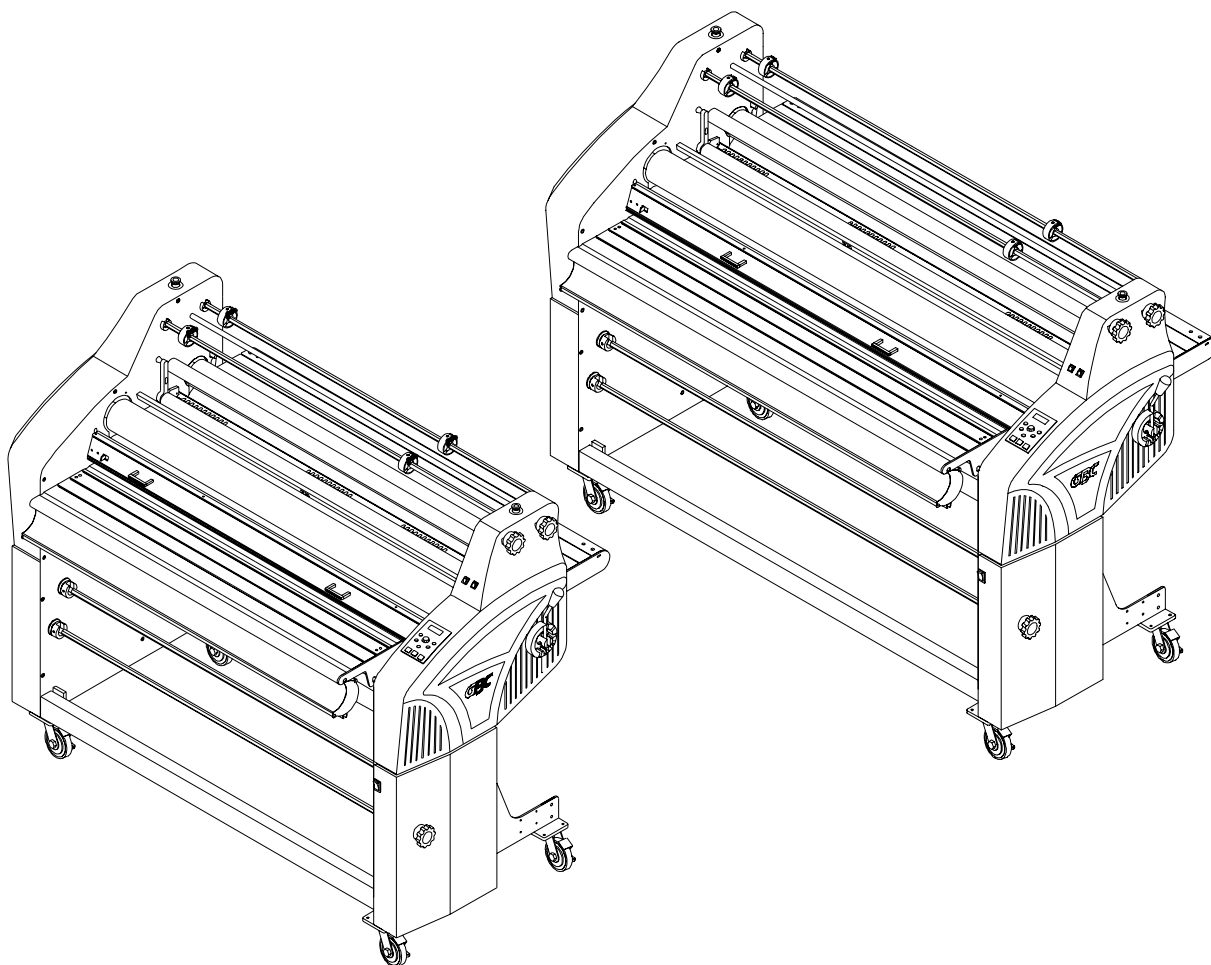




# GBC TALON 44/ 64

## 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: 930-097 (PRELIMINARY)



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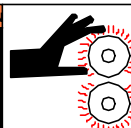
## IMPORTANT SAFETY INSTRUCTIONS

**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	⚠ ATTENTION		⚠ WARNING
Riesgo de choque eléctrico. No abra. Adentro no hay piezas reparables por el usuario. Mantenimiento solamente por personal calificado.	Risque de secousse électrique. Ne pas ouvrir. Pas de pièces réparables par l'utilisateur. Entretien seulement par personnel qualifié.		Electrical shock hazard. Do not open. No user serviceable parts inside. Refer servicing to qualified service personnel.

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

⚠ ADVERTENCIA	⚠ ATTENTION		⚠ CAUTION
RODILLOS CALIENTES. PUNTO DE PINCHAMIENTO. Mantener manos y ropa a distancia.	ROULEAUX CHAUDES. POINT DE PINCEMENT. Tenir mains et vêtements à l'écart.		HOT ROLLS. PINCH POINT. Keep hands and clothing away.

**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	⚠ ATTENTION		⚠ CAUTION
NAVAJA FILOSA. Mantener manos y dedos a distancia.	LAME COUPANTE. Tenir mains et doigts à l'écart.		SHARP BLADE. Keep hands and clothing away.

**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 TALON 44/ 64 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.**



## 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 the equipment to be free from defects in material and workmanship for a period of **90 days for parts and labor** from the date of installation. This warranty is the only warranty made by GBC and cannot be modified or amended.

