



Alliance Technology Corp.



ATC-UV-24HA

Owner's Operation Manual

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Part# OM24_36UVHARev0

INTRODUCTION

Thank you for purchasing an Alliance Technology ATC24HA UV Liquid Laminator. We have designed the ATC24HA UV Liquid Laminator to give you years of reliable service. As you become familiar with your liquid laminator, you will appreciate the high quality of its production and the excellence of its design features.

By following the guidelines for proper care and use of the ATC24HA UV Liquid Laminator, you can depend on many years of trouble free profitability from your investment.

CAUTION! Please pay attention to all shaded passages. 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.

STATEMENT OF INTENDED USE

The ATC24HA UV Liquid Laminator is intended for use with medium and small format graphic output. Graphics can vary in widths from 4" (100mm) to 24" (600mm). Mounted graphics can be up to 1" (25.4mm) thick.

The ATC24HA UV Liquid Laminator is intended for use with Alliance Technology ATC lacquer only. Use of other manufacturer's lacquers may damage the machine and will void any warranty.

WARNING! *This laminator is designed for liquid laminating. Any use other than the intended use may cause damage to the laminator or physical harm to the user.*

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

LIABILITY STATEMENT

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 previously delivered.

IMPORTANT SAFEGUARDS

SAFETY INSTRUCTIONS

IMPORTANT! When using any equipment, always follow the manufacturer's instructions for safe operation.

Make sure machine is connected to the proper power source.

Familiarize yourself with the layout of the Control Panel, and with the operation of the lacquer delivery system.

Operators should be trained on the proper use of the machine and all safety procedures.

Provide ventilation, eye protection, clean towels and rubber gloves for use during cleanup.

It is advisable to wear eye protection when filling or emptying a lacquer tank. Provide an approved emergency eyewash station near the machine.

In case of skin contact with uncured lacquer, use soap and water to clean (do not use solvents to remove lacquer from the skin—solvents help lacquer to penetrate the skin). Repeated skin contact will result in a skin rash—uncured UV liquid is a skin irritant. Cured UV liquid does not irritate the skin. (One box of latex gloves has been shipped with the machine.)

Review MSDS prior to working with UV material.

WARNING! Ensure a clean well-ventilated work area. Avoid direct skin contact with uncured UV lacquer. Wear rubber gloves and UV blocking safety glasses. Failure to avoid contact with hot surfaces may cause burns. Do not look directly at the UV light source.

CAUTION! When handling any chemical products, read the manufacturers' container labels and the Material Safety Data Sheets (MSDS) for important health, safety, and environmental information. Always follow manufacturers' instructions when handling chemicals.

To obtain MSDS Sheets for ACCUCURE™ UV Products, please call 410-634-9381.

Comply with all safety warning signs, labels, and instructions.

SAFETY WARNINGS



ROTATING PARTS: RISK OF INJURY

CAUTION! Failure to use caution near rotating rollers could result in physical injury. Be careful that items such as loose clothing, long hair and jewelry do not become entangled in rotating parts.

Beware of pinch points. Never operate machine with protective covers removed. Keep hands outside of machine when feeding materials into the machine. Never reach into machine when rollers are moving.

IMPORTANT SAFEGUARDS

ELECTRICAL PARTS - Danger of being injured by electricity.



WARNING! Do not open electrical cabinet panels because of the risk of being injured by voltage. Only authorized maintenance and service technicians should have access to the electrical cabinet panels for mechanical or electrical servicing.

IMPORTANT! Do not place heavy objects on the power supply cord.

PREVENTATIVE MEASURES.

Do not feed objects such as staples, paper clips and rough or abrasive materials through the laminating rollers.

Keep all objects, such as tools, rulers, pens, markers or knives away from the roller opening. Refrain from leaving such items on the tables to prevent them from accidentally being fed into the rollers.

IMPORTANT! NEVER cut or slice directly on the rubber covered roller as any cuts, dents, or gouges will destroy it and adversely affect the output.

UV LIGHT SAFETY.

