

Tips for Adjusting your Automatic Laminating Machine

For Models ALM 3230, 3222, and 3220

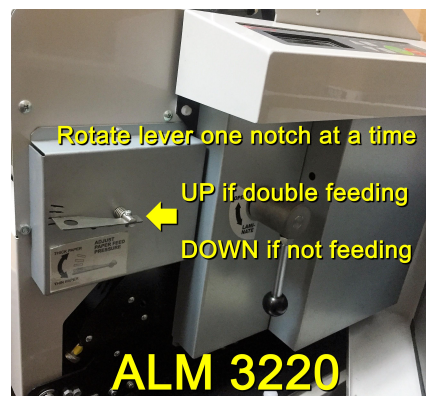
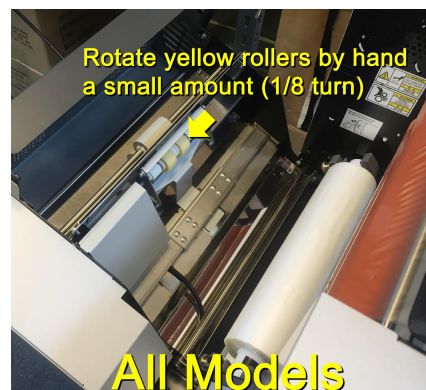
FEEDING

Fan your pages! This is important to remove static/toner cling. Doing this effectively solves most double-feed problems if the feed tray adjustments are correct.

If feeding problems occur...

1. First turn the yellow feed roller a small amount clockwise by hand.
(See right →)

2. Then set the feed roller pressure dial in small increments.
(See images below ↓)



FILM TENSION

Improper film tension can cause problems!

Make sure film is set with at least some tension, especially with thinner films. Not enough tension can create slack and cause cutting problems, too much tension can cause lamination problems and put stress on the machine. Adjusting the tension can also fix any curl in the final laminated document.

TEMPERATURE

Temperature and speed guidelines for Gloss or Matte Films:

1.5 Mil	3 Mil	5 Mil
Temp: 210F – 230F Speed: 48-68 in/min*	Temp: 220F – 240F Speed: 48-68 in/min*	Temp: 230F-250F Speed: 48-60 in/min*
*For some models, max speed is 40 or 48 in/min. Begin with above temperatures, then increase temperature as necessary for thicker paper stock.		

Questions? Call us toll free at (855) 880-7500 or visit www.saddlepointsystems.com



For more details, see any machine's Operator Manual at:
www.saddlepointsystems.com/resources/manuals-downloads/



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Cutting

Tips for setting film margins:

- When flush cutting heavy papers (no margins), leave a small bead of lamination around the outside of the sheet (1/32" or more). This will maintain waterproofing and prolong cutter life.
- Cuts should be at least slightly (1/32" or more) from the edges of the page (inside or outside - Cuts on exact edge of paper can cause jams).
- ➔ Close margins are accomplished by setting machine to "No Margin" and adjusting the cut so the machine trims the leading and trailing edges just outside of the paper edge, then set slitters by hand.

Cut adjustment for leading and trailing edges:

Press: "MODE" → "DOWN" → "Cut Adjust"

For more margin press "UP"
For less margin press "DOWN"

Use "TEMP/SPEED" button to select between front and back.

- Thin film (1.5 Mil) will require margins not to exceed 1/4" in most cases to maintain proper cutting tension (excessive margins can cause cutting problems).
- Cut adjustment may change when switching between gloss and matte films because of the optical sensor.



ALM 3230



ALM 3222



ALM 3220

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