



## OPERATING MANUAL Gfp 563TH



**Please read this manual carefully before operating!**

Unpacking, assembly, and operating videos are available at  
[www.gfpsmoothstart.com](http://www.gfpsmoothstart.com)

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## 1. Introduction

Thank you for choosing the Gfp 563TH laminator. It has been designed and manufactured to provide years of continuous service. Please read this manual thoroughly before operating. Please inspect the box and the laminator for shipping damage. Damage should be brought to the attention of the delivering carrier immediately

We reserve the right to make changes to this publication and to the products described in it without notice. The details given in this manual are based on the most recent information available to us. They may be subject to change in the future. We retain the right to make changes to the construction or the design of our products without accepting any responsibility for modifying earlier versions

**WARNING!** Any unauthorized changes or modifications to this unit without our prior written approval will void the user's warranty and will transfer health and safety obligations to the end user.



**CAUTION!** Please pay attention to all passages with these symbols. This information is vital to preventing user injury and/or damage to the unit. Failure to follow this information could void the user's warranties and transfer all safety obligations to the user.

## 2. Important Safety Instructions



In this operating manual you will find important safety messages regarding the product.

Read these instructions carefully, failure to comply with the following safety procedures could result in serious injury.


**WARNING** Do not attempt to service or repair the laminator. Only authorized maintenance and service technicians should make repairs.




**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.

**WARNING** To guard against injury, the following safety precautions must be observed in the installation and use of the laminator

## 3. Installation Safeguards



- Shipping damage should be brought to the immediate attention of the delivering carrier
- Avoid locating the laminator near sources of heat or cold. Avoid locating the laminator in the direct path of forced, heated or cooled air
- The receptacle must be located near the equipment and easily accessible.
-  Connect the attachment plug provided with the laminator to a suitably grounded outlet only. This machine must have reliable earth wire to ensure the safety of the machine during operations

- Contact an electrician should the attachment plug provided with the laminator not match the receptacles at your location
-  Ensure that the voltages of the power supply you are using match the rated working voltages before operations. Do not use incorrect power supply
-  Do not use damaged wires or sockets. If abnormal conditions occur, switch off the power supply first.
-  Only a licensed electrician should install wiring and outlet for the laminator
- Do not defeat or remove electrical and mechanical safety equipment such as interlocks, shields and guards



NOTE: This equipment has been tested and found to comply with the limits for a Class B digital device, pursuant to part 15 of the FCC Rules. These limits are designed to provide reasonable protection against harmful interference in a residential installation. This equipment generates, uses and can radiate radio frequency energy and, if not installed and used in accordance with the instructions, may cause harmful interference to radio communications. However, there is no guarantee that interference will not occur in a particular installation. If this equipment does cause harmful interference to radio or television reception, which can be determined by turning the equipment off and on, the user is encouraged to try to correct the interference by one or more of the following measures:

- Reorient or relocate the receiving antenna.
- Increase the separation between the equipment and receiver.
- Connect the equipment into an outlet on a circuit different from that to which the receiver is connected.
- Consult the dealer or an experienced radio/TV technician for help.

Changes or modifications not expressly approved by the party responsible for compliance could void the user's authority to operate the equipment.

## 4. General Safeguards



- Keep hands, long hair, loose clothing, and articles such as neckties away from rollers to avoid entanglement and entrapment. The rollers have pinch points that can trap body parts or clothing and cause serious injury
- Do not use the machines for purposes other than lamination and mounting, otherwise damages to the machine or accidents may occur
- Keep out of reach of children
- Keep flammable and wet objects away from the machine.
- Do not use flammable sprays or materials when cleaning the machine
- Do not leave the machine unattended during operations.
- Do not mount metal materials or other hard objects.
- Do not put burrs, sharp blade or rigid materials in between the two rubber rollers.
- Do not attempt to laminate items that exceed total recommended material thickness of the unit.
- Do not touch the rollers when they are hot or place foreign object inside the machine.
- Do not cut adhesive films directly on the surface of the rollers to avoid damaging the rubber coating.
- Shut down the machine after laminating to avoid misusing this machine by others.
- Shut down the power before moving the machine
- Note the locations of foot wheels while moving or operating this machine to avoid injuries to your feet.



- Disconnect from the power supply before repair or maintenance.



- Disconnect from the power supply when the machine is not in use for a long time.
- When the machine lies idle for a long period of time, raise the top rubber roller to avoid the distortion of the rubber surface.
- Do not cover the surface of the machine until the machine has completely cooled.
- Perform only the routine maintenance procedures referred to in these instructions

