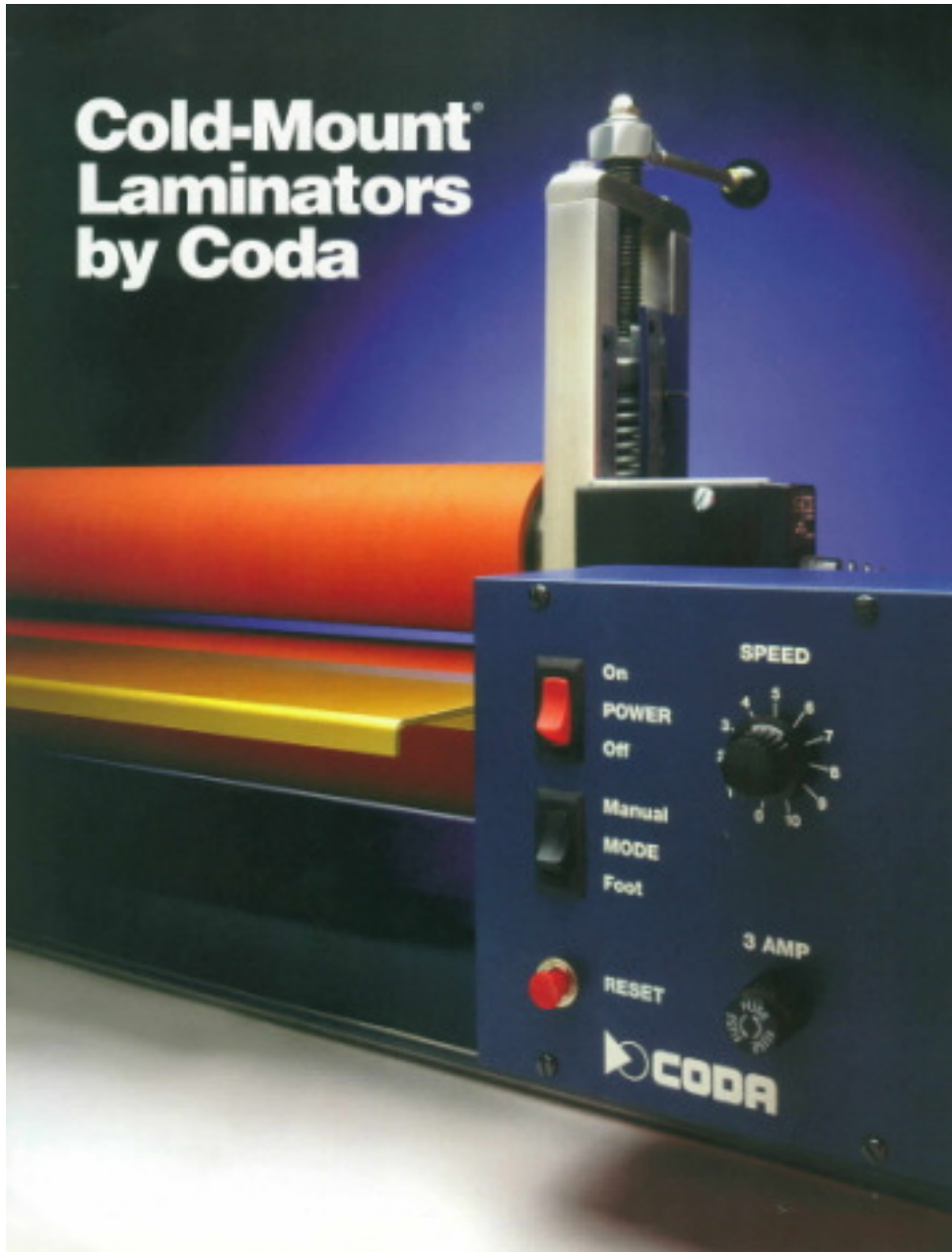


Coda Cold-Mount® Laminator Operation Guide



Finishing Products for the Imaging Industry

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Cold-Mount® Laminator Operation Guide

Index

INSTRUCTIONS

- Laminator Set-Up
- Location and Function of Controls
- Setting the Roller Pressure, Alignment and Gap
- Mounting a Print (Basic Cold-Mount® Procedure)
- Laminating a Print with a Sheeted Laminate
- Heavy Duty Roll Feed Option
- Coating Boards with Roll Adhesive
- Laminating with Roll Laminate

PRODUCTS

- Cold-Mount® System
- Cold-Mount® Adhesive Coated Boards
- Cold-Mount® Adhesives
- Cold-Mount® Laminates
- Accessories

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Laminator Set-Up

When the crated machine is delivered be sure to inspect for any shipping damage that may have occurred. If there is any damage notify the carrier and Coda, Inc. immediately. Remove the cardboard carton and unbolt the machine from the wooden base. Locate the laminator on a flat surface with enough space to work with your materials. It is important to use the laminator in a clean room as dirt and dust will stick to exposed adhesive. Adhesives and laminates perform best in a room with a temperature of 70 degrees F or higher.

In the crate is a cardboard box containing the footswitch and pressure adjustment tool (shown in section labeled Setting the Spring Pressure). Place the footswitch on the floor near the in-feed of the laminator. You will find a convenient location for the foot switch once you begin working with the laminator.

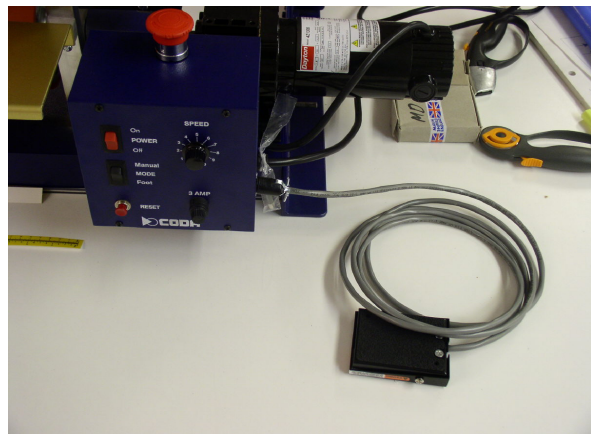


Figure 1

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Laminator Set-Up (continued)

Connect the footswitch cord to the connector on the side of the operator's control box as shown.

