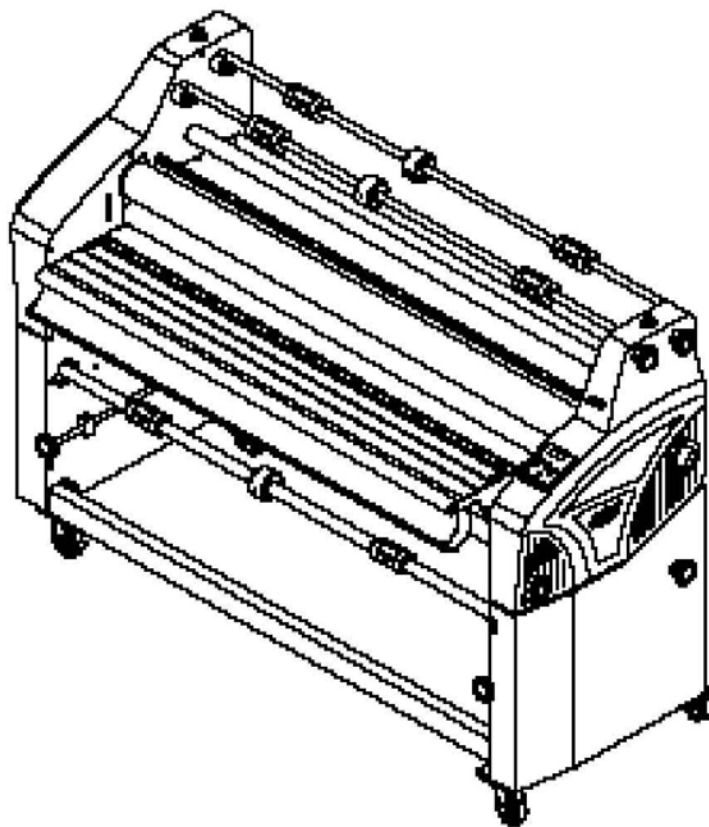


GBC 2080WFt

OPERATION AND MAINTENANCE MANUAL



Operating Instructions

I Istruzioni per l'Uso

D Bedienungsanleitungen

NL Gebruiksaanwijzing

F Mode d'Emploi

E Manual de Operación

PART NUMBER: 930-129

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IMPORTANT SAFETY INSTRUCTIONS

YOUR SAFETY AS WELL AS THE SAFETY OF OTHERS IS IMPORTANT TO GBC. IN THIS INSTRUCTION MANUAL AND ON THE PRODUCT, YOU WILL FIND IMPORTANT SAFETY MESSAGES REGARDING THE PRODUCT. READ THESE MESSAGES CAREFULLY. READ ALL OF THE INSTRUCTIONS AND SAVE THESE INSTRUCTIONS FOR LATER USE.

THE SAFETY ALERT SYMBOL PRECEDES EACH SAFETY MESSAGE IN THIS INSTRUCTION MANUAL. THE SYMBOL INDICATES A POTENTIAL PERSONAL SAFETY HAZARD TO YOU OR OTHERS, AS WELL AS PRODUCT OR PROPERTY DAMAGE. THE FOLLOWING WARNINGS ARE FOUND UPON THIS PRODUCT.

ADVERTENCIA Frequentemente verifique la zona dentro de la cubierta superior del laminador antes de cambiar el material a laminar.	ATTENTION Inspectez régulièrement l'intérieur de la zone de travail du laminateur avant de changer le matériau à laminer.		WARNING Frequent check inside laminator cover before changing material to be laminated.
--	--	---	---

THIS SAFETY MESSAGE MEANS THAT YOU COULD BE SERIOUSLY HURT OR KILLED IF YOU OPEN THE PRODUCT AND EXPOSE YOURSELF TO HAZARDOUS VOLTAGE.

ADVERTENCIA Al abrir la cubierta del laminador, preste atención a la zona de trabajo.	ATTENTION Lors de l'ouverture du laminateur, prenez garde à la zone de travail.		CAUTION HOT ROLLERS When opening laminator, be careful of hot rollers.
--	---	--	--

THIS SAFETY MESSAGE MEANS THAT YOU COULD BE BURNED AND YOUR FINGERS AND HANDS COULD BE TRAPPED AND CRUSHED IN THE HOT ROLLERS. CLOTHING, JEWELRY AND LONG HAIR COULD BE CAUGHT IN THE ROLLERS AND PULL YOU INTO THEM.

ADVERTENCIA Evite el uso de la mano para cortar el material. Use la guillotina.	ATTENTION Évitez d'utiliser la main pour couper le matériau. Utilisez la guillotine.		CAUTION SHARP BLADE Do not use hands to cut material.
---	--	---	--

THIS SAFETY MESSAGE MEANS THAT YOU COULD CUT YOURSELF IF YOU ARE NOT CAREFUL.

WARNING: THE SAFETY ALERT SYMBOL PRECEDES EACH SAFETY MESSAGE IN THIS INSTRUCTION MANUAL. THE SYMBOL INDICATES A POTENTIAL PERSONAL SAFETY HAZARD TO YOU OR OTHERS, AS WELL AS PRODUCT OR PROPERTY DAMAGE.

WARNING: DO NOT ATTEMPT TO SERVICE OR REPAIR THE LAMINATOR

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.



The safety alert symbol indicates that the surface of the part is HOT

IMPORTANT SAFEGUARDS

WARNING: TO GUARD AGAINST INJURY, THE FOLLOWING SAFETY PRECAUTIONS MUST BE OBSERVED IN THE INSTALLATION AND USE OF THE LAMINATOR.

General

Keep hands, long hair, loose clothing, and articles such as necklaces or ties away from the front of the heat and pull rollers to avoid entanglement and entrapment.

The heat rollers can reach temperatures over 300 ° F. Avoid contact with the heat rollers during operation or shortly after power has been removed from the laminator.

Keep hands and fingers away from the path of the sharp film cutter blade located at the film exit.

Do not use the laminator for other than its intended purpose.

Avoid moving the laminator on uneven floor surfaces. Never tilt the laminator.

Do not defeat or remove electrical and mechanical safety equipment such as interlocks, shields and guards.

Do not insert objects unsuitable for lamination or expose the equipment to liquids.

Electrical

The laminator should be connected only to a source of power as indicated in these instructions and on the serial plate located on the rear of the laminator.

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



CAUTION: The receptacle must be located near the equipment and easily accessible.

Do not operate the laminator with a damaged power supply cord or attachment plug, upon occurrence of a malfunction, or after the laminator has been damaged. Contact GBC's Technical Service Department or your dealer/distributor for assistance.

Service

Perform only the routine maintenance procedures referred to in these instructions.



WARNING: Do not attempt to service or repair the laminator.

Disconnect the plug from the receptacle and contact GBC's Technical Department or your dealer/distributor when one or more of the following has occurred.

- The power supply cord or attachment plug is damaged.
- Liquid has been spilled into the laminator.
- The laminator is malfunctioning after being mishandled.
- The laminator does not operate as described in these instructions.

WARRANTY

GBC warrants to the original purchaser for a period of ninety (90) days after installation that this laminator is free from defects in workmanship and material under normal use and service. GBC's obligation under this warranty is limited to replacement or repair, at GBC's option, of any part found defective by GBC without charge for material or labor.

This warranty is in lieu of all other warranties expressed or implied. **WARRANTIES OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE ARE EXPRESSLY EXCLUDED.** Any representations or promises inconsistent with, or in addition to, this warranty are unauthorized and shall not be binding upon GBC. In no event shall GBC be liable for any special, incidental or consequential damages, whether or not foreseeable.

This warranty shall be void if the product has been misused; mishandled; damaged by negligence, by accident, during shipment, or due to exposure to extreme conditions; repaired, altered, moved, or installed by anyone other than GBC or its authorized agents; or if incompatible film was used. GBC's obligation under this warranty does not include routine maintenance, cleaning, adjustment, normal cosmetic or mechanical wear, nor freight charges.

Without limiting the generality of the previous paragraph, GBC's obligation under this warranty does not include:

- damage to the pressure rollers or pull rollers caused by knives, razors, or other sharp tool; by any object falling into the working area of the laminator; or by cleaning the rollers with solutions or materials that harm their surfaces;
- damage to Lucite panels or manometer glass caused by mechanical action or by cleaning with solutions or materials that harm those surfaces; nor
- damage to the outer finish caused by mechanical action or by cleaning with solutions or materials that harm the outer finish.

For proper cleaning procedures, see the *"CARING FOR YOUR LAMINATOR"* chapter.

For European Union Residents Only: This guarantee does not affect the legal rights which consumers have under applicable national legislation governing the sale of consumer goods.

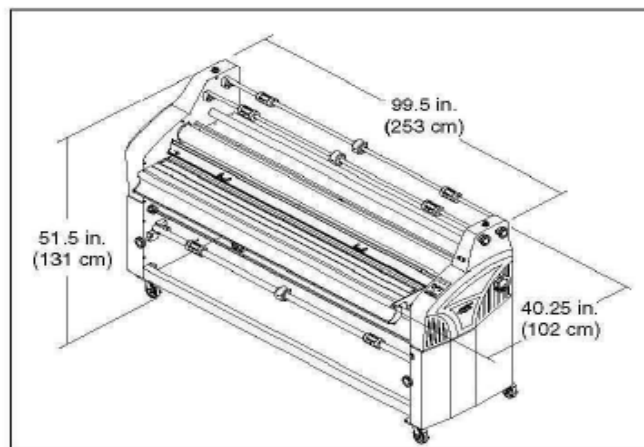


Fig. 1

SPECIFICATIONS

Operating Speed:

Up to 10 fpm (3 mpm)

Temperature range:

32 °F - 300 °F (0 °C -150 °C)

Max. Mounting Thickness:

1 in. (2.54 cm)

Max. Film Width:

80 in. (203 cm)

Dimensions (W x D x H):**Unit alone: (Figure 1)**99.5 in. x 40.25 in. x 51.5 in.
(253 cm x 102 cm x 131 cm)**Shipping:**102 in. x 43 in. x 62.5 in.
(259 cm x 109 cm x 159 cm)**Weight:****Unit alone:** 1232 lb. (559 kg.)**Shipping:** 1496 lb. (679 kg.)**Electrical Requirements:**

Refer to the serial plate located on the rear of the laminator for the specific electrical rating applicable to the unit.

