intec PRINTING SOLUTIONS | colorFlare Decorative effects for digital solutions

CF1200 SERIES USER MANUAL

Version CF1200 v1.5 - August 2018

The magic starts here

- 12m P/MIN
- 2,500 SRA4 P/HOUR
- BURST SEPARATOR WHEEL
- 100 ~ 450 gm²
- FORMATS Min: 210 x 297mm Max: 380 x 1219mm
- MULTI FX
- 1 TONNE PNEUMATIC PRESSURE
- HOT ROLLER

Laminates | Foils | Holographics

Contents

1. IMPORTANT SAFETY INSTRUCTIONS

Please read the following sections carefully, “Safety Instructions” are for the purpose of ensuring the user’s safety and to help prevent damage to property. Please read thoroughly and follow the instructions in this manual.

Symbols used in this document

Important Safety Instruction is classified as “Warning” and “Caution”, the meaning is as follows;

Warning : If you ignore this symbol, you could suffer serious injury or death

Caution: If you ignore this symbol, you could receive a serious injury or loss of property

This symbol means a prohibited action. If you ignore a prohibited action, you could suffer a personal injury and damage the machine

Reference: This symbol is used to show important information that is necessary for daily operation of the ColorFlare. Please take note of the s items, as they are key to operating the ColorFlare correctly.

Note: This symbol denotes added information to help you understand the item or function being described.

Top Tip: Information following this symbol may help you, or enable you to understand the process better, and make you more efficient (Tricks & tips style info).

1.2 WARNINGS

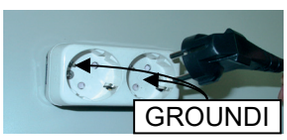
POWER WARNINGS

Do not connect or disconnect with wet hands, as this will cause an electric shock

Do not overload a power supply, as this will cause a fire and an electric shock.

Do not use a damaged plug or lead, as this could cause a fire or an electric shock

Do not use other voltage and power supply other than specified, as this will cause a fire and an electric shock.



Make sure plug is in the socket, as it could cause fire or an electric shock

Grounding is needed for your safety

A malfunction and losing electricity make an electric shock

Danger, Malfunction, loss of electricity could cause an electric shock

Do not pull the plug or bend improperly

INSTALLATION WARNINGS

Do not use materials near a naked flame

Do not use the ColorFlare in a non-ventilated or sealed place.

Only use the specified power and voltage. It can be a reason of fire flame or an electricity fire flame.

Do not dissemble, make repairs or convert the ColorFlare. Contact your dealer for repairs

Ensure all hair, neckties, necklaces, are kept free of the feeding table to avoid injury

Do not convert the safety device and safety switch.

Do not spill any liquids on the ColorFlare as this will cause damage and a possible electric shock

Do not use flammable spray or flammable materials inside or outside the machine. As this could cause a fire.

Do not allow children use of this equipment

1.3 CAUTION NOTICES

POWER CAUTION NOTICES

When moving the ColorFlare, turn off the power switch and disconnect the power plug from the socket.

When the ColorFlare is not in use, turn off the power switch, disconnect the power plug from the socket.

INSTALLATION CAUTION NOTICES

>190Kg , more than 2 people (Team Lift) or a mechanical aid are needed to carry this equipment to avoid personal injury or damage to the machine.

Keep gears and chains free of all materials

Do not touch the heated mirror roller with your hand as you could be burnt.

Please avoid installing near the following places;

Gas stove, Ventilator or Air conditioner due the higher temperature or higher humidity

Avoid the direct sunlight for the installing the machine

Make sure no vibration and dusts are found in the place during the installation.

Avoid the dark and slope place for installation

Do not place any materials on the laminator as they could catch a fire

Do not touch the film and laminating machine just after lamination finishes as you could be burnt.

Use the machine for laminating or flaring/foiling purposes only.

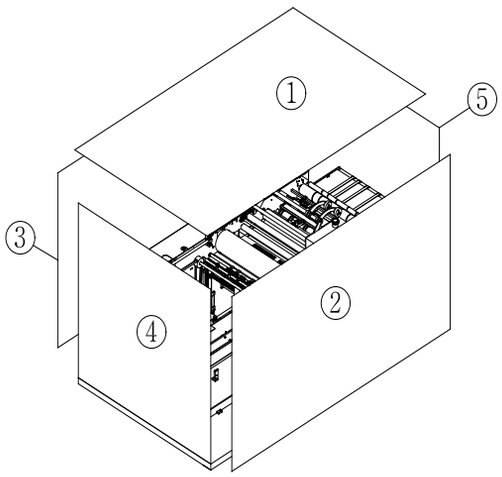
Tidy up the place near the laminating machine.

Section 2.

UNPACKING THE COLORFLARE

2. UNPACKING THE COLORFLARE

2.1 HOW TO UNPACK



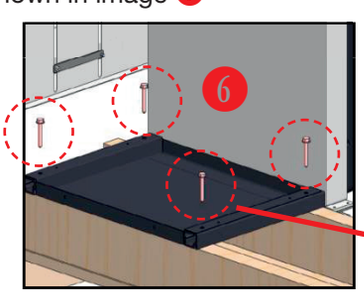
1. For rust prevention purpose, your ColorFlare CF1200 is vacuum packed with aluminium materials during packing. In addition the machine is additionally packed in wooden crate. Each wooden plate of the crate is fixed by screws to avoid external shock.

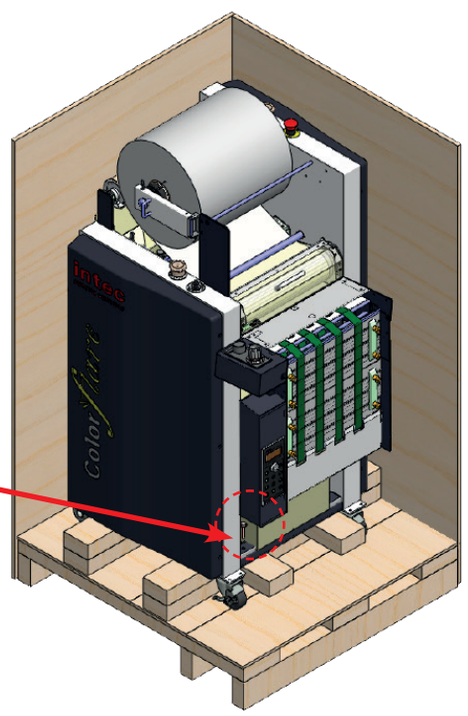
2. Wooden Crate can be opened by 11mm Box Spanner. As on the right picture, dismantle the crate and remove the vacuum packing to move it for installation.

3. After removing the Aluminium bag and the crate, please remove all other accessories before attempting to move the ColorFlare.

The ColorFlare is BOLTED through the base to the crate,.

4. You MUST remove the 4 transit bolts securing the base of the ColorFlare as shown in image 6





2.1.1 HOW TO MOVE

In the below situation, a forklift is required for moving.

1. If the ColorFlare is moved on the uneven surfaced ground.
2. If the ColorFlare has to be moved by 10m or longer distance.
3. If the packing is removed for moving.

Under the below circumstances, the use of casters is acceptable for moving.

1. If moving distance is shorter than 10m in the same place of installation.
2. At least 2 persons are required for moving. Push the corner of the machine gently & slowly.

