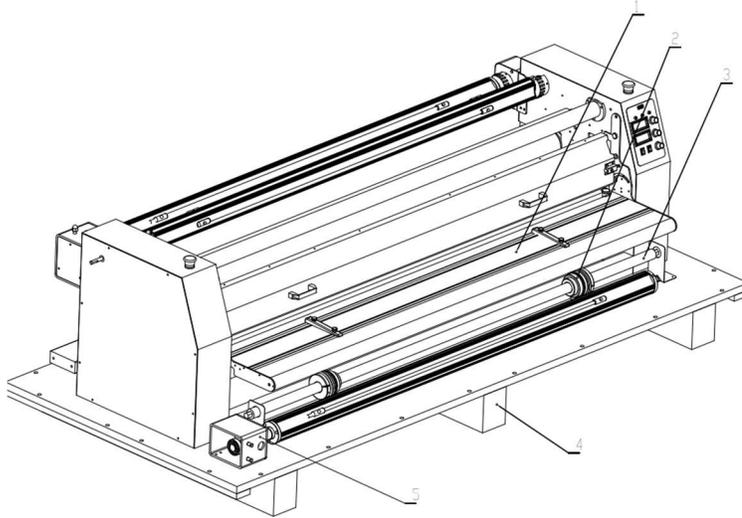
8 B. Remove Heat Tube Packages

3. Remove nuts on heater support brackets that hold the cardboard tubes to the inside of the crate and remove the heater packages.



8 C. Remove Machine from Skid

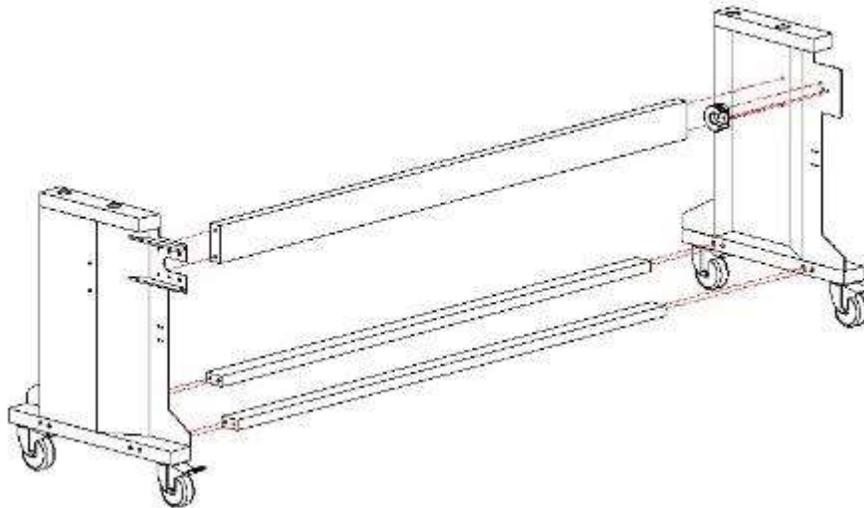
1. Remove plastic cover and accessory box.
2. Raise the In-feed table (#1) and lock in place.
3. Remove rewind tube by pushing toward the spring side.
4. Remove supply shaft (#2) from the crate base by loosening the hex bolts on core adapters and sliding to one side.



1. Infeed Table
2. Film Core Adaptor w/Brake
3. Lower Supply Mandrel
4. Shipping Skid
5. Bottom Swing-Out Shaft Assembly

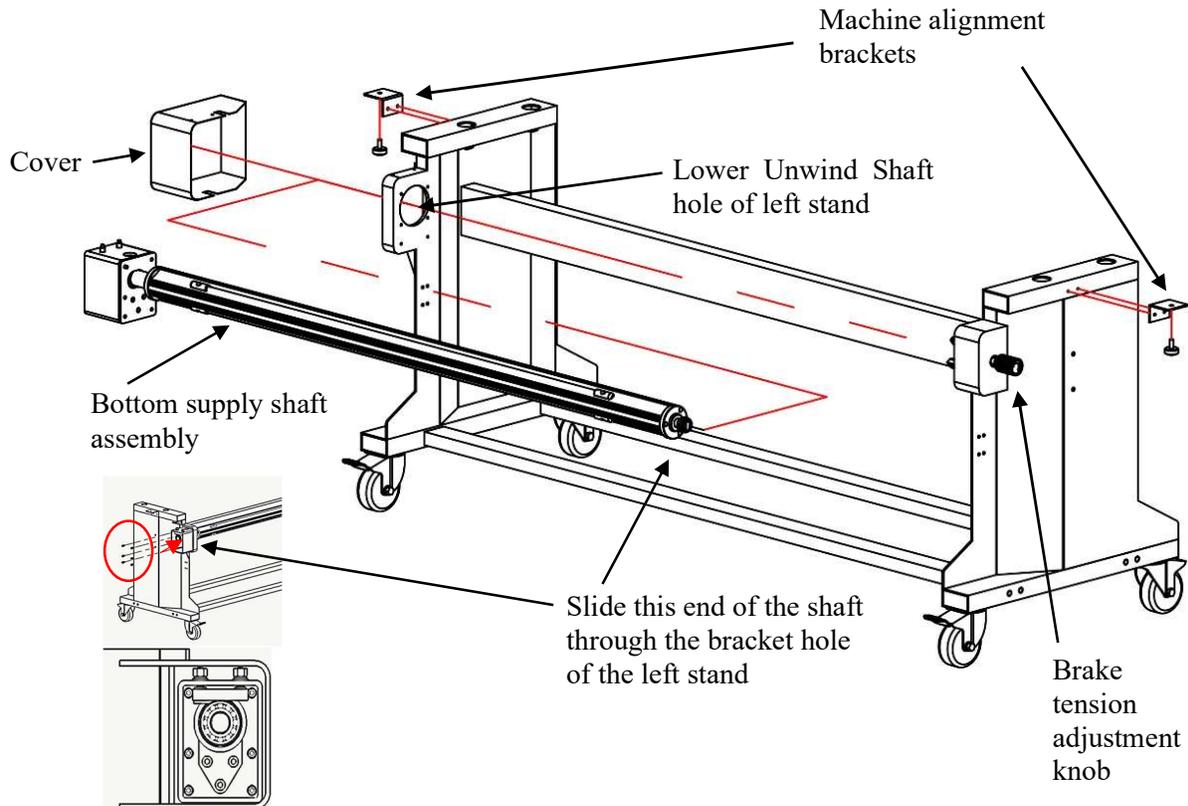
8 D. Assemble Machine Stand

1. Remove stand from shipping box.
2. Bolt cross members to stand side frame.
3. Larger cross member goes in the center and takes the shorter bolts.
4. Use a flat washer and lock washer – Flat washer contacts the stand.



8 E. Attach Lower Supply Shaft Assembly

1. Bolt the bottom supply shaft assembly to the stand with 6 bolts by sliding the shaft through the hole on the left side of the left stand
2. Bolt the cover to supply shaft assembly
3. Bolt machine alignment brackets to the outside of machine stand



5. Bolt the swingout shaft assembly to the stand with 6 bolts.
6. Bolt the cover to swing shaft assembly.
7. Bolt the machine alignment brackets to the outside of the machine stand.

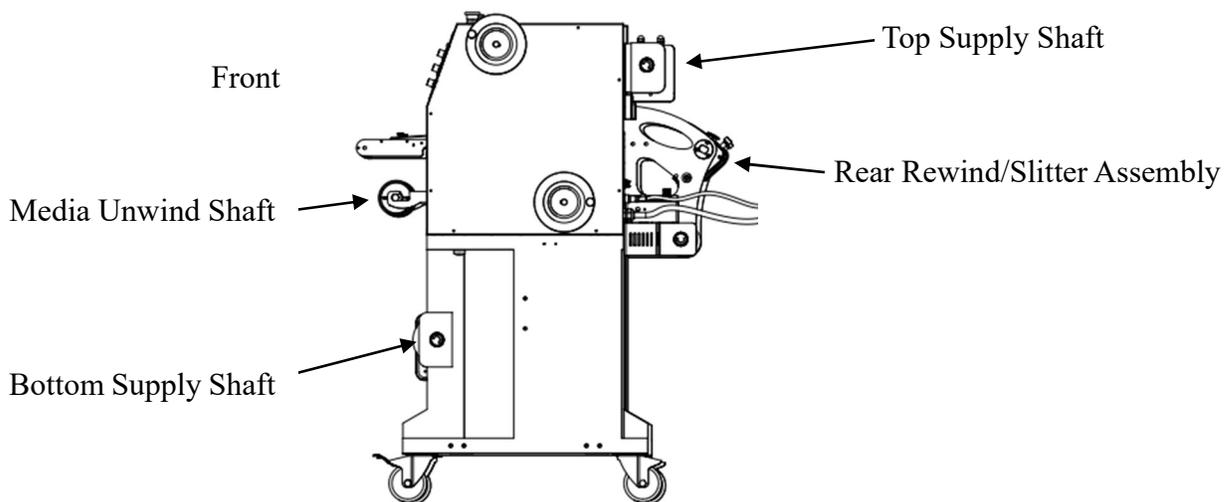
8 F. Set the Machine on the Stand

1. Remove the machine from the bottom supports of the skid.
2. Lift the machine onto support stand using a **FORKLIFT** and lifting straps that can lift 1000 lbs., to locate the machine on the stand.