U.S.:**Voltage:** 220**Current:** 11.3A**Power:** 2500 W**Phase:** Single

FCC NOTE: This equipment has been tested and found to comply with the limits for a Class A digital device, pursuant to part 15 of the FCC Rules. These limits are designed to provide reasonable protection against harmful interference when the equipment is operated in a commercial environment. This equipment generates, uses, and can radiate radio frequency energy and, if not installed and used in accordance with the instruction manual, may cause harmful interference to radio communications. Operation of this equipment in a residential area is likely to cause harmful interference in which case the user will be required to correct the interference at his/ her own expense. Changes or modifications not expressly approved by General Binding Corporation could void the users authority to operate the equipment.

This Class A digital apparatus complies with Canadian ICES-003. (Cet appareil numérique de la Classe A est conforme à la norme NMB-003 du Canada)

Europe:**Voltage:** 220V-240V---50/60Hz**Current:** 11.3A**Power :** 2500W**Phase :** Single**Interrupting Capacity:** 27A**Ambient Air Temperature:**

5-40 degree C (41-104 degree F)

Humidity Rating: 30-95%

non-condensing

Altitude Rating: Up to 1000 meters

(2540 feet)

PRE-INSTALLATION

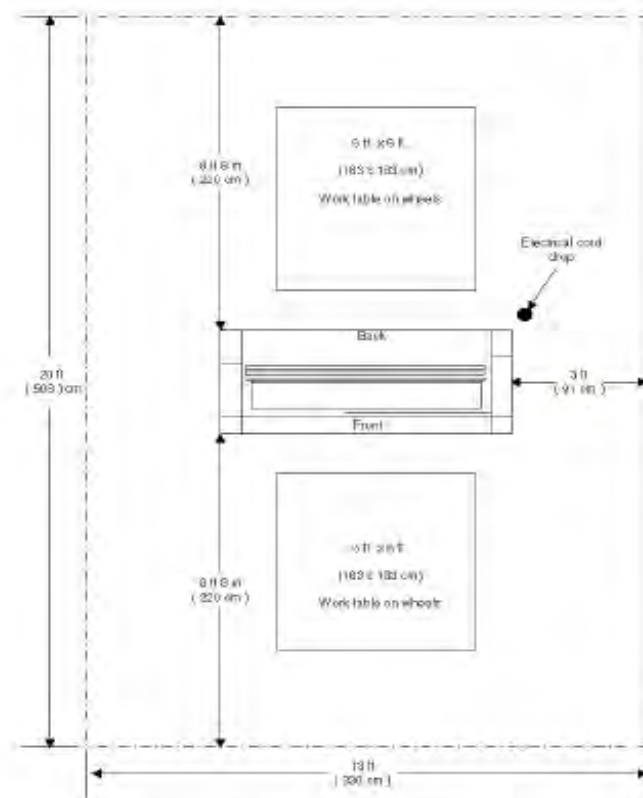


Fig. 2

Before a 2080 Wft Laminator can be installed, ensure the following requirements are met:

1. Are door ways and hallways wide enough for the laminator to be moved to the installation site?
2. Is there ample room for the laminator?
 - A work area must be established that allows for operation in both the front and rear of the laminator and provides space for efficient material flow. (Figure 2)
3. Is the environment appropriate for the laminator?
 - The laminator requires a clean, dust and vapor free environment to operate properly.
 - Avoid locating the laminator near sources of heat or cold. Avoid locating the laminator in the direct path of forced, heated or cooled air.

Air flow can cause uneven heating and cooling of the rollers and result in poor

4. Have you contacted a certified electrician to wire the receptacle and ensure that adequate power is being supplied, having the appropriate capacity, over current protection and safety lockouts available?

2080 Wft requires:

- 220V at 60hz with 15 amp service.

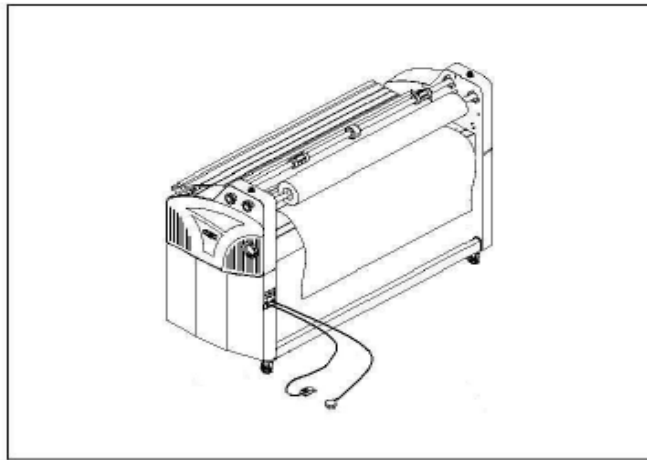


Fig. 3

INSTALLATION

1. **Shipping damage should be brought to the immediate attention of the delivering carrier.**
2. With assistance, carefully roll the laminator into position over flat and even surfaces.
3. The laminator should be positioned to allow exiting film to flow freely to the floor or a work table (Figure 3). Accumulation of laminate immediately behind the laminator as it exits the equipment may cause the film to wrap around the pull rollers, resulting in a "jammed" condition.
4. Avoid locating the laminator near sources of heat or cold. Avoid locating the laminator in the direct path of forced, heated or cooled air.
5. Once the laminator has been properly positioned, lock the castors in place. Locking the castors prevent the machine from rolling during set up, operation or servicing.
6. The heaters must be installed by a GBC qualified service technician. Refer to your Warranty section for explanation of "Qualified".
7. Connect the attachment plug provided with the laminator to a suitably grounded outlet. **Avoid connecting other equipment to the same branch circuit to which the laminator is connected, as this may result in nuisance tripping of circuit breakers or blowing fuses.**

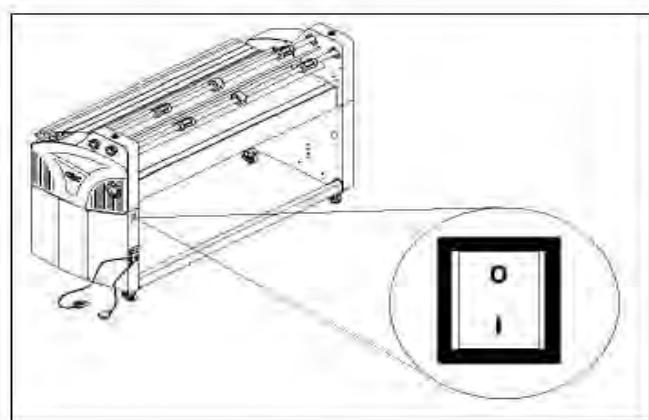


Fig. 4



Fig. 5

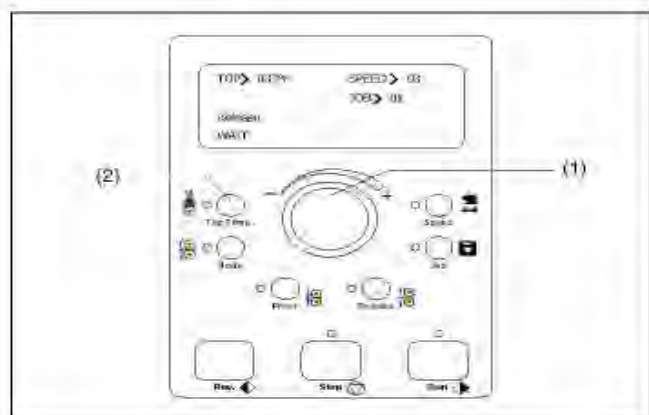


Fig. 6

CONTROL GUIDE

A. POWER ON/ OFF(I/O): (Figure 4)
Located at the back left of the machine applies power to the laminator. The control panel display will illuminate when position marked "I" is pushed. The off position, marked "O", removes power from the laminator.

B. CONTROL PANEL DISPLAY: (Figure 5) Illuminates when the laminator is plugged in and **POWER ON/ OFF** is in the on, (I), position. Displays settings for top heater, bottom heater, speed, Job, mode and ready/wait/ positioning indicator.

ROLLER POSITION INDICATOR:
Displays the current main roller position. In figure 6, the roller is shown in the "Release" position. Refer to Roller Handle for more information.

READY/ WAIT INDICATOR:
"READY" appears when actual temperature is equal to (+/- 5) set temperature. "WAIT" appears when actual temperature is lower than the set temperature. "WAIT" appears when actual temperature is higher than the set temperature.

POSITIONING INDICATOR:
"Positioning..." appears in place of the ready/ wait indicator any time the main rollers are travelling in an upward or downward motion.

C. CONTROL PANEL: (Figure 6)

The symbols (shown below) are on the control panel and upon the display. Their meanings are as follows:

(1) MASTER DIAL : Increases (+) or decreases (-) the numeric value for the selected setting when turned. Press and hold the dial to display actual temperature of top main roller.

(2) Top Temp. : When pressed, permits increasing or decreasing of the top temperature by turning the **MASTER DIAL** and value is indicated on the control panel display. Range is 32 °F- 140 °F (0 °C - 60 °C).

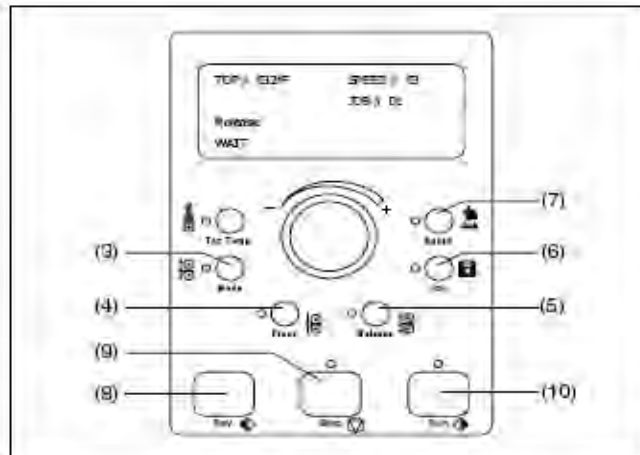


Fig.7

For items (3) through (10), refer to Figure 7.

(3) **MODE** : When pressed, permits selecting a gap or pressure setting of the main rollers by turning the **MASTER DIAL** and is indicated on the control panel display.

Available modes are:

- Release
- 1" Mounting
- 3/4" Mounting
- 1/2" Mounting
- 3/8" Mounting
- 3/16" Mounting
- 1/8" Mounting
- Low-Prs Laminating
- Mid-Prs Laminating
- High-Prs Laminating

(4) **PRESS** : When pressed, lowers the upper main roller to correspond with the **MODE** setting.

(5) **RELEASE** : When pressed, raises the upper main roller.