Never look directly at the UV curing lamps. If working at the machine wear UV blocking glasses (clear or tinted). Over exposure to UV light will result in a condition colloquially known as “welder’s flash”--the eyes will itch and burn or feel sandy for a period of time. This condition should be avoided. Permanent eye damage can result. (2 sets of UV blocking eyeglasses have been shipped with the machine.)

IMPORTANT! Read the UV CURING SAFETY MANUAL for further safety information before operating the UV coating machine.



BURN HAZZARD.

When opening UV lamp compartment for servicing or cleaning, avoid touching hot surfaces. Allow to cool before servicing.

UNCRATING AND INSTALLING

RECEIVING AND STORING CRATE

The coating machine is shipped in a wooden crate. The crate should be inspected for signs of shipping damage at the time of arrival.

Any indications of handling damage should be immediately reported to the carrier.

Extreme hot or cold temperatures 5 deg C to 55 deg C will not harm the machine. Allow the machine to stabilize to room temperature before operating. Avoid leaving the crate outside, humidity will oxidize some parts.

MOVING THE COATING MACHINE

To remove the machine from the shipping crate, remove the blocking that the machine is positioned on. Then roll the machine down the built in ramp to the floor. With the leveling feet retracted the machine can be moved on its own built in set of four wheels.

LEVELING THE MACHINE

Extend the leveling pads and level front to back then left to right in front across the top of the lacquer tray.

ELECTRICAL CONNECTIONS

Install a properly sized electric service to the machine in compliance with local electrical codes.

VENTILATION

Vent the machine to the outside atmosphere. The UV lamp produces ozone. In a closed room the levels can be harmful to health--vented to the atmosphere the ozone quickly breaks down and is not a long term pollutant.

OPERATING ENVIRONMENT

Ambient operating temperatures should be held to the range of 20 deg C to 30 deg C. The coating liquid is temperature sensitive—too thick when cold, and too thin when hot.

Humidity should be controlled: 30% to 90%.

Maximum altitude: 2250 meters or 7400 feet.

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SAFETY FEATURES

The operator's safety is of the utmost consideration. The ATC 24 UV Liquid Laminator is designed with safety and protective devices to ensure the operator's safety. However, following safe operating guidelines is still the responsibility of the operator.

EMERGENCY STOP BUTTONS

Emergency stop buttons are located on the corners of the machine. Use these buttons only in case of emergency or you may damage an image during a process. In addition the dryer and right front side panel have emergency shut down switches; do not open when machine is running.

After an emergency shut down, if you immediately restart the machine, there will be an automatic 3 minute cool down to protect the UV lamp.

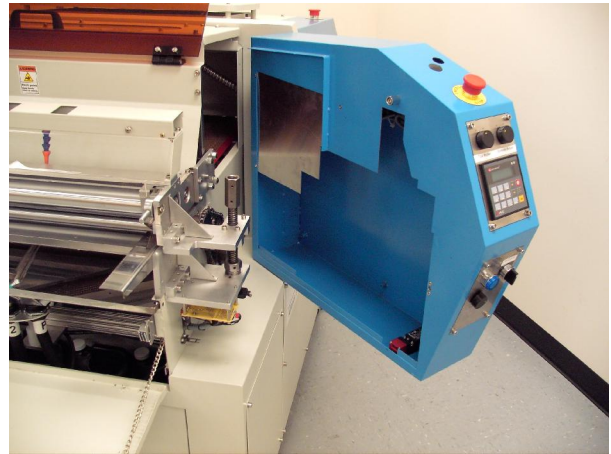


Note: The emergency stop buttons lock when pressed.

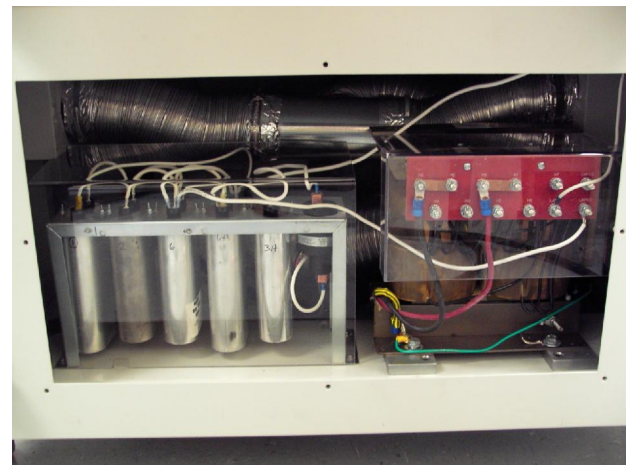
Reset the locked emergency stop push button by twisting clockwise.