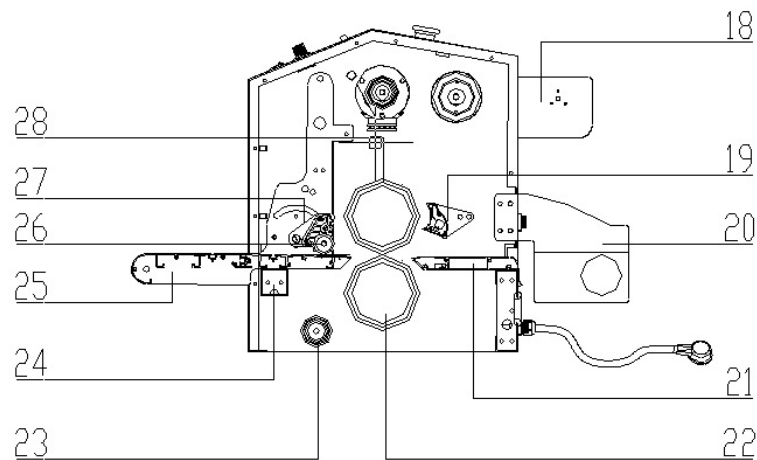
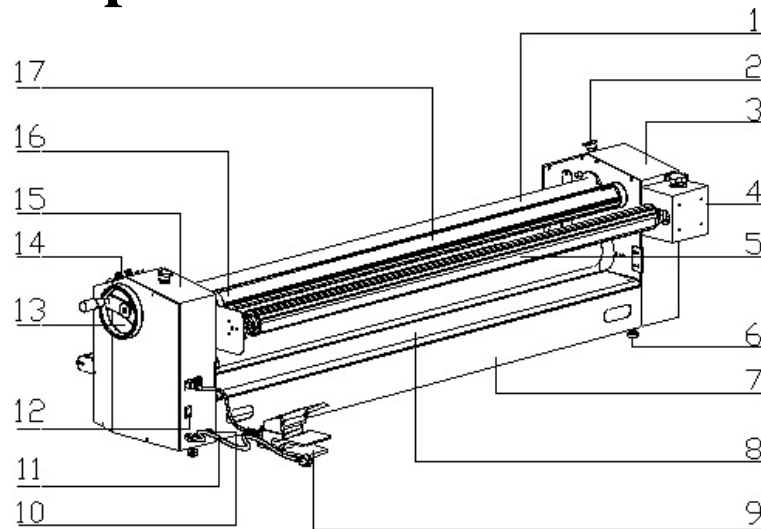
## 5. Operating Conditions

- Place machine on level surface
- Environment requirements :
- Ambient temperature: 50° F - 104° F
- Humidity : 30%—80% ; ideal humidity : 55%
- Due to the static on film rolls, you should try to keep the environment clean.
- Provide enough space around machine to ensure the safe and effective operation. The minimum area covered is 8 ft. x 10 ft.
- Do not directly cut the films on the surfaces of the rubber rollers to avoid damages to the rollers.
- Do not put burrs, sharp knives or extra thick and hard materials in between the rollers. Do not leave objects like tools, rulers, knives, etc. on the working panels or the side cabinets to avoid their being rolled into the machine accidentally and damaging the rollers.
- For repairs and replacements, please contact your local distributor. Unauthorized repairs and dismantling will affect future maintenances of the machines.
- The machine can laminate continuously objects less than ½” thick.
- For objects over ½” but less than 1” thick, use the pedal switch.
- Operator should be present while machine is in operation



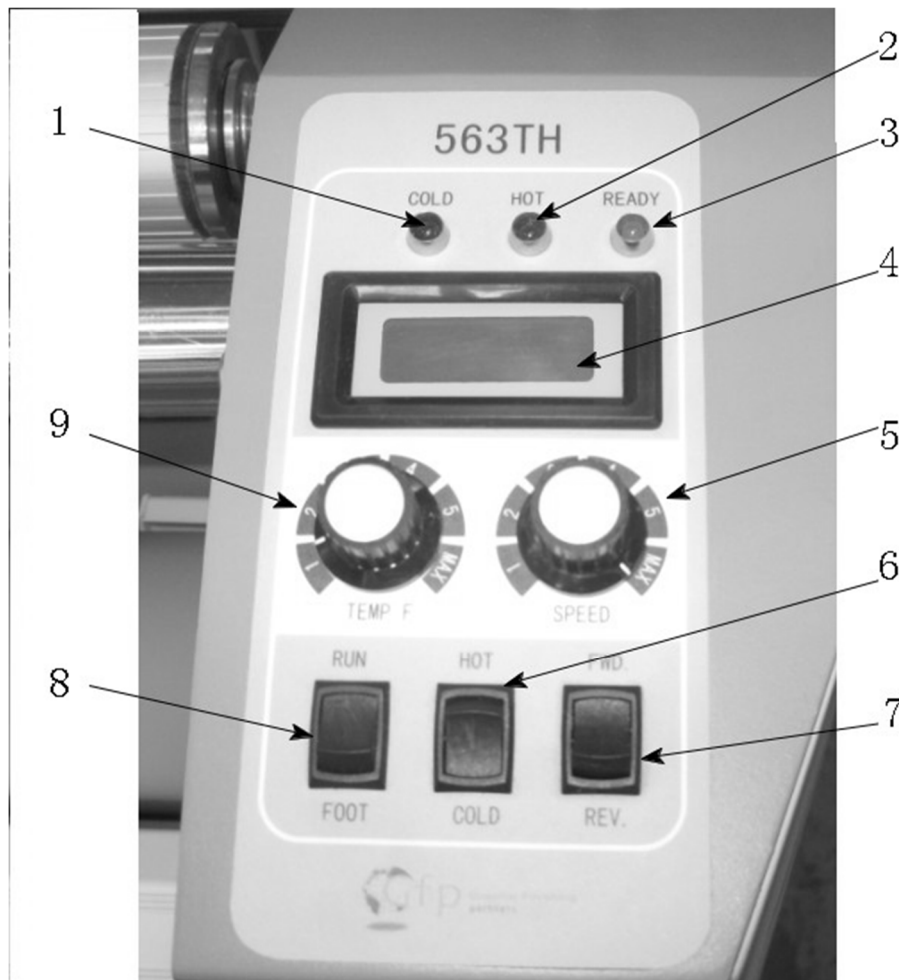
***Warning: Do not keep the machines in direct sunshine or near it.  
Do not keep the machine in dusty place or places with strong vibrations.***