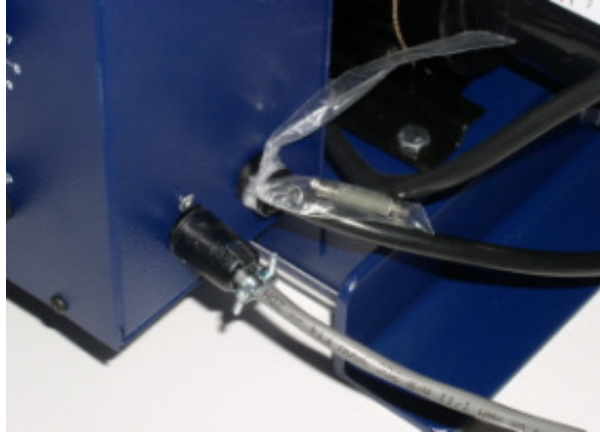


Figure 2

Plug the main power cord into a 110-115 VAC outlet.

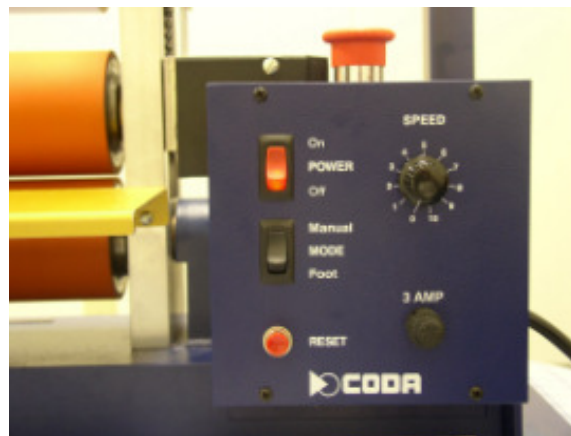


Figure 3

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Location and Function of Controls



Figure 4

- Power ON-OFF
- Manual Mode – When power is applied and Reset has been pressed the machine will run at the speed set by the Speed Dial.
- Foot Mode - When power is applied and Reset has been pressed the machine will run at the speed set by the Speed Dial whenever the footswitch is depressed.
- Reset – Machine will stop when the electric eye is interrupted. The Reset must be pressed to re-activate the machine.
- Emergency Stop – This button is located on top of the control box. Rotate and pull up to allow the machine to run. Push down for emergency STOP.
- SPEED – Controls the speed of the machine and has an integrated ON-OFF position. Note: The motor starts running when the speed is at about 2 on the Speed Dial.

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Setting the Spring Pressure

The roller pressure is a measure of the amount of force being applied to the material by the rollers. It can be adjusted in two ways, by the amount of pre-load on the pressure springs and/or by the amount of gap. Place the pressure adjustment tool into the slots and turn to adjust the pressure spring.

To adjust the amount of starting pressure applied by the pressure springs, insert the adjusting tool that came with your press into the slots in the castle nut. To increase the amount of pressure, rotate the nut clockwise so the spring compresses. To decrease the amount of pressure, rotate the nut counter-clockwise so the spring decompresses.

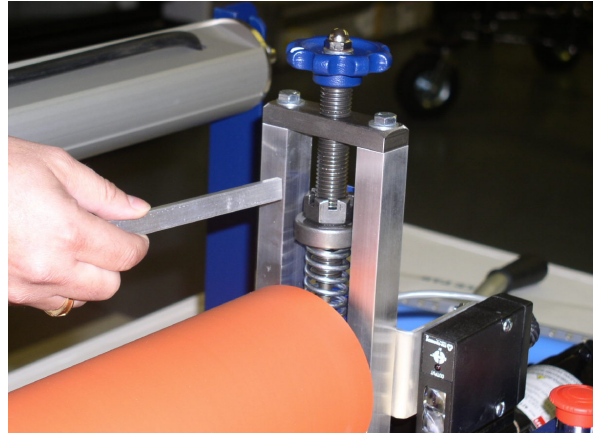


Figure 5

The pressure indicator is located on the side post assembly and is provided as a visual indication of the amount of pressure. The typical setting is 1-1/8" aligned with the top edge of the indicator. Be sure to set both sides to the same setting.

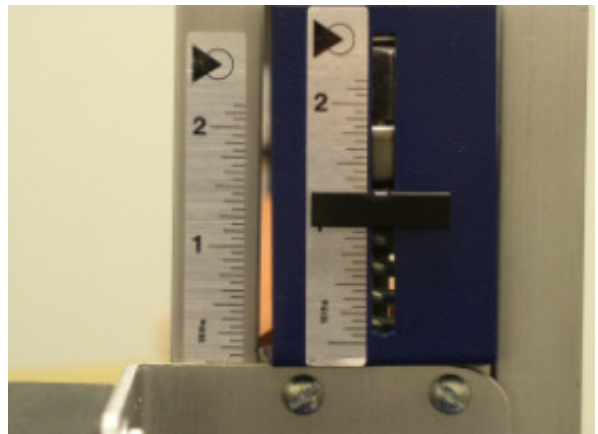


Figure 6

Adjusting the Rollers for Even Pressure

Using the gap adjusting knobs, lower the right side of the top roller so that it almost touches the bottom roller. Then do the same on the left side.

