



DryLam School & Office Laminator

Model SL27 (27"120V)

Instruction Manual

Also includes: School Smart model 679185 (manufactured: January 2011, and later)
(For School Smart models manuf. prior to January 2011 use DryLam model 27STA
Instructions)



Revised 1/20/14, 3/12/14, 4/10/15, 6/8/16, 9/7/18 Brian Jennett

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Models SL27 and 679185 Specifications	
Height	15"
Width	34"
Depth (with feed tray)	20"
Net Weight	66lbs.
Shipping weight	88 lbs.
Capacity	27"
Electrical	120V AC 60Hz 1400w
Lamination Speed	6 feet per minute

Important Safeguards

- Read all the safety and operating instructions before connecting or using this unit.
- Retain this notice and the owner’s manual for future reference.
- Adhere to all warnings and operating instructions.
- Do not use this unit near water (e.g. near a bathtub, etc.)
- The wearing of ties or jewelry while operating a laminator may be hazardous to the operator.
- Warning: Do not touch hot surfaces such as heat shoes and heat rollers.
- This unit should be installed so that its location or position does not interfere with its proper ventilation.
For example, it should not be situated on a bed, sofa, rug or similar surface that may block the ventilation openings; or placed in a built-in installation, such as bookcase or cabinet or against the wall, that may impede the flow of air through its ventilation openings.
- This unit should be situated away from heat and air ventilation systems such as radiators, heat registers, stoves, etc.
- This unit should only be connected to a power supply outlet of the voltage, amperage and frequency marked on its serial tag.
- For 120 volt machines the socket outlet shall be installed near the equipment and be easily

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accessible.

- The power supply cord should be routed so that it is not likely to be walked upon or pinched, especially near the plug, convenience receptacles, or where the cord exits from the unit.

- Unplug the machine during any machine repairs.
- Clean unit only as recommended in this instruction manual.
- Make sure to remove the Feed Table before reversing the machine!
- Care should be taken so that objects do not fall, and liquids are not spilled, into the enclosure through any openings.
- Caution: The Cutter blade is extremely sharp. Please handle carefully and dispose of properly.