## 6. System Components



- |                          |                                |                              |
|--------------------------|--------------------------------|------------------------------|
| 1. Linkage Axle          | 11. Power cord                 | 21. Exit table               |
| 2. Emergency Stop switch | 12. Main power switch          | 22. Bottom nip roller        |
| 3. Left cabinet          | 13. Roller gap hand-wheel      | 23. Support crossbar         |
| 4. Assembly cover        | 14. Control panel              | 24. Cross member             |
| 5. Top Supply mandrel    | 15. Right cabinet              | 25. In-feed table            |
| 6. Leveling foot         | 16. Rewind tube                | 26. Pressing roller          |
| 7. Rear supporting beam  | 17. Cardboard tube             | 27. Nip roller safety shield |
| 8. Exit table            | 18. Top supply mandrel bracket | 28. Top heat roller          |
| 9. Foot pedal            | 19. Temperature sensor         |                              |
| 10. Fuse                 | 20. Rear rewind assembly       |                              |

## 7. Control Panel



- |                               |                                     |
|-------------------------------|-------------------------------------|
| 1. Cold laminating indicator  | 6. Hot / Cold heater switch         |
| 2. Hot laminating indicator   | 7. Forward / Reverse switch         |
| 3. Ready light indicator      | 8. Continuous/ foot pedal operation |
| 4. Temperature display screen | 9. Temperature adjustment           |
| 5. Speed adjustment           |                                     |

### Note:

1. The machine does not have continuous reverse. Reverse can only operate using the pedal switch
2. If the photo-electric eye stops the machine, move operation switch to “Step” then back to “continuous” operation.



## 8.Packing List

Remove all parts from shipping create and boxes. Inspect parts and the machine carefully. Any missing parts should be reported to the shipper upon receipt of shipment.

<b>Main Machine Crate</b>		<b>Stand Box</b>	
<b>Part</b>	<b>Quantity</b>	<b>Part</b>	<b>Quantity</b>
Main Machine	1	Cross beams	2
Swing out shaft assembly	1	Middle beam	1
Rewind tube	1	Left side stand	1
Brake handle	1	Right side stand	1
Media support brackets	3	Swing out shaft Plate	1
Alignment brackets	2	Locking sleeves	1
Anchor bolts (M8)	2	Allen wrench 6mm	1
Stand anchor bolts (M10)	4	M8 x 100 hex screw	8
#8 flat washers	2	M8 x 20 hex screw	10
#8 spring spacer	2	M4 x 12 Philips screws	3
M8 Nut	2	M4 x 8 Philips screws	4
Foot pedal	1		
M5 x 12 hex screw	4		
Operation manual	1		
Film cutter	1		
Allen wrench 4mm	1		
Allen wrench 5mm	1		
Storage box	1		
Cloth tray	1		
Fuse 2A, 5 x 20	2		



## 9. Installation

### 9A. Remove crate top

1. Remove screws around the base of the crate including corner supports
2. Lift crate straight up and off the skid

Crate  
Top →

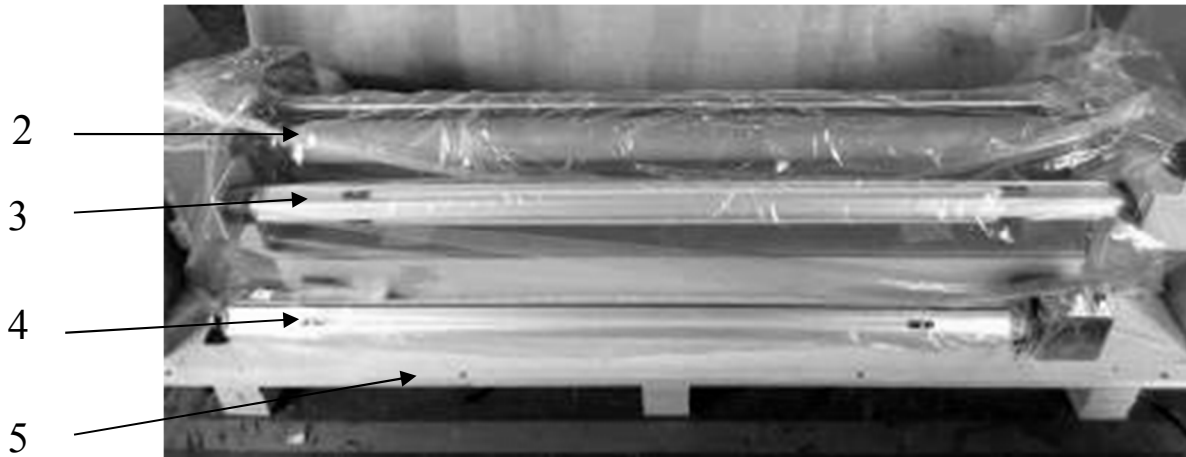


### 9B. Remove packing materials

3. Remove plastic cover and accessory box.
4. Raise the In-feed table and lock in place
5. Remove rewind tube (#3) by pushing toward the spring side
6. Remove bottom supply shaft assembly (#4) from the crate base