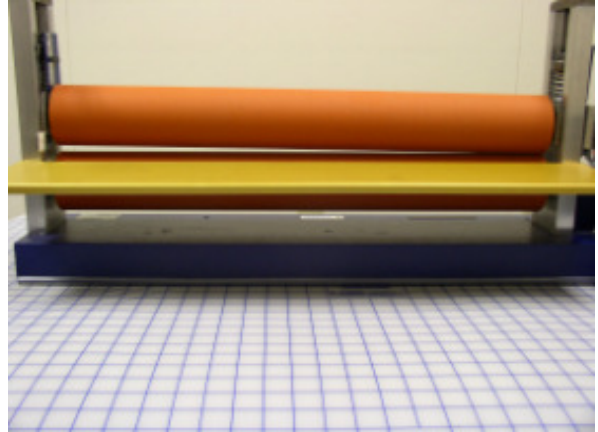


Figure 7

Next make the fine adjustment on the right by turning the gap adjusting knob clockwise until the rollers just touch. Then do the same on the left side until the rollers are parallel.

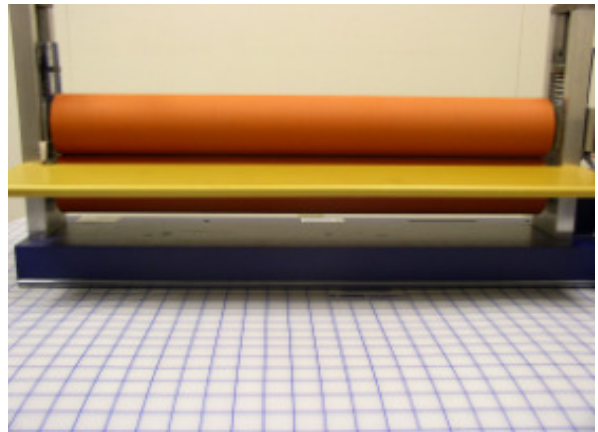


Figure 8

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Roller Alignment Procedure

Look at the top of the laminator and notice the position of the WHITE LINE on top of the gap adjusting knobs. At this point they should be very close to pointing in the same direction. Now adjust them so they are completely aligned (pointing in the same direction).



Figure 9

Any time you raise and lower the top roller you must have the lines facing the same direction. Example- When you turn the knob on the right 3 times you must also turn the knob on the left 3 times so the lines point in the same direction.

This procedure will assure even application of pressure by the top roller.

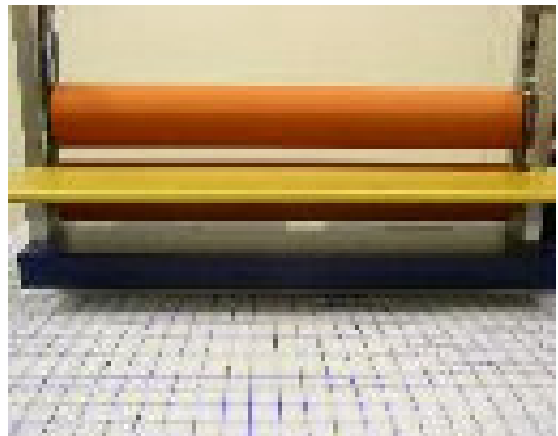


Figure 10

Setting the Roller Gap

Now that the rollers are properly aligned you are ready to set the gap for the work you are running.

Raise the top roller evenly as described in the previous section and place the substrate between the rollers.

Now lower the top roller evenly until the roller just touches the substrate. Then rotate each knob an additional three quarters of a revolution. This will allow for about 1/16" spring compression when the material is fed thru the laminator. (Rule of thumb is that the roller gap should be about 1/16" less than the thickness of the substrate.)



Figure 11

With the proper gap it will not be possible to pull the board and slide it between the rollers.

Once the gap is set feed a test board through the laminator. If the rollers crush the board, the roller gap is set too close.

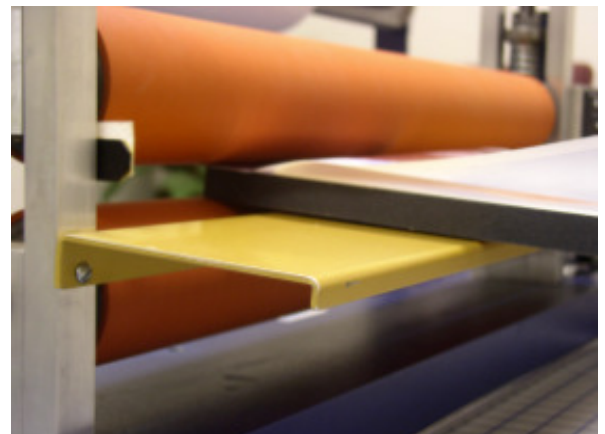


Figure 12

Basic Cold-Mount® Procedure

Using an adhesive coated board, peel the release liner back about 1-½" from the top of the substrate, then fold and put a sharp crease in the release liner.



Figure 13

Line the print up with the edges of the substrate. Lightly tack print along top ½" of substrate, working from the center out or from one side to the other, so as not to trap air. (Do NOT press along the crease in the release liner.)



Figure 14

Insert the tacked end of print about ½" into the laminator. (Do not catch release liner in the laminator.) As you start the laminator, hold the print at a 45 degree angle above the top roller.



Figure 15

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Basic Cold-Mount® Procedure (continued)

Use hand tension to wrap the print around the top roller. Make sure there are no gaps between the print and the roller.



Figure 16

Peel off the release liner. Run the print and the substrate through the laminator, taking care not to let the print flop down on the adhesive.



Figure 17

Always keep an even tight tension on the print to avoid any wrinkling. The print will come out perfectly mounted.

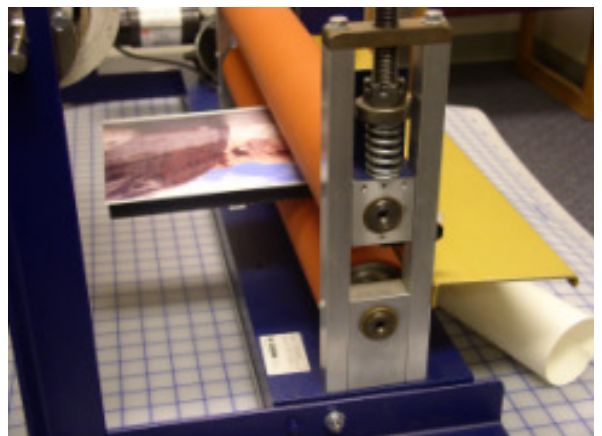


Figure 18

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Congratulations you have successfully mounted a print!