Restore the control panels by pressing the safety relay set push button.

WARNING! Before servicing, ALWAYS turn the main switch off before opening the front and rear side panels.



WARNING! Before servicing, ALWAYS disconnect the machine from the electrical service before opening the main switch cabinet or the high voltage panel.



CAUTION! Disconnect machine from electric service before opening high voltage panel. Discharge capacitors to avoid severe electric shock. Only qualified service personnel should work in this area. Open circuit voltage is in excess of 1000 volts.

FRONT TOP CONTROL PANEL



FRONT BOTTOM CONTROL PANEL



From top to bottom:

Top roller speed knob.

Bottom roller speed knob.

Controller Panel.

SEQUENCE OF CONTROLS

- 1 Safety Relay Set
- 2 Transport ON
- 3 UV Lamp ON

Turning 1 or 2 OFF shuts off UV Lamp.
With 1 or 2 OFF the UV Lamp can not start.

From top to bottom:

Safety Relay SET.

Pump Selector.

Lacquer pump speed knob.

BLOWER TIMING

The blower is triggered by the UV Lamp circuit. When the lamp is turned on there is a three minute delay before the blower comes on. When the lamp is turned off there is a three minute delay before the blower turns off.

OVERVIEW OF OPERATING FEATURES.



ROLLER ASSEMBLY.

The roller assembly is the heart of the coating machine. It is a three roller design.

The top front pinch roller supplies even lacquer to the top coating roller. Flip the spring levers up to provide pressure for the roller whenever the lacquer/wash pumps are on.

The top rubber coating roller transfers lacquer to the image being coated. Overnight, raise the rubber roller off of the bottom roller and remove pinch roller pressure. Place the pinch roller spring levers in the down position. Continuous pressure without the rubber roller turning can cause a slight indentation in the rubber.

The bottom roller presses the back of the image material ensuring an even coating pressure. The bottom roller scraper removes excess lacquer from the roller to prevent any uncured lacquer on the back of the image.

A sufficient amount of lacquer, evenly distributed across the whole roller, provides the best coating result. The lacquer pump has a variable speed knob. Too much lacquer will only make a mess at the ends of the rollers, too little will cause uneven coating. At low roller speeds less lacquer is needed. At high roller speeds more lacquer is needed.

FEEDING MATERIALS.

Materials are fed face up through the roller assembly.

ROLLER ELEVATION ADJUSTMENTS.

The nip (opening between rollers) can be adjusted from 0.000" to 1.000". There are two hand wheels, one for the right side, one for the left. Both must be turned by the same amount to elevate the rollers.



Elevate the rollers by turning the hand wheels.



Exact elevation is read on the control panel screen.



To calibrate (zero) the display, adjust the rollers until they just touch. Then press and hold the [+/- .] key for three seconds.

OVERVIEW OF OPERATING FEATURES.



DRYER.

The UV dryer section is self contained. A continuous conveyor belt transports material under the UV lamp and out the back of the machine.

The UV lamp is adjustable up and down. (It is preset at the factory for proper focus).

CAUTION! NEVER look directly at the UV lamp when lit. Use UV blocking eye protection to inspect the dryer while operating. Direct viewing of the UV light can result in eye injury.