WARNING :
The product is heavy, please be careful when moving the product to avoid injury to yourself or damage to the product.

2.2. PACKING CONTENTS

ITEMS	Q'TY(EA)	CF1200	CF1200L	CF1200LX
LAMINATOR	1	●	●	●
REAR OUTPUT TABLE	1	●	●	●
REAR OUTPUT GUIDE	2	●	●	●
AIR COMPRESSOR	1	●	●	●
AIR HOSE	1	●	●	●
GLASS TUBE FUSE (20mm) 250V/5.0A	2	●	●	●
GLASS TUBE FUSE (20mm) 250V/6.3A	2	●	●	●
5mm L WRENCH	1	●	●	●
USER MANUAL	1	●	●	●
FLARING IDLE ROLLER	1	●	●	●
PREMIUM FLARING ROLLER ASSEMBLY*	1	-	●	●
EXTENDED FEED TABLE *	1	-	●	●
ADDITIONAL ARM ASSEMBLY**	2	-	-	●
ADDITIONAL INPUT CORE HOLDER**	1	-	-	●

CF1200

CF1200LX

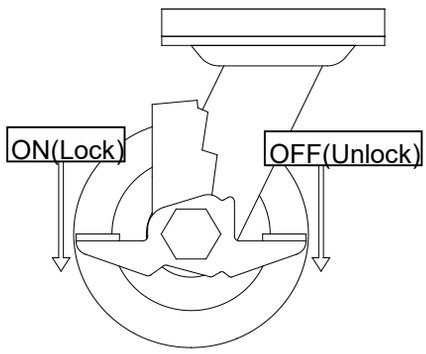
** The extended feed table and Premium Flaring roller assembly are an option on the mode CF1200, however, are supplied as standard on the CF1200L and CF1200LX models.*

*** The Additional Arm assembly and Additional Input Core holder is an option on the CF1200 and CF1200L models, and supplied as standard on the CF1200LX.*

2.3. INSTALLATION

2.3.1 Explanation of Caster Wheels

To move the machine over short distances.
Please be aware that the Caster has a locking device.
Thus, when moving, please release the caster lock.
To lock or unlock, press
"ON(Lock)" lever
or press
"OFF(Unlock)" lever.
After moving is done, press "ON" to fix the machine.



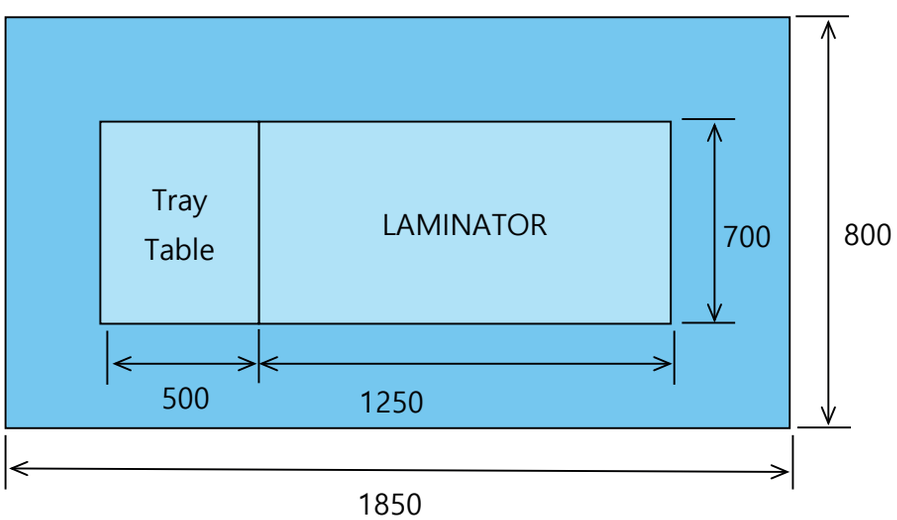
2.3.2 Positioning requirements

1. The ColorFlare should be installed on a hard & even surfaced ground.
2. If inflammables / ignition materials are nearby the product, this could be a cause of fire.
3. The Heated rollers emit heat in operation, please ensure the installation site has good ventilation.

2.3.3 Floor Plan

Dimension (WxLxH)	**700*1250*1340(mm)**
Working Space (WxL)	**800*1850(mm)**

* Installation Space is different from its working circumstance.



2.3.4 Power Connection

Power has to be at AC 220~240V/11A / Plug-in at Independent Outlet

WARNING : Grounding is required for safety. Otherwise, this could be a cause of malfunction or electric shock.

WARNING : Do not plug the product with the other devices at 1 outlet at the same time. Otherwise, this could be a cause of fire by overheat at outlet.

WARNING : Please follow the specification of power / voltage. Otherwise, this could cause a fire or electric shock.

WARNING : Insert the power plug firmly into the power connector, if the plug is lightly inserted then it may short in the connector and this can cause of fire due to overheating at outlet.

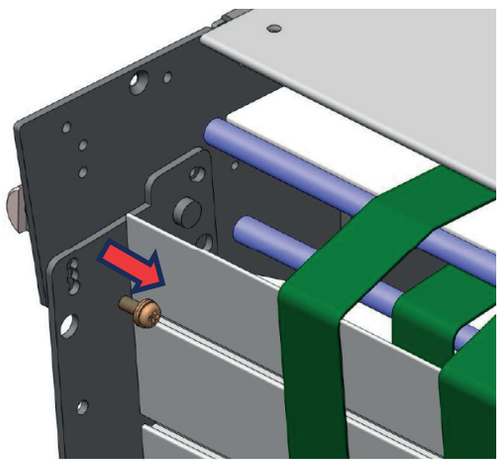
3.
ASSEMBLING THE COLORFLARE

3.1 ASSEMBLING THE FEED TABLE

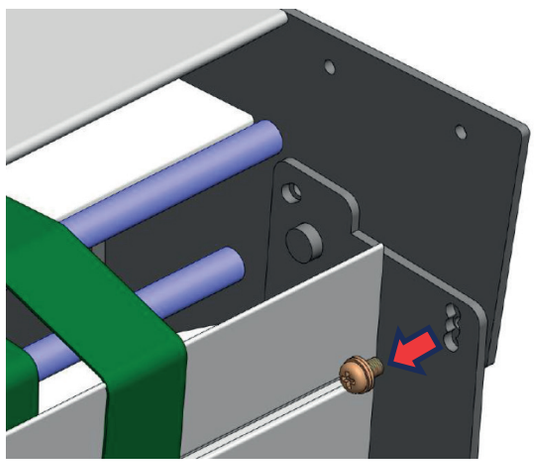
During transit the ColorFlare CF1200's feed table is folded vertically and locked into position using transit bolts. Upon installation you must remove the bolts, raise the table and lock the feed table into the horizontal position for daily use.

