

Lamination System Operation



STEP 1: APPLY GLUE WEB

The operator starts the process by feeding the substrate through the glue application area. Adjustable pinch rollers dispense the glue web automatically as the substrate advances. Once the glue has been applied, a hot knife or hot wire (LS Series) system is used to separate the glue

STEP 2: INDEX LAMINATE

The laminate is manually positioned to an adjustable indexing pin. The advancing substrate with glue trips a finger switch, which activates the laminate drive.

*LAMINATE DRIVE AVAILABLE ONLY ON LS SERIES UNITS

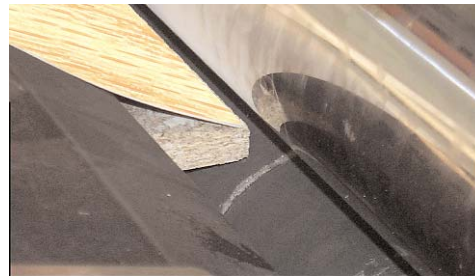


STEP 3: HEAT BANK ACTIVATED

The substrate with glue passes under triple heat banks. The glue web is flash activated and advances to the pinch roll area.

STEP 4: LAMINATION OF BOARD

The face material and substrate meet and enter the pinch rollers where they are bonded together. A laminated panel is cleanly and efficiently produced.....



....and ready for immediate fabrication!

Application Specifications

Typical Lamination Applications

Face / Laminate Materials

Rolled Stock, Papers, Melamine, High Pressure Laminate (all grades), Fabrics, Decorative Wall Coverings, Cabinet Liner, Backed Veneers, Hardboard 1/8", Lauan, Linoleum, Fiberglass, Synthetics & Metals

Substrate Materials

Foams, Particle Board, MDF, Plywood, Lauan, Honeycomb Core, Fiber Board, Synthetics, Flake Board, Hardwoods

Laminating Systems

Available Width Units	S26/S 50	LS 50	S 62	LS 62
Maximum Substrate Widths:	50"	50"	62"	62"
Minimum Substrate Widths:	12"	12"	12"	12"
Maximum Substrate Length: if using Glue Web cutoff	8'	12'	8'	12'
Minimum Substrate Length:				
With Carrier	12"	12"	12"	12"
With-Out Carrier	27"	27"	27"	27"
With Laminate Drive	N/A	54"	N/A	54"
Substrate Thickness**	1/8" - 4"	1/8" - 4"	1/8" - 4"	1/8" - 4"
Minimum Laminate Widths:	12"	12"	12"	12"
Minimum Laminate Length***	12"	12"	12"	12"
Feed Rate Per Minute****	Up to 30'	Up to 40'	Up to 30'	Up to 40'

Materials must be acclimated to room temperature (no less than 65 degrees) prior to use.

- * Smaller parts under 12" will require using a carrier sheet.
- ** Additional pinch roller height can be accommodated up to 6".
- *** Materials under 52" must be fed manually.
- **** Speed based upon materials

System Specifications

S & LS Series Features

√ = Standard

	<u>S Series Unit</u>	<u>LS Series Unit</u>
4" Pinch Roller Opening	√	√
Triple Heat Banks	√	√
Digital Pinch Roller Height Indicator	√	√
Heavy 2 1/2" Conveyor Rollers	√	√
Temp Control with LED Readout	√	<i>*Included in PLC Control</i>
Laminate Drive System	N/A	√
Pneumatic Hot Wire Cutoff System	N/A	√
PLC Touchpad Control	N/A	√
Auto Cool Down	N/A	√
Auto Shut Down	N/A	√
12' Panel Capability	N/A	√
Stainless Steel Trim Finish	N/A	√

Physical Dimensions

Length	21'	26'
Width (base)	6'	6'
Height	5.5'	5.5'
Air Consumption	1cfm / 100psi*	1cfm / 100psi
Electrical Voltage	240 or 480 3 Phase	240 or 480 3 Phase

*Air consumption required on S Series only if machine is equipped with Roll Feed Attachment.

Machine Electrical Requirements (All Units Three Phase Electrical)

Unit Type	240 Volt	480 Volt
S 50 Series & LS 50 Series Laminator 27 KW. 27,000 watts	80 Amp Draw	40 Amp Draw
S 62 Series & LS 62 Series Laminator 36 KW. 36,000 watts	95 Amp Draw	48 Amp Draw