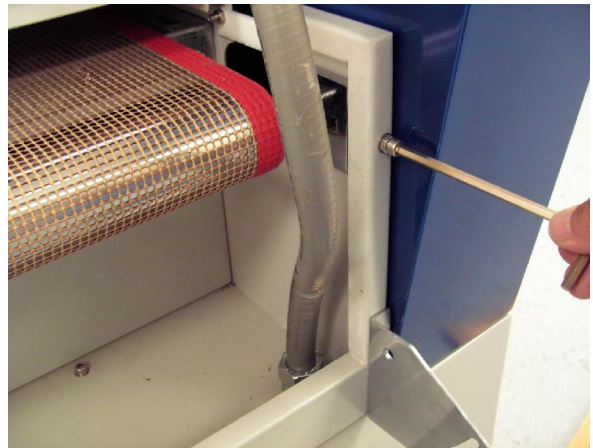
Two pairs (one dark, one clear) of UV safety glasses are supplied with the machine.

ADJUSTMENTS

There is one adjustable shade on the front side of the lamp housing--it is adjusted to limit the amount of reflected UV light being emitted from the UV lamp housing. Adjust for the least amount of stray UV light. Usually the front shade can be set quite low.

From time to time the transport mat may need adjusting. There are two tension screws for the mat at the rear of the machine: one right and one left. If the mat is wandering to one side you can adjust these screws. Be careful, when adjusting remember *less is more*. Very small

adjustments can have very large results. Typically you tighten the side that the mat is traveling to--but not always. Depending on the overall mat tension you may need to loosen the side the mat is traveling from. Also remember that cold tracking for the mat may be different than hot tracking. Adjust the first time when cold, and thereafter only when hot. And finally remember, only expect to get consistent tracking if the machine is off of its wheels and level.





OVERVIEW

The lacquer system is designed to recover and recirculate unused lacquer. From the bottom container the lacquer is pumped to the top rollers. From the top rollers the overflow drips into a drain pan and flows back into the bottom container. There is a screen filter on the pump tube in the container.

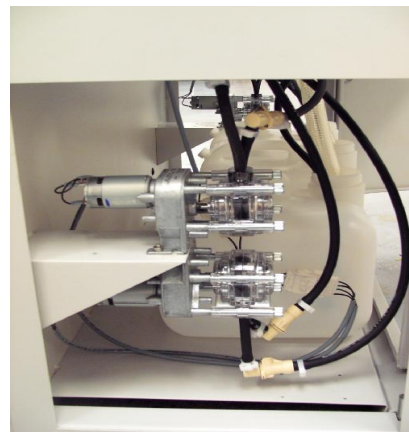
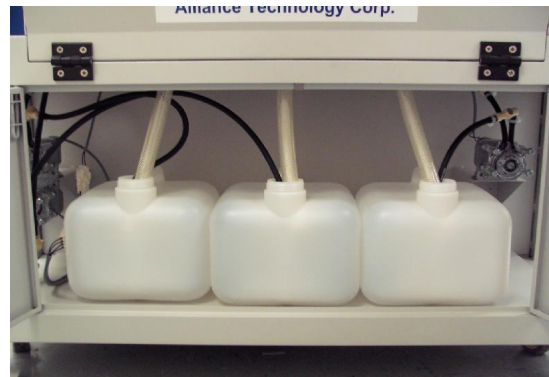
On the front bottom control panel there is a pump speed knob. Set the pump speed so that lacquer is flowing across the crease formed by the top roller pair (*make sure the pinch roller levers are up*). But reduce the pump speed so that a minimum amount of lacquer is spilling over the roller ends. If you speed up the rollers, speed up the pump. If you slow down the rollers, slow down the pump.

There are three pumps, three containers, and three return drain tubes. You can select P1, P2, or P3 on the front panel. When you select and turn on a pump the display automatically goes to a 10 second delay screen and asks "Drain Correct?". Press [0] to avoid turning on the pump--the screen will return to the original pump screen--you then have as much time as you need to correct the drain connection.

CAUTION! Avoid cross contamination! Before starting pumps, make sure the right (matching) drain is correct.

LACQUER OPERATING TEMPERATURE

The operating temperature of the machine is determined by the temperature of the coating liquid. Optimum temperature of the liquid is 68°F (20°C), but it can be used between 68°F to 86°F (20° to 30°C). Below 68°F (20°C) the liquid will thicken, drain more slowly, and collect in the drain pan. Above 86°F (30°C) the liquid thins, and effective coating thickness will decrease.



CAUTION: Avoid skin contact with coating lacquers. Wash off immediately with soap and water. Wear safety glasses and gloves when handling coating lacquers.

