

Nip Roll Section

The most critical adjustment of the nip and pull rolls is the “zero” position. This adjustment makes the top roll parallel to the bottom roll which creates even pressure and pull distribution across the face of the roll. If the rolls are out of adjustment, the machine will not laminate properly. Zeroing the nip is done at the factory before shipment, but should be checked at startup and if laminator is not creating quality output.

Checking the Nip

1. Place two pieces of thin paper (approximately 1.0” wide by 12.0” long) between the upper pressure roll and the lower roll (about 6.0” from each end).
2. Set the shim dial to the “0” setting. Set the nip pressure regulator to 35 psi. Close the nip rolls.
3. Pull gently on both pieces of paper, if both pieces of paper have the same drag, the nip is fine, if the drag is different, follow the procedure below to correct the setting. The pull rolls are adjusted the same as the nip rolls.

Zeroing the Nip

1. Loosen the set screw in the cylinder stop and turn the cylinder stop counter clockwise.
2. Set the shim wheel at “0”, or if you are adjusting to a specific material, set the shim wheel at the closest shim setting.
3. Set the nip pressure regulator to 35psi.
4. Close the nip onto the paper strips
5. Gently pull on both pieces of paper to determine if they have the same drag. If one is extremely hard to pull on the cylinder stop on that side needs to be adjusted clockwise to lift the roll. If it is too easy to pull out, the cylinder stop needs to be turned counter clockwise to lower the roll.
6. The nip roll must be opened to adjust the cylinder stops. Use small incremental turns on the stops, ie. ¼ turns or less. Close the nip roll after the adjustment and pull the strips again.
7. Once the strips have the same drag on them, open the nip roll and tighten the setscrews in each cylinder stop being careful not to turn the cylinder stop.