1 →

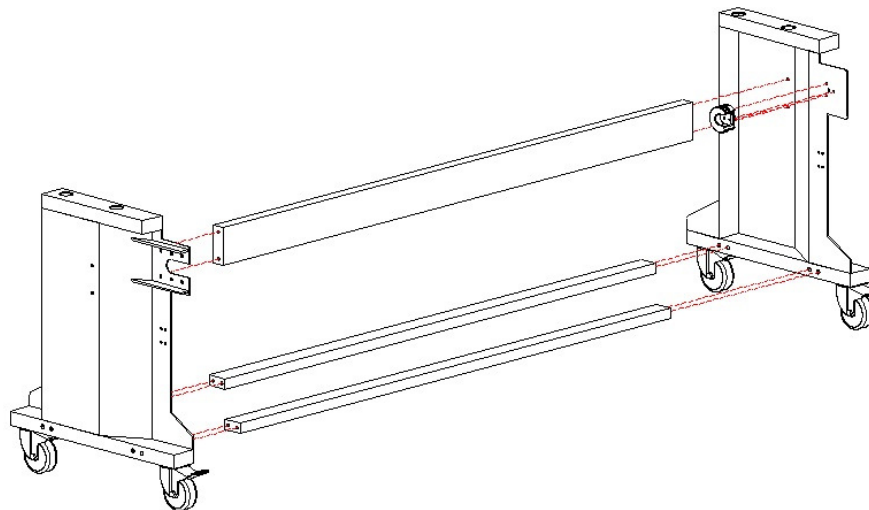




1. Accessory box and manual
2. Top rewind mandrel
3. Top supply mandrel
4. Bottom supply shaft assembly
5. Shipping skid

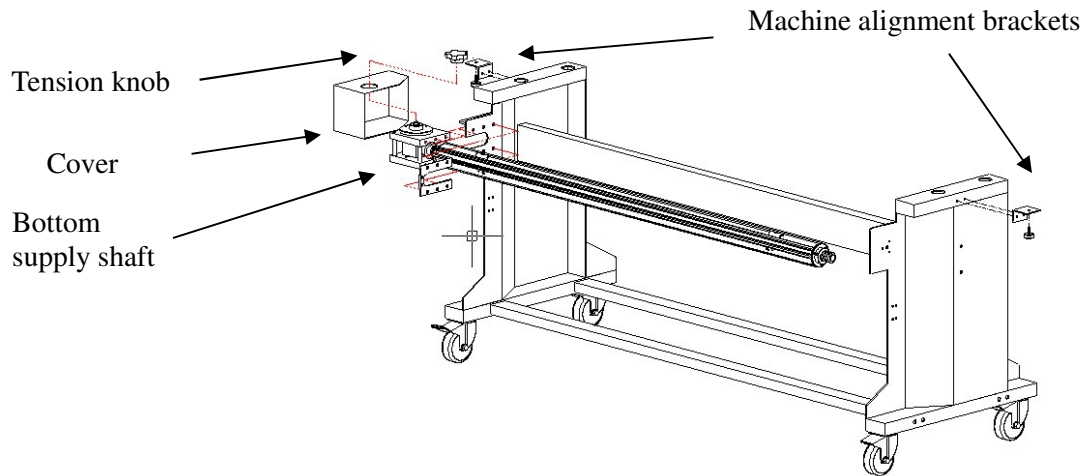
### 9C. Assemble machine stand

1. Remove stand from shipping box
2. Bolt cross members to stand side frame
3. Larger cross member goes in the center and takes the shorter bolts
4. Use a flat washer and lock washer – Flat washer contacts the stand.



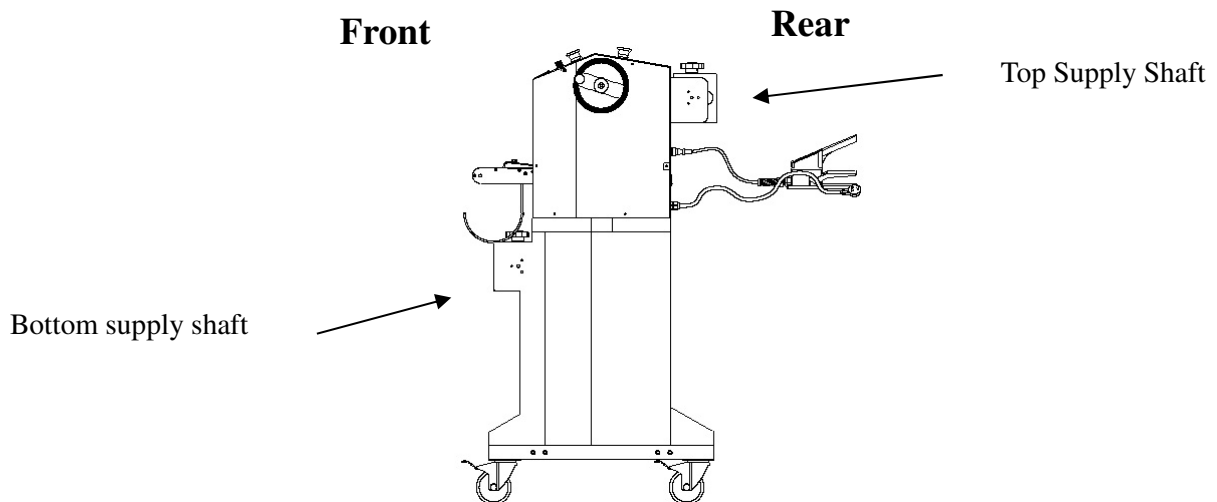
### 9D. Attach lower supply shaft assembly

1. Bolt bottom supply shaft assembly to the stand with 6 bolts
2. Bolt cover to supply shaft assembly
3. Bolt machine alignment brackets to the outside of machine stand



### 9E. Set machine on stand

1. Lift machine from shipping skid and onto machine stand  
Note: Bottom Supply Shaft on stand goes to the **Front** of the machine