GBC IPFG's sole and exclusive liability and the customer's sole and exclusive remedy under this warranty shall be, at GBC IPFG's option, to repair or replace any such defective part or product. These remedies are only available if GBC IPFG's examination of the product discloses to GBC IPFG's satisfaction that such defects actually exist and were not caused by misuse, neglect, attempt to repair, unauthorized alteration or modification, incorrect line voltage, fire, accident, flood or other hazard.

### Limited Warranty

This warranty specifically does not cover damage to the laminating rollers caused by knives, razor blades, other sharp objects, failure caused by adhesives or improper use of the machine. Warranty repair or replacement does not extend the warranty beyond the initial 90 day period from the date of installation.



**WARNING: Unauthorized customer alterations will void this warranty.**

**THE WARRANTY MADE HEREIN IS IN LIEU OF ALL OTHER WARRANTIES, EXPRESSED OR IMPLIED, INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. GBC WILL NOT BE LIABLE FOR PROPERTY DAMAGE OR PERSONAL INJURY (UNLESS PRIMARILY CAUSED BY ITS NEGLIGENCE), LOSS OF PROFIT OR OTHER INCIDENTAL OR CONSEQUENTIAL DAMAGES ARISING OUT OF THE USE OR INABILITY TO USE THE EQUIPMENT.**

### Exclusions to the Warranty

This warranty specifically does not cover;

1. Damage to the laminating rollers caused by knives, razor blades, other sharp objects or failure caused by adhesives.
2. Damage to the machine caused by lifting, tilting and/or any attempt to position the machine other than rolling on the installed castors on even surfaces.
3. Improper use of the machine.
4. Damage due from unqualified person(s) servicing the machine.

**QUALIFIED:** Any person(s) trained by GBC to perform service related work on such equipment.

**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.

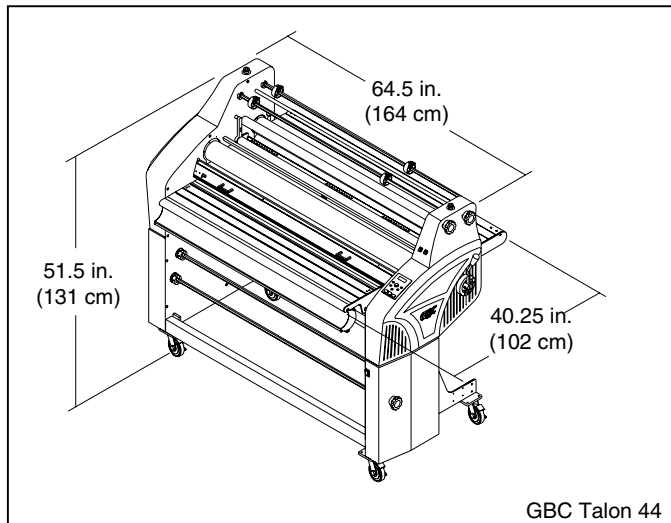


Fig. 1

## SPECIFICATIONS - TALON 44

**Operating Speed:**

Up to 10 fpm (3 mpm)

**Temperature range:**

32 °F - 270 °F (0 °C - 132 °C)

**Max. Mounting Thickness:**

1/2 in. (1.3 cm)

**Max. Film Width:**

Talon 44: 44 in. (112 cm)

**Dimensions (W x D x H):****Unit alone: (Figure 1)**

64.5 in. x 40.25 in. x 51.5 in.

(164 cm x 102 cm x 131 cm)

**Shipping:**

67 in. x 43 in. x 62.5 in.

(170 cm x 109 cm x 159 cm)

**Weight:****Unit alone:** 788 lb. (357 kg.)**Shipping:** 965 lb. (438 kg.)**Electrical Requirements:**

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

**Voltage:** 220V~60 Hz**Current:** 14.3A**Power:** 3200 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)

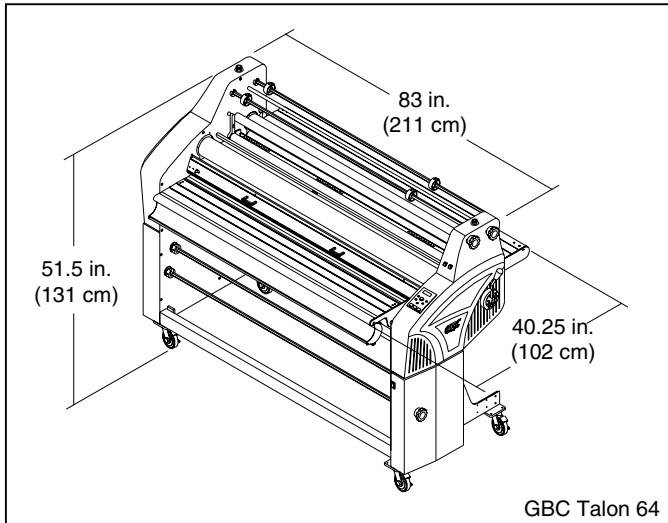


Fig. 2

## SPECIFICATIONS - TALON 64

**Operating Speed:**

Up to 10 fpm (3 mpm)

**Temperature range:**

32 °F - 270 °F (0 °C - 132 °C)

**Max. Mounting Thickness:**

1/2 in. (1.3 cm)

**Max. Film Width:**

Talon 64: 64 in. (163 cm)

**Dimensions (W x D x H):****Unit alone: (Figure 2)**

83 in. x 40.25 in. x 51.5 in.