All boards with the same thickness can now be mounted one after the other without further adjustment.

If mounting onto a substrate of a different thickness, the gap must be re-adjusted. Be sure to check all adjustments prior to running new jobs.

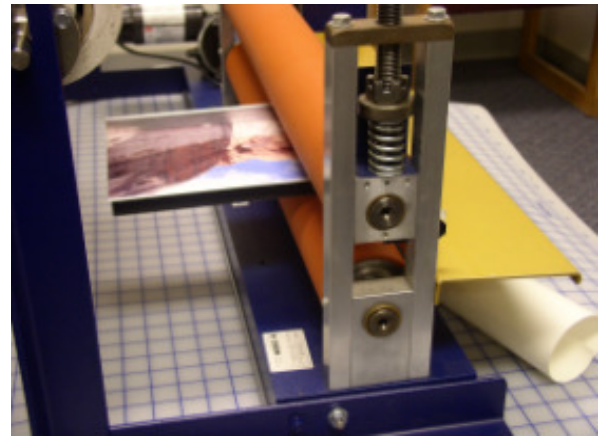


Figure 19

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Laminating a Print with a Sheeted Laminate

Always laminate an image before you mount it. Use a slow speed setting to assure good bonding of laminate to your print. Lamination speeds are at 1-½ to 3 on the Speed Dial. Never stop laminating in the middle of the image or a pressure line will occur. Always use a sled to guarantee even pressure. Use a pre-cut sheet or a roll of pressure sensitive over-laminate.

Use a sled made of a stiffer board (we recommend Gatorfoam) that is coated and the release paper is intact (providing a non-stick surface).

First feed the sled into the laminator with the release liner up so the rollers pinch it and hold it in place. Now take a sheeted laminate that is at least 2" larger than the print, peel back the release liner 1/2", put a sharp crease in it and tack it to the sled. Start the laminator and run it until the rollers are on the section of the laminate that is bonded to the sled.



Figure 20

Place the print with the image facing up under the laminate and wrap the laminate evenly around the top roller while holding the release liner.

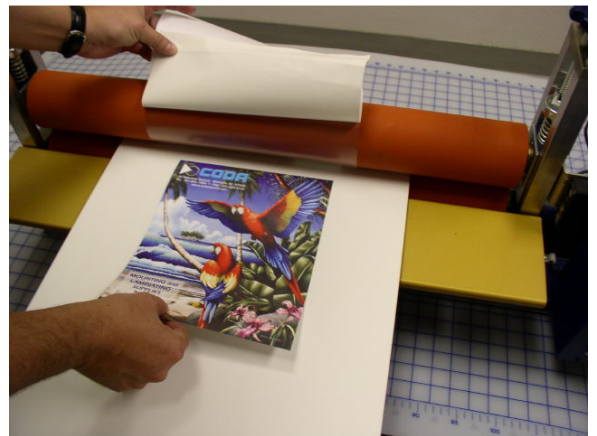


Figure 21

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Laminating a Print with a Sheeted Laminate (continued)

Start the laminator while holding the release liner and run it as slow as possible. Running slow applies the pressure for a longer period of time across the entire width which will result in a better adhesion of the laminate to the print.



Figure 22

Be sure to hold the release liner, peeling it back slowly as the laminate is fed into the laminator. Be careful not to allow the release liner to feed into the laminator and get pinched between the rollers.



Figure 23

Laminating a Print with a Sheeted Laminate (continued)

Do not peel the release liner all the way off and let the laminate fall onto the print as this will trap air and cause bubbles.



Figure 24

The laminate should make first contact with the print at the same point that the top roller contacts the print. This will insure even application of the laminate to the print.



Figure 25

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Laminating a Print with a Sheeted Laminate (continued)

Remove the laminated print from the sled by lifting it. The print should be easy to remove as it is sticking to the release liner on the sled.

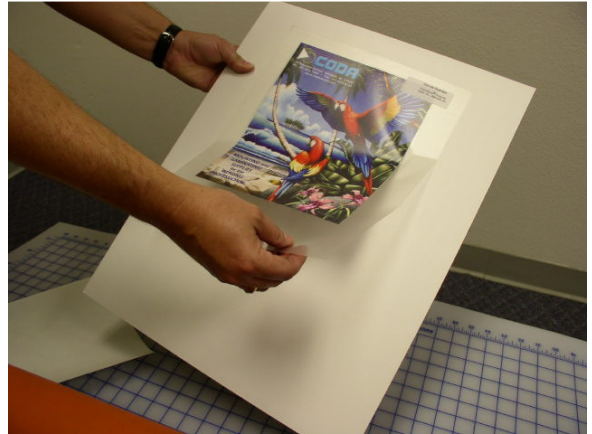


Figure 26

Place the image on a cutting matt and trim to size.



Figure 27

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Heavy Duty Roll Feed

Inspect the contents of the HEAVY DUTY ROLL FEED kit to familiarize yourself with the parts that make it up.

The kit consists of the following five parts:

- Left Side Bracket
- Right Side Bracket
- Unwind Shaft
- Tension Brake
- Threaded Rod



Figure 28

** Optional Heavy Duty Roll Feed*

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Heavy Duty Roll Feed Assembly

The Cold-Mount® Laminator should be on a sturdy level table top before attaching the Roll Feed Brackets.

To attach the Heavy Duty Roll Feed to the Laminator:

Place the brackets against the ends of the laminator base. The left bracket mounts against the left side of the machine and the right bracket mounts against the right side of the machine. Each bracket has a white label on it which identifies it as right or left.