**Heavy! Handle with care!!**

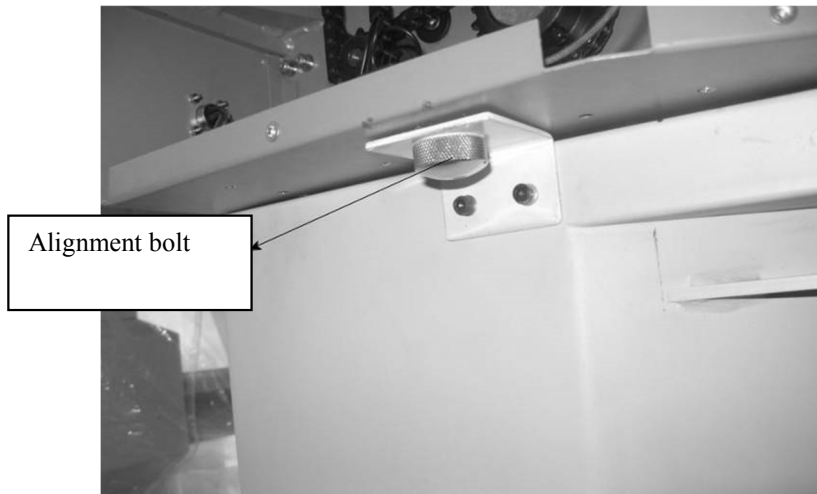


**Warning: when moving the machine, you should have your hands holding on the upper supporting beam and the rear supporting beam. Do not use roller gap adjustment hand-wheel for lifting!**

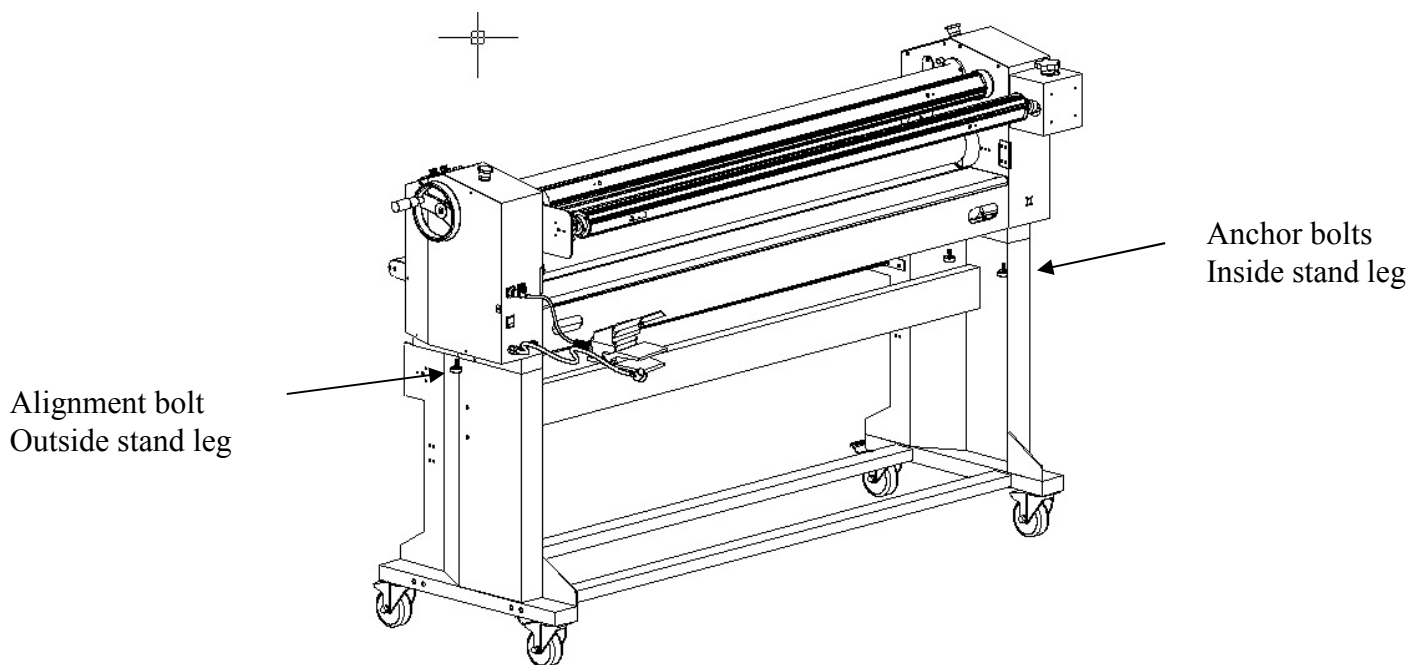
## 9F. Align machine to stand

1. Screw one Alignment bolt through the alignment bracket into machine frame on the **outside** of each stand leg.

Note: You may need to slide machine to align holes in machine frame with machine stand



2. Screw two (2) Anchor bolts through the stand into the bottom of machine frame on the **inside** of each stand leg



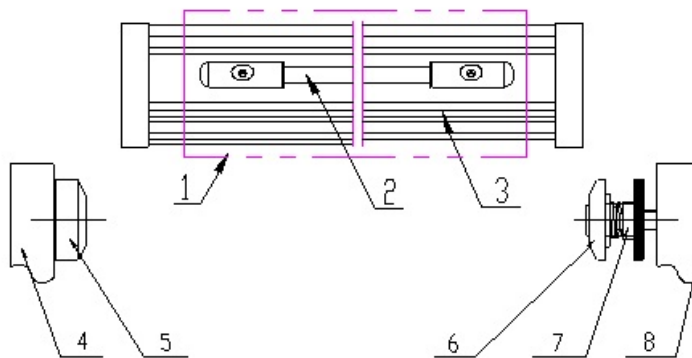
## 10. Additional Installation items

1. Check drive chains for tightness
2. Check all drive set screws for tightness
3. Check all electrical connections and input power and test for proper operation

## 11. Install rewind tube

1. Loosen the pressure-adjusting nut near the right cabinet, and the rewind tube can then be removed from the machine
2. Slide a paper tube onto the rewind tube
3. Return the rewind tube onto the positioning sleeves
4. The rewind tube is driven by friction. The friction and tension will be increased with a left turn of the pressure-adjusting nut, and a right turn will decrease them.