(6) **JOB** : When pressed, permits scrolling of job numbers by turning the **MASTER DIAL** and is indicated on the control panel display. Range is 1 - 10.

To store parameters for a particular job number, select the desired job number location, enter the upper and lower temperatures and speed, then press **JOB** .

(7) **SPEED** : When pressed, permits increasing or decreasing of speed by turning the **MASTER DIAL** and is indicated on the control panel display. Range is 1 - 10.

(8) **REV** : When pressed and held, reverses roller movement to clear film jams and wrap-ups.

(9) **STOP** : Stops the movement of the rollers.

(10) **RUN** : When pressed, activates rollers for normal operation.

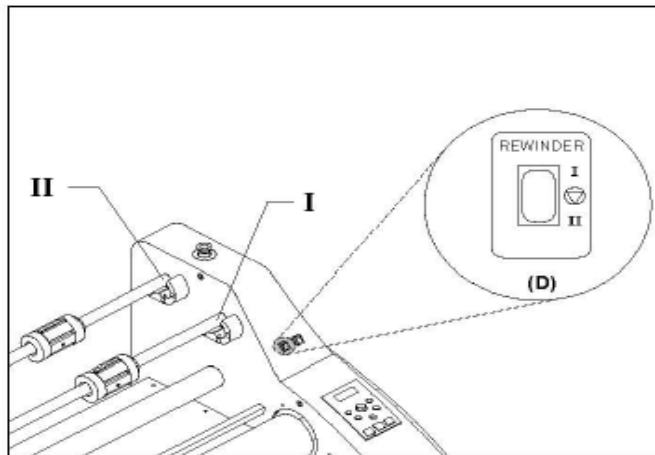


Fig. 8

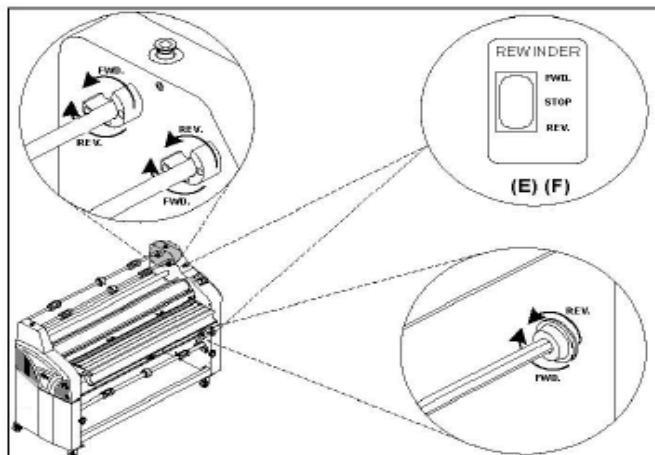


Fig. 9

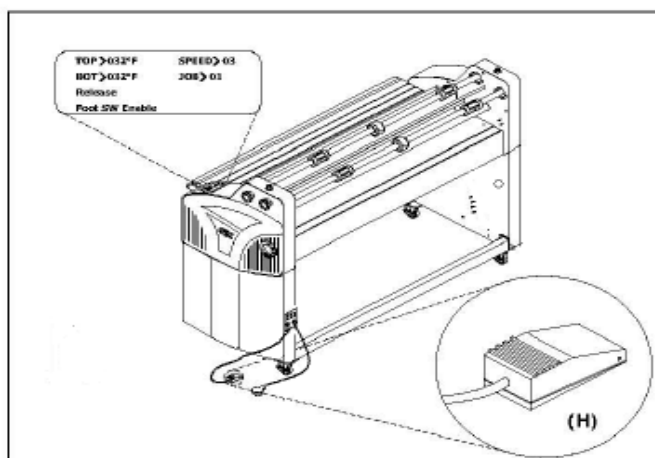


Fig. 10

D. REWINDER SELECTION

SWITCH: (Figure 8) This switch enables the operator to control the function of the upper rewind/unwind shafts.

I : In this position, turns the power on to the upper front rewind/unwind shaft.

⊖ : In this position, neither the upper front or upper rear rewind/unwind shaft is selected for motor power.

II : In this position, turns the power on to the upper rear rewind/unwind shaft.

E. UPPER REWINDER DIRECTION

SWITCH: (Figure 9) This switch enables the operator to control the direction of the upper rewind/unwind shafts.

"FWD.": In this position, the motor runs in a forward direction.

"STOP" : Stops the retractor motor for the rewind/unwind shaft selected.

"REV.": In this position, the motor runs in a reverse direction.

F. LOWER REWINDER DIRECTION

SWITCH: (Figure 9) This switch enables the operator to control the direction of the Lower rewind/unwind shaft.

"FWD.": In this position, the motor runs in a forward direction.

"STOP" : Stops the retractor motor for the rewind/unwind shaft selected.

"REV.": In this position, the motor runs in a reverse direction.

G. FOOT SW ENABLE: (Figure 10)

In this mode permits operation using the footswitch.

To enable the foot switch, press and hold **STOP** ⊖ until you hear a beep, approximately 3 seconds. **FOOT SW ENABLE** flashes where **READY/ WAIT** is indicated.

Press and hold **STOP** ⊖ again to disable the foot switch.

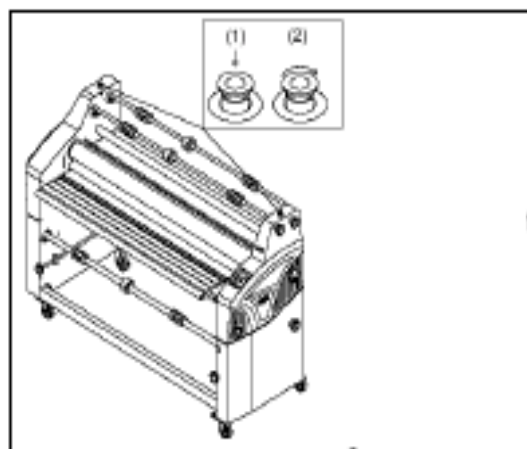


Fig. 11

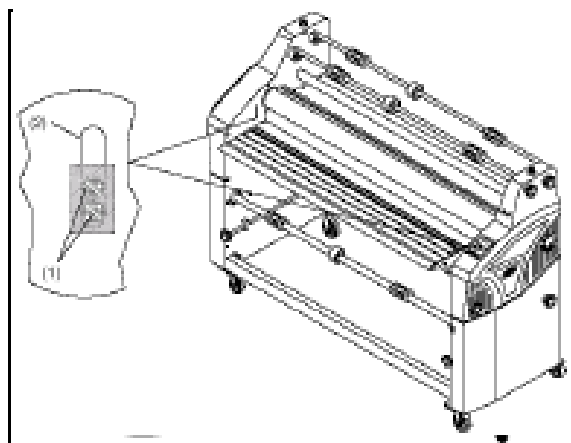


Fig. 14

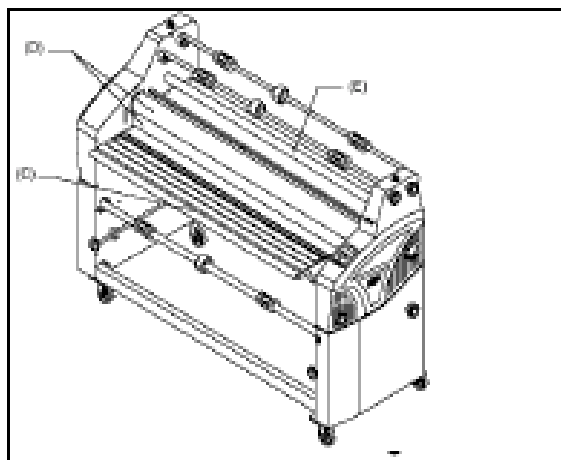


Fig. 15

FEATURES GUIDE

A. E-STOP: (Figure 11) Two E-STOP buttons exist on the laminator. One on each side of the upper cabinet.

To engage (1), press either push button, roller movement is stopped.

To disengage (2), turn the push button clockwise once the emergency condition has been resolved.

B. SAFETY SHIELD INTERLOCK LATCH: (Figure 14) Used to lock the safety shield into position and activate an interlock switch. The interlock latch is located on the left side of the safety shield. When pushed to the full left (1), the safety shield is locked. When pushed to the full right (2), the safety shield is unlocked.

C. SAFETY SHIELD: (Figure 14) Prevents entanglement, entrapment and inadvertent contact with the heat rollers. **The laminator will operate only when the Safety Shield is located in the fully locked position.**

To remove the safety shield, unlock the safety shield interlock latch and lift the safety shield (1) up and away from the safety shield mounting pins (2).

D. FEED TABLE: (Figure 15) The Feed Table is used to position items for lamination. **The laminator will operate only when the Feed Table and Feed Table Latch are properly installed.**

E. MAIN ROLLERS: (Figure 15) Silicone rubber coated steel tubes compress the film to the items being laminated. The upper main roller can be heated. Heat is provided by an internal heating element. The main rollers are motor driven for ease of loading new film.

F. IDLER BAR: (Figure 15) The idler bars, located near each heat roller, are used to direct the film to the heat roller nip.