UV LAMP AND BLOWER OPERATION

Medium pressure UV lamps have a characteristic start up. The quartz glass bulbs are filled with argon and little droplets of mercury. When high voltage is first applied to the lamp the argon lights and glows. It is the glowing argon that heats the bulb and evaporates the mercury. It is the mercury vapor arc that produces UV radiation. Because of this evaporation cycle, when the lamp is turned off, there is an automatic 3 minute blower cooling cycle.

Repeated starts shorten the life of the UV bulb. It is customary to light the bulb once each day. Instead of turning off the lamp, it is placed in stand-by mode. There is a stand-by position (LOW) one screen below the UV LAMP screen.

Over time the UV output of the lamp will weaken and the lamp will have to be replaced. Another cause of UV loss is a dirty reflector, or a surface damaged reflector, in the lamp housing—before replacing the UV bulb clean the reflector with alcohol.

REMOVING LAMP

Turn off the main switch and wait five minutes for the lamp capacitors to discharge. Open the two rear sides. The lamp terminals can then be disconnected on each end. The retainer plate on one side can be unscrewed and the lamp can be carefully removed from that side.

IMPORTANT! Wear cotton gloves when handling quartz lamps. Oil from the fingers will mark the quartz when the lamp is heated and cause failure. Wash the lamp surface with clean propyl alcohol prior to starting for the first time.

UV LAMP AND DRYING SPEED

The UV lamp puts out more heat energy than UV energy. The slower the dryer speed the greater the energy absorbed by the substrate, both heat and UV. Some substrates are not very heat tolerant. These must go through the dryer at higher speeds.

ROLLER SPEEDS AND COATING RESULTS

Top and bottom roller speeds are independently controlled to allow flexibility in coating results.

NOTE: Both rollers run at the same surface speed when both speed knobs are set at "0". This setting is used with the rollers touching to drain excess lacquer from the top nip and clean the machine. Five to ten minutes in this mode is usually sufficient.

There are basically two types of materials. Thick materials which require the rollers to be set with a gap and thin materials which are run through nearly closed or fully closed rollers.

THICK MATERIALS

Measure the material thickness with the electronic calipers provided. Measure in more than one place, material thickness can vary. Set the roller gap (nip) slightly below the measured thickness. Closing the nip by 0.006" to 0.012" should give good results.

Coating thickness is greater when the top roller runs faster than the bottom roller. Example: top 10, bottom 5.

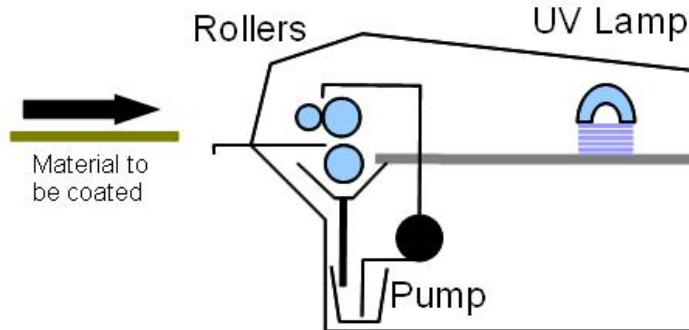
THIN MATERIALS

Thin substrates require more attention. First there is the scraper. The scraper needs to be properly adjusted so that the backs of coated materials do not pick up UV lacquer. You should routinely check the backs of thin materials to verify that the scraper is doing its job.

Second, thin materials can adhere to the coating roller--thin materials that have an affinity for wrapping around the coating roller will need a leader, or will need to be taped to a board.

Materials that have enough weight (stiffness) will coat without problems. Decal material and cyclone paper fall into this category.