**Note: Adjust the rewind tube pressure-adjustment nut to allow the backing paper to be removed and the film to enter the rollers evenly**



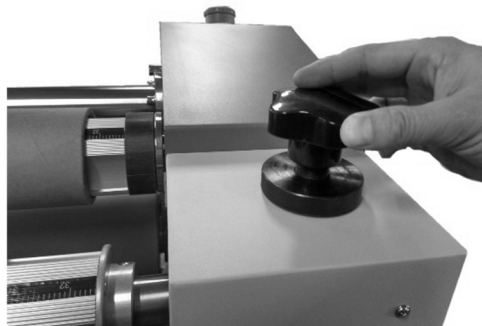
1. Paper tube 2. Rubber core lock 3. Rewind Tube 4. Left side cabinet  
5. Positioning sleeve 6. Positioning sleeve 7. Pressure-adjusting nut 8. Right side cabinet

## 12. Loading Film

1. Rotate the locking outer sleeve in the direction of the arrow to the open position, aligned with the inner sleeve
2. Swing the supply shaft out to load position and slide the film roll onto the shaft  
Note: If using Liner-in film, the web should come off the bottom of the roll, for Liner-out film, the web should come off the top of the roll (see treading diagram in section #13)
3. Swing shaft back into position and rotate locking outer sleeve to secure the roll
4. Align film roll with a number on the supply shaft, positioning the roll in the middle of the supply shaft



5. Adjust the brake tension by turning the adjusting knob on top of the supply roll assembly (see Brake tension adjustment section #16)



6. Repeat process with bottom supply shaft using Mounting adhesive or media roll
7. Position bottom supply roll using the same number position used on the top supply roll to align top and bottom rolls



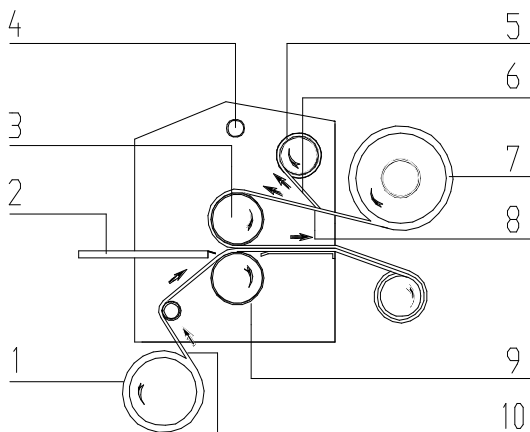
## 13. Threading Film

1. Pull the top film web under the rewind shaft, making sure there is proper resistance. The resistance can be adjusted with the adjusting knob on top of the supply shaft assembly
2. Turn the pressure-adjusting hand-wheel to lift up the top rubber roller.
3. Pass the film through the two rollers and lay on the rear working panel.
4. Pull the film flat then turn the pressure-adjusting hand-wheel to lower the upper rubber roller.
5. Separate the paper liner from the film web to allow enough liner to be taped to the paper rewind tube on the top rewind shaft

**NOTE: Slide film cutter between the paper liner and film to cut liner only. Be careful not to cut the top heat roller**

6. Use foot pedal to advance the film web until the adhesive is exposed on the front of the heat roller
7. Raise the feed tray assembly
8. Bring the mounting adhesive or media web up in front of the idler roller and tack to the exposed film web adhesive
9. Lower the feed tray assembly
10. Use foot pedal to advance both webs until cleared of the nip rollers

**Note: The film should be wrinkleless and tight to the surface of the heat roller. If the film is not tight enough, increase the roller pressure. If wrinkles appear in the film web, adjust the brake tension knobs on both supply rolls**



1. Bottom supply roll
2. Front working table
3. Top heat roller
4. Linkage shaft for roller pressure-adjustment
5. Liner rewind tube
6. Paper liner
7. PSA film roll
8. Film supply web
9. Bottom nip roller
10. Bottom supply web



## 14. Operation

1. Plug power cord into a proper receptacle



- Connect the attachment plug provided with the laminator to a suitably grounded outlet only. This machine must have reliable earth wire to ensure the safety of the machine during operations
  - Contact an electrician should the attachment plug provided with the laminator not match the receptacles at your location
  - Ensure that the voltages of the power supply you are using match the rated working voltages before operations. Do not use incorrect power supply
  - Do not use damaged wires or sockets. If abnormal conditions occur, switch off the power supply first.
2. Turn power to “ON” with the rear power switch
  3. **Cold laminating:** When doing cold laminating, turn the switch to ‘Cold’
  4. **Hot Laminating:** Turn switch to “Hot” and set the needed temperature
  5. When the Green Ready indicator light is on the rollers are up to temperature  
**NOTE: The temperature should meet the material to be laminated. If too high, the quality will be affected**
  6. The indicated temperature shows the surface temperature of the rollers. The temperature switch points to the set position. Actual temperature is shown on the LCD readout. The LCD does not work with the machine is in the “Cold” operating condition.