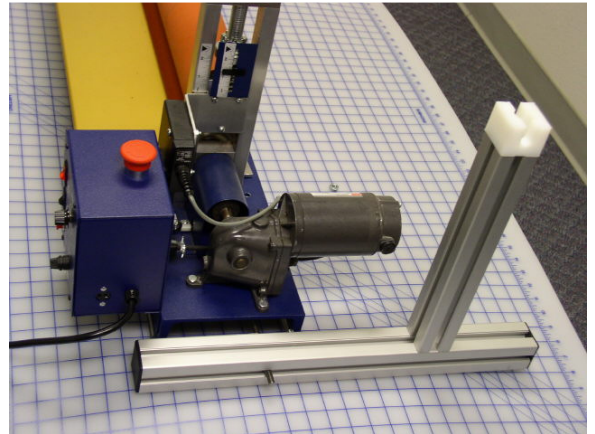


Figure 29

The brackets should be positioned so the labels are against the ends of the laminator base. There is a fillister head screw on the label side of each bracket. Position the bracket so this screw head is butted against the output side of the machine base. This will “index” the brackets to the machine to help assure that the feed bar will be parallel to the rollers of the machine.

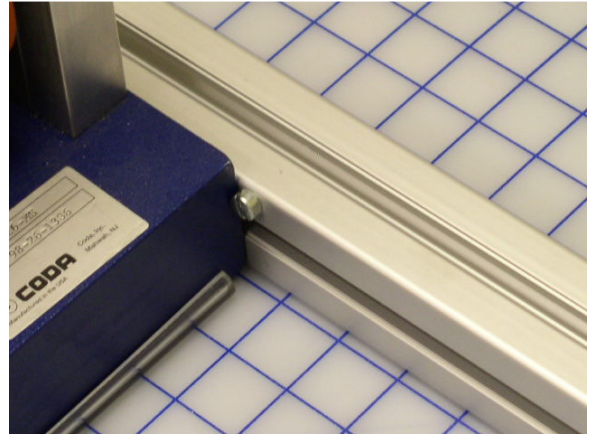


Figure 30

The threaded rod should be positioned so it goes through the hole drilled in one bracket base, all the way across the machine under the machine base and through the hole in the other bracket. Use a wrench to tighten the nuts on each end to clamp the brackets against the base.

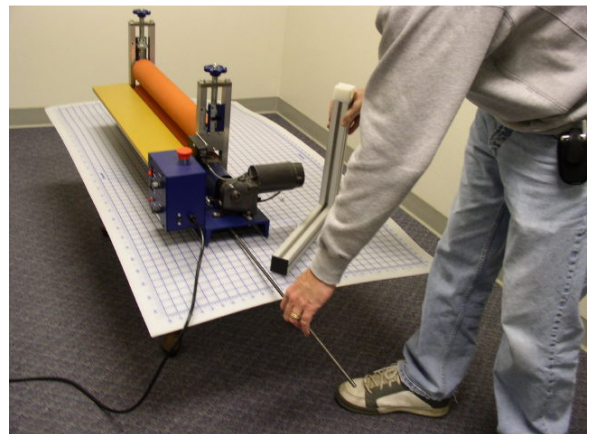


Figure 31

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Heavy Duty Roll Feed Assembly

Figure 32 shows the tension brake location and orientation. By tightening the brake screw more drag is applied to the feed-bar which increases the amount of tension in the material being applied. By loosening the brake screw less drag is applied to the feed-bar which decreases the amount of tension in the material being applied



Figure 32

Figure 33 shows an adhesive being applied to an uncoated board using the Heavy Duty Roll Feed.

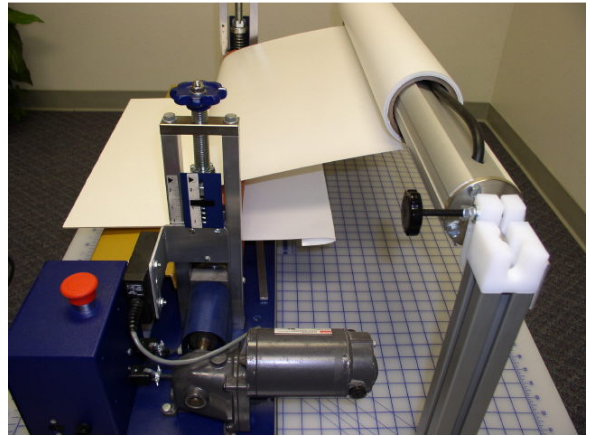


Figure 33

Figure 34 shows the Heavy Duty Roll Feed assembled to a 26" Laminator.

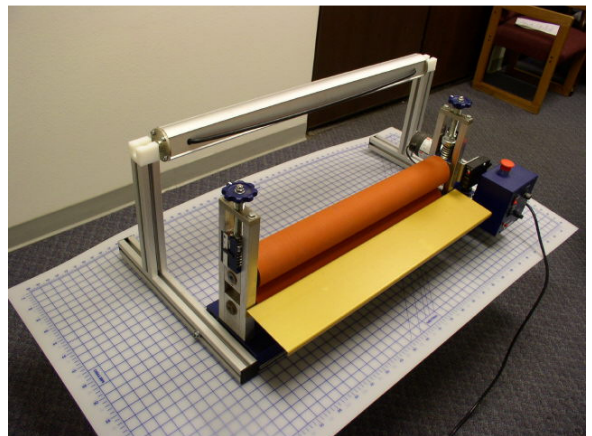


Figure 34

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Laminating with the Heavy Duty Roll Feed

Position a roll of laminate on the feed-bar then insert the feed-bar into the slots on the brackets.

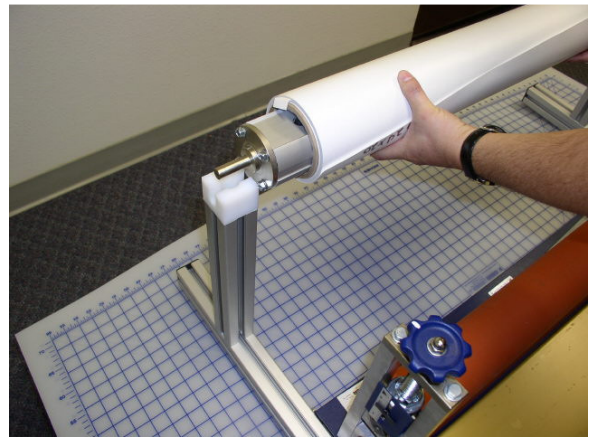


Figure 35

Place the tension brake on the right side of the feed-bar.