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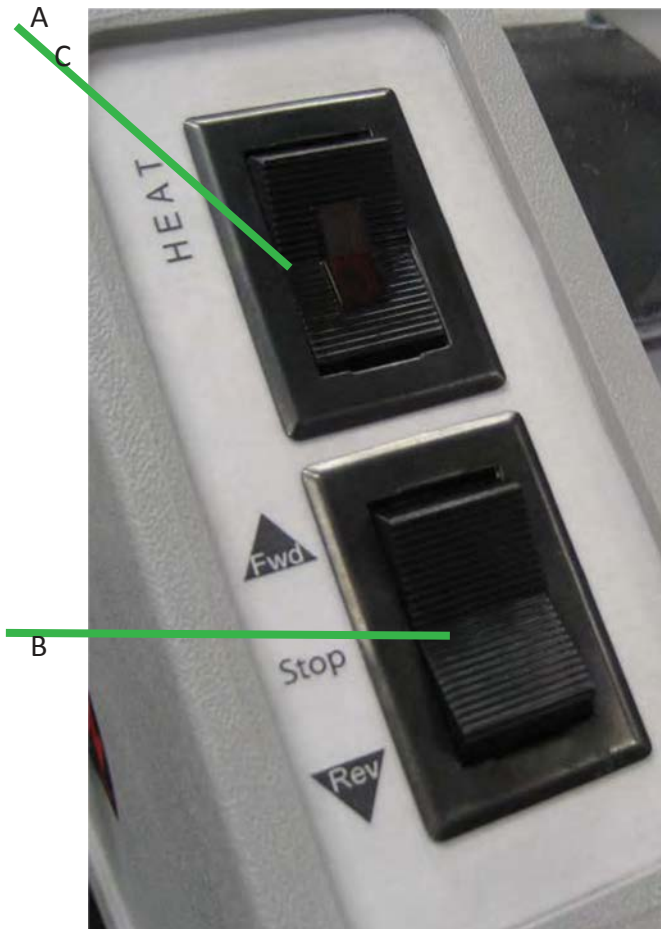
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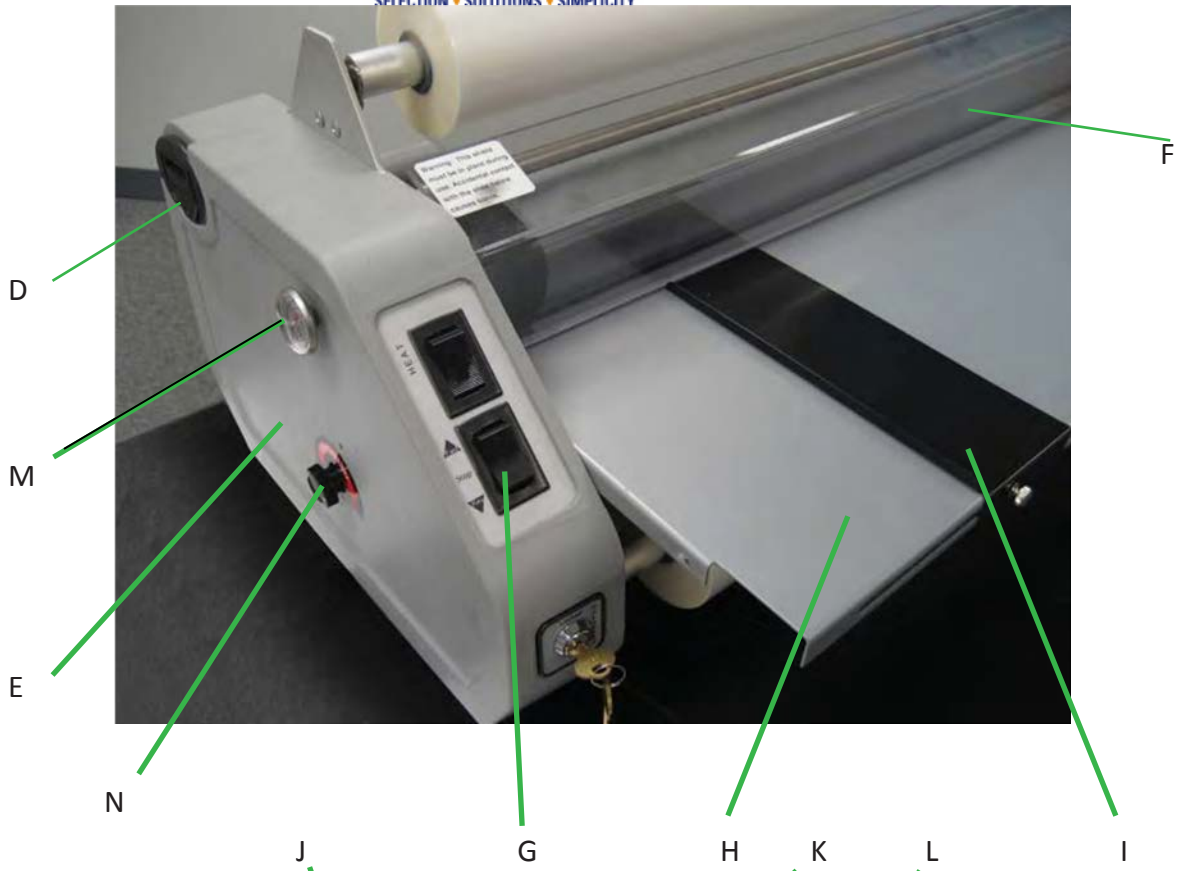
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General Diagrams

The Model SL27 offers a reverse feature and is designed to laminate a variety of materials using up to 27" laminating film. Tension Adjusting Knobs (L) are conveniently located to the right sides of the supply shafts (K) for easy access. A Control Panel (G) is located on the Left Housing (E), with a Motor Stop/Reverse switch (B), and a Heat On/Off Switch (A).



