

# Wukonlami Laminating Machine Manual

Model: WK1700-T1



# Introduction

## 1. Warning

1. Installation and operation of this equipment must be carefully consulted in this manual.
2. Rubber roll skin material is silica gel, open packaging or use process, can not be touched with hard or sharp blades.
3. When installing the left and right brackets of the drawing mandrel, the seams must be closely seamed.
4. When removing quartz tubes, great care must be taken. Quartz tubes are fragile parts and must be handled lightly.
5. When opening the cover plate of the chassis, be sure to screw the last two screws and drop suddenly, breaking the oil-water separator and others.
6. When installing quartz tube, do not connect 220 volt voltage. After installing quartz tube, remember to seal the cover plate of the chassis to prevent the human body from touching the electronic components in the chassis, which will affect the safety of people and property.
7. Do not place your hand in the middle of the cots to prevent gripping; do not place hard objects and blades on the aluminium platform to damage the cots.
8. After coating, remember to place soft film between cots to prolong the service life of cots.
9. Cots can be scrubbed with alcohol. Do not scrub with a cloth with hard impurities such as wire.
10. Access appropriate power supply.

## 2. Description

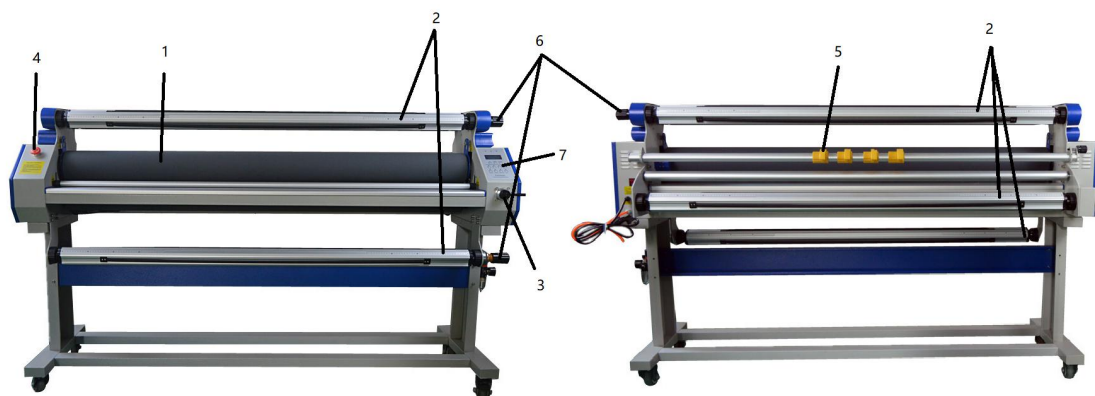
WK1700-S1 is a new type of coating equipment, which has the functions of automatic stripping of paper lining and photo winding. The bottom roll is driven by a motor, and the film with rubber surface and the picture are pressed and driven by the top roll and the bottom roll to form an automatic stripping of lining paper, which is to form the linear internal force movement of the printed image between the main rolls and avoid the tedious manual winding. Labor saving and simple operation. Because of its innovative structure, it has been welcomed by users since its launch.

The machine has four film mandrels and two silicone rollers to support continuous film or long picture film coating. And through the rolling force of the main roll, the automatic stripping and photo winding of the lining are realized. It is easy to use, efficient, energy-saving and easy to adjust speed.

### 3. Technical parameters

Maximum covering width	1600 mm	Maximum film covering speed	6 m/min
Cot lifting height	28mm	Cots material	Silica gel
Top cot diameter	130mm	Bottom cot diameter	110 mm
Heating mode	Infrared heating	Heating temperature	Room- 60 degrees
Heating power	2000W	Cot lifting method	Pneumatic lifting
Motor Power	80W	Voltage	220V (110v)
Equipment size	2000X800X1360mm	Packaging size	2150X800X730mm
Net weight of equipment	160kg	Packing Gross Weight	200 kg

### 4. Part name



#### 1. Top and bottom rollers

The top roll and bottom roll are one of the most important parts of the film covering machine, whose material is silica gel. Silica gel has the characteristics of high temperature resistance, wear resistance, corrosion resistance and non-sticky.