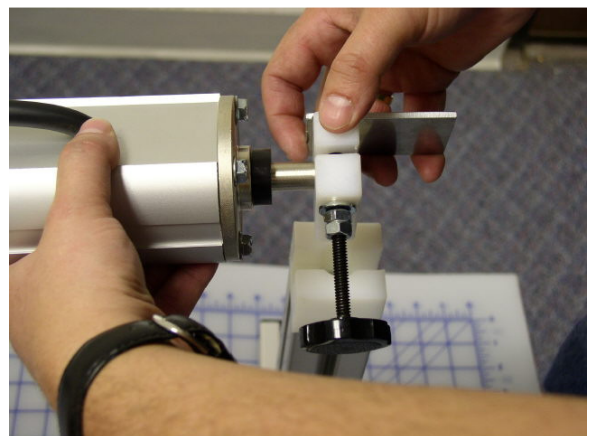


Figure 36

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Laminating with the Heavy Duty Roll Feed (continued)

Select a leader board and sled of the same thickness and set the roller gap (1/16" less than sled thickness) as defined in previous sections for setting Roller Gap, Alignment and Pressure.

Peel back the release liner and drape the laminate over the rollers. Push the leader board in between the rollers causing the laminate to go with it. Feed the leader board through until the trailing edge is about in the middle of the feed tray, then stop the laminator.

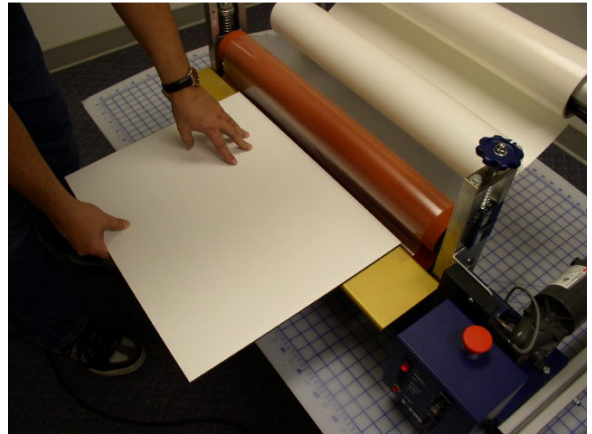


Figure37|

Now butt the leading edge of the sled up to the trailing edge of the leader board and laminate the print.



Figure 38

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Coating Boards with the Heavy Duty Roll Feed

Place adhesive roll on feed bar and center it to the rollers.



Figure 39

Turn tension brake ½ turn from the loose (no brake) position and set the Speed Dial to 4.



Figure 41

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Set the roller gap ($1/16$ " less than board thickness) as defined in previous sections for setting roller gap, alignment and pressure. Drape the adhesive over the rollers then push the board in between the rollers causing the adhesive to go with it.

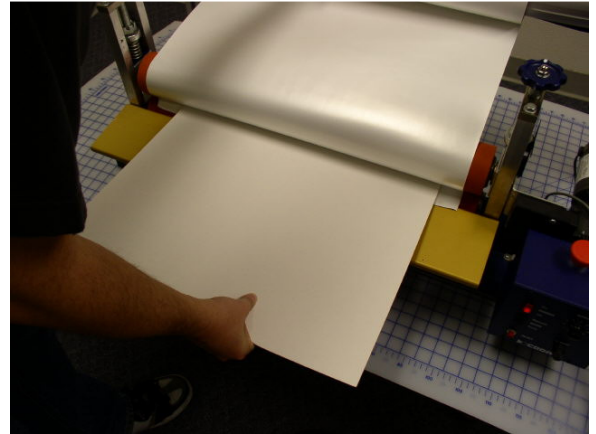


Figure 42

Feed the board through until the trailing edge is about in the middle of the feed tray, then stop the laminator and butt the next board to be coated up against it. You are now ready to feed boards and coat continuously.

You can use a leader board to begin this process if you prefer.

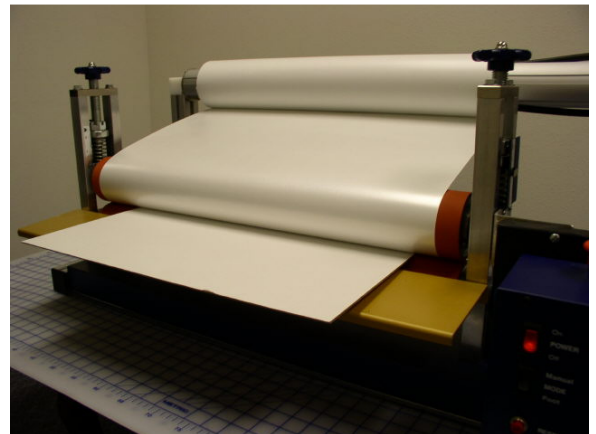


Figure 43

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Coating Boards with the Heavy Duty Roll Feed

Once the board is coated it should be cut and trimmed right away. The coated boards can be used immediately for mounting or properly stored for later use.



Figure 44

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Coda Cold-Mount® System

The Cold-Mount® System is a system comprised of Coda's Cold-Mount® laminator, floor stand and scrap rewind. The base is made from extruded aluminum with total-locking casters. This provides a solid, portable mounting system. In addition there is an automatic scrap rewind with tension control. This feature enables the operator to rewind the release liner hands free. It is very useful for laminating long, wide outputs such as banners and signs.