Controller Panel Screens



Step 1

Rollers

- 1) ▾ Adjust Nip
- 2) ▴ Turn On Rollers
- 3) Adjust Speed



Step 2

Pump

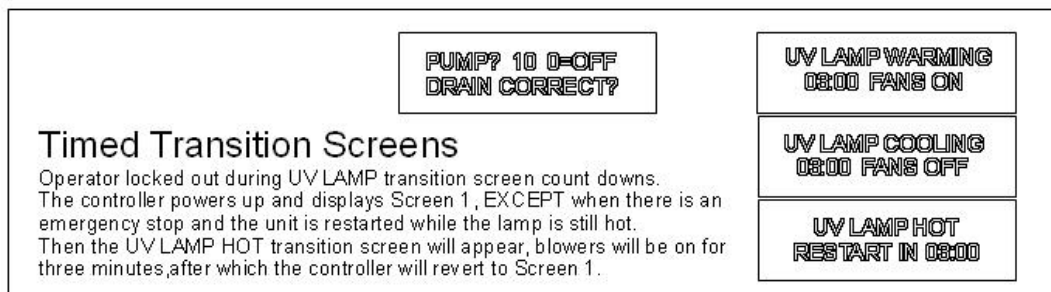
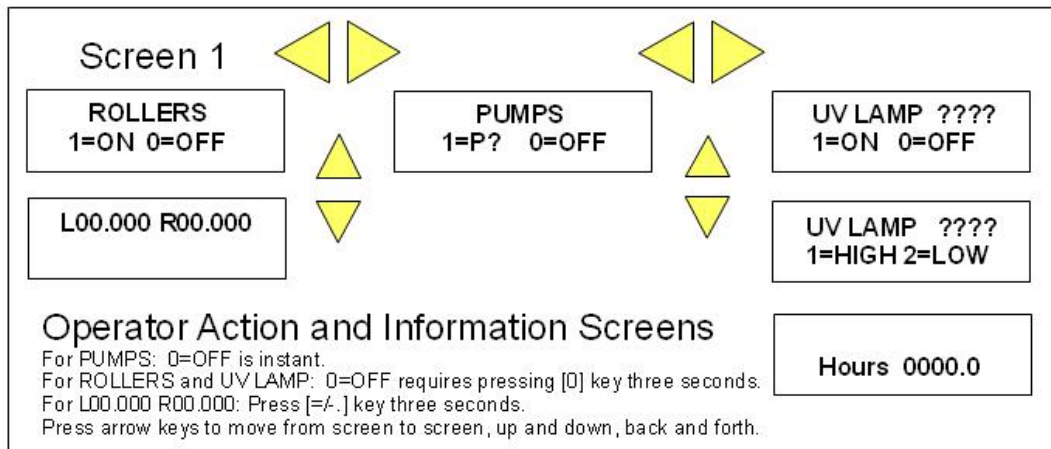
- 1) Select Pump
- 2) Check Pinch Roller, Set Drain
- 3) Turn On Pump



Step 3

UV Lamp

- 1) Start Lamp
- 2) 3 Minute Warm Up
- 3) Start Coating



OPERATING DETAILS

Safety Circuit

When you turn on the main switch the blue safety set light will come on. Press the safety set button, the blue light should go out. If the light stays on, check the four E-stop switches (twist to release) and make sure the rear cover is closed and the front side panels are closed (safety interlock switches). When the light goes out the controller will power up.

Rollers Screen

Transport has to be running (rollers turning) for the pumps to work and for the UV lamp to come on. The controller powers up in the rollers on/off screen. On is instant, off requires pressing and holding for at least three seconds.

Pumps Screen

Use the arrow key to move to the pumps screen. Don't forget to flip the levers on the pinch roller before starting the pumps. Select P1, P2, or P3 with the selector switch. The pump transition screen reminds you to verify the drain setting. If the drain setting is wrong just press [0]. On takes 10 seconds, off is instant.

UV Lamp Screen

You will be locked out during the UV Lamp timed transition screens. These protect the UV lamp. If you have an emergency shut down and you turn on the machine before the lamp cools the machine will start with the "UV Lamp Hot Restart In 3:00 minutes", other wise it will come up in "Rollers 1=ON 0=OFF". As with the roller screen, on is instant, off requires pressing and holding [0] for three seconds.

UV Lamp High/Low Screen

When you are not curing product, put the UV lamp into Low mode. Low mode extends the life of the lamp. Shutdowns and restarts shorten the life of the lamp.