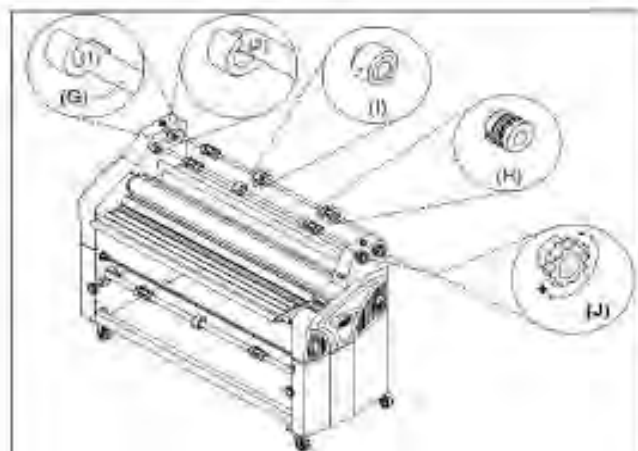


Fig. 16

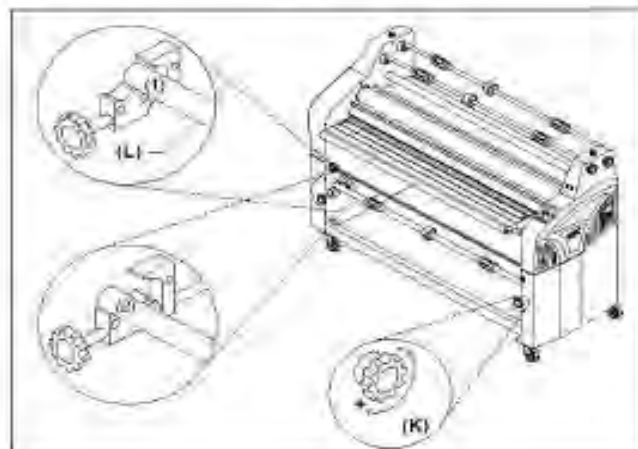


Fig. 17

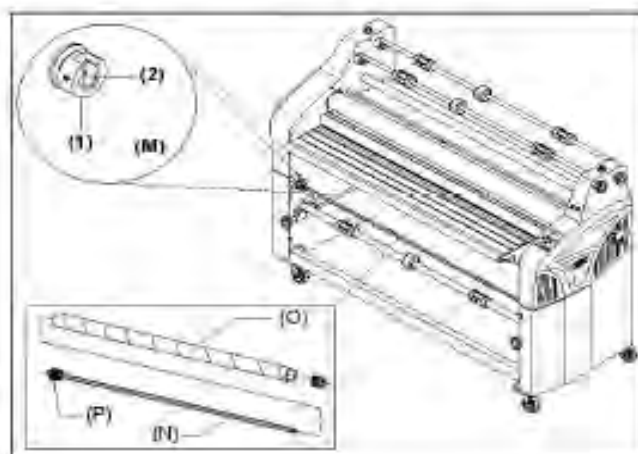


Fig. 18

G. UPPER UNWIND/REWIND SHAFT:

(Figure 16) The upper unwind/rewind shaft holds the upper film supply or rewind tube on the machine.

To remove the upper unwind/rewind shaft, slide the shaft from the web position (1) on the shaft stopper to the load position (2) and carefully lift up and out.

H. CORE ADAPTORS: (Figure 16)

Hold and lock the rolls of film on the shafts to prevent side to side shifting.

I. CORE SUPPORT: (Figure 16)

Supports the center of the film core.

J. UPPER UNWIND/REWIND

TENSION KNOBS: (Figure 16) Used to apply brake tension to the upper unwind/rewind shafts. Turning the knob clockwise increases tension and counterclockwise decreases brake tension.

K. LOWER UNWIND TENSION

KNOBS: (Figure 17) Left and right adjustable brake tensions. Applies brake tension to the lower unwind shaft. Turning the knob clockwise increases tension and counterclockwise decreases brake tension.

L. LOWER UNWIND SHAFT: (Figure 17)

The lower unwind shaft holds the lower film supply on the machine.

To remove the lower unwind shaft, slide the lower unwind shaft from the web position (1) on the brake base to the load position (2) and carefully lift up and out.

M. LOWER REWIND SHAFT LOCK:

(Figure 18) Secures the left side of the lower rewind shaft. To remove a shaft, turn the outer dial (1) opening so it aligns with the inner u-channel (2) opening and lift up and out and pulling the hex end out.

N. REWIND SHAFT: (Figure 18)

The rewind shaft holds the rewind tube on the machine.

O. REWIND TUBE: (Figure 18)

The two rewind tubes located at the front of the machine are used to rewind release liners. The one located at the rear of the machine is used to rewind the finished product.

P. REWIND ADAPTORS: (Figure 18)

Hold and lock the rewind tube on the rewind shafts to prevent side to side shifting.

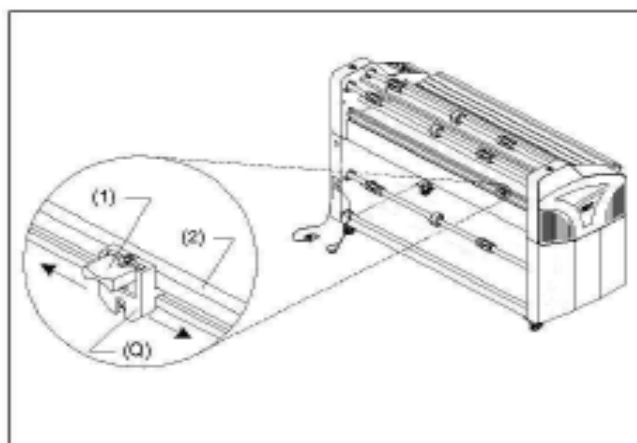


Fig. 19

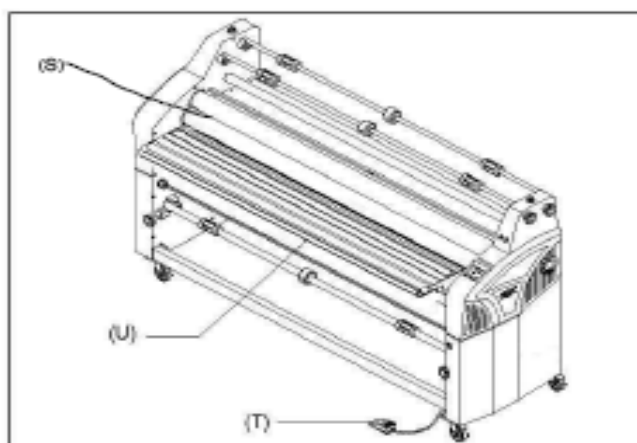


Fig. 20

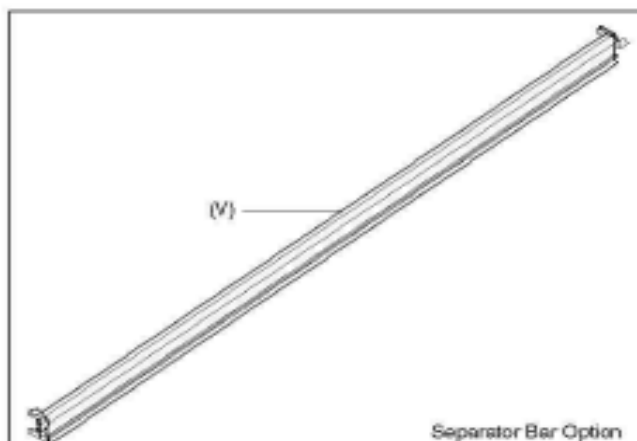


Fig. 21

Q. REAR SLITTER: (Figure 19) Used to cut the film web where it exits the rear of the laminator.

To make a cut, push down on the blade engage lever and slide to the opposite side.

R. FILM WEB: Laminating film loaded into the machine.

S. NIP POINT: The point at which the top and bottom rollers come into contact. The Nip Point of the heat rollers is the place at which the items for lamination are introduced into the laminator.

T. FOOTSWITCH: (Figure 20) Used to assist in webbing of the machine and initial feeding of material.

U. PRINT UNWIND BASKET: (Figure 20) Holds a rolled image. Prevents the image from touching the floor.

V. SEPARATOR BAR OPTION: (Figure 21) Required if running Accushield® material.

2080 Wft Part No. 2020578

To install, replace the rear slit with the separator bar.

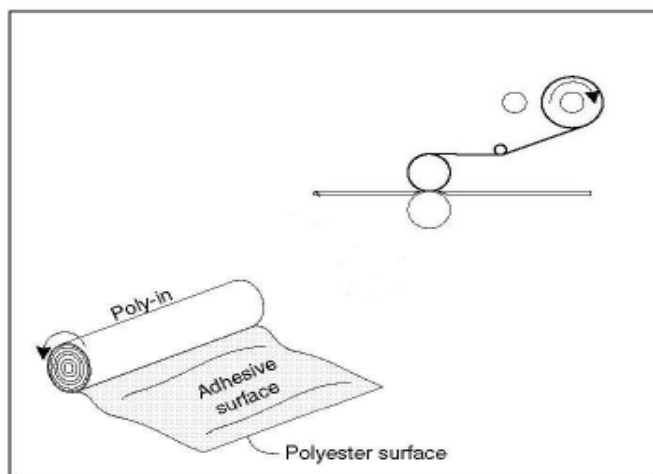


Fig. 20

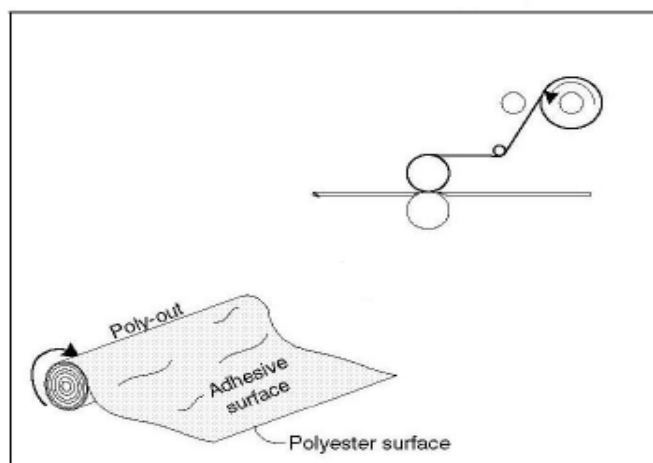


Fig. 21

OPERATING INSTRUCTIONS

FILM LOADING & THREADING

The top and bottom rolls of laminating film must be of the same width and be present simultaneously. A small amount of adhesive will "squeeze out" during lamination. Hardened adhesive deposits can damage the heat rollers. To avoid any damage, select "Low-Prs Laminating" on the roller handle, rotate the rollers at slowest speed with the top heat on. Refer to the section entitled *Caring for the 2080 WFT LAMINATOR* for instructions regarding removal of the accumulated adhesive.

Adhesive will deposit on the rollers if:

- Only one roll is used.
- Different widths of rolls are loaded together.
- Either roll is loaded adhesive side against a heat roller.
- One or both rolls of film are allowed to run completely off its core.

The adhesive side of the film is on the inner side of the web (Figure 20). The shiny side of clear film must contact the heat rollers. The dull side of the film contains the adhesive. Use extreme caution when loading delustered (matte) film as both sides appear dull.

Always change the top and bottom supply rolls at the same time. Near the end of each roll of GBC laminating film is a label stating "Warning-End of Roll". The appearance of this label on either the top or bottom roll requires that new rolls of film be installed as soon as the item presently being laminated completely exits the rear of the laminator. Do not introduce any additional items into the laminator when the warning label is visible.

To load a roll of film;

1. Pull the film shaft to the load position.
2. Lift the film shaft up and out.
3. Slide the roll of film onto the film shaft ensuring adhesive side is out.
4. Replace the film shaft.
5. Center the roll of film. The upper film should align with the lower film.