3.1.1 REMOVING THE TRANSIT SCREWS

1. Remove the M5 x 12 (Long Bolt) from the left frame (as shown).



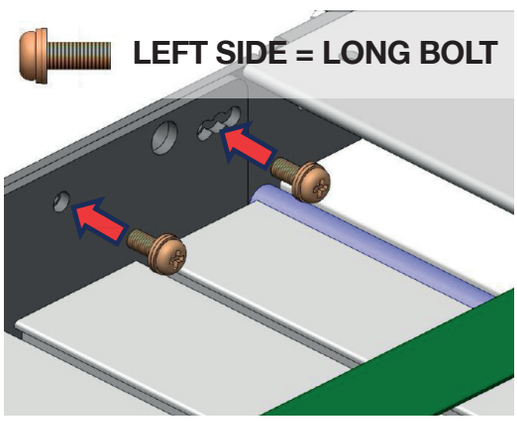
2. Remove the M5 x 8 (Short Bolt) from the right frame (as shown).

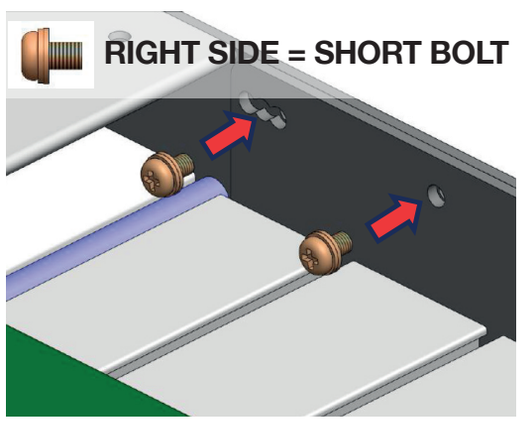


3.1.2 ASSEMBLING THE TABLE

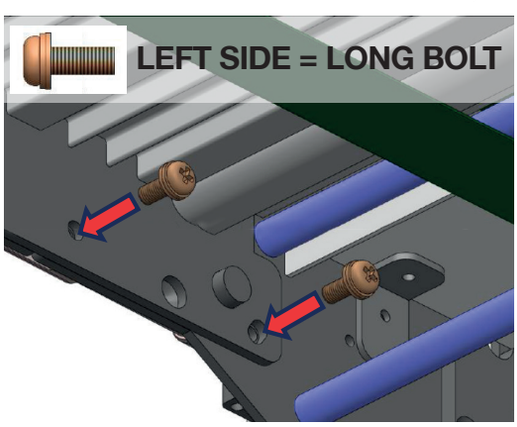
Once the bolts have been removed, unfold the table, raising it to the Horizontal position. The table must then be fixed into position.

Be sure to use the correct bolts for each side. The M5 x 12 (longer bolts) must go in the left frame positions as they locate against a micro-switch which enables operation. Failure to use the correct bolts may give an error and prevent operation.

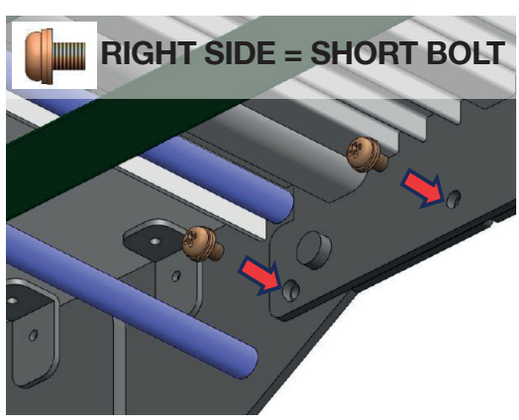




3. Using the M5 x 12 (Long Bolt) secure the left side of the table into position (2 locating holes above the table, 2 under the table)



2. Using the M5 x 12 (Short Bolt) secure the right side of the table into position (2 locating holes above the table, 2 under the table).



3.2 ADJUSTING THE FEED TABLE - ANGULAR ADJUSTMENT

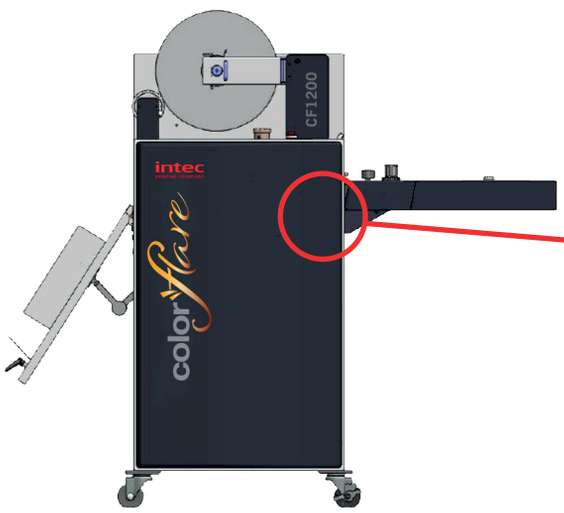
The ColorFlare CF1200's feed table has 3 distinct operating positions. The angle of the feed table is set at 5^{O} when the product is shipped from the factory, however if you wish you can change the default angle of the feed table. The available angles are 0^{O} (Completely Flat) , 5^{O} and 10^{O} incline.

The purpose of the incline is to improve paper feeding performance of the semi-automatic feed system.

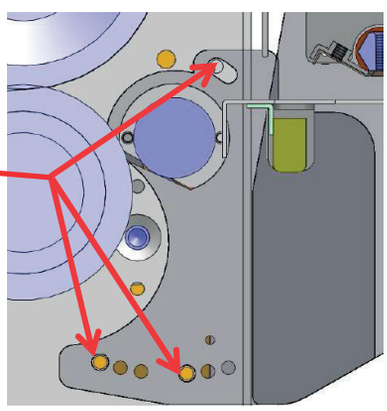
In most cases it does not need to be adjusted. However, if you wish to adjust the angle of the feed table, please follow the guide below to move the position of the angle fixing bolts.

The top bolt shown is under the Heated Roller Safety cover, you need to remove the cover to access the bolt, please ensure the unit is switched off and cooled before adjusting the table.

3.2.1 Table Angle 0^{O} (Flat)



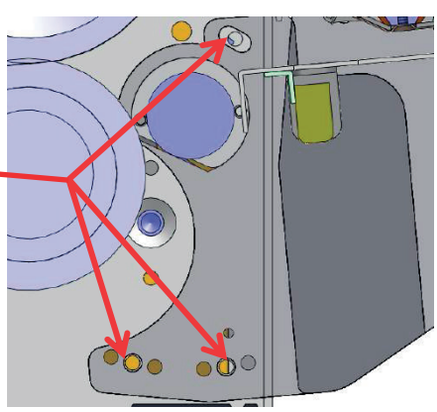
BOLT Positions
for table at 0^{O}



3.2.2 Table Angle 5^{O} (Slight Incline - Default)

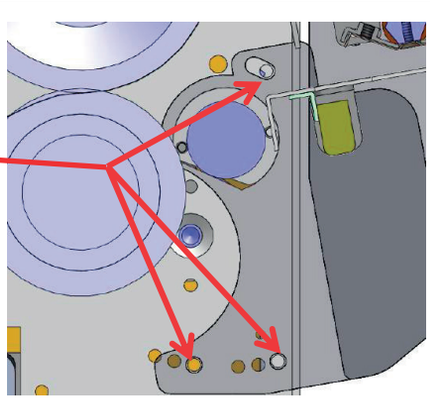
BOLT Positions
for table at 5^{O}

(This is the DEFAULT setting)



3.2.3 Table Angle 10^{O} (Inclined)

BOLT Positions
for table at 10^{O}



3.3 INSTALLING AND CONNECTING THE AIR COMPRESSOR

To laminate or foil, an even pressure is required in the NIP, between the heated mirror roller and the pressure roller. Many laminating and foiling systems use mechanical pressure or screw adjustment to deliver the pressure to bond your media to the laminating film, however mechanical pressure is less consistent and lower than pneumatic pressure. On mechanical laminators, the lower pressure means you have to work slower.