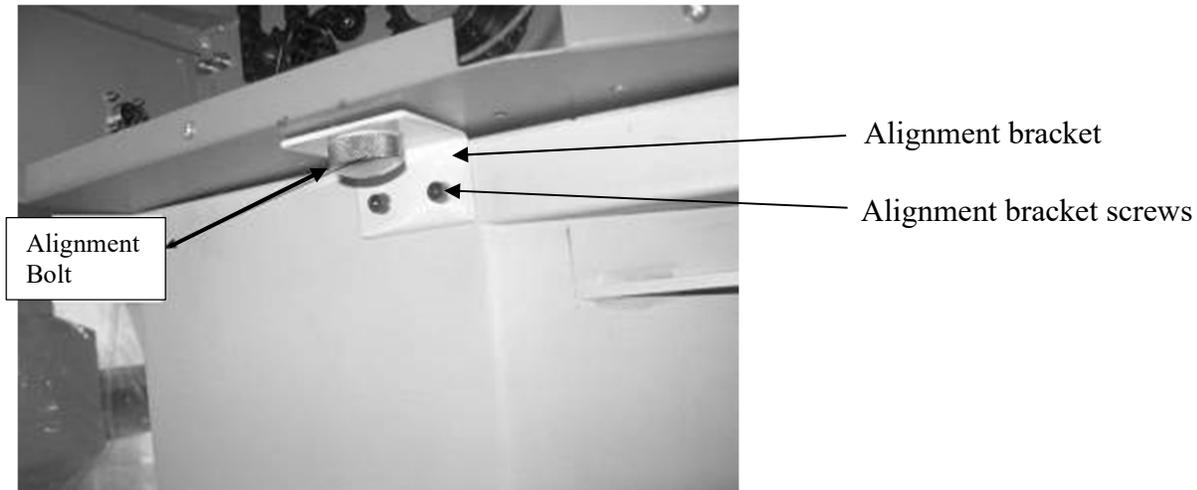
Heavy! Handle with care!!

NOTE: Bottom Supply Shaft on the stand goes to the Front of the machine



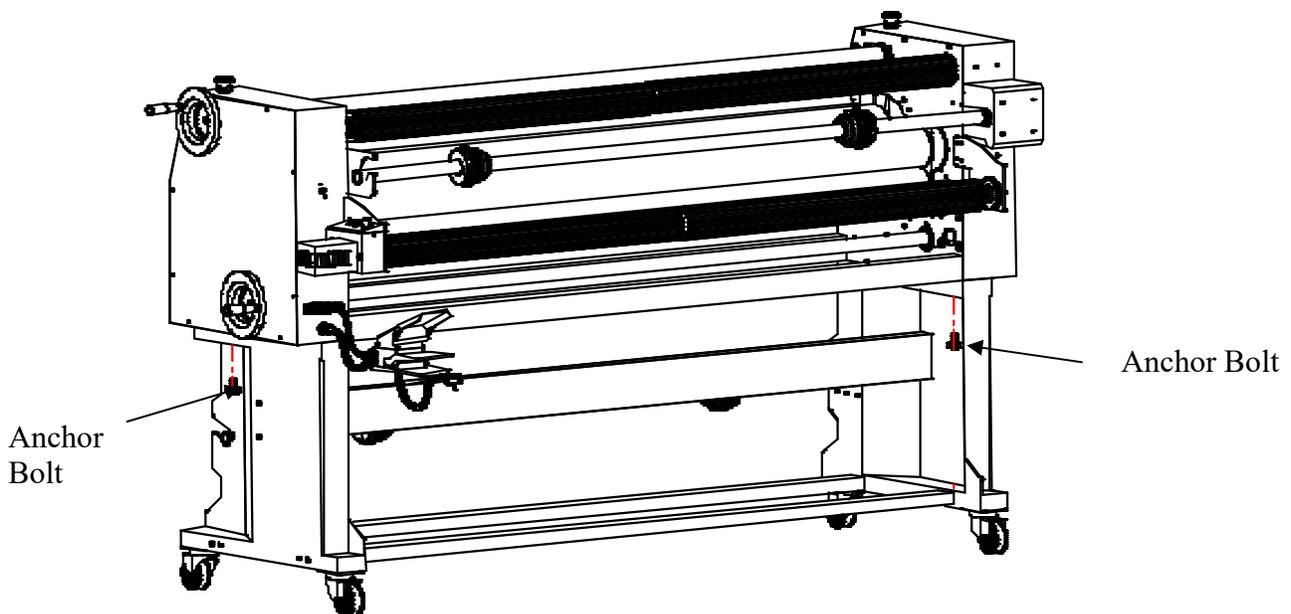
8 G. Align the Machine to the Stand

1. Attach alignment brackets to outside of both stand legs
2. Insert one alignment anchor bolt through the bracket on the outside of the stand into bottom of the machine on each side.
3. Secure the alignment bolt to the inside of the cabinet with the provided flat washer, lock washer and hex nut.



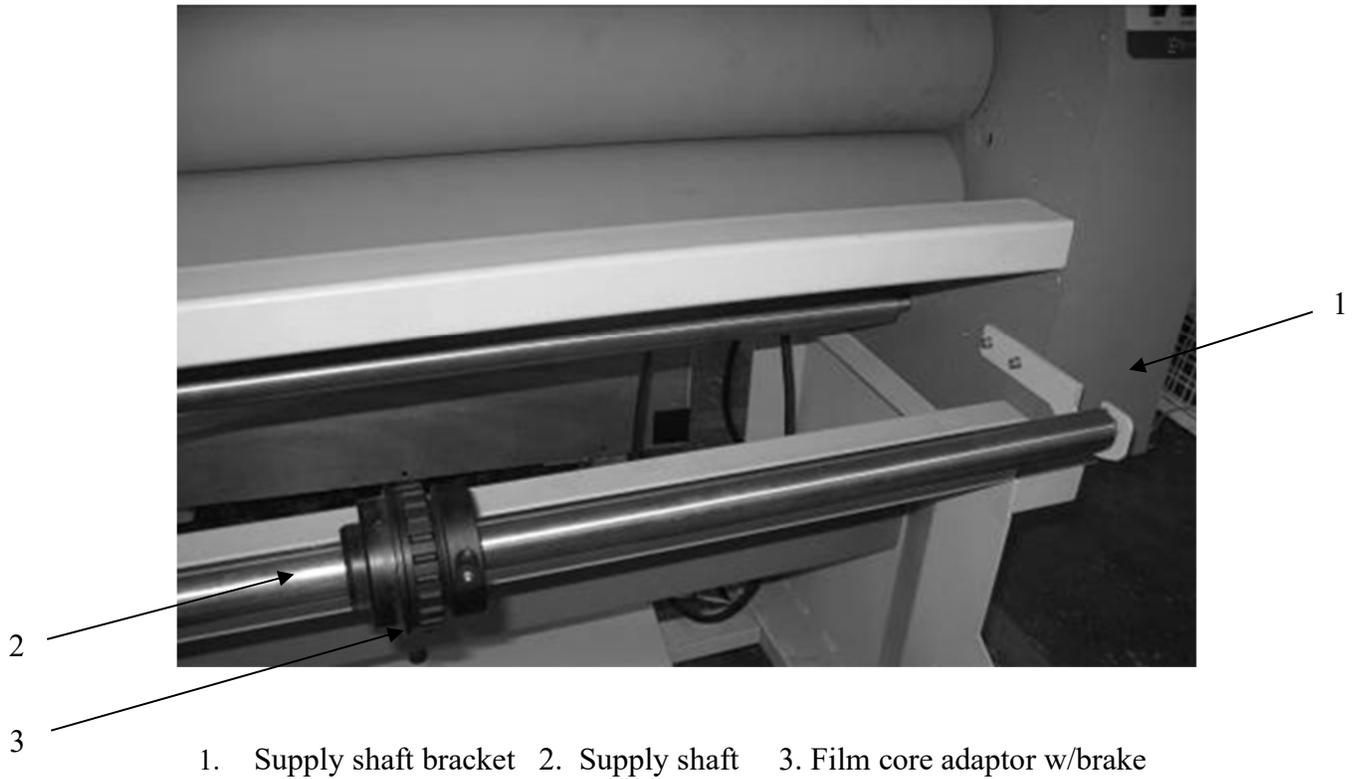
NOTE: Failure to properly install the alignment brackets will result in the web skewing which will end in costly ruined output.