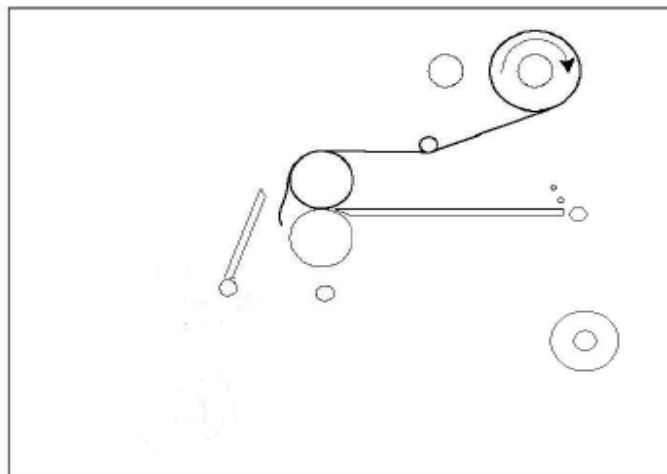


Fig. 21

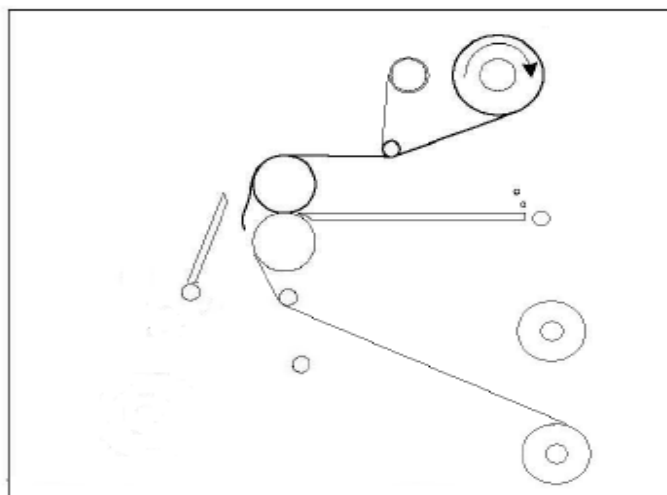


Fig. 22

LOADING TOP THERMAL FILM

This procedure describes how to load the upper roll of film onto the laminator. Figure 21 uses poly-in film and the upper rear unwind/rewind position for illustration purpose.

1. Turn the **Power ON/OFF** to on (I). Set top heat temperature for the film type you are using.
2. Ensure no brake tension is applied to the film shaft.
3. Remove the safety shield and pivot the feed table down.
4. Pull the top roll of film down under the idler bar and allow to drape over the top heat roller (Figure 21).
5. Reference one of the loading bottom material procedures.

LOADING TOP PSA FILM

This procedure describes how to load the upper roll of film onto the laminator. Figure 22 uses PSA film and the upper rear unwind/rewind position for illustration purpose.

1. Turn the **Power ON/OFF** to on (I). If the laminator is already hot, turn **POWER ON/OFF** to the off (O) position and allow the unit to cool. Once cool, turn the laminator back on.
2. Ensure no brake tension is applied to the film shaft.
3. Remove the safety shield and pivot the feed table down.
4. Set the roll of film in the rear unwind/rewind position and the rewind tube in the front unwind/rewind position.
5. Pull the top roll of film down under the idler bar and up the upper front rewind tube.
6. Place one piece of masking tape in the center of the film and secure to the rewind tube.
7. Make two full wraps around the rewind tube, then carefully score the laminate without cutting the release liner.
8. Pull the laminate down allowing it to drape over the upper main roller.
9. Reference one of the loading bottom material procedures.

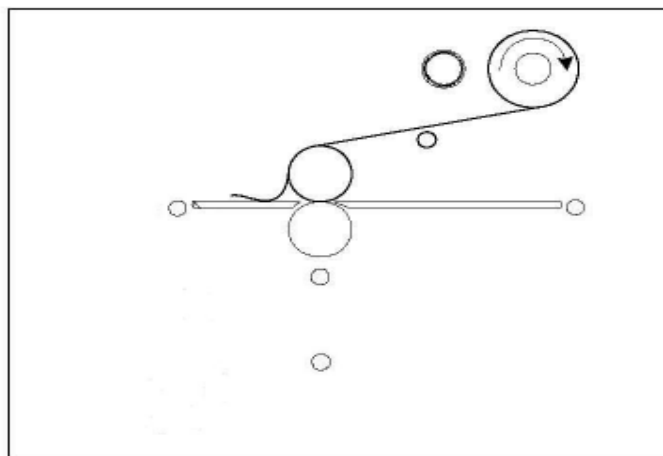


Fig. 23

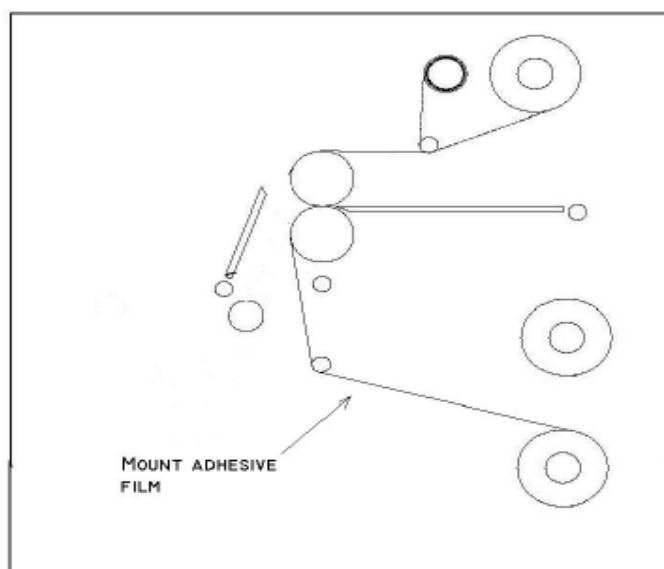


Fig. 24

LOADING MOUNT ADHESIVE (UPPER)

This procedure describes how to load a roll of mount adhesive using the upper position for pre-coating (Figure 23).

1. Turn the **Power ON/OFF** to on (I). If the laminator is already hot, turn **POWER ON/OFF** to the off (O) position and allow the unit to cool. Once cool, turn the laminator back on.
2. Ensure no brake tension is applied to the film shaft.
3. Remove the safety shield.
4. Set the roll of mount adhesive in the upper rear unwind/rewind position.
5. Pull the mount adhesive over the upper idler and upper main roller allowing the material to rest on the top of the feed table.
6. Reference **THREADING CARD PROCEDURE** next.

LOADING MOUNT ADHESIVE (LOWER)

This procedure describes how to load a roll of mount adhesive using the lower unwind position for decaling (Figure 24).

1. At this point you should have an upper roll of film loaded onto the laminator.
2. Ensure no brake tension is applied to the film shaft.
3. Adhere the mount adhesive to the loaded upper roll of film by pulling the mount adhesive straight up towards the main rollers. Do not web around the lower idler.

NOTE: You may follow this procedure to load a roll of Kraft Paper for single side lamination.

4. Reference **THREADING CARD PROCEDURE** next.

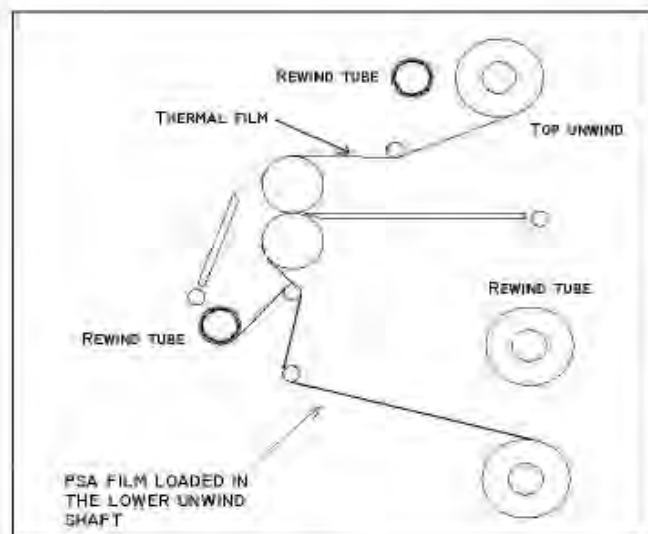


Fig. 25

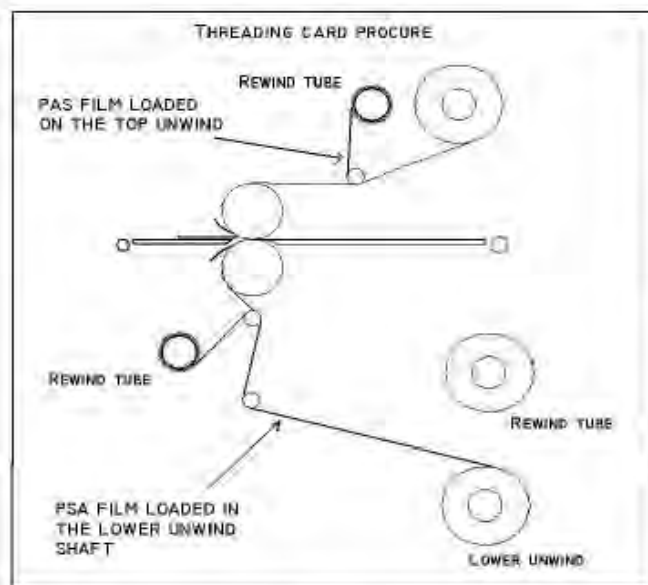


Fig. 26

LOADING LOWER PSA FILM

This procedure describes how to load a roll of PSA film using the lower unwind position (Figure 25).

1. At this point you should have an upper roll of film loaded onto the laminator and a rewind tube on the lower rewind shaft.
2. Ensure no brake tension is applied to the film shaft.
3. Pull the lower roll of film around the lower idler bar and towards the lower rewind.
4. Place one piece of masking tape in the center of the film and secure to the rewind tube.
5. Make two full wraps around the rewind tube, then carefully score the laminate without cutting the release liner.
6. Adhere the lower PSA film to the loaded upper roll of film by pulling the film straight up towards the main rollers.
7. Reference **THREADING CARD PROCEDURE** next.

THREADING CARD PROCEDURE

This procedure describes how feed two loaded films through the main rollers (Figure 26).