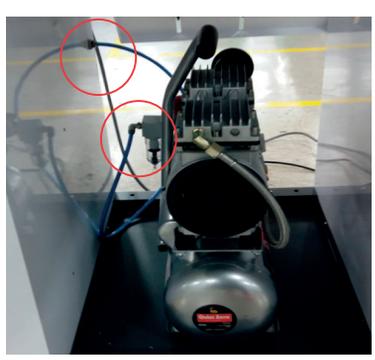
Your ColorFlare 1200 series machine uses pneumatic pressure. This provides many advantages over mechanical pressured systems including easier and faster set up, with much greater control. Pneumatic pressure delivers addition pressure of up to 10x greater than mechanical methods can achieve and this provides smoother results on a wider range of material and the added advantage of faster lamination or foiling.

Your ColorFlare CF1200, is supplied complete with a compressor which can be placed inside the frame. The compressed air is used in the ColorFlare CF1200 to activate the bursting roller , the pull roller and pressure on the heated mirror roller.

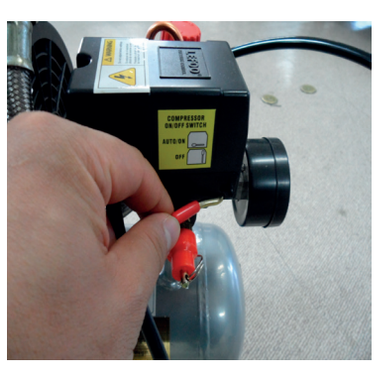
3.3.1 Connecting the air compressor

It is recommended to place the air compressor on the base, inside the frame of the ColorFlare.

1. Connect the supplied air hose to the air compressor and then connect the other end to the connector at the rear inside of the ColorFlare. (As shown right)



2. The Compressor has it's own independent power connector. So connect this to your mains power supply.



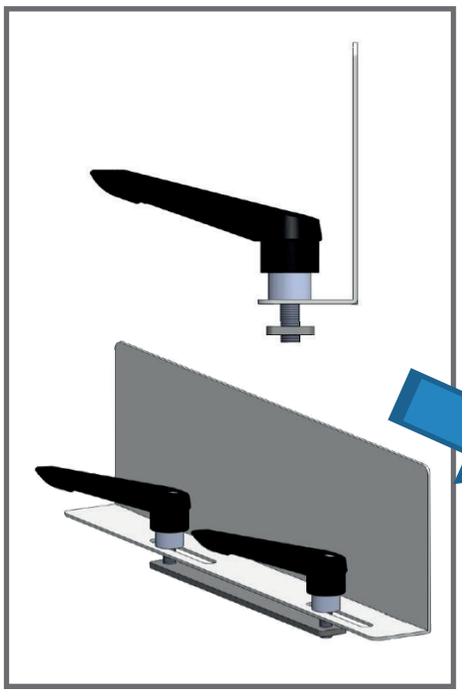
During operation condensation will naturally occur inside the compressor and a large amount of moisture (water) is produced. This is perfectly normal. However, to avoid the compressor from becoming damaged due to rust, and to ensure the filter remains dry, it is necessary to remove such moisture (water) at least, once a day.

Use the release valve after switching off the compressor to release any remaining air and moisture.

3.4 ASSEMBLING THE REAR OUTPUT TRAY

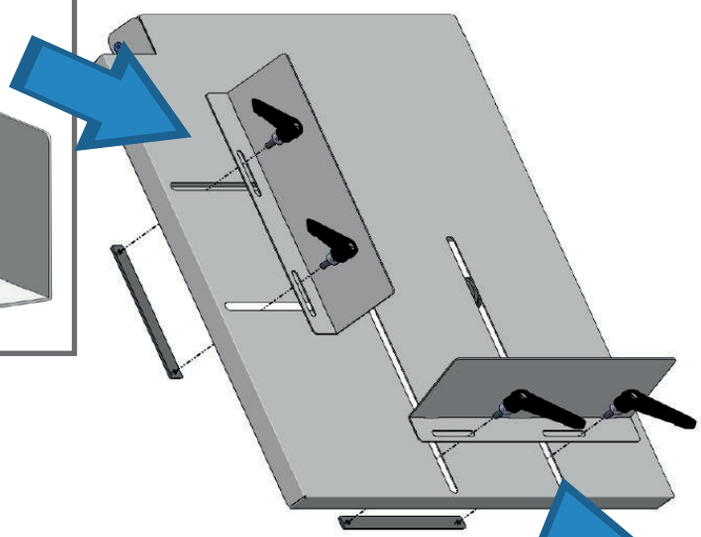
The REAR Output tray is design to catch your sheets after laminating or foiling. In transit the left and bottom guides are not installed. Remove these from the packing and fit them to the Output tray.

The Side guide, is vertical/ 90^{O} while the bottom guide is angled up to prevent the sheets bouncing or sliding over the guide. Please ensure to fit the correct angled guide in the correct position.



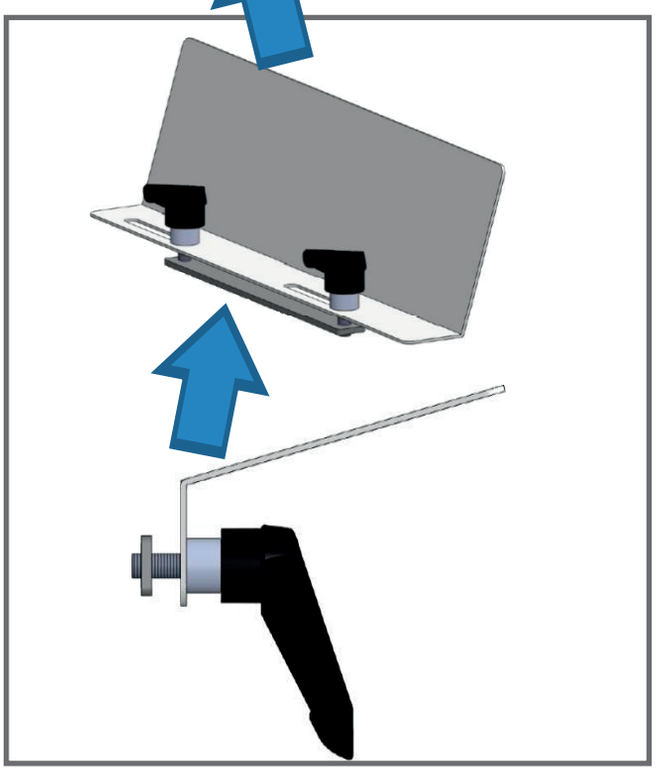
3.4.1 LEFT 90^{O} Side Guide

1. The solid retaining bar is positioned behind the output tray. The Hand levers are fitted from the top of the output tray and pass through the bracket, through the slots in the output tray and fix into the bar you positioned behind the tray. (As shown left)



3.4.2 BOTTOM Guide

2. Ensure you use the bracket that is inclined towards the output tray, as this prevents sheets sliding down over the guide.
As with the assembly of the side bracket, the solid retaining bar is positioned behind the output tray. The Hand levers are fitted from the top of the output tray and pass through the bracket, through the slots in the output tray and fix into the bar you positioned behind the tray. (As shown right)



3.5 OPENING & FOLDING the Output Tray Table

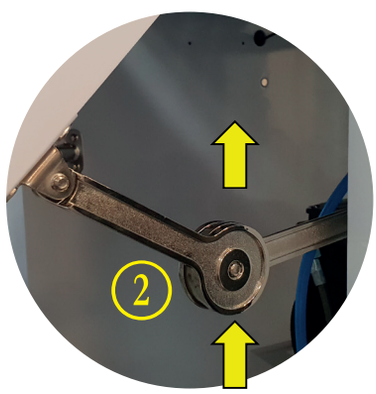
The output tray table is a folding table to save space when the ColorFlare is not in use. The table is designed for easy handling and to stack the output.