4. Insert four (4) anchor bolts through the stand into the bottom of machine.



8 H. Install the Front Media Unwind Shaft

1. Bolt left and right supply shaft brackets inside machine frame.
2. Insert Supply shaft and film core adaptors.



9. Installing the Heat Tubes

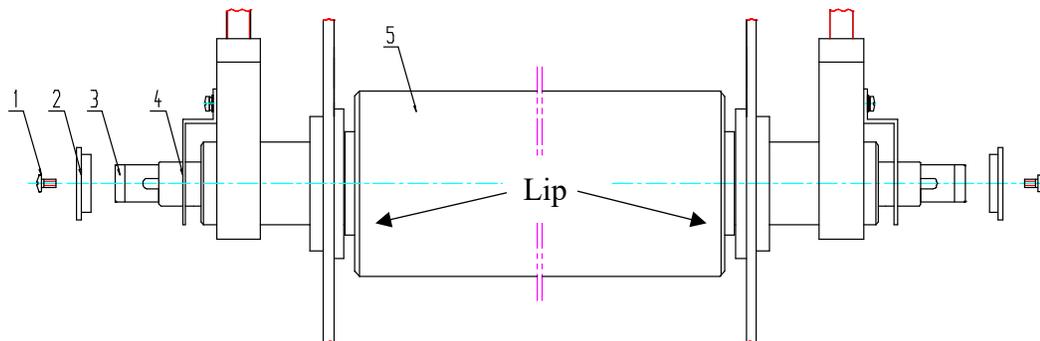


Warning: Do not attempt this with the machine plugged in. Machine must be unplugged and the power turned off!

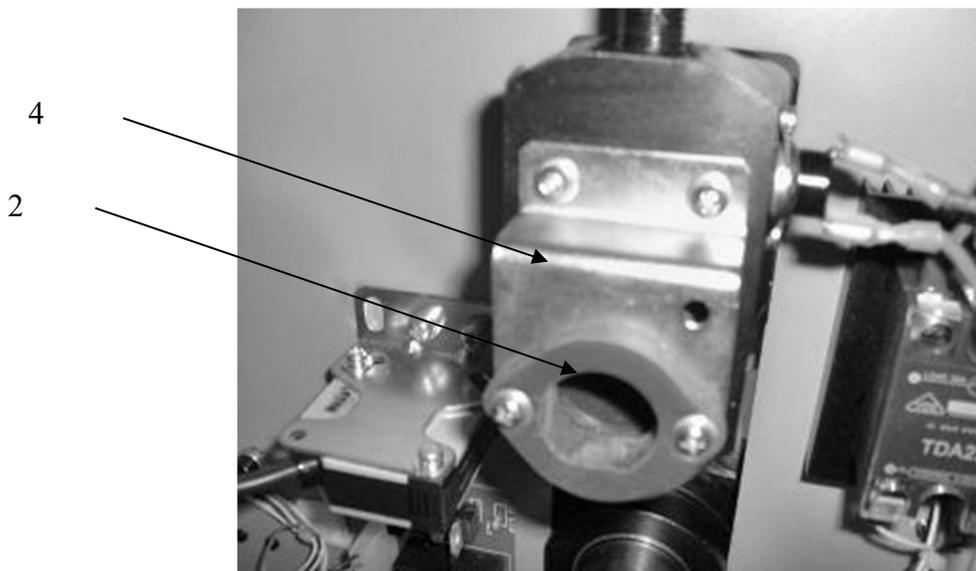
9 A. Inserting the Heat Tubes

1. Remove Hand Wheels from right side cover.
2. Remove the right and left cabinet covers.
3. Remove left and right heater rubber cushion (2) from support brackets (4).
4. Insert heat tube through the core of the roller (longer heat tube on top).
5. Align ends with flat spots with flat side of rubber cushions.
6. Replace left and right heater rubber cushions.

NOTE: There is a lip on the inside of the roller; you will have to **carefully** cantilever the heat tubes

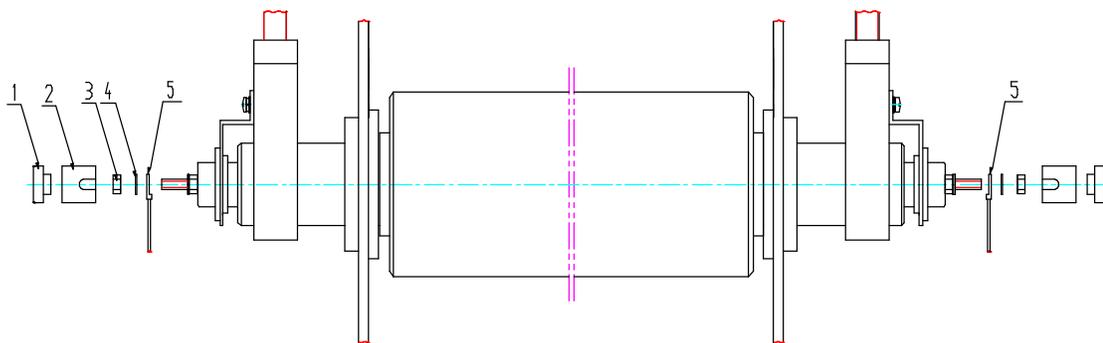


1. Screw 2. Rubber cushion 3. Heat tube 4. Support Bracket 5. Roller

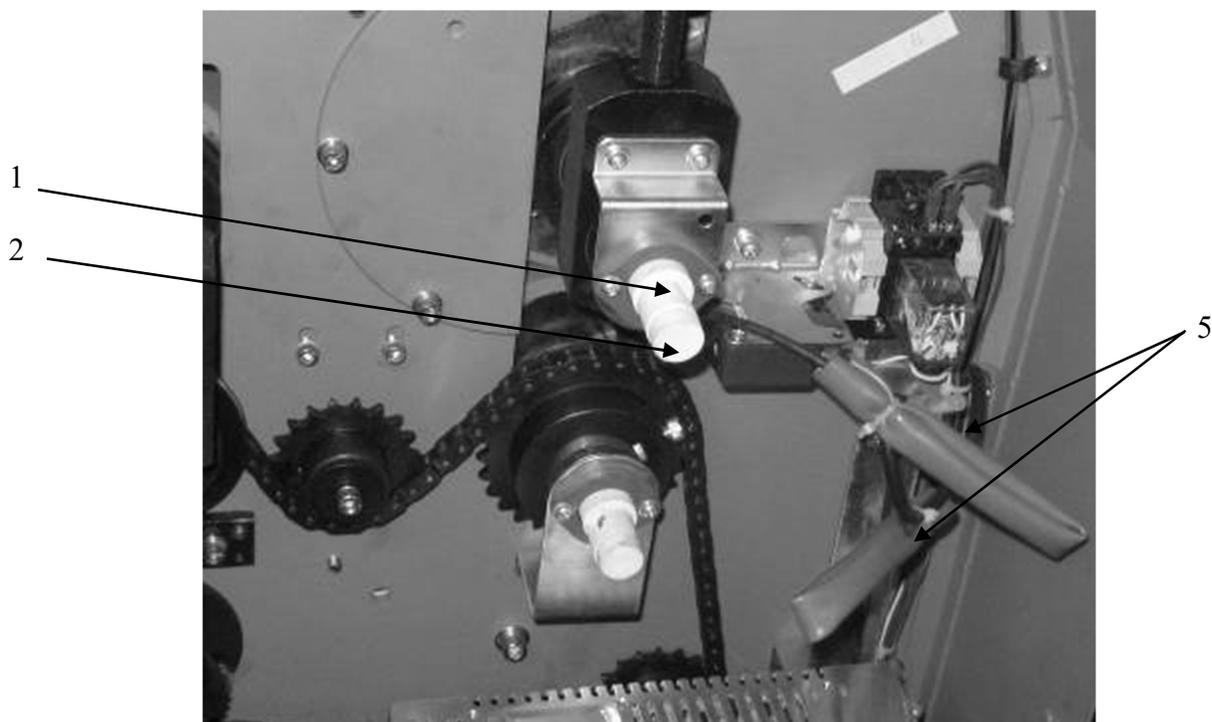


9 B. Connecting the Electric Wires

1. With the tube in place, remove the porcelain sleeve (1), porcelain cap (2), hex nut (3), and flat washer (4) from both ends.
2. Connect the two ends to the electric wire connectors for both top and bottom heaters.
3. Replace flat washer, hex nut, porcelain insert and porcelain cap.
4. Replace side covers and hand wheel.