The Feed Tray (H) and Feed Guide (I) provide a smooth, durable paper path and the Heat Guard (F) protects hands from hot surfaces inside. Teflon coated Heat Shoes (J) minimize friction. The Cutter (D) cuts and trims your laminated documents and the Key Switch (C) prevents unauthorized usage.



I.

Unpacking

Remove the laminator from its box by grasping the housings and pulling up. Do not use rollers or shafts as handles - this could cause damage. Choose a location for the laminator that is clean, well-lit and draft free. Make sure it is not in the path of any fans, room air conditioners, or positioned too close to the wall. The laminator comes to you ready to load the film onto the supply shafts, thread the film through the machine, perform basic setup and install the feed table for laminating.

II.

Information about Laminating Film

Laminating film is made up of two layers: a glossy polyester layer which gives the lamination its strength, clarity and rigidity, and a dull or matte side which is heat activated and serves as the “glue” to bond the film to the product being laminated. Once heated, small amounts of the “glue” side can stick to the heat shoes and rollers and must be periodically cleaned from the laminator.

Laminating film is available in a variety of different lengths, and thicknesses. Models SL27 and 679185 School Smart Laminators are designed to use 1.5 mil (#150), and 3 mil (#300), film thicknesses.

III.

Operating

A.

Control Panel

The control panel is located on the left side of the laminator. This panel is used to control the various machine functions listed below.

Heat (A, M, N)

The temperature can be turned either “on” or “off” using the heat switch (A) which is located on the control panel. The heat can be controlled manually using the heat control knob (N) located on the left housing (E). A thermostat (M) is also located on the left housing (E) and provides the current temperature of the laminator. Note: depending on room conditions and desired set point, it will take between 20 and 30 minutes for the laminator to heat up to desired temperature.

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Motor B

The motor will not run unless the key switch is turned “ON” (in the horizontal position). To stop the motor, press the “Stop/Reverse” switch in the “Stop” (center) position. To start the motor, press the “Stop/Reverse” switch in the “Fwd” (up) position. To reverse the motor, press the “Stop/Reverse” switch in the “Rev” (down) position. The motor will remain in reverse only as long as the button is depressed.

Key switch

The key switch (located just below the control panel) locks out the motor, allowing the machine to remain heated; yet, preventing unauthorized usage when in the locked position.

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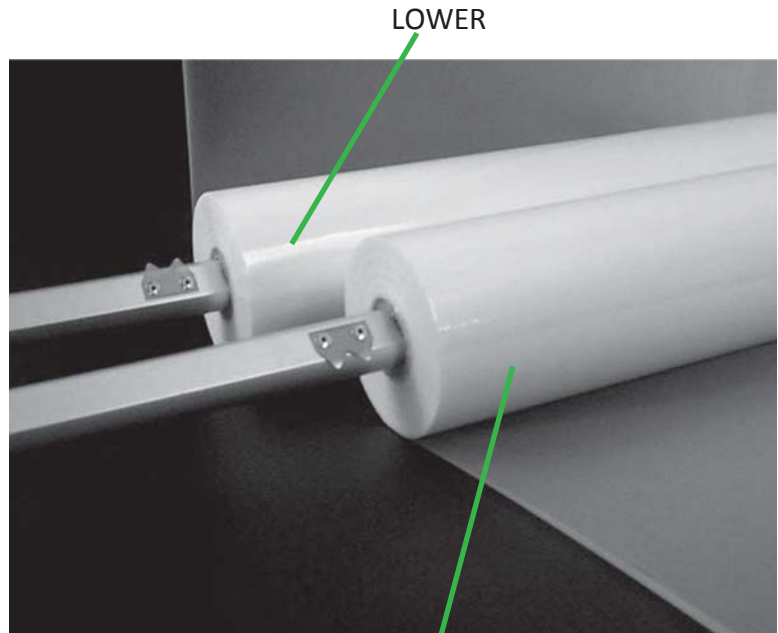
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Loading Film on 1" Supply Shafts