The output tray has a steep decline to help prevent sheets with static properties to stack as well as possible. Please ensure the tray is aligned as shown in the following diagrams below.

3.5.1 Locking the tray UP in operating position

1. Ensure the guides are placed at an angle to enable the media is stacked neatly. Then pull the Output tray up, holding part ①

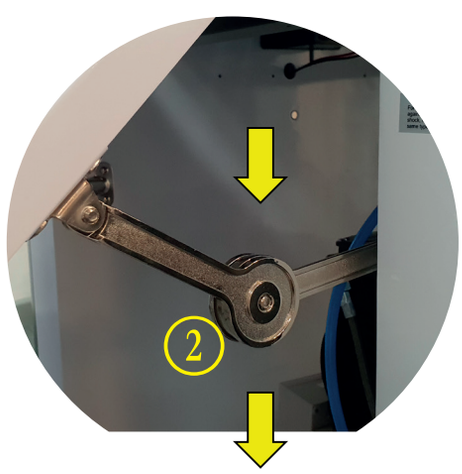
2. Push up the centre of the Ratchet ② hinge on both sides, while holding the output tray



3.5.2 Folding the tray DOWN when not in use

3. When you wish to fold away the table Simply hold the table again lightly at the bottom at point ①.

4. Push down on the ratchet at point ②.



5. Push the output table tray down.

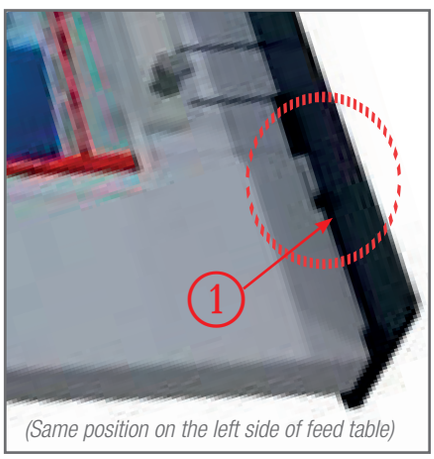
3.6 ATTACHING THE EXTENSION FEEDING TABLE (*CF1200L/LX)

The extension feed table is designed to enable volume users of lamination or foiling to more conveniently feed their media, providing a space for a stack of media that can be manually shuffled into the semi automated feed system or to accept longer format sizes up to 1200mm in length.

The extension feed table is an option on the ColorFlare CF1000, but supplied as standard with the ColorFlare CF1000L and CF1000LX.

3.6.1 Position of Locating Pins

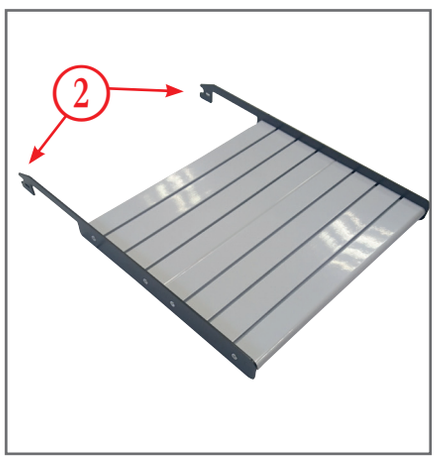
1. Locate the recess at the end of the Feed table on the edges as shown (1). The extension tables' connecting points will insert here.



(Same position on the left side of feed table)

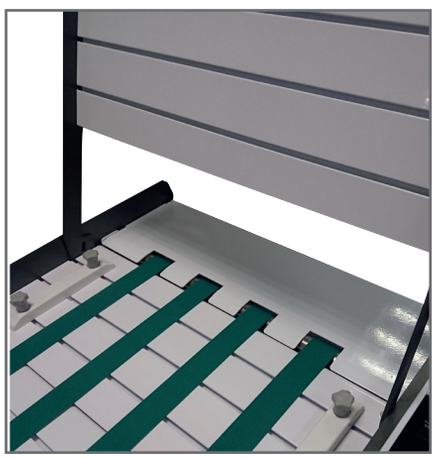
3.6.2 Extension Table brackets

2. Locate the corresponding connection points on the end of the extension table (2) that will be inserted in to the feed table in step (1)



3.6.3 Fitting Extension Table

3. Holding the extension table at 90° to the feed table, insert the extension table locating points

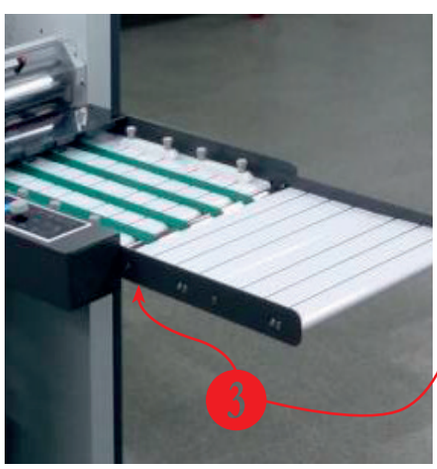


3.6.4 Pivot extension table down

4. Pivot/lower the extension table down to the horizontal position.

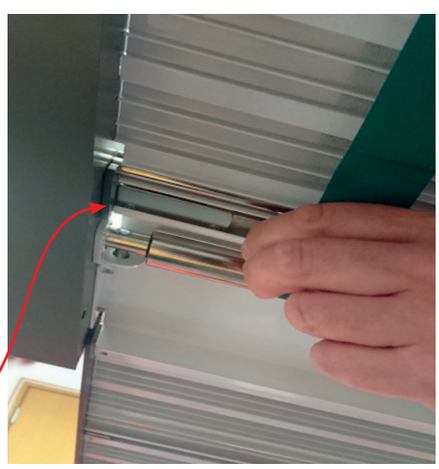
3.6.5 Table Fitted

5. With the extension table lowered. Look under the table to engage the Safety catch.(3)



3.6.6 Lock table in place

6. Engage the safety lock under the table into the left frame, to secure the extension table into place. (3)



Please ensure you engage the safety lock under the extension table. This prevents the table from being dislodged and potentially falling off if the ColorFlare is knocked into.