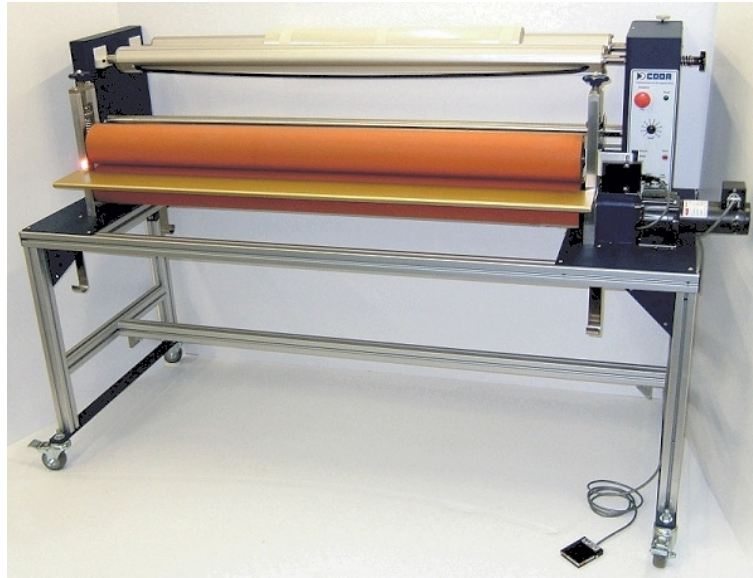


Figure 45



Figure 46

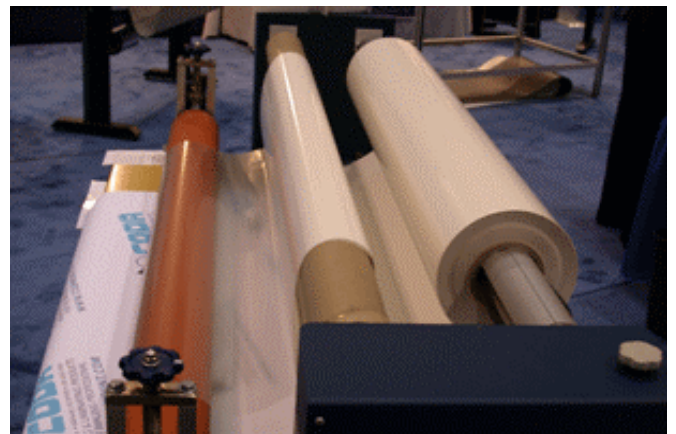


Figure 47

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Coda Cold Pressure Sensitive Laminates

Coda, Inc. has a variety of roll and sheet laminates:

- Glossy
- Lustre
- Matte
- Canvas
- E-Lam

All laminates can be cut to your specific size requirements.

Contact Coda for an Overlam sample pack.



Figure 48

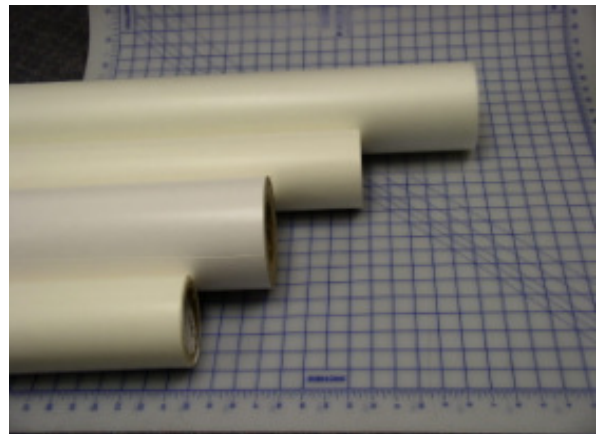


Figure 49

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Coda Mounting Adhesives

Coda's high performance mounting adhesives are available in rolls:

- Double Release (DR) *
- Single Release Clear (SR)
- Single Release White (SRW)
- Cold-Mount 1 (CM1)
- Transparency (Optically Clear)

* DR also available in cut sheets.



Figure 50



Figure 51

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Coda Pre-Coated Boards

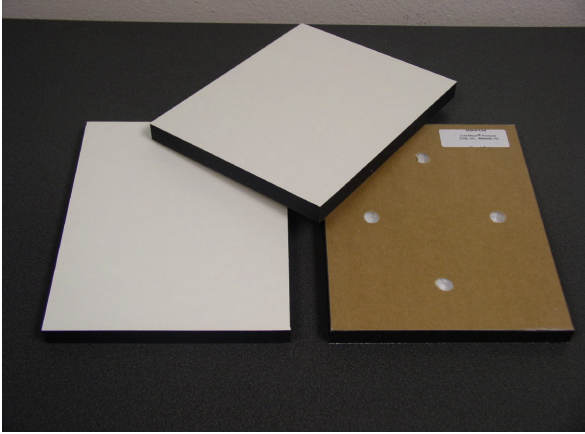


Figure 52



Figure 53

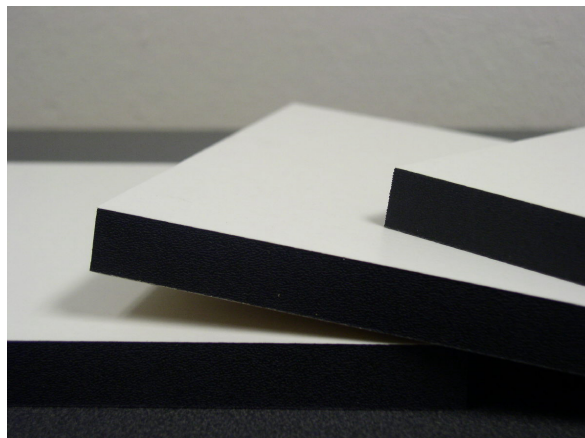


Figure 54

Coda has a wide variety of adhesive coated boards. These are high quality, popular substrates:

- Gatorfoam
- Styrene
- Codafoam
- Foam Core
- Hardboard
- Cardboard

Finished display mounts called Stand-Outs and Mural Mounts are also available (shown above in figures 52 and 54).

Contact Coda for a board sample pack.