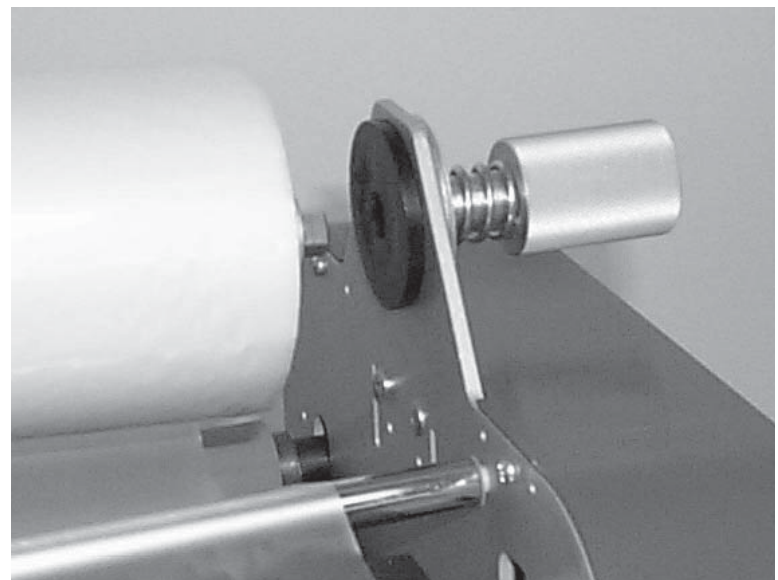
Unpack the upper and lower supply shafts. The upper and lower supply shafts are different. The word "TOP" is stamped on the shaft of the upper supply shaft and the word "LOW" is stamped on the shaft of the lower supply shaft. The ends of each supply shaft are also different. The round "hanger" end fits in the bracket on the left side of the laminator. The "slot end" fits into the tension adjuster on the right side.

Slide the film roll onto the supply shaft by rotating the supply shaft in the **opposite direction** of the gripper points, leaving equal lengths of supply shaft sticking out of each end. The film roll will slide over the gripper, which will keep the roll from turning on the shaft.

Load the supply shaft on the laminator by inserting the slot end of the supply shaft into the tension adjuster on the right side and then lowering the hanger end into the bracket on the left side.



UPPER



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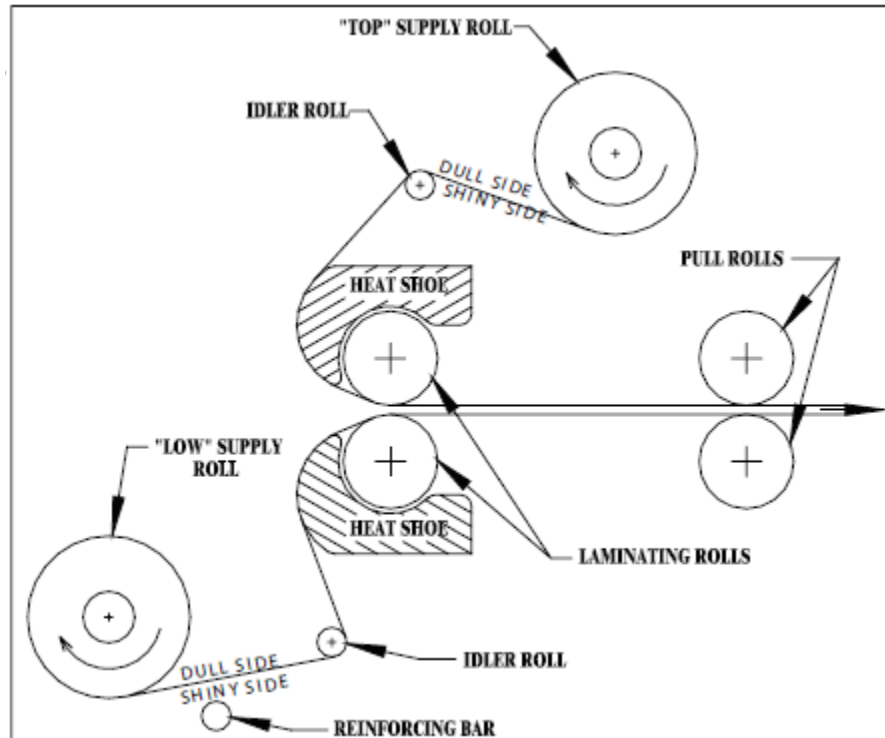
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Threading the Laminator

Remove the feed tray and the heat guard. Thread the film as shown in the figure on the right. Pull the film around the idler rollers as shown. On some models do not mistake the reinforcing bar for the idler roller. Make sure the glossy and dull sides of the film are as indicated in the diagram. The dull side must not touch the heat shoes! Position the threading board provided.