(211 cm x 102 cm x 131 cm)

**Shipping:**

85 in. x 43 in. x 62.5 in.

(216 cm x 109 cm x 159 cm)

**Weight:****Unit alone:** 1030 lb. (467 kg.)**Shipping:** 1250 lb. (567 kg.)**Electrical Requirements:**

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

**Voltage:** 220V~60 Hz**Current:** 15A**Power:** 3500 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)

## PRE-INSTALLATION

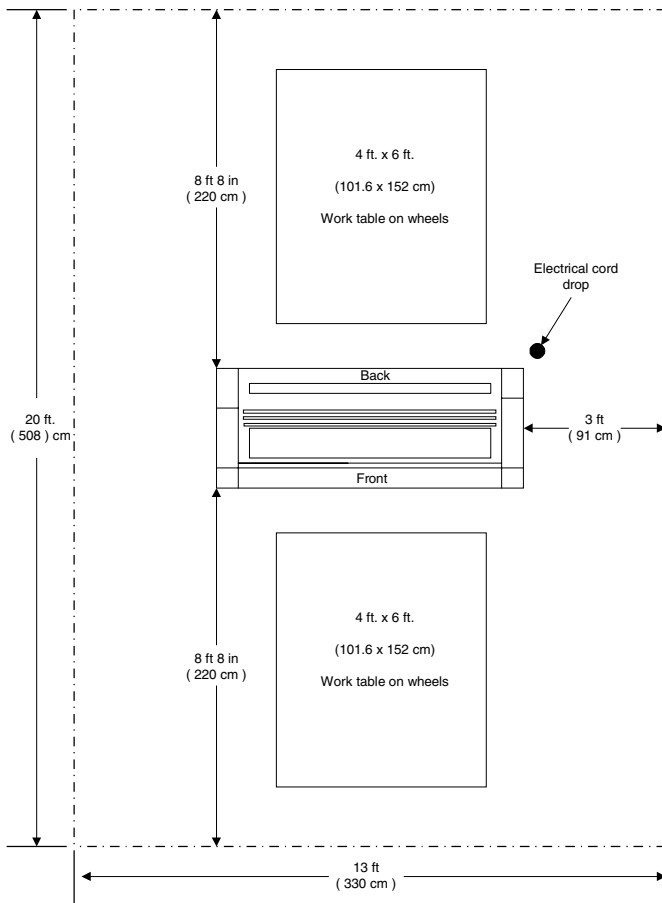


Fig. 3

Before a Talon 44/ 64 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 3)
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/ cooling of the rollers and result in poor output quality.**

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?