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Coda Accessories

- Shortcut Safety Print Trimmer. Lengths available: 28", 40", 52", and 64".
- Coda Cutting Mat (100 mil thick). Sizes available: 36" x 60" and 48" x 96".



Figure 56

- Sure Clean Print Roller with a pad of roller cleaning sheets.



Figure 57

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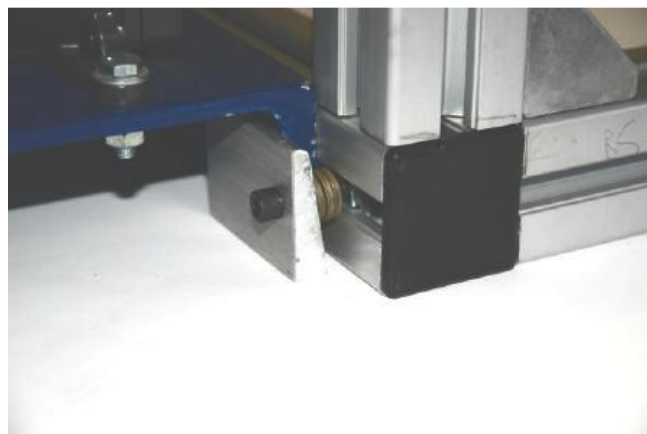
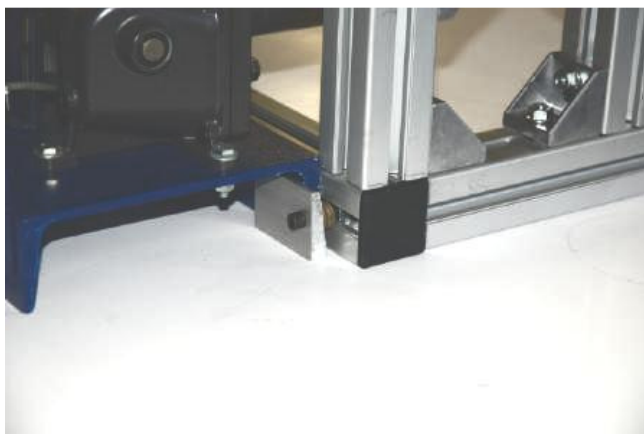
Cold-Mount® Laminator Operation Manual

January 2006

Feed/Take-Up Attachment Instructions



To begin using the Feed/Take-Up Attachment (FTU) it must first be positioned behind the press then secured to the base. First position the FTU as shown in the pictures above.



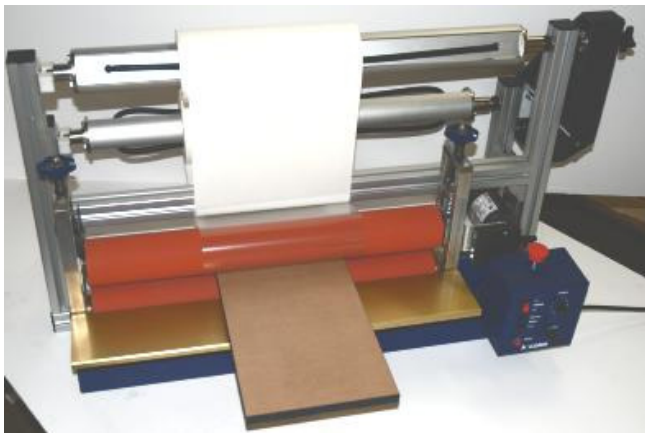
Next secure each side of the FTU to the base of the press using the clamps as shown in the pictures above.

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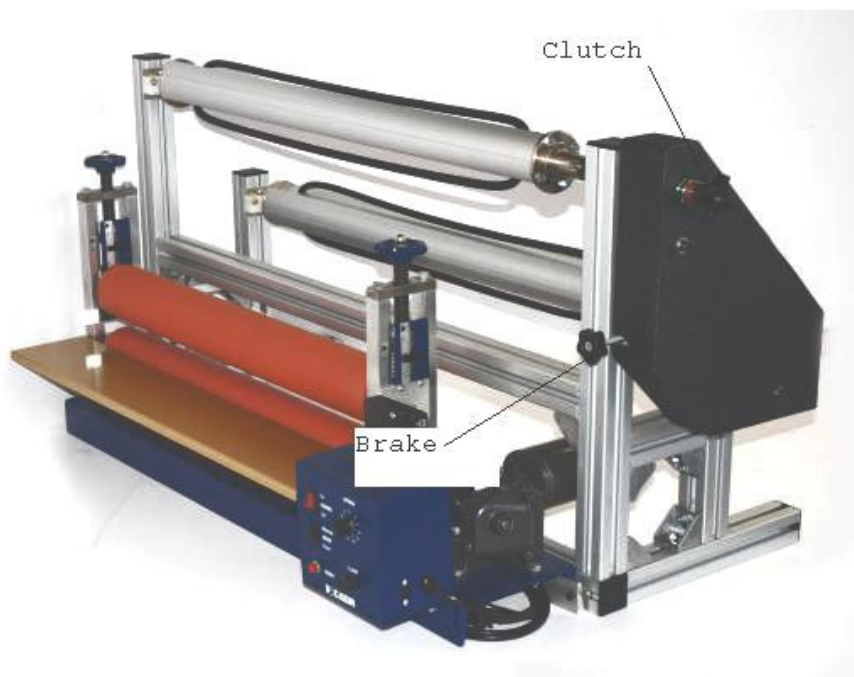
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Feed/Take-Up Attachment Instructions



The Feed Roll is installed on the autolock feedbar in the lower position farthest from the press. The take-up bar is installed in the upper position closer to the press. Once the rolls are installed web the material as shown using the cross bar as a peel bar or the point where the release liner separates from the film. To adjust the separation point tighten the clutch knob to move this point closer to the peel bar or loosen it to move it further away from the peel bar. To adjust the tension on the feed material tighten (cw rotation) the drag brake to increase the tension and loosen it to decrease the tension.



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