Turn power and key switch to on.



Start the motor by pressing the “Fwd” button. Feed the threading board and film in between the heat shoes. This will pull the film through the rollers until it comes out the back of the laminator.



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Slide the top and bottom film rolls from side to side on the supply shafts so that the film is perfectly aligned top and bottom (Note: lack of proper overlap will cause the film to deposit residue on the heat shoes and rollers, so this procedure is critical). Replace feed tray and heat guard.



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Laminating

After the machine is threaded (see “Loading Film on 1” Supply Shafts”) and threaded (see “Threading the Laminator”), it is ready to laminate. Ensure that the laminator has reached the preset temperature as indicated on the thermometer. The temperature should never be allowed to go over 275F and, in the cases of some film, should be lower. Always consult the film manufacturer for the correct melt temperature. Place document on the feed table and align with the feed guide to assure straight and even lamination. Start the motor with the “Fwd” button and if necessary, adjust the supply roll tension (see E. Supply Roll Tension Adjustment). With both hands, guide the document into the throat of the laminator. While the document is pulled into the laminating rollers, keep document flat on the feed table while applying a slight back pressure. Also, be certain the film/paper is exiting the laminator, other a “wrap-around” may occur. As the document exits the rear rollers, allow 3” to 6” of film to clear the rollers at the end of your document and turn the motor switch to stop. Using the hand held cutter, hold tension on the laminated document and slice through the film to release the document. Multiple documents can be run successfully if desired and cut at a later time.

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Supply Roll Tension Adjustment (L)

Top and bottom supply rolls should always have about the same tension. By turning the top roll with one hand, and the bottom roll with the other hand, it can be determined if one of the rolls is tighter than the other.

Note: Too much tension can destroy film, documents, make noise and damage the machine.

Adjust the tension to the minimum amount required. Do this by loosening the tension knobs until there is no tension on the film. With the machine threaded and at operating temperature, turn the motor switch to forward. Tighten the adjusting knobs only until the wrinkles in the film are removed.



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Note: As the diameter of the film roll decreases, tension should be reduced.

To increase tension, turn the adjusting knob clockwise. To decrease tension, turn the knob counterclockwise. If the tension is not equal top and bottom, the laminated product will curl or may “bunch up” in the roller area. If the material curls up as it comes out of the machine, the top roll is probably tighter than the bottom. If it curls down, the bottom roll is probably tighter.

Note: Make sure the black tension disks are flat against the side panel. They should be rotating, both top and bottom, while film is feeding.

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Maintaining the Model SL27 / 679185 Laminator

Care and Cleaning

In the normal course of operating DryLam Model SL27 and School Smart Model 679185, dirt and adhesive will accumulate on the heat shoes and rubber rollers (the process of lamination produces static electricity which attracts airborne dust and dirt). Regular inspection and cleaning will assure that this does not become a problem.

Never use hard, sharp, or abrasive items to clean the heat shoes. The shoes are coated with a non-stick surface that could easily be damaged. Likewise, do not use sharp metallic objects or steel wool to clean the rubber rollers. Any scratches, indentations, or marks left on the rollers will appear on the laminated product.

To clean the shoes and rollers, use a clean, lint-free cloth. Some suggested solvents are Poly-Off®, rubbing alcohol (isopropyl), fingernail polish remover (with acetone) and Goof-Off®.