UV Lamp Hours Screen

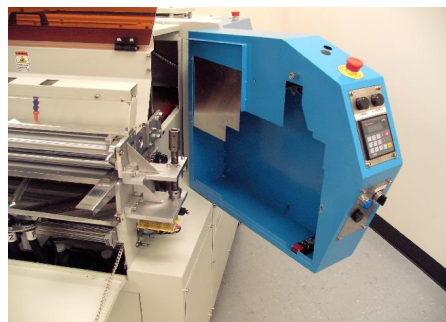
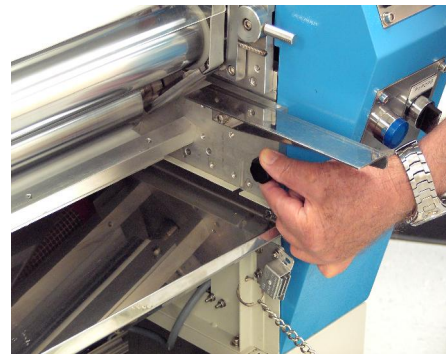
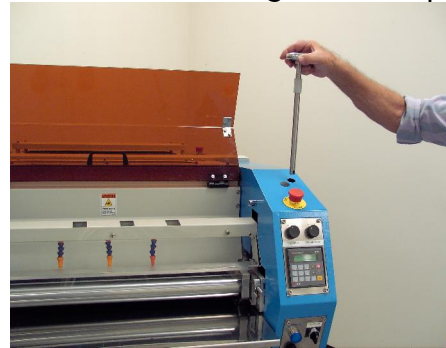
Cumulative lamp hours, not resettable. The

hour meter runs when the lamp is on.

Record current value when replacing lamp.

Roller Elevation Screen

The screen down from "Rollers 1=ON 0=OFF" is the readout for the roller elevation knobs. One turn of the knob = 0.166" (~4mm). The maximum number of turns is a little over 6 (1" nip capacity). Don't go crazy turning the knobs. Turn clockwise to raise the roller, counterclockwise to lower. When turning counterclockwise, STOP turning when you see the rollers touch each other. If you continue turning counterclockwise you will back the brass acme nuts out of their retainers. If you look inside you will see why--to open the door, pull the hand wheel straight up and out of the door, then remove the thumbscrew and swing the door open.



Both handwheels need to be turned by the same amount.

SETUP AND OPERATION.

WARNING! Always wear rubber gloves and glasses when handling UV lacquers. If you get lacquer on your skin, wash it off immediately with soap and water. Do not use solvents to remove lacquer from the skin—solvents help lacquer to penetrate the skin.

START UP.

Check lacquer supply. If you need to add to the reservoir do so now. Also check the alcohol cleaning reservoir. If you are running linty materials (canvas) you will need to open and clean the inlet filter for whichever coating lacquer you have been using. The filter screen can be cleaned by flushing with isopropanol alcohol.

CAUTION! Avoid skin contact with uncured UV lacquer, if you get it on your skin wash it off immediately with soap and water. Never use alcohol to remove lacquer from the skin.

Remove the feed table and inspect the scraper for cleanliness. If you are running clean materials you may never have to clean the scraper, if you are running canvas (linty materials) you may need to clean the scraper on a regular basis.

Turn on the Main Switch. Press the SR Set button on the coater front panel.

Turn on the transport. Set both speed knobs to 10. The top and bottom rollers should be separated; you can adjust rollers to touch each other after the top roller is coated with lacquer.

Turn on the UV lamp, allow the lamp to warm up and the blower to come on.

CAUTION! Wear eye protection if the UV lamp is lit.

Select P1 or P3, check that the drain

matches your selection.

Check the roller settings. Pinch roller should be engaged. The rollers should be level. Turn on the lacquer pump. Set the pump speed. If you are running thin material adjust the top and bottom roller so that they just touch.

Check the scraper, make sure the bottom roller is being scraped clean. Replace the feed table.

SHUT DOWN.