**Talon 44 requires:**

- 220V at 60hz with 14.3 amp service. Use a Nema

**Talon 64 requires:**

- 220V at 60hz with 15 amp service. Use a Nema

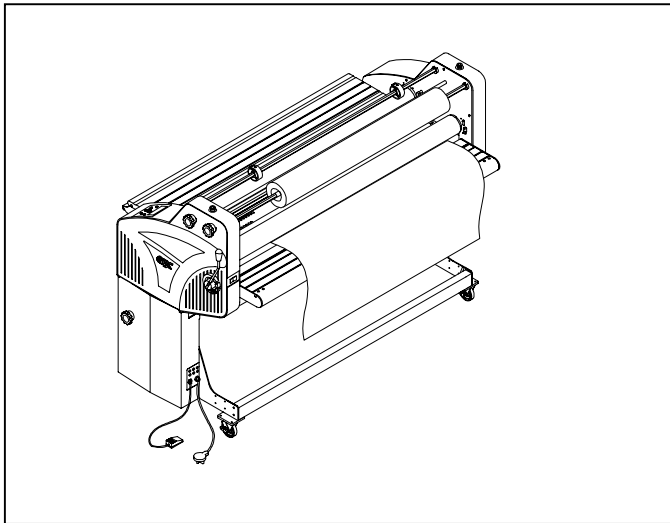


Fig. 4

## 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 4). 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.**

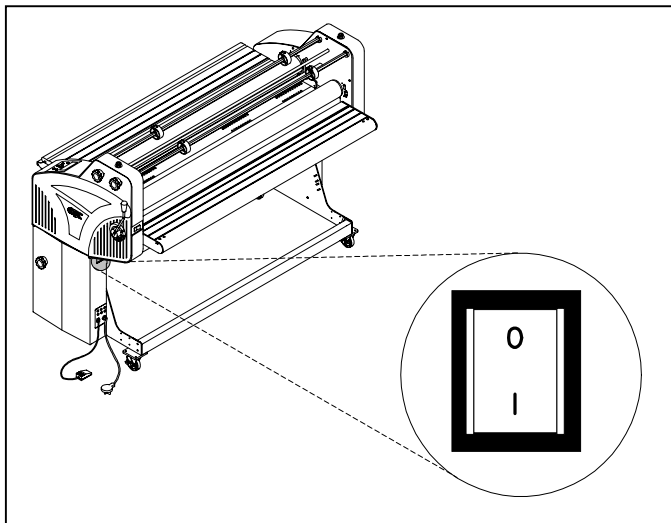


Fig. 5

TOP > 032°F      SPEED > 03  
 BOT > 032°F      JOB > 01  
 Release  
 WAIT

Fig. 6

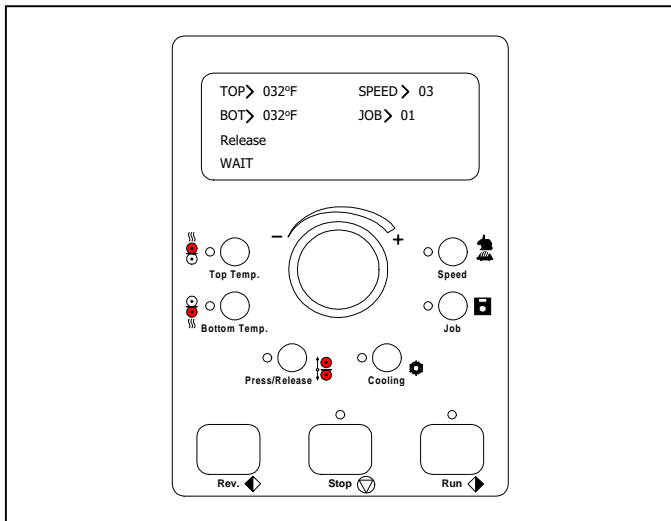


Fig. 7

## CONTROL GUIDE

### A. POWER ON/ OFF: (Figure 5)

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 6) 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 7, 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 traveling in an upward or downward motion.

### C. CONTROL PANEL: (Figure 7)

**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 and bottom main rollers.

**Top Temp.**  : When pressed, permits increasing or decreasing of the top temperature by turning the **MASTER DIAL**  and is indicated on the control panel display. Range is 32°F - 266°F (0°C - 130°C).

**Bottom Temp.**  : When pressed, permits increasing or decreasing of the bottom temperature by turning the **MASTER DIAL**  and is indicated on the control panel display. Range is 32°F - 266°F (0°C - 130°C).

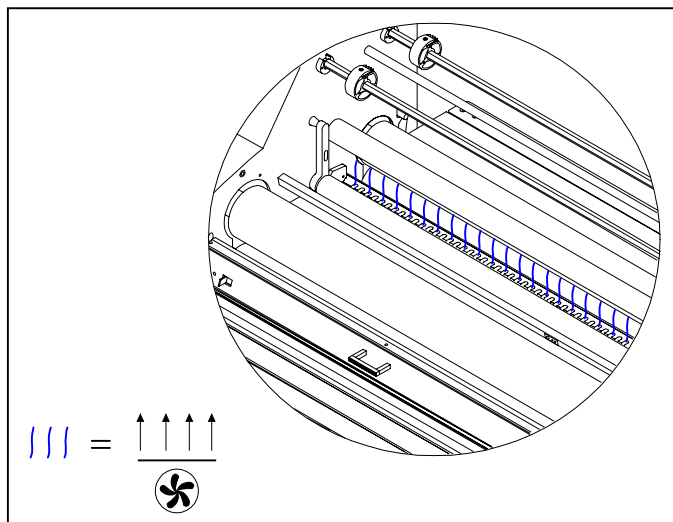


Fig. 8

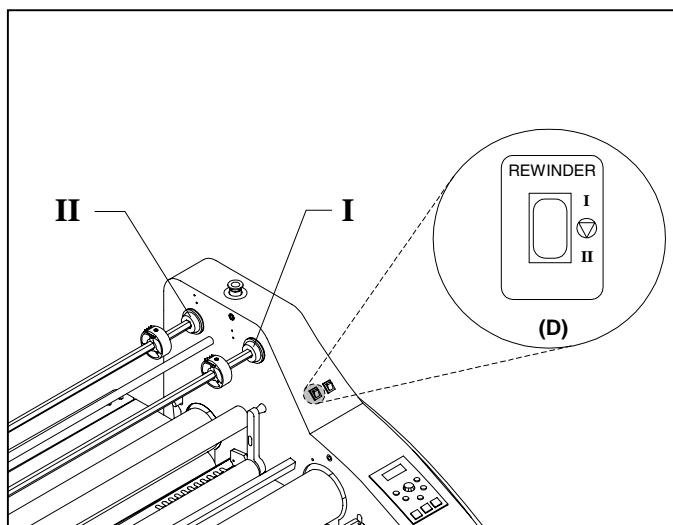









Fig. 9


**Press/ Release**  : When pressed, raises the upper main roller over riding the pull roller handle setting. When pressed again, reverts to current pull roller handle setting.


**Cooling**  : (Figure 8) When pressed, turns on the cooling fans. When pressed again, turns off the cooling fans.


**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. Job 10 is reserved for running Accushield material.

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** .

**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.

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


**STOP**  : Stops the movement of the rollers.

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

#### D. REWINDER SELECTION

**SWITCH:** (Figure 9) 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.



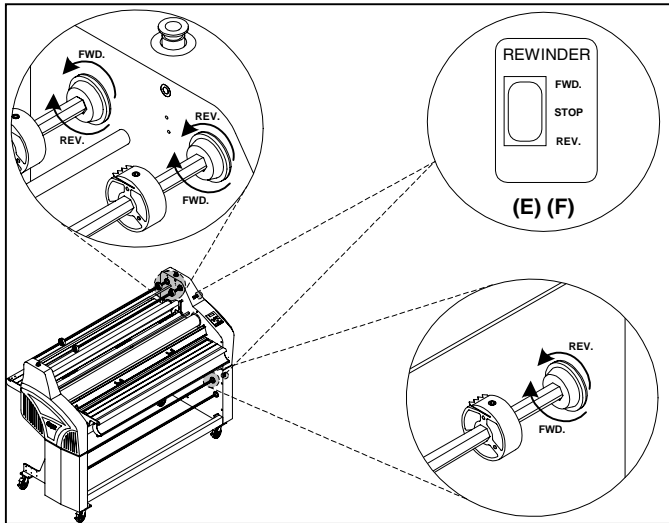


Fig. 10

**E. UPPER REWINDER DIRECTION SWITCH:** (Figure 10) 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 rewinder motor for the rewind/ unwind shaft selected.