After cleaning the shoes, as described above, it is **HIGHLY** recommended to use the DryLam Maintenance Kit (DryLam part number

01300). The Maintenance Kit includes Dry Film Lubricant and a microfiber cloth. After the face of the shoes have been cleaned spray a liberal amount of the Dry Film Lubricant into the microfiber cloth and wipe on the face of the heat shoes. There will be a glossy shine afterwards. Do not remove the residue of the lubricant. This lubricant allows the film to slide over the shoes easily, reduces noise and will reduce linear scratches in the film.



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Specific Troubleshooting Guide

	Increase Heat	Decrease Heat	Worn, Dirty, Or Damaged Rollers	Increase Tension On Supply Rolls	Dirty Heat Shoes	Moist Or Coated Product	Decrease Tension On Supply Rolls	Check Threading Diagram
Wrinkles on Film (side to side)		●	●	●				
Wrinkles on Film (lengthwise)		●			●		●	
Plastic not bonding	●							
Bubbles or Blisters		●	●			●		
Impressions on product			●					
Squeaking sounds						●		●
Film narrowing on shoes						●		●
Film wrinkling on shoes	●			●				
Continuous blemish			●		●	●		
Cloudy film	●							
"Orange Peel" Finish		●						
Film sticks to rollers			●					●
Film sticks to shoes					●			●
Film won't stay aligned								●
No seal on edges	●			●				
Poor seal - one side only						●		

Removing a "Wrap-Around"

A "wrap-around" occurs if the film exiting the rear rollers curls around one of them causing the laminate to wind around the roller.

If the wrap-around is not severe, simply use the reverse feature and back the film out. Make sure to remove the Feed Table before reversing the machine! It is advisable to have one person operate the motor switch while the other person pulls the film back out the front.

Removing a “Wrap-Around” (cont’d)

For extreme wrap-arounds (i.e. when film and/or product have wrapped around the rubber rollers several times) it may be helpful to follow this procedure:

Shut the machine off! DryLam Model SL27 and School Smart model 679185 have set screws at both ends of each laminating and pull roller. With the use of a 3/32” hex key (allen wrench), loosen all four set screws on the pull rollers. Cut the film between the laminating and pull rollers, grab the loose end and pull. The rollers may rotate freely on the roll shafts and the “wrap-around” may easily unwrap. Tighten all the set screws and rethread the film.



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Replacing the hand held Cutter Blades

The hand held cutter blade can be replaced by removing the small screw on the back of the cutter, then removing the cutter back. Caution: The cutter blade is extremely sharp. Please handle carefully and dispose of properly. Remove and discard the old blade. Re-install cutter back and screw. Caution: Do not over tighten screw.



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Important Information

PLEASE DO NOT DESTROY THE SHIPPING CARTON!

DryLam urges you to store the original carton in which your laminator was shipped. Should you ever need to return your laminator to our repair and service center it is best repacked in the original carton to reduce the chance of damage during transport. Our special foam filled carton ensures the laminator's safe transit to our service facility. Failure to use the original box and packing material will likely result in shipping damage. If you have any shipping or service inquiries, please contact DryLam's Tech-Line and Service Department, at 888-633-1973 Ext 8575.

Warranty: A One Year Warranty will be issued from date of product shipment. Please supply the model and serial numbers (located on the rear panel of the machine) on all correspondence concerning your laminator.

Equipment Warranty

We warrant to the original purchaser the equipment manufactured to be free from defects in material and workmanship under normal use and service. Our obligation under this warranty shall be limited to the repair or exchange of any part or parts which may prove defective under normal use and service within one year from the date of shipment and which our examination shall disclose to our satisfaction to be a manufacturing defect. Warranty does not include damage due to operator error or general maintenance. Warranty does not cover shipping, or shipping related damage. Note: You will be charged for the replacement of any parts which are damaged as a result of improper packaging. When a laminator is returned to DryLam's Service Center for repair it is recommended that all loose items be retained on site. Loose items are classified as (but not limited to) supply shafts, film rolls, heat guard, thermometer, feed table, etc. Loose items add to shipping weight and may cause damage to the machine in shipping. When necessary, purchaser shall properly pack and return the unit to DryLam's Service Center freight and insurance prepaid.

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