## 15. Nip Roller Pressure Adjustment

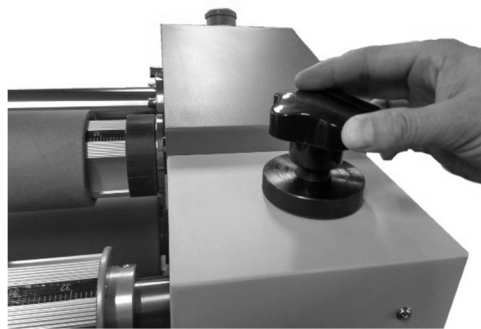
1. When the pressure-adjusting hand-wheel is turned clockwise, the top rubber roller comes down and the pressure will increase
2. With a counter-clock turn, the top rubber roller goes up and the pressure will decrease.
3. Bring the nip roller down to just touch the film, then increase 1/8 turn.

Note: Too much nip pressure will wrinkle the output

## 16. Brake Tension Adjustment

1. Adjust brake tension by turning the Tension adjustment knobs on top of each supply shaft assembly
2. Apply only enough brake tension to remove wrinkles from the vinyl web before it enters the nip rollers
3. Brake tension should not prevent roll from turning

Note: Excessive brake tension will cause waves or wrinkles in vinyl



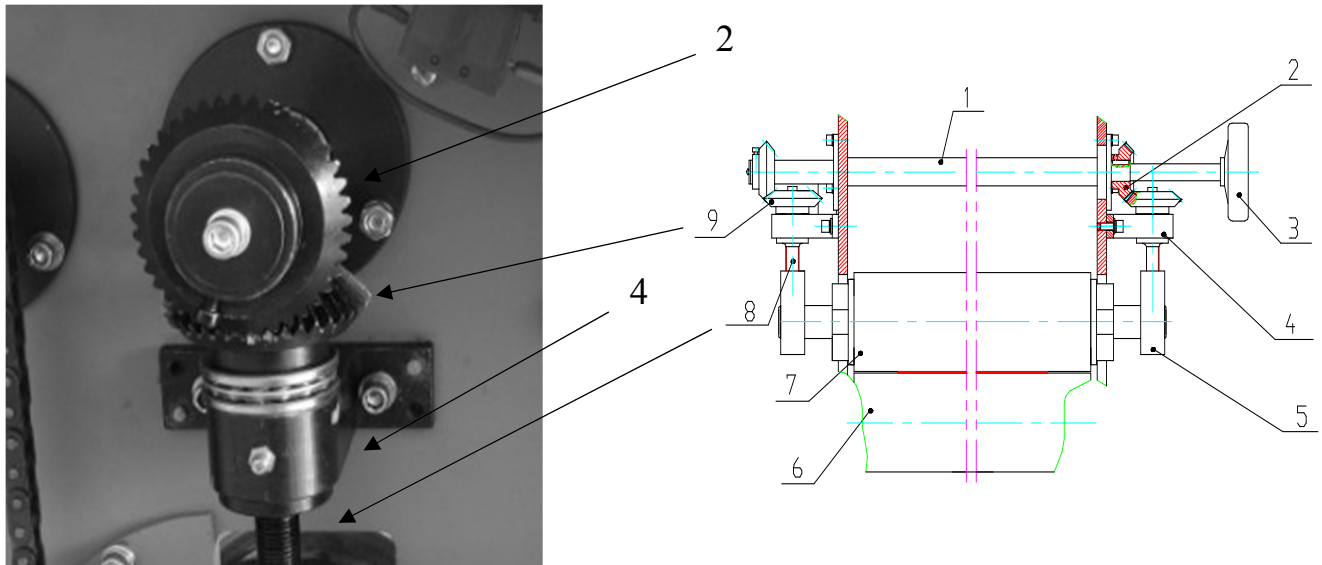
## 17. Removing Press Roller Assembly

1. Unscrew knurled thumb screw securing left side of Press roller assembly
2. Lift off and remove Press Roller assembly



## 18. Roller Gap Adjustment

1. Check for uneven roller gap
  - a. Place a sheet of paper between the rollers the full width of the laminator
  - a. Turn the pressure-adjusting hand-wheel to lower the upper rubber roller so the two rollers just touch
  - b. Check to see if the space between the rubber rollers is even across the width of the machine by pull on the sheet of paper across the width
2. If the space is not even, open the left and the right cabinet covers
  - a. Check if the left and right pressure-adjusting brackets (#4) are loose
    - If loose, tighten brackets and then replace cabinet covers
  - b. Check if the longitudinal taper gears (#9) on the two sides are loose
    - If they are loose, remove the screws of pressure-adjusting brackets, tilt the longitudinal taper gear, and tighten the screws on the top
    - Replace the pressure-adjusting brackets and cabinet covers
  - c. If space between the rollers is still not even
    - Remove the left transverse taper gear (#2), turn the longitudinal taper gear (#9) until the space of the two sides of rubber rollers becomes even.
    - Replace the transverse taper gear (#2), tighten the screws and replace the side covers



1. Linkage Axis 2. Transverse Taper Gear 3. Pressure-Adjusting Hand-wheel  
 4. Pressure-Adjusting Bracket 5. Pressure-Adjusting Blocks 6. Lower rubber Roller  
 7. Upper rubber Roller 8. Pressure-Adjusting Orientation Axis 9. Longitudinal Taper Gear

## 19. Optional Rewind

One or two sets of Rewind devices can be added to the machine as required. One can be fixed in the rear of the machine for rewinding finished material, and another on the front of the stand to take up backing paper from the bottom roll of cold film when doing double-side cold lamination.