“**REV.**” : In this position, the motor runs in a reverse direction.

**F. LOWER REWINDER DIRECTION SWITCH:** (Figure 10) 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 rewinder motor for the rewind/ unwind shaft selected.


“**REV.**” : In this position, the motor runs in a reverse direction.

**G. REAR CONTROL SWITCH:** This switch enables the operator to run jobs from the rear operating position of the laminator when rear controls are enabled.


“**REVERSE**” : In this position, the rollers turn from the front operating position towards the rear operating position.

“**STOP**” : Stops the movement of the rollers.

“**RUN**” : In this position, the rollers turn from the rear operating position towards the front operating position.

To enable the rear control switch, press and hold **JOB**  until you hear a beep, approximately 3 seconds. **REAR CONTROL** replaces **READY/ WAIT** on the control panel display.


Replace the rear slitter with the safety shield properly installed and latched.

Press and hold **JOB**  again to disable the rear control switch.

**H. FOOT SW ENABLE:** 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.

## FEATURES GUIDE

**A. E-STOP:** Two E-STOP buttons exist on the laminator. One on each side of the upper cabinet.

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

To dis-engage, turn the push button clockwise once the emergency condition has been resolved.

**B. SAFETY SHIELD INTERLOCK**

**LATCH:** 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, the safety shield is locked. When pushed to the full right, the safety shield is unlocked.

**C. SAFETY SHIELD:** 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 the safety shield up and away from the safety shield mounting pins.

**D. FEED TABLE:** 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. HEAT ROLLERS:** Silicone rubber coated steel tubes heat the laminating film and compress the heated film to the items being laminated. Heat is provided by an internal heating element. The heat rollers are motor driven for ease of loading new film.

**F. PULL ROLLERS:** The pull rollers, located at the back of the laminator, are motor driven. They simultaneously pull the film and improve the quality of the laminated item.

**G. ROLLER HANDLE:** The roller handle manually sets the position of the pull rollers while simultaneously electronically setting the main rollers.

Available settings are;

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

**K. IDLER BAR:** The idler bars, located near each heat roller, are used to direct the film to the heat roller nip.

**H. CHILL IDLER:** Assist in the cooling process of the web material as it exits the heat rollers.

To engage the chill idler, grip the chill idler handles located on each side of the chill idler and lower to the web position. To disengage the chill idler, move the chill idler to its rest position.

**I. COOLING FANS:** Assist in the cooling process by pushing unheated air onto the web material as it exits the heated rollers. This feature can be controlled from the control panel.

**J. FILM SHAFT:** The film shaft holds the film supply on the machine.

To remove the film shaft, lift up on the round end of the unwind/rewind shaft then pull the hex end of the shaft out and away from the laminator.

**K. LOWER SHAFT LOCK:** Secures the left side of the lower shafts. To remove a shaft, turn the outer dial opening so it aligns with the inner u-channel opening and lift up and out.

**L. REWIND SHAFT:** The rewind shaft holds the rewind tube on the machine.

**M. REWIND TUBE:** 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.

**N. UNWIND/REWIND TENSION:**

Used to apply resistance to the film shaft.

To increase film shaft brake, turn the film shaft brake dial clockwise. Counter clockwise will decrease film shaft brake tension.

**O. CORE ADAPTORS:** Hold and lock the rolls of film on the shafts to prevent side to side shifting.

**P. REWIND ADAPTORS:** Hold and lock the rewind tube on the rewind shafts to prevent side to side shifting.

**Q. REAR TABLE:** Provides a working surface when operating the machine from the rear. This table may also be lowered when webbing for roll to roll applications.

To lower, slide the left and right side rear table latches to the unlatched position.

**R. REAR SLITTER:** 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 apposite side.

**S. FILM WEB:** Laminating film loaded into the machine.

**T. 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.

**U. FOOTSWITCH:** Used to assist in webbing of the machine and initial feeding of material.

**V. PRINT UNWIND BASKET:** Holds a rolled image. Prevents the image from touching the floor.

**W. OPTIONS**

**SEPARATOR BAR:** Required if running Accushield® material.

(Talon 44 Part # 2020580)

(Talon 64 Part # 2020579)

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

**REWIND KIT:** Enables roll to roll webbing of material. This kit must be installed by a qualified GBC service representative.

(Talon 44 Part # 1715822)

(Talon 64 Part # 1715823)

## 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 the roller handle, rotate the rollers at slowest speed with heat on. Refer to the section entitled **CARING FOR THE TALON 44/ 64 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. 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. Lift up on the round end (left side) of the unwind/ rewind shaft.
2. Pull the hex end (right side) of the shaft out and away from the laminator.
3. Slide the roll of film onto the film shaft ensuring adhesive side is out.
4. Replace the shaft with the hex end in first then the round end.
5. Center the roll of film.

### WEBBING THERMAL FILM USING THREADING CARD

The following procedure uses the film threading card provided with new rolls of GBC film. The laminator should be cool to the touch before proceeding. For pressure sensitive film (PSA), refer to the section entitled **WEBBING USING FILM THREADING CARD FOR PSA FILM**.