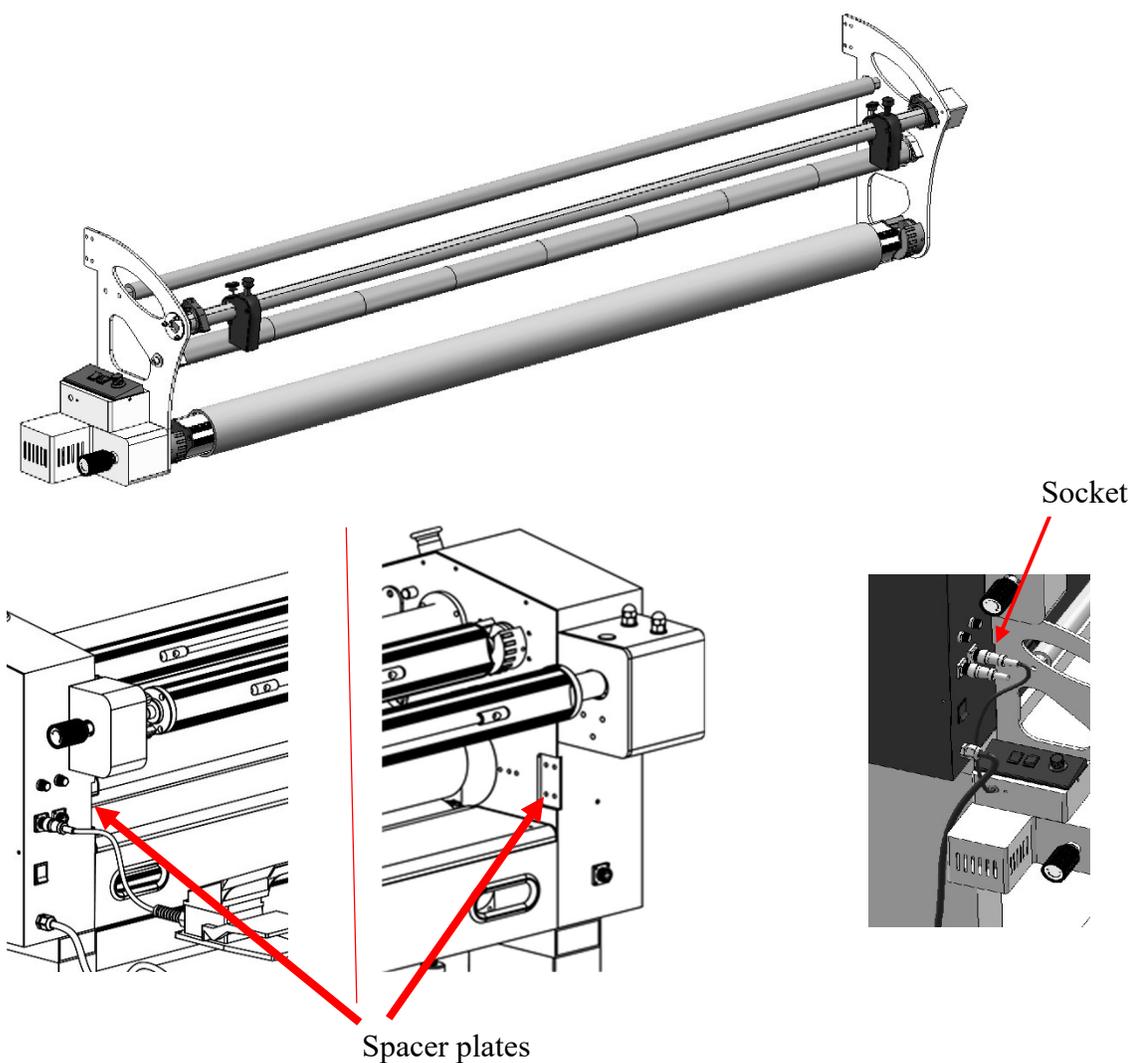
1. Porcelain sleeve 2. Porcelain cap 3. Hex nut 4. Flat washer 5. Electric wire connector



10. Installing the Lower Rear Rewind

1. Remove the spacer plates from each side of the machine.
2. Install the right-side bracket w/cradle with the supplied hardware.
3. Install the left side bracket with the Control Panel on the left side of the machine.
4. Insert the power jack into the corresponding receptacle.

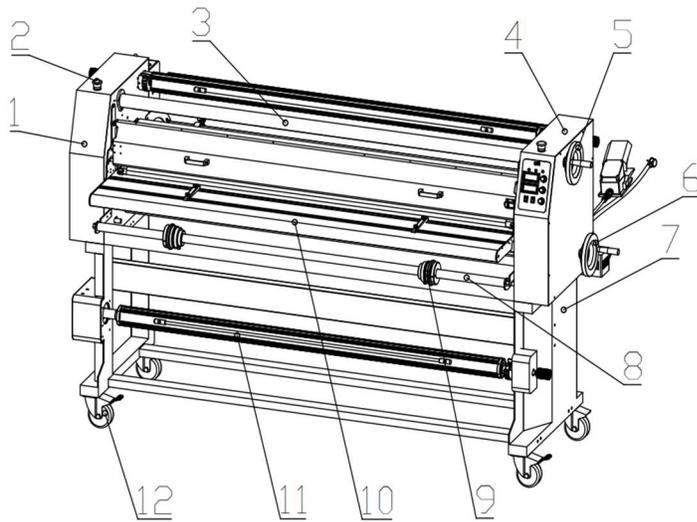
NOTE: Holes with the paint removed will receive the bolts with the 'star' washers.



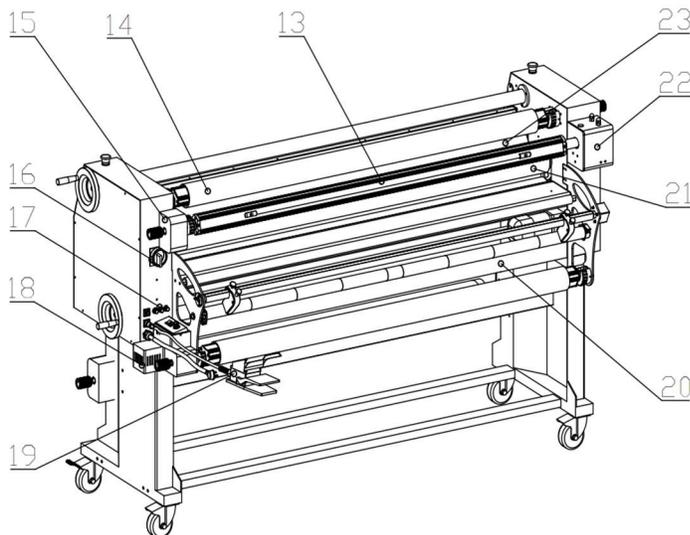
11. Additional Installation Items

5. Check drive chains for tightness.
6. Check all drive set screws for tightness.
7. Check all electrical connections and input power and test for proper operation.