1. At this point you should have an upper roll of film and lower roller roll of film loaded onto the laminator.
2. The table and safety shield should be properly installed.
3. Push the threading card into the main roller nip. The threading card becomes sandwiched between the upper and lower loaded films.
4. Set a **MODE** [MODE] button, press the **RUN** [RUN] button.
5. Once the threading card has cleared the main roller nip, press the **STOP** [STOP] button.
6. Use the rear slit to cut the threading card from the web.
7. If you are not running the laminator, set the **MODE** [MODE] to the "RELEASE" setting.
8. Now refer to the section entitled **START LAMINATING**.

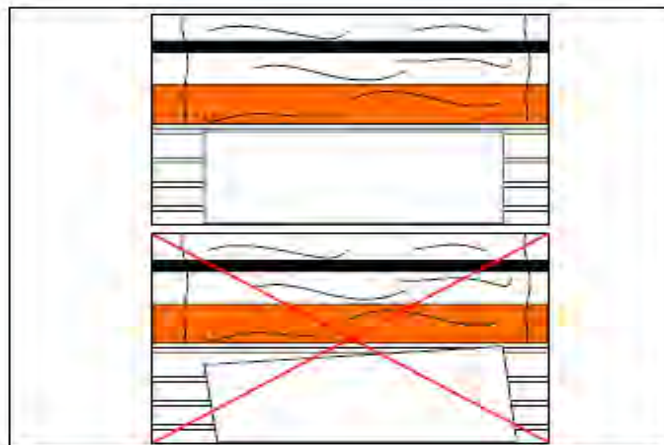


Fig. 27

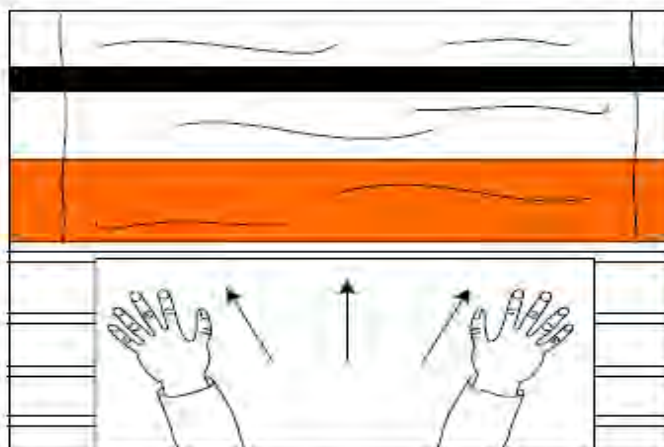


Fig. 28

START LAMINATING

1. At this point you should have your laminator webbed with the appropriate material for your application.
2. The safety shield and feed table should be in the normal operating position.
3. Select a **JOB**  and ensure the proper speed and temperatures are set. Refer to the section entitled **SPEED/ TEMPERATURE GUIDE**.
4. Select a **MODE** .
5. Press the **RELEASE**  button. The main rollers gap.
6. Press the **RUN** () button.
7. Press the **PRESS**  button. The main rollers close.
8. Make any necessary film brake tension and/ or rewind brake tension adjustments to achieve desired output quality.
9. Position the item to be laminated on the feed table.
10. Align the leading edge of the item square to the heat roller nip (Figure 27).
11. With both hands and an outward force push the image slower than the speed of the rollers into the nip of the heat rollers (Figure 28).
12. Once the last item to be laminated has exited the laminator, press the **STOP**  button.
13. Set **MODE**  to the "RELEASE" setting.

CAUTION: Avoid forcing the image into the heat roller nip. The image may buckle if not avoided.

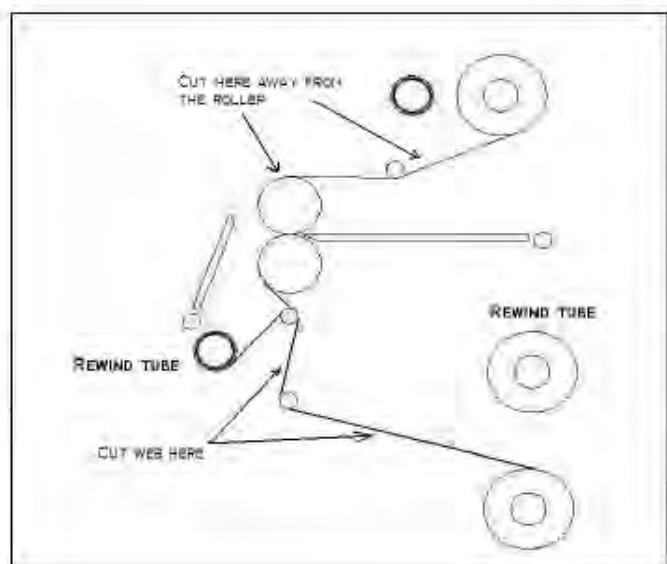


Fig. 29

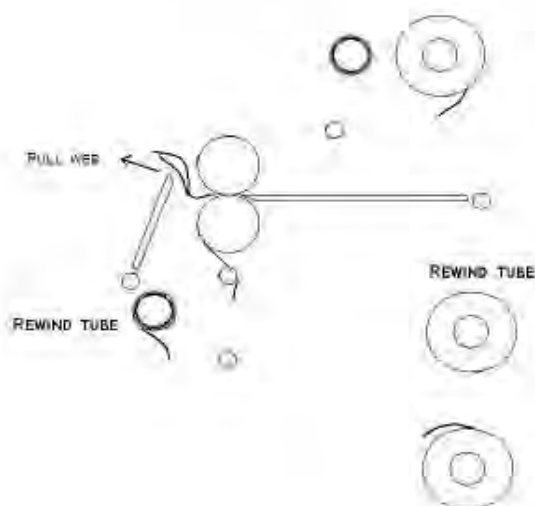


Fig. 30

TO UNWEB THE LAMINATOR

Unweb the laminator if you are changing film widths, cleaning the rollers or have finished using the machine for the day.

1. Using the rear slit, cut the output from the web.
2. Set **MODE** [8] to the "**RELEASE**" setting.
3. Remove the safety shield and tilt the feed table.
4. Cut the remaining top and bottom film webs between the supply rolls and the heat rollers (Figure 29). **Be careful not to cut any of the rollers!**
5. Carefully grab hold of the web (top and bottom film), from the front operating position and pull towards you (Figure 30).
6. Do not allow the adhesive side of the film to contact the heat or pull rollers.
7. Refer to the section entitled **CARING FOR THE TALON 80 LAMINATOR** for instructions regarding removal of the accumulated adhesive.

CLEARING A FILM JAM (Wrap-up)

Film jams (wrap-ups) may occur if the film is loaded backwards or if the area at which film exits the equipment is blocked. The film, when jammed, wraps around the heat rollers during webbing if a threading card is not used or pull rollers during operation.

To clear a jam:

1. Immediately stop the laminator by pressing **STOP** [X].
2. Remove the safety shield and tilt the feed table.
3. Press and hold **REVERSE** [←] until the jam has cleared the main rollers.
4. Press the **RELEASE** [8] button. The main rollers gap.
5. Manually assist the material through the main rollers.
6. Once the jam has been cleared, press the **PRESS** [9] button. The main rollers close.
7. You can now resume laminating.

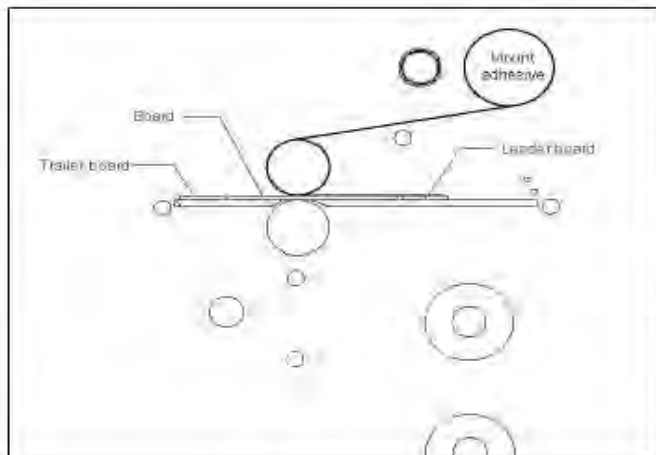


Fig. 31

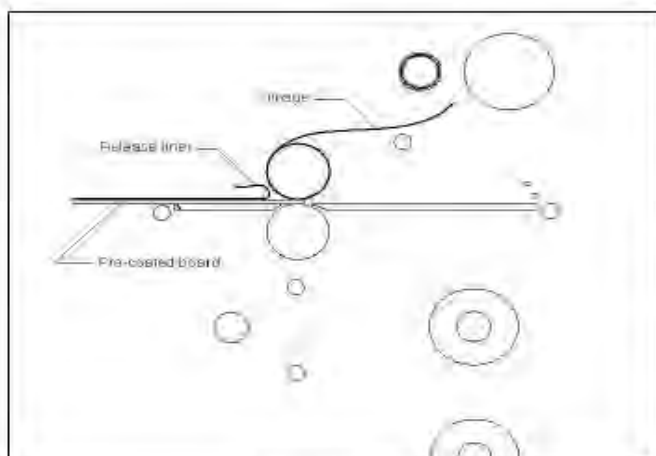


Fig. 32

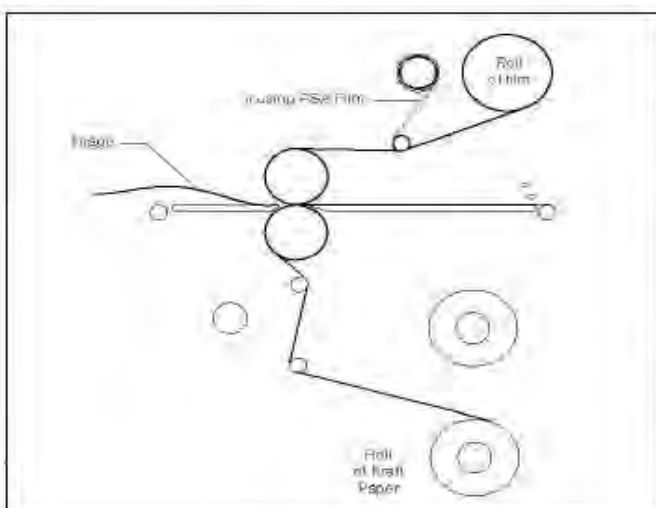


Fig. 33

APPLICATIONS

TIPS FOR PRE-COATING BOARDS (Figure 31)

1. Load the laminator as illustrated in Figure 31.
3. Set the **MODE** $\frac{1}{8}$ to the correct thickness.
4. The width of the roll should not exceed the width of the board by more than 1/2 in. (1.3 cm).
5. Use a leader board to start the run and a trailer board to finish the run.
6. Do not stop the run in the middle of a board.
7. Have the boards nearby to butt end to end during feeding.