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 shafts.
3. Remove the safety shield and pivot the feed table down.
3. Pull the top roll of film down under the idler bar and allow to drape over the top heat roller.
4. Pull the lower film behind the lower idler bar and up towards the film draped over the top heat roller.
5. Use a threading card to push the two materials through the heat roller nip.
6. Pivot the table back to its feeding position while ensuring the threading card is on top of the feed table.
7. If using the chill idler, lower it to the web position at this time.
8. Replace the safety shield.
9. Set speed to 3 or less.
10. Set the roller handle to the **"Low-Prs Laminating"** position.
11. Press the **RUN** (▶) button.
12. From the rear of the machine, guide the web over the chill idler, if engaged, and through the pull rollers.
13. Once the threading card has completely cleared the pull rollers, press the **STOP** (⏏) button.
14. Use the rear slit to cut the threading card from the web.
15. Set the roller handle to the **"RELEASE"** position.
16. Now refer to the section entitled **START LAMINATING**.

# **WEBBING PSA FILM USING THREADING CARD.**

The laminator should be cool to the touch before proceeding.

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 shafts.
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. Pull the laminate down allowing it to drape over the upper heat roller.
8. Pull the lower film behind the lower idler bar and up towards the lower rewind tube.
9. Make two full wraps around the rewind tube, then carefully score the laminate without cutting the release liner. Pull the laminate up towards the film draped over the upper heat roller.
10. Use a threading card to push the two materials through the heat roller nip.
11. If using the chill idler, lower it to the web position at this time.
12. Pivot the table back to it's feeding position while ensuring the threading card is on top of the feed table.
13. Replace the safety shield.
14. Set speed to 3 or less.
15. Set the roller handle to the **"Low-Prs Laminating"** position.
16. Press the **RUN (◀▶)** button.
17. From the rear of the machine, guide the web over the chill idler, if engaged, and through the pull rollers.

18. Adjust the rewind brake so that the laminate separates from the release liner just above the heat roller for the upper material and just below the heat roller for the lower material.
19. Once the threading card has completely cleared the pull rollers, press the **STOP** (⏏) button.
20. Use the rear slit to cut the threading card from the web.
21. Set the roller handle to the **"RELEASE"** position.
22. Now refer to the section entitled **START LAMINATING**.

#### **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. Set the roller handle to one of the laminating positions.
5. Press the **PRESS/ RELEASE** (⏏) button. The main rollers gap.
6. Press the **RUN** (▶) button.
7. Press the **PRESS/ RELEASE** (⏏) 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.
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.



**CAUTION: Avoid forcing the image into the heat roller nip.**



#### METHOD FOR TACKING NEW FILM TO EXISTING FILM

The following describes a method for loading film whereby the existing film present on the heat rollers may be used in place of the threading card to draw the new film through the laminator. The adhesive of the existing film must be tacky or liquefied. Leading edges of the new film will be overlapped onto the tacky adhesive of the old film. The existing film and the new film will be pulled through the laminator together.

1. Cut remaining top and bottom film webs between the idler bar and heat rollers.



**CATION: DO NOT CUT THE HEAT ROLLERS WHEN CUTTING THE FILM WEB.**

2. Remove the safety shield and tilt the feed table down.
3. Do not allow the adhesive side of the film to contact the heat or pull rollers. Liquefied or tacky adhesive deposited on heat rollers will require the rollers to be cleaned per the section entitled **CARING FOR THE TALON 44/64 LAMINATOR**.
4. Replace both the top and bottom rolls of film with new rolls. Ensure the adhesive side is facing out.
5. Pull the film around the idler bars, with the exception of PSA mounting adhesives without a release liner.
6. Tack the new film to the existing film on the heat rollers. For PSA film, pull the release liner up and attach to the rewind tube.
7. Use the footswitch to advance the film into the heat roller nip.
8. Observe the film being pulled through the laminator to assure that the remaining existing film and the new film are advancing concurrently. Any separation between the films will require stopping the motor immediately and the situation corrected.
9. Press **STOP** (⏏) once the newly threaded film has completely exited the pull rollers.

**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 slitter, cut the output from the web.
2. Set the roller handle to the **"Release"** position.
3. Remove the safety shield and tilt the feed table.
4. Cut remaining top and bottom film webs between supply rolls and heat rollers. **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.
6. Do not allow the adhesive side of the film to contact the heat or pull rollers.

**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** (⏏).
2. Remove the safety shield and tilt the feed table.
3. Press and hold **REVERSE** (⏮) until the jam has cleared the heat rollers or pull rollers.
4. Set the roller handle to the **"Release"** position.
5. Manually assist the material through the main rollers and/or pull rollers.
6. Once the jam has been cleared, set the roller handle to one of the laminating positions.
7. You can now resume laminating.

## APPLICATIONS

**TIPS FOR PRE-COATING BOARDS**

1. Load the laminator with proper materials.
2. Ensure the chill idler is in the rest position.
3. Set the roller pressure handle 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. Using the pull rollers will allow you to leave gaps between boards.
7. If not using the pull rollers, have the boards nearby to butt end to end during feeding.

**TIPS FOR USING THE REAR ROLLERS**

1. If the front rollers are heated, you may perform certain applications from the rear operating position of the laminator.
2. Ensure the chill idler is in the rest position if using boards.
3. Ensure the safety shield is located in the rear position.
4. Ensure the **REAR CONTROLS** have been enabled.
5. You may perform mounting applications, pre-coating applications and single side applications from the rear of the machine.