12. System Components

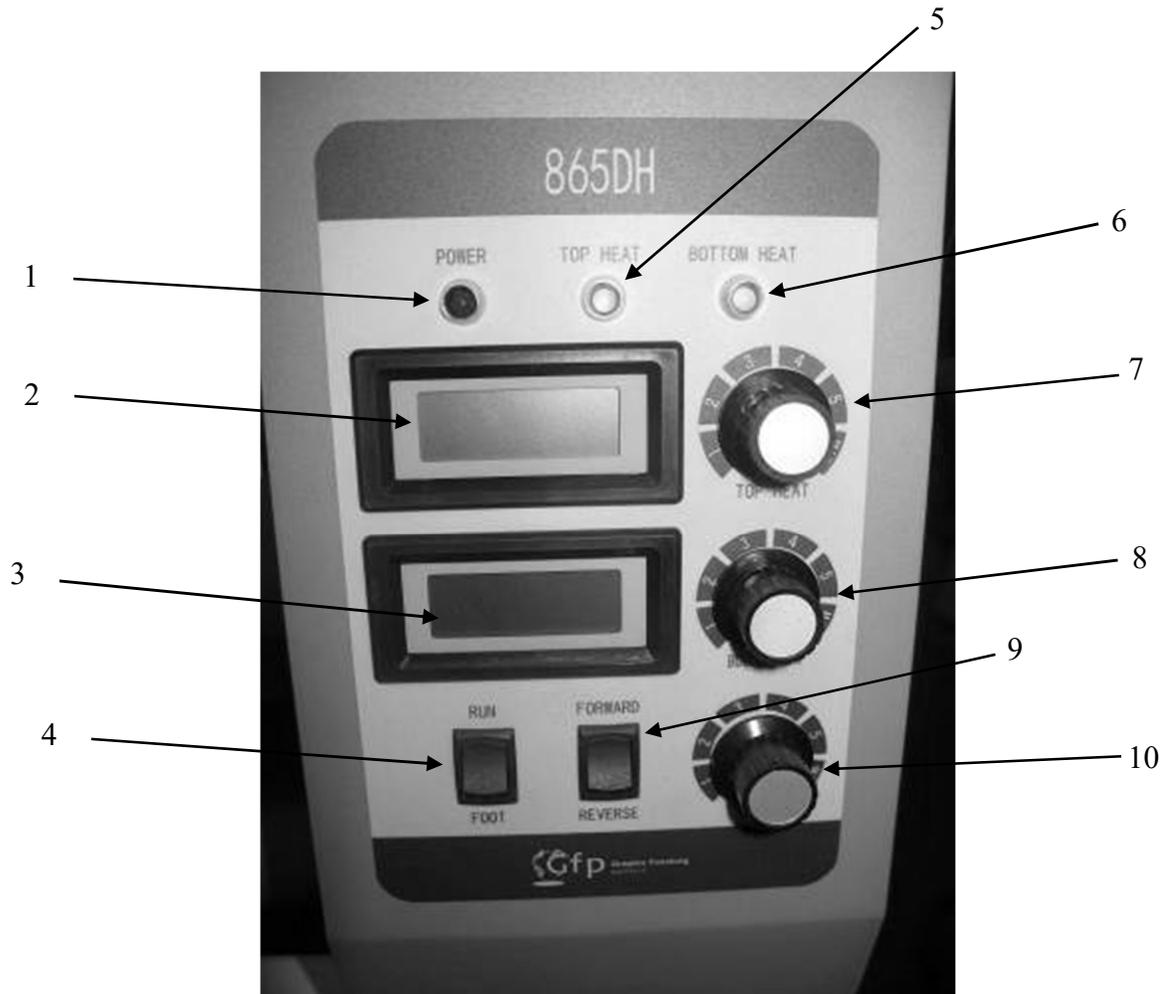


1. Left Side Cabinet
2. Emergency Stop Switch (E-Stop)
3. Linkage Shaft for pressure-adjustment
4. Right Side Cabinet
5. Pressure-adjust Handwheel, Heat Rollers
6. Pressure-adjust Handwheel, Pull Rollers
7. Stand
8. Lower Supply Shaft
9. Core Adaptor w/Brake Assembly
10. Feed Tray
11. Bottom Swing-Out Unwind Shaft
12. Castor w/Brake



13. Top Swing-Out Supply Shaft
14. Top Rewind Shaft for Release Liner
15. Upper Supply Shaft Brake Assembly
16. Main ON/OFF Rotary Switch
17. Fuses
18. Lower Rear Rewind Control Panel
19. Foot Pedal
20. Lower Rear Support Bar
21. Upper Heat Sensor Bar
22. Upper Supply Shaft Axis Housing
23. Upper Rewind Shaft Clutch Knob

13. Control Panel



1. Power Indicator
2. Top Roller Temp Display
3. Bottom Roller Temp Display
4. RUN/FOOT Switch
5. Top Heat Indicator

6. Bottom Heat Indicator
7. Top Heat Control Knob
8. Bottom heat Control Knob
9. FORWARD/REVERSE Switch
10. Speed Control Knob

Note:

1. The machine does not have continuous Reverse. Reverse can only operate using the foot pedal.
2. If the photo-electric eye stops the machine, wait 5 seconds, move operation switch to “FOOT” then back to “RUN” operation.
3. Temperature control knobs include ON/OFF switches. Full turn counterclockwise will turn heater off.
4. Heat indicator lights will flash RED until they approach the set temperature, they will then flash reddish green. Once they reach selected temperature, they will turn to solid GREEN.

14. Operation

1. General operation

- Turn power to “ON” with the rear rotary power switch, POWER light on control will illuminate.

2. Cold laminating:

- When doing cold laminating, make sure both temperature dials are turned fully counterclockwise to turn off heaters.
- Adjust speed dial to desired position.

3. Top Heat Assist Laminating for PSA Films

- Rotate TOP heater dial clockwise to turn on the top heater only.
- Select desired temperature setting.
- Recommended temperature setting for most applications with PSA film is dial setting 2 for approximately 100° F.
- Recommended speed setting is dial setting 2 for 5 ft./min..

4. Thermal Laminating (Encapsulation)

- Turn both temperature dials clockwise to turn on both top and bottom heaters.
- Select desired temperature and speed settings.
- Recommended temperature settings:
 - a. Low temperature film (activation temperature 185° F) - Dial setting 4 = +/- 200° F
 - b. High temperature film (activation temperature 210° F) - Dial setting 5 = +/- 230° F
- Recommended speed settings

<u>Film gauge</u>	<u>Dial</u>	<u>ft./min</u>
1.5 mil	4	8
3.0 mil	2.5	6
5.0 mil	2	5
10 mil	1.5	2.5

NOTE:

- Recommended settings are starting points only and should be adjusted according to quality of output achieved.
- Excess heat may damage the printed image or cause waves. Insufficient heat may result in ‘silvering’ and poor lamination.
- Thinner stocks can be run faster while thicker stocks or heavy ink coverage should be run slower.
- Some stocks and ink-sets cannot be effectively laminated with thermal films. Compatibility testing is recommended before laminating long runs.

NOTE: The surface temperature of the rollers is shown on the LCD readout. The LCD does not work when the heaters are turned off.

15. Removing Print Hold-down Assembly

1. For roll-to-roll applications and mounting, it may be necessary to remove the print hold down assembly.
2. Unscrew the knurled thumb screws securing the Print Hold-down Assembly.
3. Lift off and remove assembly.



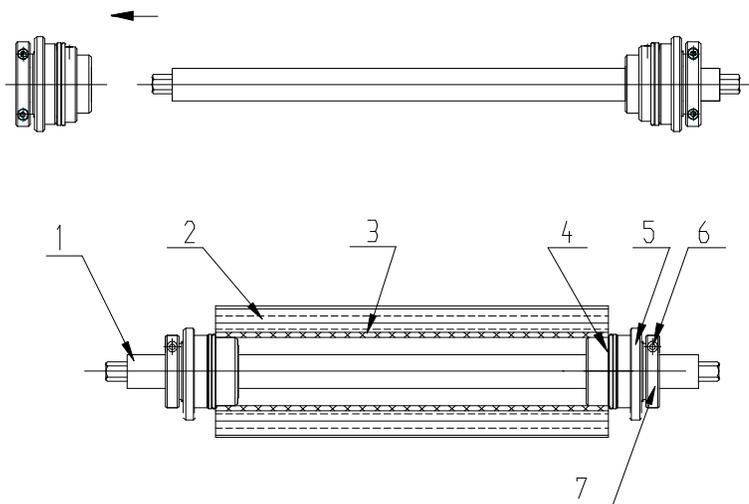
16. Loading Film

1. Swing out the top supply shaft.
2. Loosen the fastening screws on the film core adaptor on one side of the supply shaft, then slide it off the supply shaft.
3. Slide the film rolls onto the supply shaft.

4. Return the film core adaptor to the supply shaft.
5. Position the film in the middle of the supply shaft and measure the distance from one side of the film core adaptor to the side frame or use the substrate width positions pre-printed on the supply shaft.
6. Fasten the screws for film core adaptor (Note: there should be 1/8" clearance between the positioning and the adjusting sleeves of the film core adaptor to make brake adjustment easier),
7. Adjust the brake tension by turning the adjusting sleeve (Note: the brake tension should not prevent roll from turning)
8. Repeat process with the bottom supply shaft.
9. Position bottom roll same distance from side frame as the top supply roll or use the pre-printed positions on the supply shafts.



Warning Ensure the safety shield is in place before operating the Laminator. Operating without the safety shield can cause serious injury



- | | |
|--|---|
| 1. Axles of the supply shaft | 5. Adjusting sleeve |
| 2. Cold laminating film (lining paper) | 6. Fastening screws for the film core adaptor |
| 3. Film Core | 7. Film core adaptor |
| 4. Positioning sleeve | |

17. Threading Film

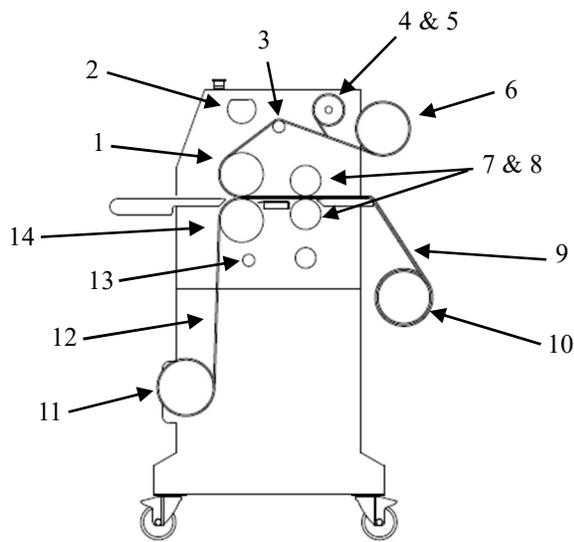
17 A. Cold PSA Film

1. Place cold film roll on top supply shaft and a roll of media on the bottom.
(See “Loading Film” section 15)
2. Pull the film and paper liner by hand over the top idler roller drape down across the front Nip roller.
3. Turn the front hand-wheel counterclockwise to raise the front Nip roller.
4. Turn the rear hand-wheel to raise the rear pull. This roller will remain in the up position when using Cold PSA film
5. Pass the film through the Nip rollers, between the pull rollers, and lay on the rear exit panel. Pull the film flat then turn the front hand wheel to lower the front Nip roller.
6. Separate the paper liner from the film web between the supply roll and the idler roller and pull the liner up and tape it to the cardboard tube on the top rewind tube.
7. Use foot pedal to advance the film web until the adhesive is exposed on the front of the Nip roller.
8. Raise the feed tray assembly.
9. Bring the bottom media roll up behind the idler roller and tack to the exposed film web adhesive.
10. Lower the feed tray assembly.
11. Use foot pedal to advance both webs until cleared of the nip rollers.
12. Lower the top Nip roller to the desired nip pressure.