TIPS FOR MOUNTING PRE-COATED BOARDS (Figure 32)

1. Load the laminator as illustrated in Figure 32.
2. Heat, 125 °F (52 °C), may assist the process and increase output quality.
3. Ensure the image is contoured to the main roller width to prevent skewing.
4. For large mounting, have a second person assist.
3. Do not stop once you have started the mounting process through the machine.

TIPS FOR SINGLE SIDED LAMINATION (Figure 33)

1. Load the laminator as illustrated in Figure 33.
2. Use kraft paper for one-sided lamination whenever the items to be laminated are narrower than the film you are using.
3. If not using kraft paper, use a scrap piece to finish the run or you will have adhesive on your rollers.
4. Running the web over the chill idler may improve the flatness of the output.
5. A little heat, 125 °F (52 °C), may help eliminate silvering effects associated with PSA films.

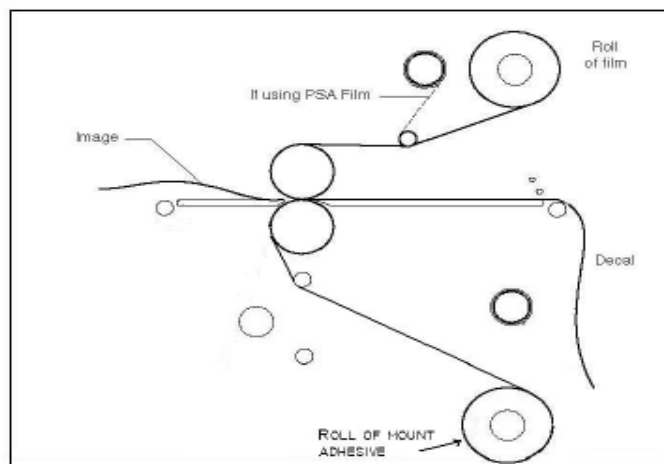


Fig. 34

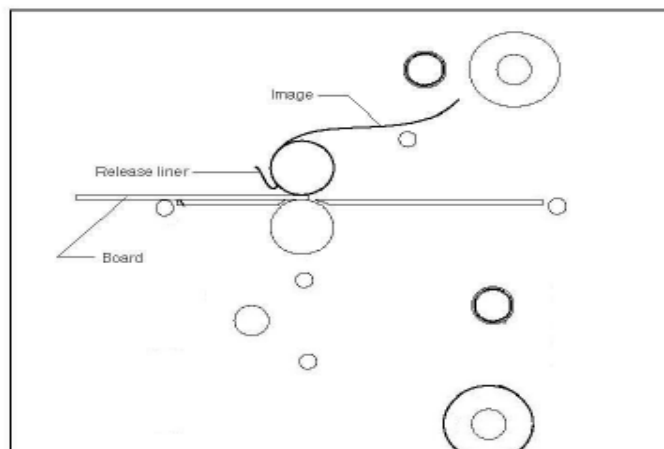


Fig. 35

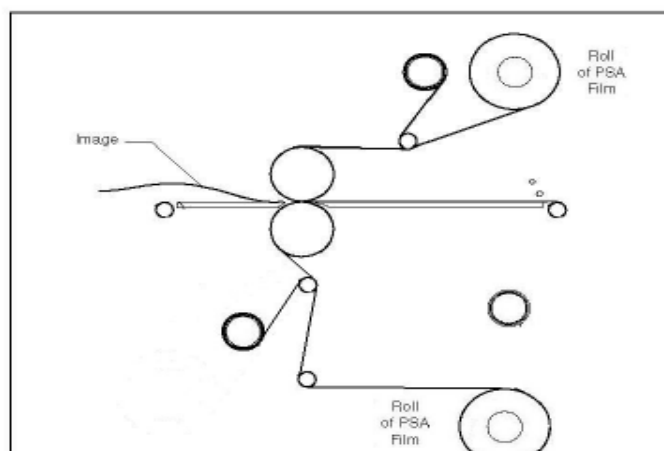


Fig. 36

TIPS FOR CREATING A DECAL (Figure 34)

1. Load the laminator as illustrated in Figure 34.
2. The over laminate may be PSA or thermal type.
3. If using thermal type, pay attention to the Poly-in/ Poly-out rule.
4. Run a test material prior to running the actual image to ensure flat output.
5. Use minimal brake tension to achieve quality output.
6. Do not web the PSA mount adhesive around the lower web idler.

TIPS FOR MOUNTING A DECAL (Figure 35)

1. Load the laminator as illustrated in Figure 35.
2. The image should not exceed the width of the board by more than 1 in. (2.54 cm) per side.
3. Tack about 1 in. (2.54 cm) of the leading edge of the decal to the leading edge of the board.
4. When tacking the leading edge, start in the center and work to the sides.
5. Use a board that exceeds the size of the decal if inexperienced in the mounting application.

TIPS FOR PSA ENCAPSULATION (Figure 36)

1. Load the laminator as illustrated in Figure 36.
2. Always use two rolls of the same width.
3. Use minimal brake tension to achieve flat output.
4. The separation of the laminate and the release liner should be maintained close to the heat rollers.
5. A little heat, 125 °F (52 °C), may help eliminate silvering effects associated with PSA films.

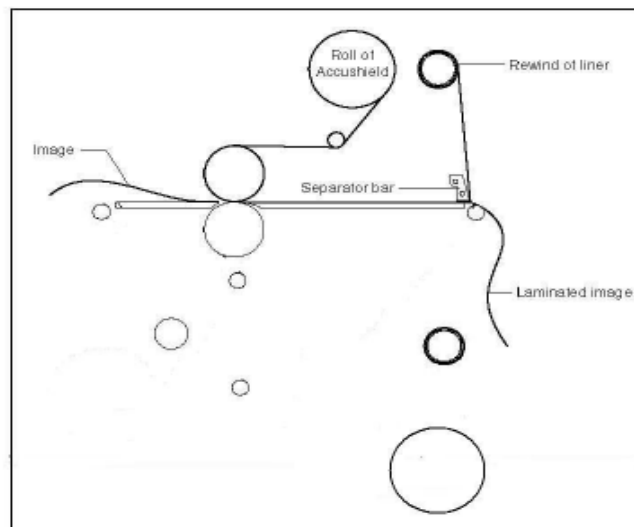


Fig. 37

TIPS FOR ACCUSHIELD™ (Figure 37)

1. Load the laminator as illustrated in Figure 42.
2. You must have the Separator bar option to accurately run this material.
3. Liner rewind tension will be greater than normal operating standards.
4. Do not attempt to run this material greater than a speed setting of 4.
5. To prevent some adhesive adhering to the rollers, you may choose to use a roll of kraft paper for a carrier with the roll to roll rewind option installed.

SPEED/ TEMPERATURE GUIDE

This is only a general reference guide.
Different settings may be suitable as the
warm up time, lamination time and
materials change. (Figure 38 & 39)

Factors that may effect the speed and
temperature parameters;

1. Image length
2. Image width
3. Ink coverage
4. Paper type
5. Laminate thickness
6. Operating environment
7. Condition of the rollers
8. Line voltage (effects heaters)
9. Using vacuum and/ or cooling features.

12/02 You may have to adjust temperature or
speed depending on stock finish, thickness and
ink coverage.

*Turn heat off when not in use.

Stock	Film Gauge	Nap-Lam II		Nap-Lam I		*Vinyl		Premium		Hi-Tac	
		Settings		Settings		Settings		Settings		Settings	
	mil	Temp (F)	Speed	Temp (F)	Speed	Temp (F)	Speed	Temp (F)	Speed	Temp (F)	Speed
20# Bond	1.5	248	8	290	7					255	8
	3	239	6	270	5			225	4		
	5	230	5	250	3	230	5	220	3		
	10	221	3					210	3		
80# Bond	1.5	248	6	295	7					255	6
	3	239	5	275	5			230	4		
	5	230	3	250	2	230	3	225	3		
	10	221	2					215	3		
10 Pt. Board	1.5	248	5	300	6					255	4
	3	239	4	275	4			235	4		
	5	230	2	250	2	230	2	230	3		
	10	221	2					220	2		

Fig. 38

GBC U.S & CE T-2080WFt

Effect of incorporated Fiber optic on sequence of operation

Machine run mode	Situation 1 Normal operation (No Interruption to any safety circuitry & Fiber optic beam) High voltage.	Situation 2 Interrupted fiber optic beam or opened any safety circuitry &	Situation 3 Fiber optic beam Cleared + all safety circuitries are closed
Forward mode	Using the Control panel: Forward Speed: Zero to Max.	Machine stops Instantly.	Machine will not run. It will remain stationary.
Press push button forward switch	Note: Operator can switch from foot pedal mode to control without stopping machine. Press " <u>Run</u> " push button to switch before taking foot off foot pedal.	To override, use Foot pedal and machine will run @ a safety mode of 3f/m.	Push <u>RUN</u> button switch or press foot pedal to run machine again (Normal operation) mode.
	Using the Foot pedal switch: Forward Speed: Zero to Max. Note: Operator can Press foot pedal to switch from control panel at preset speed.	Machine Runs @ 3f/m. (Automatic override from high to low voltage)	Machine will remain at low voltage of safety mode speed of 3f/m. Operator will have two available choices to reset to normal operation mode: Choice A: 1) Release foot pedal to stop machine. 2) Press foot pedal again to start machine at original preset control panel knob speed (pot). Choice B: 1) Press and hold " <u>Run</u> " push button switch on the control panel while foot is still on pedal. 2) Release foot pedal. 3) Speed stays at 3f/m, but at high voltage. 4) Adjust speed using "speed knob"

Reverse mode	Control panel: Reverse speed: 3f/m Note: Push "reverse" button switch And then push "Run" button switch.	N/A	N/A
	Foot switch: Reverse speed: 3f/m Note: 1) Just Press foot pedal to switch mode and take over from control panel. 2) If foot pedal is released, machine will stop. 3) Push "reverse" button switch and then push "Run" Switch to change back to control panel mode.	N/A	N/A
Initial sequence: 1) Fiber optic second function: If the fiber optic beams are being obstructed while the upper roller is coming down to close the nip; the roller will go up immediately instead of coming down. This will apply to both, upper main and upper pull roller. 2) Optics location: A) Available at <u>main roller forward nip entrance</u> . B) Not available at <u>main roller reverse nip entrance</u> .			