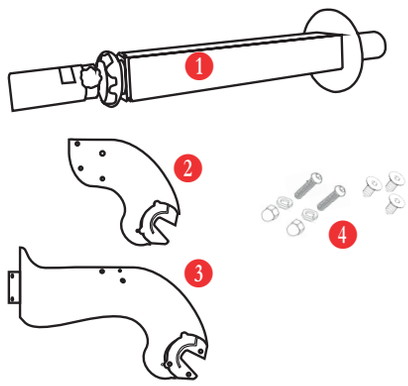
3.7 ATTACHING SECOND ROLLER ASSEMBLY (*CF1200LX)

3.7.1 Unpacking Items

1. Unpack the Second Arm assembly kit. There should be three packages and a pack of fixings.

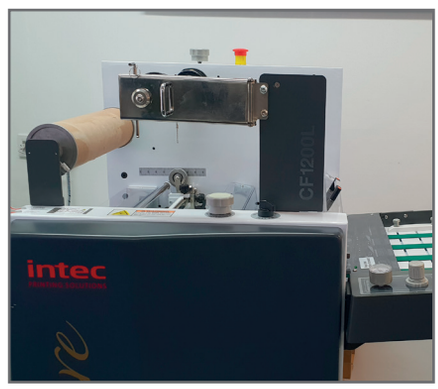
3.7.2 Package Contents

2. You should have a Roller assembly 1, a Small Arm 2, a Large Arm 3 and a pack of fixings 4.



3.7.3 Items to remove

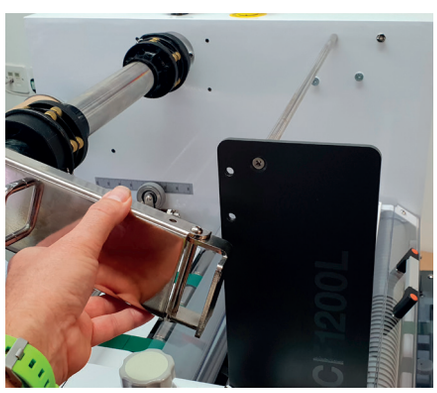
3. Remove the side panel, in order to fit the Small Arm and replace the side panel with the new Large Arm.



3.7.4 Remove Shaft Support Bracket

4. Unscrew the two bolts that secure the Shaft Support Bracket.

5. Temporarily remove the Shaft Support bracket, but keep it safe as you will need to replace it later.



6. It should look like this, at this point.

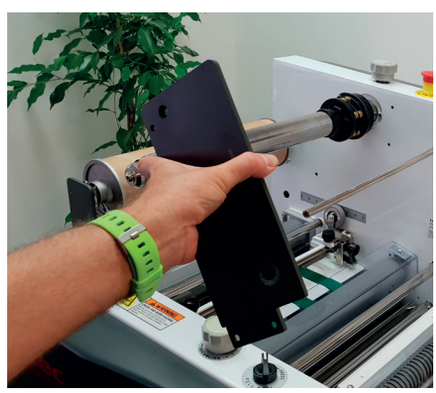
3.7.5 Support shaft screw

7. Remove the outer screw for the support bar.

3.7.6 Remove lower fixing bolts & take off Side plate

8. Remove the two lower fixing bolts on the inside of the side panel.

9. Now remove the side panel.



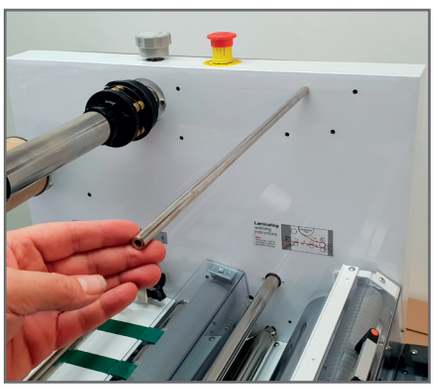
3.7 ATTACHING SECOND ROLLER ASSEMBLY (Cont.)

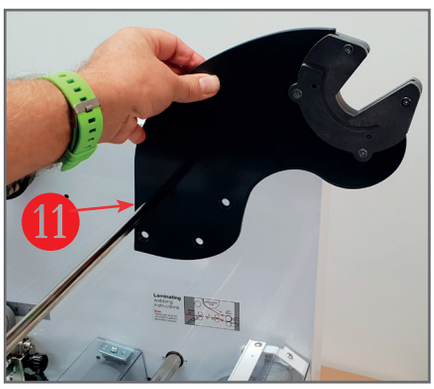
3.7.7 Install Small Arm onto Support Shaft

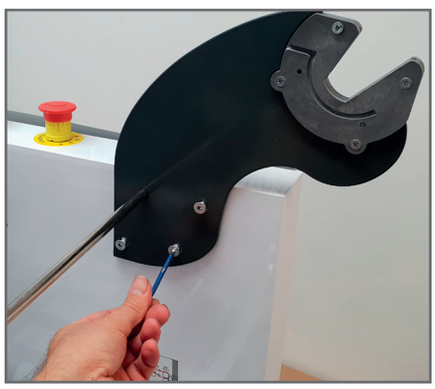
10. Locate the end of the support bar. You will use this to locate the Small Arm Bracket.

11. Slide the small arm down over the support bar using the hole shown in the small arm bracket.

12. Using the supplied 3 countersunk bolts, fix the small arm in position.





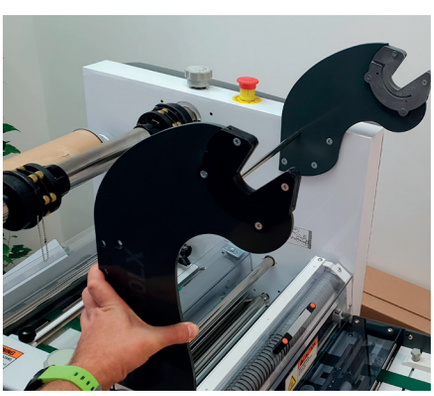


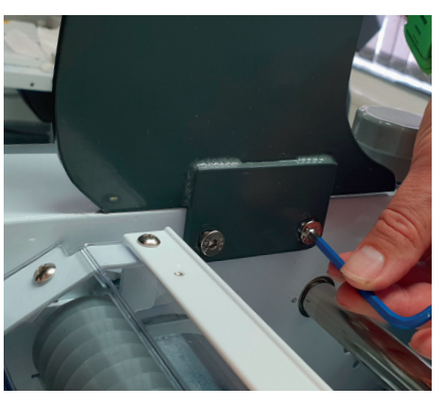
3.7.8 Install Large Arm

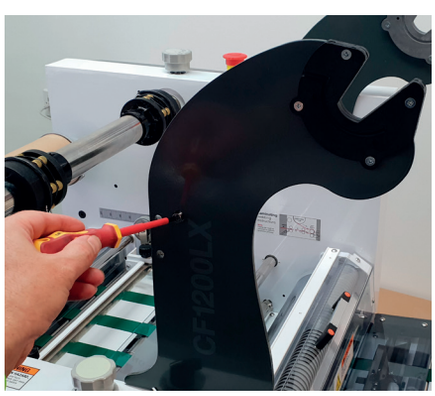
13. Refit the Large Arm supplied in the kit, to replace the side panel that was removed.