#### 2. Drawing axis, film axis, paper axis and finished product axis

The four mandrels are composed of aluminum rods, aluminum heads, bearings, rubber strips and other components. The outer diameter is controlled within 3 inches, which facilitates the loading and unloading of conventional film products on the market, such as yellow film, laminating film and so on. In the operation process, rubber strips play a slippery role to ensure that there is no sliding, too loose, too tight and so on.

#### 3. Pneumatic switch and cylinder

Pneumatic switch has upper, middle and lower three models. In the case of air in the equipment, the top roll can be lifted up, the top roll can be lowered down, and the middle gear can temporarily lock the air inflow and output. The cylinder type of this equipment is SDA50-30, which makes the lifting height of top roll more than 28 mm. With the use of pneumatic system,

the lifting and descending of top rollers are synchronized, and the re-pressure plays a key role.

#### 4. Emergency stop switch

When the machine is in an emergency or dangerous state, the power supply can be cut off by the emergency stop switch and the equipment can be stopped to protect the safety of the person and equipment.

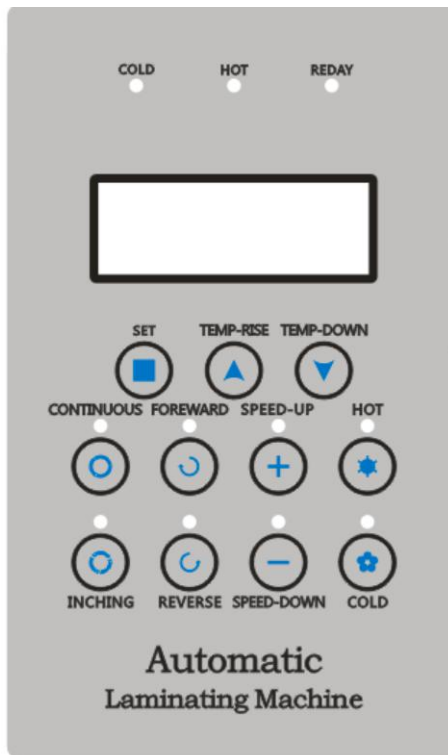
#### 5. Cutter (optional)

The use of cutting knife can make it possible to cut vertically and white edges at the same time in the process of film covering.

#### 6. Tighten your grip.


The tightening handle is mainly used to adjust the tightening force of four mandrels. Before leaving the factory, the four handles have been debugged accordingly. Users can use them directly. The tightening force is increased by twisting clockwise; the tightening force is reduced by twisting counterclockwise.


#### 7. Simple panel





(1) Speed settings: 0-9, with up  and down

 buttons.

(2) Film covering: press FOREWARD key  and the indicator light is on, the cot is turning forward and the film covering begins.

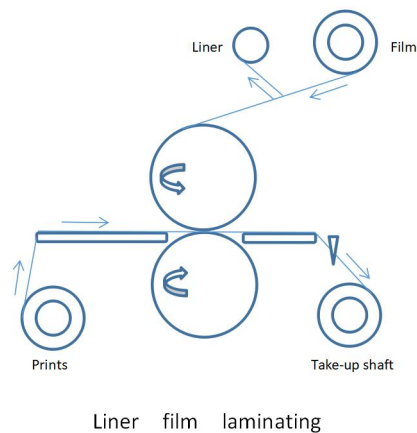
(3) Removing film: press REVERSE key  and the indicator light is on, the cots are reversed.

(4) Temperature settings: TEMP-RISE  ,  
TEMP-DOWN 

(5) Mode settings: HOT and Cold, CONTINUOUS  and INCHING .

## 5. Operation instructions

### 1. Working sketch map



### 2. Operation steps

(1) Turn on the main power supply.