THE ART OF LAMINATION

BASIC RULES

Do not attempt to laminate abrasive or metal objects such as staples, paper clips and glitter, as they may damage the heat or pull rollers.

Do not force items into the nip area of the heat rollers. An item that is not easily drawn into the laminator by the heat rollers is probably too thick to laminate.

Wrinkles may result if an attempt is made to reposition an item once it has been grasped by the heat rollers.

Do not stop the laminator before an item has completely exited the pull rollers. Even a momentary stop will cause a mark (heat line) on the laminated item.

Good, consistent lamination is a result of combining proper heat, tension and dwell time. Dwell time is controlled by the speed of the motor and is defined as the amount of time the material to be laminated is compressed between the heat rollers.

As a general rule, thicker items and film need to run at slower speeds because they extract more heat from the rollers at a quicker rate. Setting the speed control at slower settings gives the laminator longer dwell time thus allowing proper lamination of thick items. Thinner items, such as standard copier paper (20 lb. bond) and tissue paper, extract less heat from the rollers and can be run at faster speeds.

FILM TENSION

Proper film tension, known as brake tension, is the minimum amount required to eliminate wrinkles in the finished item. The film should be taut. A properly adjusted roll of film should not require excessive force to turn by hand.

Film tension should be enough to introduce a minor amount of drag as the film unrolls. Insufficient tension causes wrinkles, while too much tension causes stretching (necking). Uneven tension between the top and bottom rolls create curl. Too much upper tension creates upward curl while too much bottom tension causes downward curl.

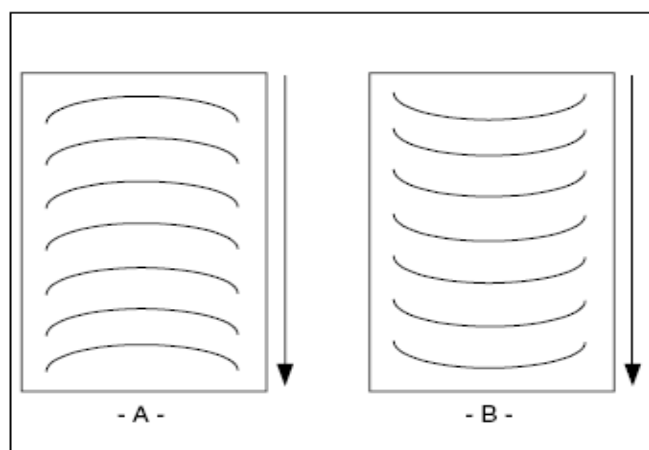


Fig. 43

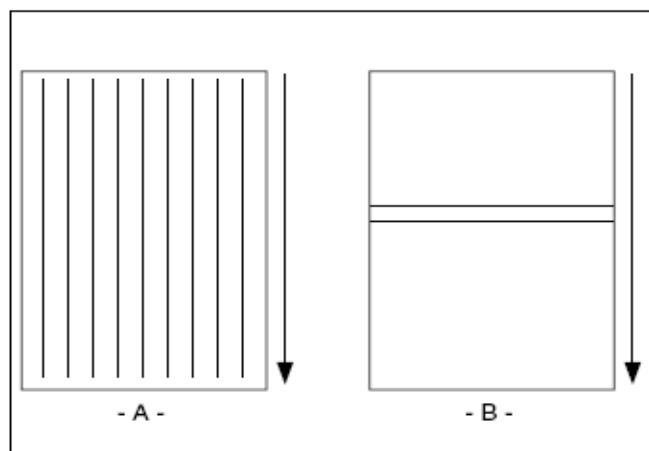


Fig. 44

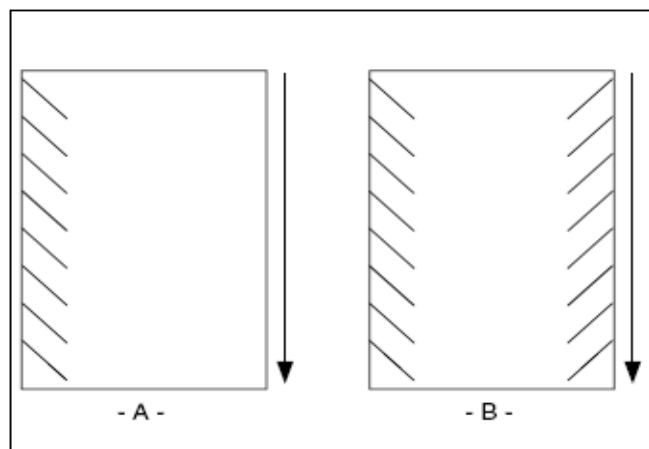


Fig. 45

HEAT

The "WAIT (Too COLD)" indicator may appear if the speed is set too fast for the material being laminated. Either lower the speed setting or press STOP and wait until the "READY" indicator appears.

Operation of the laminator for more than thirty minutes at a time may necessitate a lower speed setting. It is recommended that, during periods of long runs, the items being laminated are alternated between thick and thin. Do not combine thick and thin items at the same time, as this will result in a poor edge seal around the thinner material. If you are unsure that the laminator is set at the proper speed for the item to be laminated, run a test piece (scrap) of the same or similar material through the laminator. This procedure is recommended because rotating the heat roller prior to lamination will more evenly distribute the heat. Make speed adjustments if necessary.

OUTPUT

1. "D" waves in the image (Figure 43 A).
 - Check paper tension.
 - Paper may be damp or not dry.
2. "D" waves in the laminate (Figure 43 B).
 - Laminating pressure setting.
3. Straight waves in output (Figure 44 A).
 - Check operational settings for materials being used.
4. Indent waves in output after pull rollers (Figure 44 B).
 - Insufficient cooling time.
 - Output was handled prior to cooling.
 - Machine was stopped on print.
5. Angled waves in the output (Figure 45 A & B).
 - Laminating pressure setting.
 - Check for even paper tension (Figure 45 A only)

MAINTENANCE

CARING FOR THE GBC TALON 80 LAMINATOR

GBC offers Cleaning kits as well as Extended Maintenance Agreements.

Contact your local GBC Service Representative or your dealer/distributor for additional information.

The only maintenance required by the operator is to periodically clean the main rollers and schedule semi annual maintenance checks.

The following procedure will help keep the main rollers free of adhesive that has been deposited along the edge of the laminating film. Proper alignment of the rolls of film reduces the amount of "squeeze out".



WARNING: Do not attempt to laminate adhesives marked "Flammable".

- Do not laminate glitter and/ or metallic items. Damage to the rollers may result.



WARNING: Do not apply any cleaning fluids or solvents to the rollers. Some solvents and fluids could ignite on upper heated roller.

- Never clean rollers with sharp or pointed objects.
- Hardened adhesive deposits on the rollers can cause damage to the rollers. Rotate the rollers at the lowest speed setting on the control panel.



CAUTION: THE FOLLOWING PROCEDURE IS PERFORMED WHILE THE LAMINATOR IS HOT. USE EXTREME CAUTION.

1. Remove the film from the laminator following the procedure outlined in steps 1 through 6 of the section entitled *TO UNWEB THE LAMINATOR*.
2. Preheat the laminator until the "READY" indicator appears.
3. Remove the safety shield and tilt the feed table.
4. Rub the top and bottom heat rollers with a 3M™ Scotch-Brite™ pad. **DO NOT USE METAL SCOURING PADS!**
5. Use the footswitch to rotate the lower main roller to an unclean portion. The upper main roller is free spinning. Continue this process until the complete surface of both rollers are clean.
6. Refer to the beginning of the section entitled *OPERATING INSTRUCTIONS* to web your laminator.

*NOTE: Do not use metal scouring pads to clean the rollers.

TROUBLESHOOTING GUIDE

SYMPTOM	POSSIBLE CAUSE	CORRECTIVE ACTION
The control panel display does not illuminate when POWER ON/OFF is in the ON, marked "I", position.	Laminator not connected to electrical supply.	Insert attachment plug into receptacle.
Main rollers do not turn when press the RUN (▶) button.	Fiber optics are blocked Feed table not properly installed. E-STOP is engaged	Remove blockage from fiber optics See Fiber optics sequence of operations. Tilt feed table and properly replace it. Pull out on the E-STOP push button.
Main rollers only turn if I use the footswitch.	Laminator is in Footswitch mode.	Disengage the footswitch mode.
Laminated items exhibit curling.	Tension between the top and bottom film roll is unequal. Tension on top or bottom roll of film is too loose. Speed setting too slow. Bottom film roll may be improperly loaded.	Adjust tension per section <i>FILM TENSION</i> . Adjust tension per section <i>FILM TENSION</i> . Slightly speed up the laminator. Make sure bottom roll of film is around idler bar and the it is in the normal operating position.
Adhesive deposited on main rollers.	Top and bottom film webs not aligned. Laminate improperly loaded.	Release main roller pressure, align the rolls of film. Adhesive (matte) side of laminate film may be against the upper main roller. Unweb and reload the film properly.
Unsatisfactory adhesion of laminate.	Speed setting too fast for type of material being laminated. Insufficient heat. Laminate improperly loaded. Heat rollers require cleaning. Laminated item unsuitable for adhesion.	Lower speed setting by pressing SLOW button to slower speed Wait for "READY" indicator to appear in the control panel display. Adhesive side of film must be facing away from the heat rollers. Bottom roll of film not threaded behind the idle bar. Clean heat rollers per procedure in section <i>CARING FOR THE GBC 2080WFT LAMINATOR</i> . Item may be dirty or may have nonporous surface that is extremely difficult to laminate.
Waves in my output	See sub section <i>OUTPUT</i> . Nips may be out of calibration.	Under section titled <i>THE ART OF LAMINATION</i> . Place a service call for calibration check.

SERVICE AGREEMENT

GBC's Equipment Maintenance Agreement will insure the quality performance and long life built into your laminator.

A service charge for travel time, labor and parts may be incurred for each out of warranty service call. GBC's Equipment Maintenance Agreement decreases these expenses and protects your valuable investment. GBC offers several types of agreements to suit your needs and budget. To contact GBC write to:

GBC NATIONAL SERVICE
ONE GBC PLAZA
NORTHBROOK, IL 60062 U.S.A.
1.847.272.3700

IN CANADA: GBC NATIONAL SERVICE
49 RAILSIDE ROAD
DON MILLS, ONTARIO
M3A 1B3

Part Number 930-129 Revision -A



General Binding Corporation
One GBC Plaza
Northbrook, IL 60062-4195