**TIPS FOR MOUNTING PRE-COATED BOARDS**

1. Load the laminator with proper materials.
2. Ensure the chill idler is in the rest position.
3. Ensure the chill idler is removed, the rear slitter is to one side and the inline slitters are not obstructing the path of the boards.
4. Heat, 125 °F (52 °C), may assist the process and increase output quality.
5. Do not stop once you have started the mounting process through the machine.

#### **TIPS FOR SINGLE SIDED LAMINATION**

1. Load the laminator with proper materials.
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.

#### **TIPS FOR CREATING A DECAL**

1. Load the laminator with proper materials.
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**

1. Load the laminator with proper materials.
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**

1. Load the laminator with proper materials.
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.
6. Use of the chill idler may or may not help in the output quality. Try both methods.

**TIPS FOR THERMAL****ENCAPSULATION**

1. Load the laminator with proper materials.
2. Always use two rolls of film the same width.
3. Use minimal brake tension to achieve flat output.
4. Increase speed gradually to maintain the activating temperature required for the laminate you are using.
5. Length and width of image, ink coverage and paper type may effect the temperature and speed recommended in the **SPEED/TEMPERATURE GUIDE**.

**TIPS FOR ACCUSHIELD**

1. Load the laminator with proper materials.
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 rol 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 10 A & B)**

Factors that may effect the speed and temepature parameters;

1. Image length
2. Image width
3. Ink coverage
4. Paper type
5. Laminate thickness
6. Operating enviroment
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	
20#	mil	Temp (F)	Speed	Temp (F)	Speed	Temp (F)	Speed	Temp (F)	Speed	Temp (F)	Speed
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#	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. 10 A**

## 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.

The pull roller clutch is set at the factory. Periodic adjustments may be necessary if after adjusting unwind and rewind brake tensions do not improve your output quality.

## 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.

- Check paper tension.
- Paper may be damp or not dry.

### 2. “D” waves in the laminate.

- Main air supply setting.
- Check heat roller nip calibration.
- Check pull roller nip calibration.

### 3. Straight waves in output.

- Check operational settings for materials being used.

### 4. Indent waves in output after pull rollers.

- Insufficient cooling time.
- Output was handled prior to cooling.
- Use cooling feature if not on.
- Machine was stopped on print.

### 5. Angled waves in the output.

- Main air supply setting
- Check heat roller nip calibration
- Check pull roller nip calibration
- Check for even paper tension (Figure 45 A only)



## MAINTENANCE

### CARING FOR THE GBCTALON 44/64 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 heat rollers and schedule semi annual maintenance checks.

The following procedure will help keep the heat 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 heated rollers.**

- 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 heat/ pull roller to an unclean portion. The upper heat/ pull rollers are 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.

## TROUBLE-SHOOTING GUIDE

SYMPTOM	POSSIBLE CAUSE	CORRECTIVE ACTION
• The control panel display does not illuminate when <b>POWER ON/OFF</b> is in the <b>ON</b> , marked "I", position.	Laminator not connected to electrical supply.	Insert attachment plug into receptacle.
• Heat rollers do not turn when I press the <b>RUN</b> (↻) button.	Safety shield is not properly installed. Feed table not properly installed. E-STOP is engaged	Remove safety shield and properly replace it. Tilt feed table and properly replace it. Pull out on the E-STOP push button.
• Heat rollers only turn if I use the footswitch.	Laminator is in FootSwitch mode.	disengage the footswitch mode.
• Rear controls do not operate.	Rear controls are not enabled. Safety shield is not installed in the rear position.	Enable rear controls. Remove the rear splitter and installed the safety shield.
• 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. Chill idler not used.	Adjust tension per section <b>FILM TENSION</b> . Adjust tension per section <b>FILM TENSION</b> . Slightly speed up the laminator. Make sure bottom roll of film is around idler bar and the it is in the normal operating position. Move the chill idler to the web position.
• Adhesive deposited on heat rollers.	Top and bottom film webs not aligned. Laminate improperly loaded.	Release heat and pull roller pressure, align the rolls of film. Adhesive (matte) side of laminate film may be against the heat rollers. 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 <b>SLOW</b> button to slower speed Wait for " <b>READY</b> " 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 <b>CARING FOR THE GBC TALON 44/64 LAMINATOR</b> . Item may be dirty or may have non-porous surface that is extremely difficult to laminate.
• Waves in my output	See sub section <b>OUTPUT</b> . Nips may be out of calibration.	Under section titled <b>THE ART OF LAMINATION</b> . 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.

