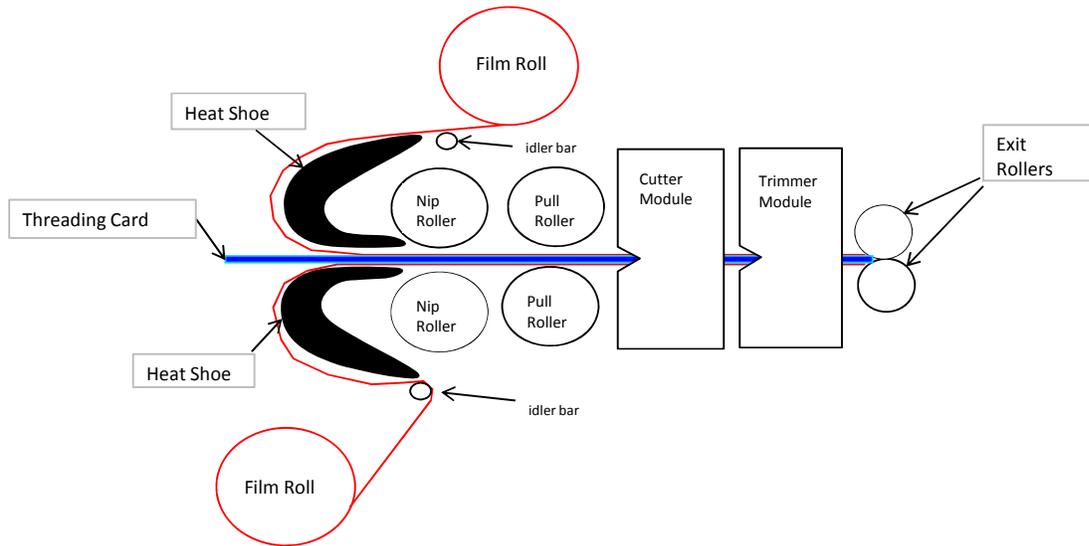


ALM Threading - Film Overlap Method



This method of threading the laminator is similar to threading any traditional laminator. It is important to note that there are a few extra steps to insure proper threading of the ALM3220. Most notably is making sure the trimmer knives are in the "Film Set" position. Additionally, the threading card will be pushed manually through the machine to the back exit rollers. Failure to manually push the threading card to this position could lead to a film wrap on the nip or pull rollers or potential damage to the cutter and trimmer modules can occur.

- 1.) Follow Diagram for correct threading path, over top idler bar, under bottom idler bar.
- 2.) Slightly overlap film from top roll and bottom roll 2 to 3 inches and tack film in place.
- 3.) Make sure nip rollers are in the open position.
- 4.) Make sure trimmer module knives are in "Film Set" position.
- 5.) Push threading card into overlap film and into the lamination nip area between the heat shoes.
- 6.) With your hand turn the top and bottom rolls of film to take tension off the web.
- 7.) Push the threading card by hand through the nip roller and pull roller sections.
- 8.) You may have to use your hand to again turn the top and bottom film rolls and take tension off the web.
- 9.) Continue pushing by hand the threading card through the cutter module and trimmer module
- 10.) Continue pushing threading card by hand until it stops. This will happen when the card meets the exit rollers.
- 11.) There should be approximately 2-3 inches of threading card remaining at the front if the card has made it all the way to the back exit rollers.
- 12.) If there is more than 2-3 inches of threading card remaining at the front, then the card has not made it through the cutter or trimmer module yet. Keep the card horizontal and level, and make sure film tension is slack by hand turning the film rolls to relieve tension....keep pushing until only 2-3 inches of card is visible and the card stops when it meets the back exit rollers.
- 13.) Close the lamination nip rollers.
- 14.) Manually advance film web with switch at the back of the machine near the trimmer module.
- 15.) The threading card with film tacked to it should exit the machine within 3-5 seconds.
- 16.) Count the seconds, if more than 5 seconds pass and the threading card does not begin exiting the machine, immediately stop advancing the laminator as a potential wrap and jam is taking place. You must start over from step number 1. But first clear the laminator by opening the nip rollers and reversing the drive and pulling the web clear from the front.
- 17.) If the threading card does begin to exit from the rear, continue to manually advance laminator by holding the switch until the entire threading card has exited.
- 18.) You can continue manually advancing the film with the switch to insure proper film alignment and tension (usually with 2-3 feet).
- 19.) Clear ALM of the threaded film by releasing the manual advance switch, then pressing the cutter button by the switch. After the cut, pull the tail of the film from the rear to clear the cutter and trimmer modules.
- 20.) Set film tension on the supply mandrels and position trimmer knives according for the sheet being run.
- 21.) Ready to laminate, place stack in feeder and hit start button.