Installing the Rewind device:

1. Remove 4 screws and inserts bolted inside each side frame
2. Bolt rewind motor assembly to control side frame and rewind bracket to opposite side frame where the inserts were located
3. Place rewind tube onto the brackets.
4. Plug rewind motor into side frame plug outlet

Operating rewind motor:

1. Select “Combine”, rewind will match the speed of the laminator
2. Select “Single”, rewind runs independent of laminator
3. Adjust speed of rewind with rewind speed control
4. Select “Forward” rewind motor turns clockwise
5. Select “Reverse” rewind motor turns counter-clockwise



## 20. Troubleshooting

Problems	Causes	Solutions
Machine does not turn on	<ol style="list-style-type: none"> <li>1. No power supply</li> <li>2. Main power switch is OFF</li> <li>3. Circuit breaker has tripped</li> <li>4. Blown main power fuse</li> <li>5. Motor has failed</li> </ol>	<ol style="list-style-type: none"> <li>1. Plug in power cord</li> <li>2. Place power switch to ON</li> <li>3. Reset circuit breaker</li> <li>4. Replace fuse on rear panel</li> <li>5. Change the electric motor</li> </ol>
Rollers do not turn after “Run” button is pressed	<ol style="list-style-type: none"> <li>1. Emergency switch is engaged</li> <li>2. Excess roller nip pressure</li> </ol>	<ol style="list-style-type: none"> <li>1. Disengage emergency switch</li> <li>2. Reduce the nip pressure of the rubber rollers</li> </ol>
Heat roller not heating	<ol style="list-style-type: none"> <li>1. Heater not set</li> </ol>	<ol style="list-style-type: none"> <li>1. Switch heater on, adjust temperature setting knob</li> </ol>
Poor film adhesion or cloudy prints	<ol style="list-style-type: none"> <li>1. Nip roller pressure to low.</li> <li>2. Dust on the surface of the print</li> </ol>	<ol style="list-style-type: none"> <li>1. Increase nip roller pressure</li> <li>2. Clean print surface before lamination</li> </ol>
Poor film adhesion on one side	<ol style="list-style-type: none"> <li>1. Nip roller pressure on the two sides is not even</li> </ol>	<ol style="list-style-type: none"> <li>1. See “Roller gap adjustment”</li> </ol>
Lamination output is curled	<ol style="list-style-type: none"> <li>1. Sheet is curled upward</li> <li>2. Sheet is curled downward</li> </ol>	<ol style="list-style-type: none"> <li>1. Reduce top roll tension</li> <li>2. Reduce bottom roll tension</li> </ol>
Film supply roll gets loose during operation	<ol style="list-style-type: none"> <li>1. Not enough brake tension on supply roll</li> </ol>	<ol style="list-style-type: none"> <li>1. Increase brake tension on supply roll</li> </ol>
Backing paper gets loose when being rolled up	<ol style="list-style-type: none"> <li>1. Not enough brake tension on the backing paper rewind roller</li> </ol>	<ol style="list-style-type: none"> <li>1. Increase brake tension on backing paper rewind roller</li> </ol>
Wrinkles in film both on top and bottom	<ol style="list-style-type: none"> <li>1. Too much nip roller pressure</li> </ol>	<ol style="list-style-type: none"> <li>1. Reduce nip pressure with hand wheel</li> </ol>

## 21. Specifications

Description	563TH
Laminating Width	63"
Roller Diameter	4.5"
Roller Gap	1"
Max Temperature	122° F
Film core size	3"
Laminating Speed	0-20 Ft/min
Pressure Adjustment	Hand wheel
Heat Method	Metal alloy tube
Power Supply	110 v 15 amp
Power Consumption	1400 W
Net weight	503 lbs.
Output height	38"
Dimensions	82 x 28.5 x 50"
Shipping weight Machine	530 lbs.
Shipping weight stand	140 lbs.
Shipping dimensions machine	89.4 x 33 x 29"
Shipping dimensions stand	75 x 33 x 5.8"



## 22. Warranty

### EQUIPMENT WARRANTY

January 2014

Graphic Finishing Partners, LLC warrants each new Gfp Laminator is free from defects in material and workmanship for a period of one (1) year from the date of installation. A machine which proves defective in materials or workmanship within the warranty period will be repaired or, at Gfp's option, replaced without charge. This warranty is extended only to the original purchaser.

This warranty is the only warranty made by Gfp and cannot be modified or amended. Gfp's sole and exclusive liability and the customer's sole and exclusive remedy under this warranty shall be, at Gfp's option, to repair or replace any such defective part or product. These remedies are only available if Gfp's examination of the product discloses to Gfp'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.

The warranty made herein is in lieu of all other warranties, expressed or implied, including any warranty or merchantability or fitness for a particular purpose. Gfp will not be liable for personal 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 this equipment.

This warranty specifically does not cover damage to laminating rollers caused by knives, razor blades, or any sharp objects or abrasives, or failure caused by adhesives, or damage caused by lifting, tilting and/or any attempt to position the machine other than rolling on the installed castors or feet on even surfaces, or improper use of the machine. Warranty repair or replacement by Gfp or its authorized reseller(s) does not extend the warranty beyond the initial period from the date of installation. Unauthorized customer alterations will void this warranty.

#### Contact Information

##### CORRESPONDENCE:

Graphic Finishing Partners LLC  
PO Box 1097  
Maryland Heights, MO. 63043  
800-986-2005  
[sales@gfpartnersllc.com](mailto:sales@gfpartnersllc.com)  
[www.gfpartnersllc.com](http://www.gfpartnersllc.com)

##### SHIPPING:

Graphic Finishing Partners, LLC  
13878 Parks Steed Drive  
Earth City, MO. 63045