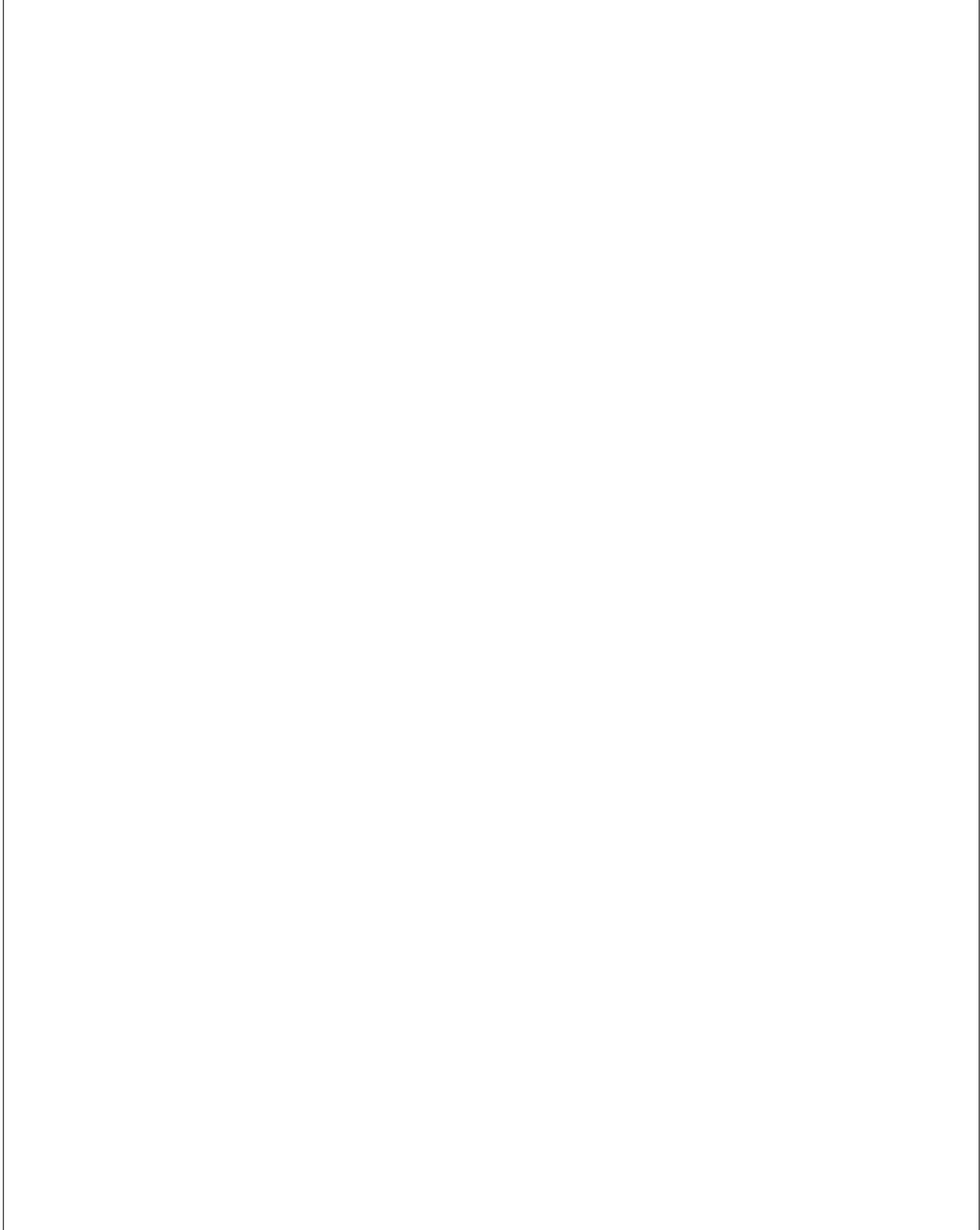
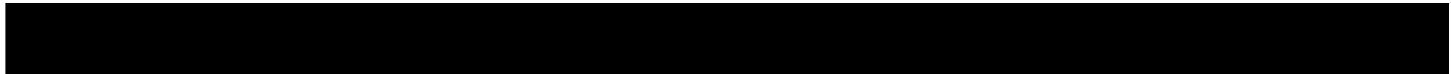
A service charge for travel time, labor and parts may be incurred for each out of warranty service call. GBC's Equipment Maintenance Agreement decreases these expenses and protects your valuable investment. GBC offers several types of agreements to suit your needs and budget. To contact GBC write to:

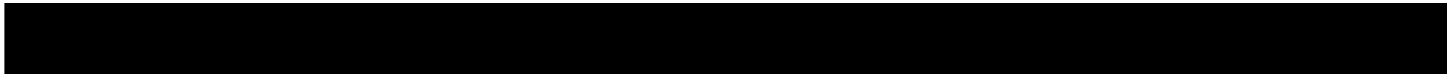
GBC NATIONAL SERVICE  
ONE GBC PLAZA  
NORTHBROOK, IL 60062 U.S.A.  
1.847.272.3700

IN CANADA:

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

Part Number 930-097 Revision -





## RECOMMENDED SPARES

GBC Recommends these spare items to reduce your down time in the event of a problem with your laminator. By having these recommended items on hand, your machine can be up and running usually on the same day if it goes down which enables you to produce quality lamination that much sooner. You may choose to order all the recommended items or condense the list to fit your comfort and needs.

<u>Part number</u>	<u>Item</u>	<u>Qty</u>
704090141	Power switch	1
601211113	Core stopper pin	2
705200201	Infrared sensor assembly	2
609070104	Cross fan motor	1
705090302	Solid state relay	2
706011731	PCB, 220 Relay module	1
706011730	PCB, Main	1
610011706	Transformer	1
607040150	Heat roller, Talon 44	2
607040528	Heat roller, Talon 64	2
607040523	Pull Roller, Talon 44	2
607040518	Pull Roller, Talon 64	2
6090202	DC Geared motor	2
704090419	Micro switch	2
601220615	Heater, Talon 44	2
601220546	Heater, Talon 64	2
810600026	Heater support wire	2
703090103	Power switch, rocker	1
705031114	Display	1
706011733	PCB, Control panel	1
613050221	Rear slitter blade	2

## ILLUSTRATED PARTS









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

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