(2) If the room temperature is higher, press the COLD key. If the room temperature is low or can not reach the temperature required for film covering, press the HOT key, then press the temperature setting key, press the TEMP-UP key, set the required temperature to wait for heating, and then proceed to the next operation.

(3) Before coating, put the film and picture on the corresponding mandrel, the mandrel of receiving lining paper and finished products should be lined with paper cylinder. The mandrel has digital display. The material has 914, 1070, 1270, 1520 mm specifications. The material, picture and carton are all in the middle appropriate position, and the position of the same digital display is guaranteed.

(4) When the heating is over, press TEMP-DOWN key, then adjust the speed lower gear, such as 1 gear.

(5) According to the working sketch map, peel off the film and lining, make the picture and film flat and fit, press the pneumatic switch.

(6) Cover the film slowly. After a short distance, the finished product is taped onto the carton. At the same time, the cutting knife is positioned. Continue to step on the foot switch and continue to cover the film.

(7) In the process of film-covering, we should carefully observe whether the film and the picture are arched. If the picture is arched, we need to adjust the tension of the drawing mandrel. If the lining is rolled too slowly, we need to increase the tension of the lining mandrel. If there is a deviation in cutting, it can be adjusted by adjusting the knife to fine-tune the knob.

(8) When everything is normal, press the CONTINUOUS key and the film can be covered continuously and the speed can be increased.

When the coating is finished, press the INCHING key to finish the operation and continue the coating of the next roll of materials.

## 6. Installation instructions

1. Open the package. The list is as below.

Name	Quantity	Remark
Host	1	
Drawing mandrel left bracket	1	
Drawing mandrel right bracket	1	
Frame foot	2	Left and right general
Quartz tube	2	Only needs one installation to prevent damage during transportation.
Square tube (40-60)	2	
Oil-water separator	1	
Screw bag	1	
Description	1	

2. Remove the quartz tube gently.

3. Installing rack feet

4. Install oil-water separator.

5. Install the left and right brackets of the drawing mandrel. When installing the brackets, pay attention to the tightness of the seams.

6. Install quartz tube.



(A:Quartz tube B:White high temperature line)

(C:Quartz tube bracket D:Rubber roller)

7. Connect the air pump. The air pump is full and the air output is connected to the left side of the oil-water separator, and the right side interface is inserted into the trachea to supply gas to the equipment.

## **8. Troubleshooting**

**1. Simple panel shows, but cots do not rotate.**

**Check whether the emergency stop switch is pressed.**

**Check if the foot control key is pressed.**

**Check whether the output of the switching power supply is less than 24 volts.**

**Check whether the emergency stop switch is damaged.**

**Check whether the line is loose.**

**2. Can't add temperature.**

**Check whether the setting temperature is lower than the indoor temperature.**

**Check whether the temperature control switch is damaged.**

**Check whether the temperature control probe is damaged.**

**Check whether the quartz tube is damaged.**

**3. The temperature exceeds the set temperature (flushing temperature).**

**The temperature control probe has been damaged.**

**4. Plastic film deviation.**

**Check whether the cots are worn out.**

**Check whether the tension of the drawing mandrel can be adjusted and whether the friction disc has been worn.**

**Check whether the shaft and bearing in the aluminium head part of the drawing mandrel are slippery.**

**5. Laminating film.**

**Check whether the cots are damaged.**

**Check whether the left and right brackets of the drawing mandrel are fitted tightly or not.**

**Failure to fit on the same horizontal line is the main reason for the film wrinkling.**

**6. There are bubbles in the film.**

**Check whether the cots are damaged.**

**Check whether the barometer pointer is below 0.2Mpa.**

**7. Paper lining can't be put away.**

**Check the end of the discharge mandrel and whether the friction disc is worn.**

**Check the mandrel end, sprocket and long axle of receiving lining paper.**

**8. Shaft shaking of finished product.**

**Check the end of mandrel, sprocket and long axle.**

**Check that the end tension of finished mandrel is too tight or too loose.**