NOTE: Slide film cutter between the paper liner and film to cut liner only. Be careful not to cut the top heat roller.

NOTE: The film should be wrinkleless and tight to the surface of the heat roller. If wrinkles appear in the film web, adjust the brake tension on both sides of the film roll.

NOTE: When using a roll of mounting adhesive on the bottom shaft, follow the same procedure but web the mounting adhesive **IN FRONT OF** the bottom idler roller in this illustration



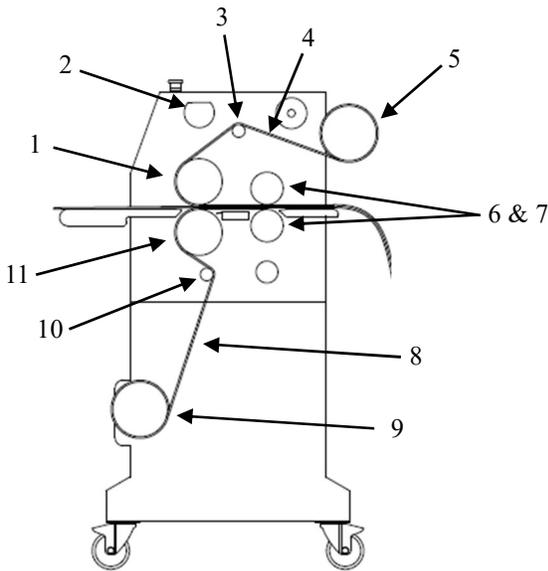
1. Top Heat Roller
2. Linkage Shaft for Roller Adjustment
3. Top Idler Roller
4. Liner Rewind Tube
5. Paper Liner
6. PSA Film Roll
7. Top Rear Pull Roller
8. Bottom Rear Pull Roller
9. PSA Film Web
10. Rear Rewind
11. Bottom Supply Roll
12. Mount Adhesive
13. Bottom Idler Roller
14. Bottom Heat Roller

17 B. Thermal Film Threading

1. Place thermal film roll on top and bottom supply shafts.
(See "Loading film" section 14)
2. Pull the top film over the top idler roller and drape down across the front Nip roller.
3. Turn the front hand-wheel counterclockwise to raise the front Nip roller.
4. Turn the rear hand-wheel to raise the rear pull.
5. Raise the feed tray assembly.
6. Pull the bottom film behind the bottom idler roller and up over the two nip rollers.
7. Using a threading board, pass the two film webs through the Nip rollers,
8. Lower the top nip roller by turning the front hand wheel clockwise until the two rollers touch.
9. Use foot pedal to advance the film web into the Pull rollers then lower the rear puller roller by turning the rear hand wheel clockwise until the rollers touch.
10. Lower the feed tray assembly.
11. Use foot pedal to advance both webs until cleared of the pull rollers.
12. Adjust the roller pressure on both sets of rollers to the desired position.



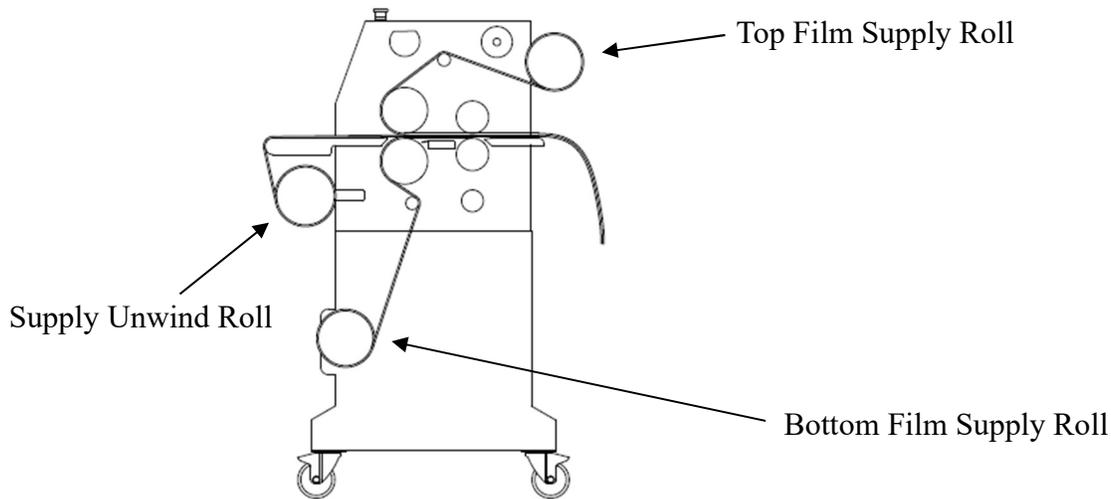
Warning Ensure the safety shield is in place before operating the Laminator. Operating without the safety shield can cause serious injury.



1. Top Heat Roller
2. Linkage Shaft for Roller Adjustment
3. Top Idler Roller
4. Top Film Web
5. Top Film Supply Roll
6. Top Rear Pull Roller
7. Bottom Rear Pull Roller
8. Bottom Film Web
9. Bottom Film Supply Roll
10. Bottom Idler Roller
11. Bottom Heat Roller

17 C. Threading Media Unwind for Encapsulation w/Thermal Film

1. Thread two rolls of thermal film as in section 17 B. above.
2. Remove supply shaft from front unwind brackets.
2. Loosen the fastening screws on the film core adaptor on one side of the supply shaft and slide it off the supply shaft.
3. Slide the media roll onto the supply shaft.
4. Return the film core adaptor to the supply shaft.
5. Position the media in the middle of the supply shaft and measure the distance from one side of the film core adaptor to the side frame or use the substrate width positions printed on the supply shaft.
6. Fasten the screws for film core adaptor.
7. (Note: there should be 1/8" clearance between the positioning and the adjusting sleeves of the film core adaptor to make brake adjustment easier),
8. Adjust the brake tension by turning the adjusting sleeve (**NOTE:** the brake tension should not prevent roll from turning)
9. Pull media web up over the feed tray and align with thermal film web. Loosen film core adaptors and move media web into desired position then retighten.
10. Use foot pedal to advance the film web while pushing media web into the nip point where it will contact the hot film and be pulled through the machine.



18. Roller Pressure Adjustment

- When the pressure-adjusting hand-wheel is turned clockwise, the top rubber roller comes down and the pressure will increase.
- When turned counterclockwise, the top rubber roller goes up and the pressure will decrease.
- Too much nip pressure will wrinkle the output through the center of the web. Lower the top roller until it just touches the film, note the position of the handle on the hand wheel and increase one (1) number on the face of a clock.

19. Roller Gap Adjustment

To check for uneven roller gap:

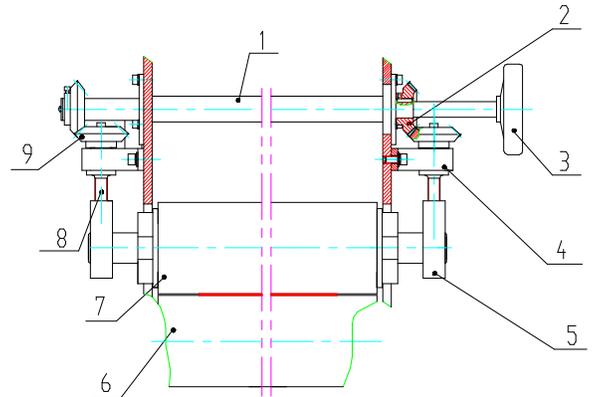
- Place a sheet of paper between the rollers the full width of the laminator.
 - Turn the pressure-adjusting hand wheel to lower the upper rubber roller.
 - Apply some pressure so the two rollers just touch.
 - Check to see if the space in between the rubber rollers is even across the machine.
1. If the space is not even:
 - a. Open the left and the right cabinet covers.
 - b. Check whether the left and right pressure-adjusting brackets are loose.
 2. If loose, tighten brackets and then replace cabinet covers.
 - a. Check whether the longitudinal taper gears on the two sides are loose.
 - b. If they are loose, take apart the left transverse taper gear and then remove the screws of

pressure-adjusting brackets, then tilt the longitudinal taper gear, and tighten the screws on the top of the gear.

3. Remove the left transverse taper gear, turn the longitudinal taper gear until the space of the two side.

of rubber rollers becomes even.