14. Fix the lower bolts, to secure the large arm in place

15. Fix the support bar, using the cross head screw.



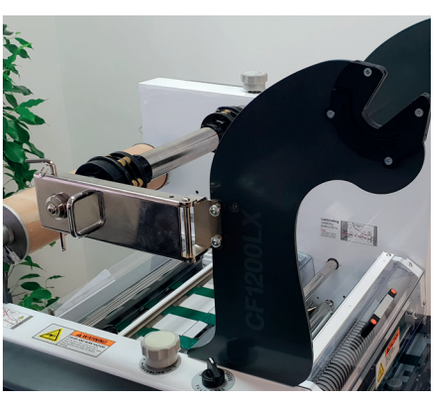


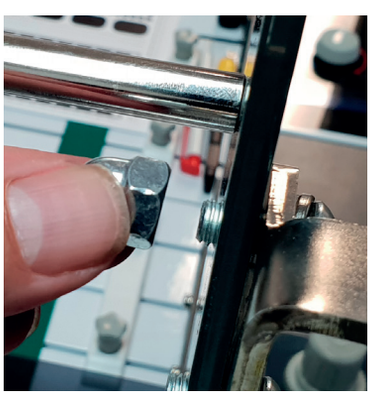


3.7.9 Attach Shaft Support Bracket

16. Attach the Shaft Support Bracket, using the longer screws supplied in the accessories pack

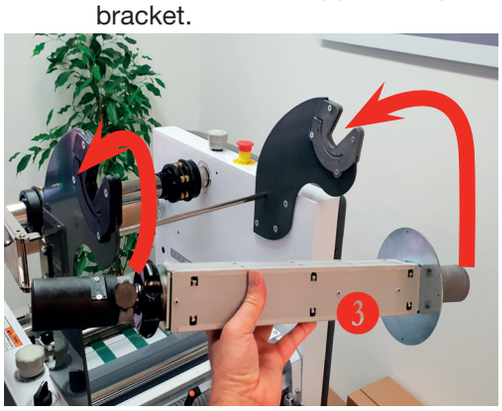
17. Attach the Cap Nuts to the rear of the Shaft Support bracket botls.





3.7.10 Install second Roller

18. Finally fit the second arm, by matching the color of the handles on either side, to the color of the Support cups/ bracket.



3.8 EXPLANATION OF WARNING NOTICES

For your safety, the below stickers are attached. Please follow the warning to avoid injury during operation.

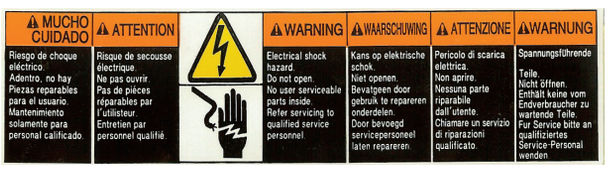
Roller caution

Roller's higher temperature and pressure can damage your body

Higher Temperature

Do not touch the heated roller with your hand as you could be burnt.

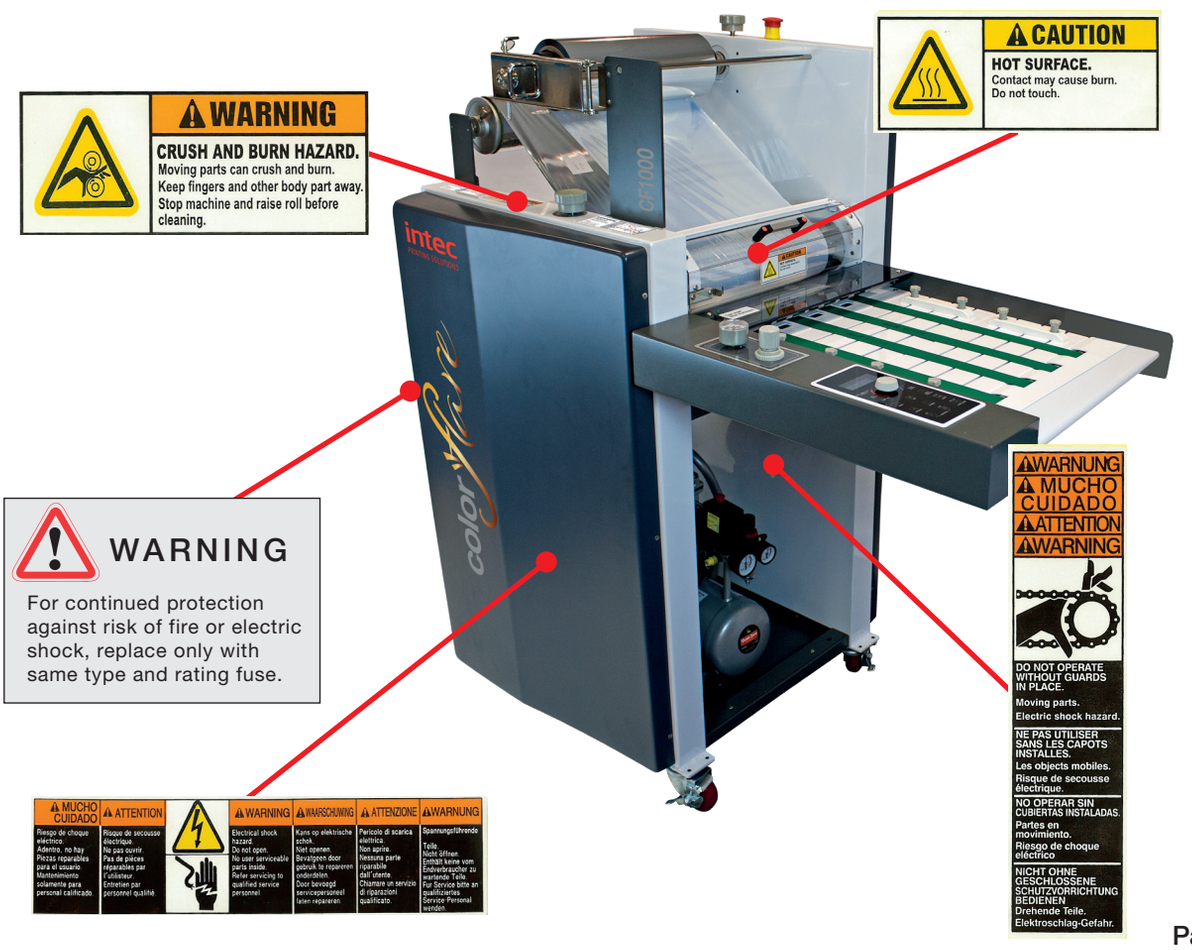
Electricity Caution



Inside the machine, high voltage flows,
Do not open the outer case
You can suffer injury or sudden death with electricity shock