When you are ready to shut the machine down:

- 1) Turn off the pump.
- 2) Lower the top roller until it touches the bottom roller. Set both roller speeds to 0 (the roller speed controls are programmed to run at the same surface speed at the zero settings). Run the machine for five or ten minutes to let the lacquer drain from the rollers.
- 3) You can shut down the lamp from the lamp screen. This can be done while the rollers are "draining". Or you can separate the rollers, loosen the pinch roller, and shut down the machine from the roller screen. Your option.

Always remember to remove pressure from the rubber roller when you shut down.

CLEANING THE COATING MACHINE

WARNING! Always wear rubber gloves and glasses when handling UV lacquers. If you get lacquer on your skin, wash it off immediately with soap and water. Do not use solvents to remove lacquer from the skin—solvents help lacquer to penetrate the skin. When working with alcohol avoid skin contact and provide adequate ventilation.

CLEANING CYCLE.

The cleaning cycle is similar to standard coating. Wash (P2) is selected on the pump selector switch and the drain is turned to the P2 position. With the rollers in contact, run the machine for ten or fifteen minutes. ***Top and bottom rollers should be set to the same "0" speed setting.***

If you are cleaning the machine to change to a new lacquer that may be incompatible with the old lacquer, after the first cleaning cycle replace the alcohol and repeat the cycle.

Problem	Solution
The laminator will not turn on.	Confirm that the power cable is plugged into the mains outlet. Confirm that the Main Power switch is ON. Confirm that the Emergency Stop buttons were not activated. Rotate to reset. The blue Set Light should go OFF when SR Set push button is pressed. The rear lamp housing door and the right front side cabinet door need to be closed tight for the blue Set Light to go off. Unplug the laminator and check the fuses inside the right cabinet. Only authorized safety or maintenance personnel should do this.
The motor will not run.	Turn the motor speed up. Unplug the laminator and check the fuses. Only authorized safety or maintenance personnel should do this.

TECHNICAL SERVICE

For technical assistance, please contact your Technical Service representative (see rear cover).

When calling for Technical Service please have the Laminator Serial Number (listed on the Identification Plate) available. The Identification plate is located on the rear left side of the laminator.

REPLACEMENT PARTS

Have your machine serial # available when ordering replacement parts. Your serial # will automatically correct for any changes in production and will ensure that you get the right parts.

PART REFERENCE	DESCRIPTION
UV24 coating roller	Replacement rubber coating roller.
UV24 roller bearing	Replacement ball bearing for all coating rollers.
UV24 lamp	Replacement 24" UV medium pressure mercury lamp.
UV24 conveyor belt	Replacement dryer conveyor belt.
UV24 pump	Replacement peristaltic pump.
UV24 pump tube	Replacement peristaltic pump tube.
UV24 tube disconnect	Replacement tubing connector.
UV24 pump tube strainer	Replacement pump inlet strainer.
UV24 speed control	Replacement motor speed control.

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TECHNICAL SPECIFICATIONS

ATC UV24

COATING

Width: Up to 24" wide sheets.

Coating Speed: Variable up to 25 feet per minute.

Coating Liquids: Gloss, Luster, and Matte.

Separate pump and filters for two lacquers plus wash.

MACHINE DIMENSIONS

Width: 52" (Including 8 x 8 vent on left side).

Length: 68" (plus 20" collector tray)

Height: 51"

ELECTRICAL REQUIREMENTS

USA/CANADA 230vac 1phase 30amp 60Hz

INTERNATIONAL 380vac 3 phase with neutral 30amp 50Hz

Alliance Technology Corporation warrants to the original consumer purchaser that each new ATC UV 24 Liquid Laminator, which proves defective in materials or workmanship within the applicable warranty period, will be repaired or, at our option, replaced without charge.

The applicable warranty shall be one year from date of purchase with the exception of EPDM rollers that will be six months from date of purchase.

"Original consumer purchaser" means the person who first purchased the product covered by this warranty other than for purpose of resale.

The warranty extends to and is enforceable by only the original consumer purchaser, and only for the period (during the applicable term), which the product remains in the possession of the original consumer purchaser. This warranty does not apply if it is found that at any time the equipment has not been used for its intended purpose.

For more information regarding this warranty, please contact your distributor.

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 user.

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

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