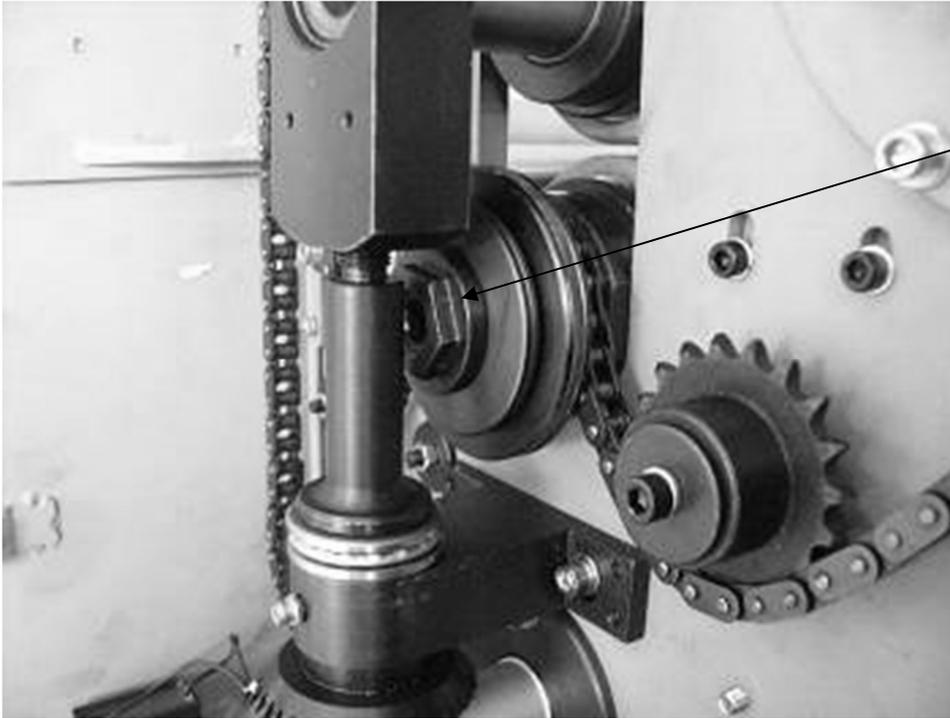
4. Tighten the screws of each component and replace the side covers.



1. Linkage Axle 2. Transverse Taper Gear 3. Pressure-Adjusting Hand-wheel
 4. Pressure-Adjusting Bracket 5. Pressure-Adjusting Blocks 6. Lower Rubber Roller
 7. Upper Rubber Roller 8. Jack Screw 9. Longitudinal Taper Gear

20. Pull Roller Clutch Adjustment

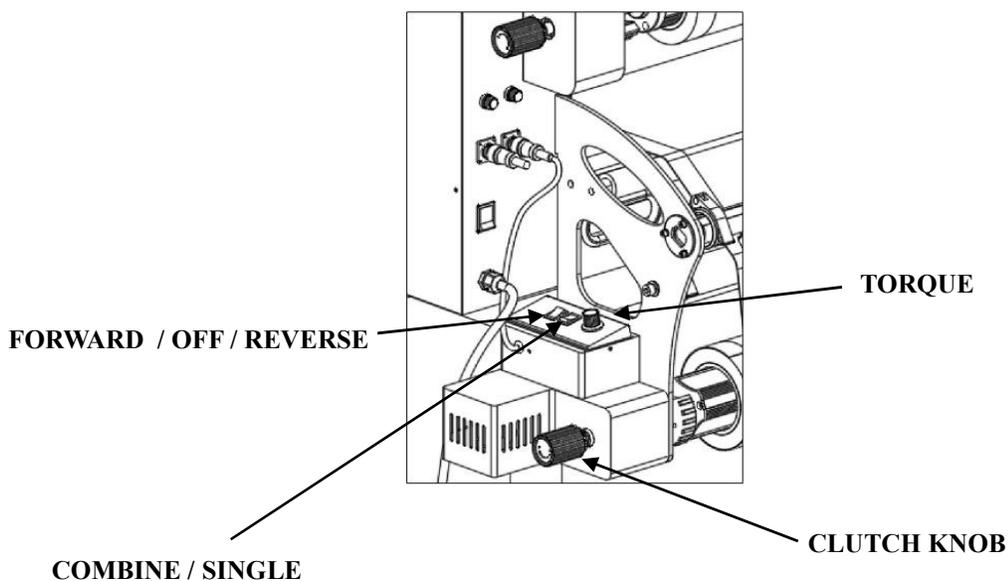
- A friction clutch is installed on the drive side of the rear lower pull roller shaft inside the left cabinet. Adjusting the compression nut will increase or decrease the rear pull roller speed to regulate film tension between the nip and the pull rollers.
- Adjust the compression nut by using the locking wrench supplied with the machine. Rotating the nut clockwise will increase speed of the pull rollers and so the film tension between the nip and pull rollers; a clockwise rotation will decrease the pull roller speed and so the film tension.
- The machine is adjusted before delivery; under normal conditions the clutch should not need further adjustment.
- However, if the output web has horizontal waves (across the width of the web), the clutch may need to be adjusted clockwise to increase the speed of the pull rollers. This will increase the web tension between the nip and pull rollers to reduce the horizontal waves.
- Conversely, if the output web has vertical waves (running the length of the web), the clutch may need to be adjusted counterclockwise to reduce the speed of the pull rollers. This will decrease the tension between the rollers and reduce the vertical waves.



Compression Nut

21. Using the Rear Rewind Assembly

1. **FORWARD/OFF/REVERSE:** Allows the operator to run the unit in forward or reverse
2. **TORQUE:** Increase/decrease the motor power for heavier webs.
3. **COMBINE/SINGLE:** Used if there is a separate rewind unit on the front. Most jobs will only require the use of Single.
4. **CLUTCH KNOB:** Increase/decrease the motor power for heavier webs.



22. Troubleshooting

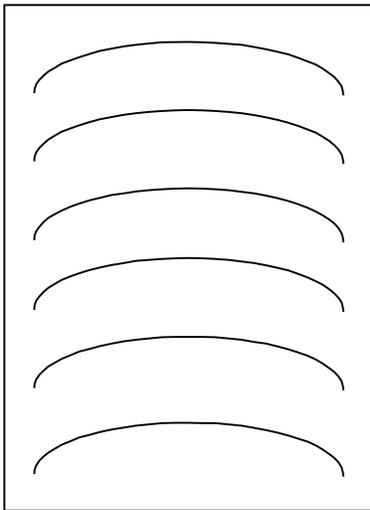
22 A. The Machine

Problems	Causes	Solutions
Machine does not turn on	<ol style="list-style-type: none"> 1. No power supply 2. Main power switch is OFF 3. Circuit breaker has tripped 4. Blown main power fuse 5. Motor has failed 	<ol style="list-style-type: none"> 1. Plug in power cord 2. Place power switch to ON 3. Reset circuit breaker 4. Replace fuse on rear panel 5. Change the electric motor
Rollers do not turn after “Run” button is pressed	<ol style="list-style-type: none"> 1. Emergency switch is engaged 2. Excess roller nip pressure 	<ol style="list-style-type: none"> 1. Disengage emergency switch 2. Reduce the nip pressure of the rubber rollers
Heat roller not heating	<ol style="list-style-type: none"> 1. Heater not set 	<ol style="list-style-type: none"> 1. Switch heater on, adjust temperature setting knob
Poor film adhesion or cloudy prints	<ol style="list-style-type: none"> 1. Nip roller pressure to low. 2. Dust on the surface of the print 	<ol style="list-style-type: none"> 1. Increase nip roller pressure 2. Clean print surface before lamination
Poor film adhesion on one side	<ol style="list-style-type: none"> 1. Nip roller pressure on the two sides is not even 	<ol style="list-style-type: none"> 1. See “Roller gap adjustment”
Lamination output is curled	<ol style="list-style-type: none"> 1. Sheet is curled upward 2. Sheet is curled downward 	<ol style="list-style-type: none"> 1. Reduce top roll tension 2. Reduce bottom roll tension
Film supply roll gets loose during operation	<ol style="list-style-type: none"> 1. Not enough brake tension on supply roll 	<ol style="list-style-type: none"> 1. Increase brake tension on supply roll
Backing paper gets loose when being rolled up	<ol style="list-style-type: none"> 1. Not enough brake tension on the backing paper rewind roller 	<ol style="list-style-type: none"> 1. Increase brake tension on backing paper rewind roller
Wrinkles in the center of the web, both on top and bottom	<ol style="list-style-type: none"> 1. Too much nip roller pressure 	<ol style="list-style-type: none"> 1. Reduce nip pressure with hand wheel

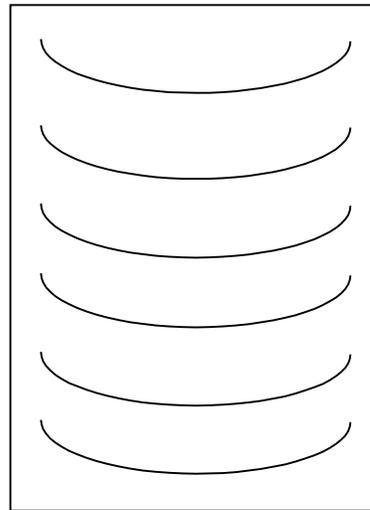
22. Troubleshooting

22 B. Thermal Film Output

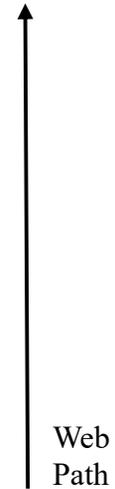
The conditions listed shown below can be a little complicated depending on where they are observed. Special attention needs to be paid to the area where the problem(s) is/are noticed. The Gfp 865DH does not have spring loaded rollers, they have a direct drive loading mechanism which eliminates the problems that can be caused from pressure spring failures.



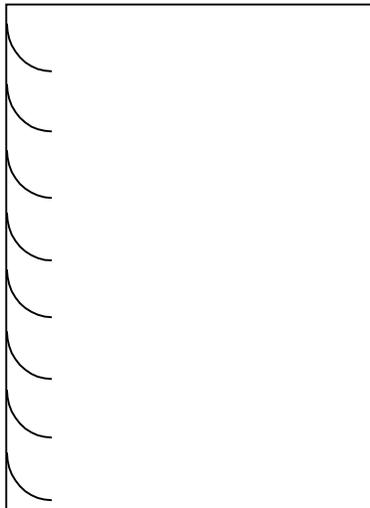
These two conditions are observed from the front of the machine where the items are being fed into the heat rollers



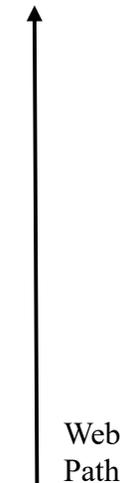
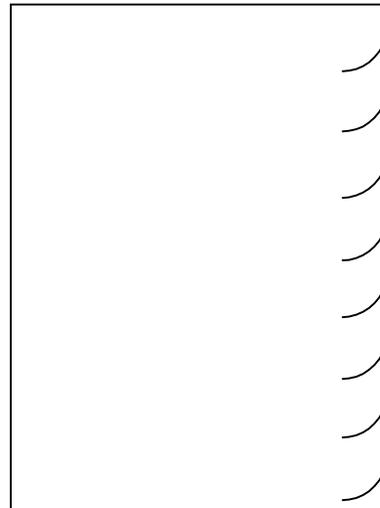
Heat rollers are pulling harder on the edges; release a little of the pressure



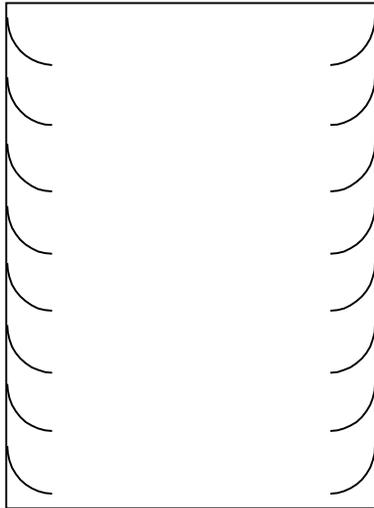
Heat rollers are pulling harder in the center; add a little more pressure



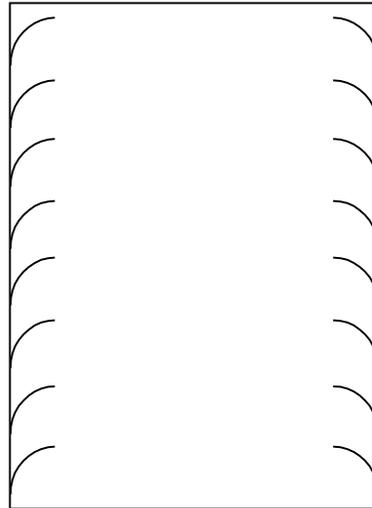
These two conditions are observed from the rear of the machine where the web is exiting the pull rollers



The nip pressure is off on either the left or the right side of the machine. A nip adjustment needs to be performed on the pull rollers, see **19. Roller Gap Adjustment**



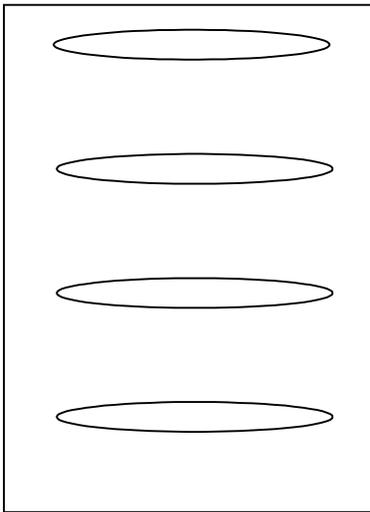
These two conditions are observed from either the area between the heat and pull rollers or the rear of the machine where the web is exiting the pull rollers



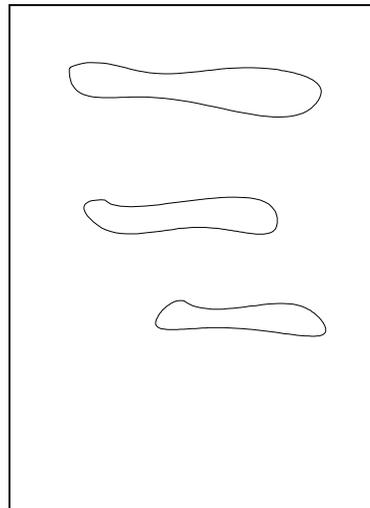
↑
Web Path

1. Clutch is too tight
2. Too much pressure on the pull rollers, see **20. Pull roller clutch adjustment**

1. Clutch is too loose
2. Not enough pressure on the pull rollers, see **20. Pull roller clutch adjustment**



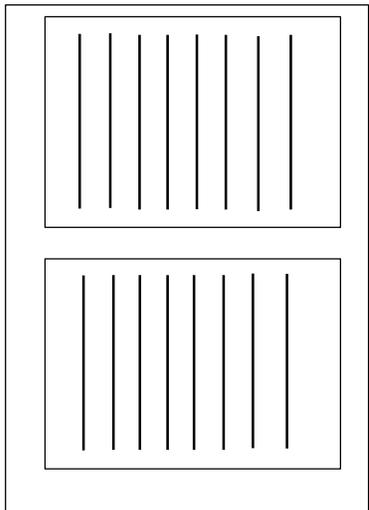
These two conditions are observed in the web after exiting the pull rollers



↑
Web Path

Consistent distance between the bubbles is caused by bowed rollers

Bubbles that start midway or near the end of the print are caused by excess moisture in the media



Media not compatible with high heat; receptive coating, film and adhesive cooling down at different rates

These two conditions are observed in the web after exiting the pull rollers



Lines consistent with the circumference of the rollers; flat spots on the heat roller from being left under pressure too long

23. Specifications

Description	865DH-4
Laminating Width	65"
Roller Diameter	5.25"
Roller Gap	1.2"
Max Temperature	266° F
Film core size	3"
Laminating Speed	0-13 Ft/min
Pressure Adjustment	Hand wheel
Heat Method	Quartz tube
Power Supply	240v 24 Amp
Power Consumption	5700 W
Net weight	847 lbs.
Output height	36"
Dimensions	87W x 49H x 45L"
Shipping weight Machine	1048 lbs.
Shipping dimensions machine	89.25W x 40.25H x 42.5L"



24. Warranty

January 2014

Graphic Finishing Partners, LLC warrants each new Gfp Laminator is free from defects in material and workmanship for a period of one (1) year from the date of installation. A machine which proves defective in materials or workmanship within the warranty period will be repaired or, at Gfp's option, replaced without charge. This warranty is extended only to the original purchaser.

This warranty is the only warranty made by Gfp and cannot be modified or amended. Gfp's sole and exclusive liability and the customer's sole and exclusive remedy under this warranty shall be, at Gfp's option, to repair or replace any such defective part or product. These remedies are only available if Gfp's examination of the product discloses to Gfp's satisfaction that such defects actually exist and were not caused by misuse, neglect, attempt to repair, unauthorized alteration or modification, incorrect line voltage, fire, accident, flood or other hazard.

The warranty made herein is in lieu of all other warranties, expressed or implied, including any warranty or merchantability or fitness for a particular purpose. Gfp will not be liable for personal damage or personal injury (unless primarily caused by its negligence), loss of profit, or other incidental or consequential damages arising out of the use or inability to use this equipment.

This warranty specifically does not cover damage to laminating rollers caused by knives, razor blades, or any sharp objects or abrasives, or failure caused by adhesives, or damage caused by lifting, tilting and/or any attempt to position the machine other than rolling on the installed castors or feet on even surfaces, or improper use of the machine. Warranty repair or replacement by Gfp or its authorized reseller(s) does not extend the warranty beyond the initial period from the date of installation. Unauthorized customer alterations will void this warranty.

Contact Information

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