Chain Caution

Avoid placing your hand in or on the chain.
You can suffer an injury

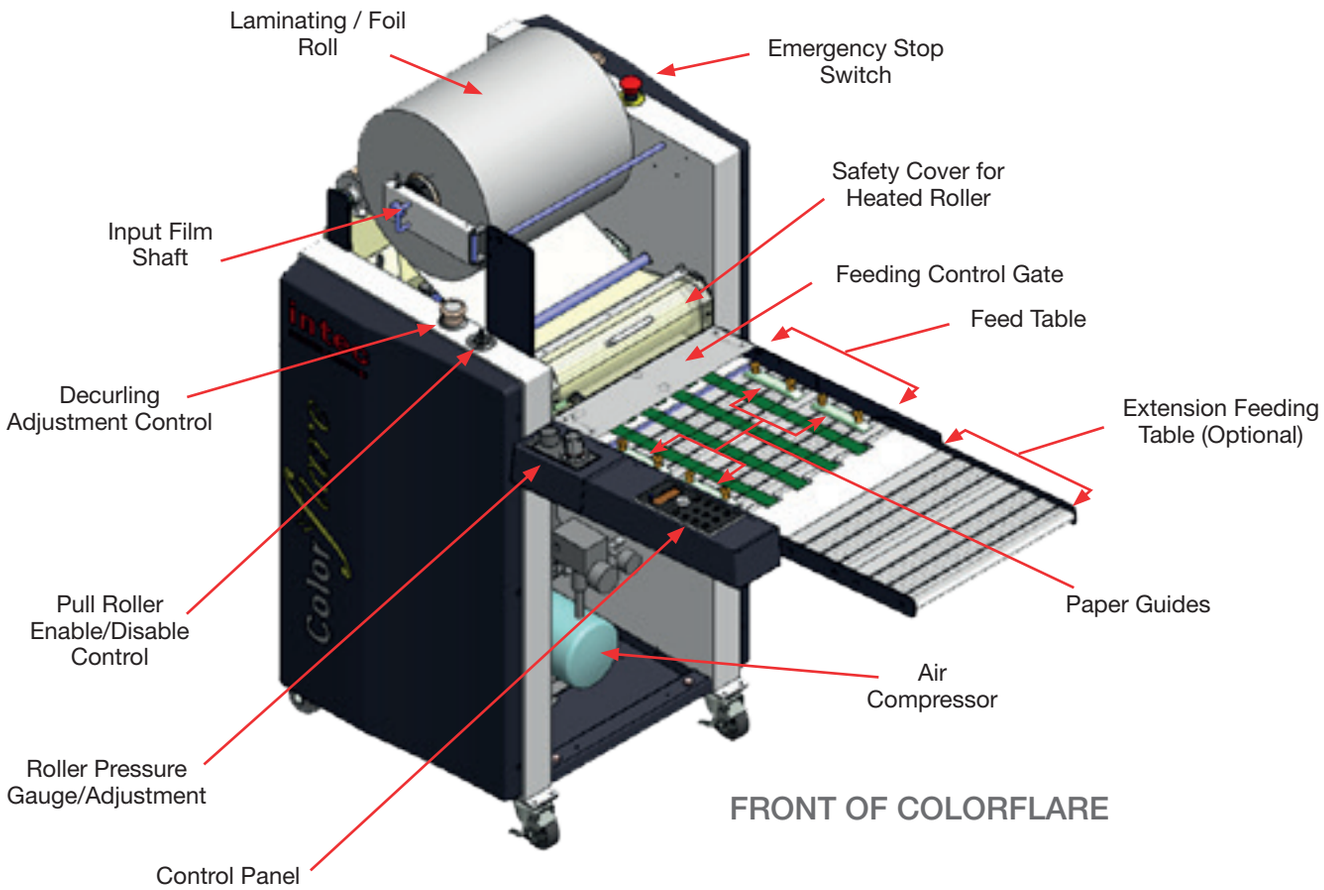


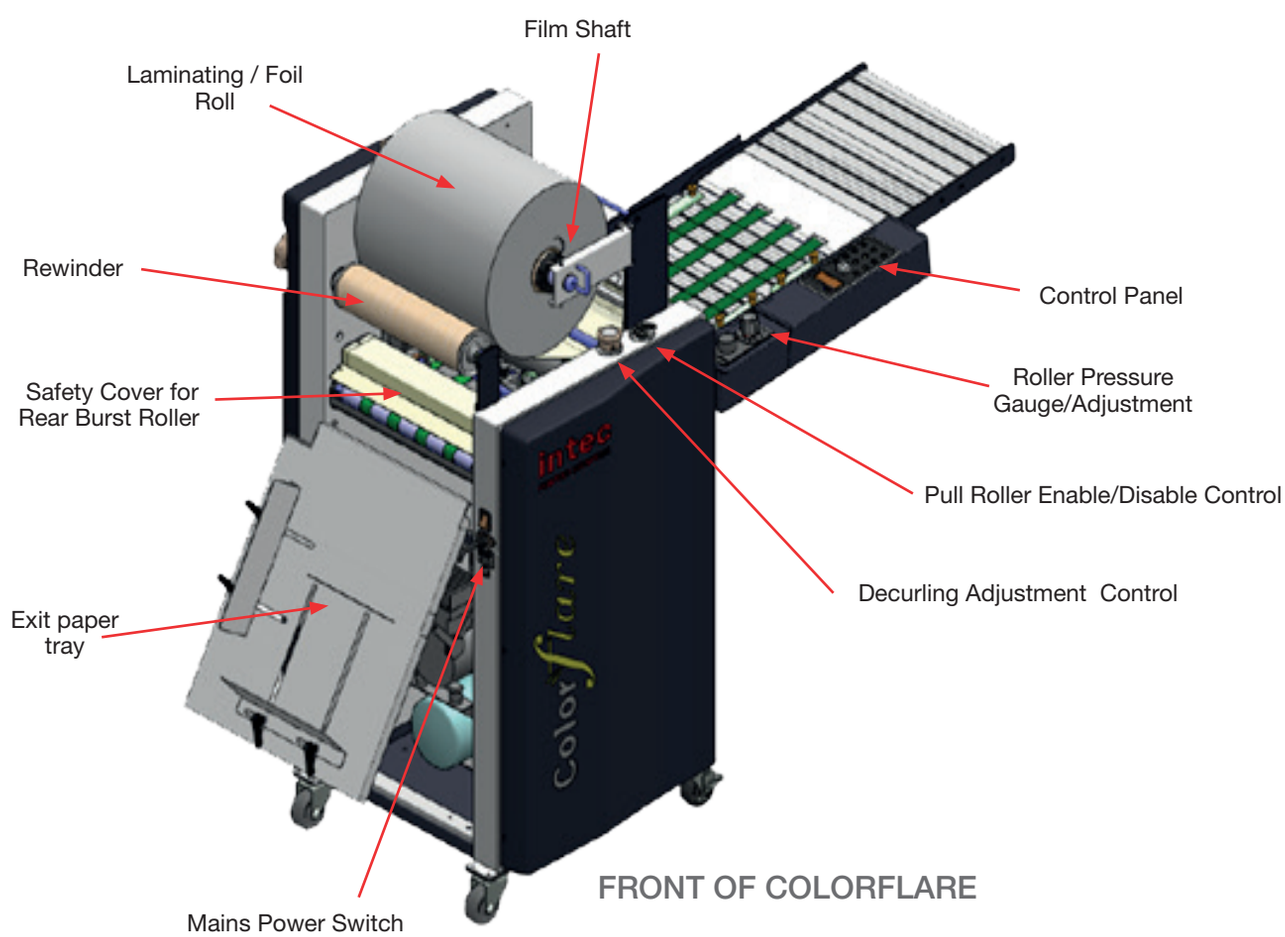
WARNING

For continued protection against risk of fire or electric shock, replace only with same type and rating fuse.

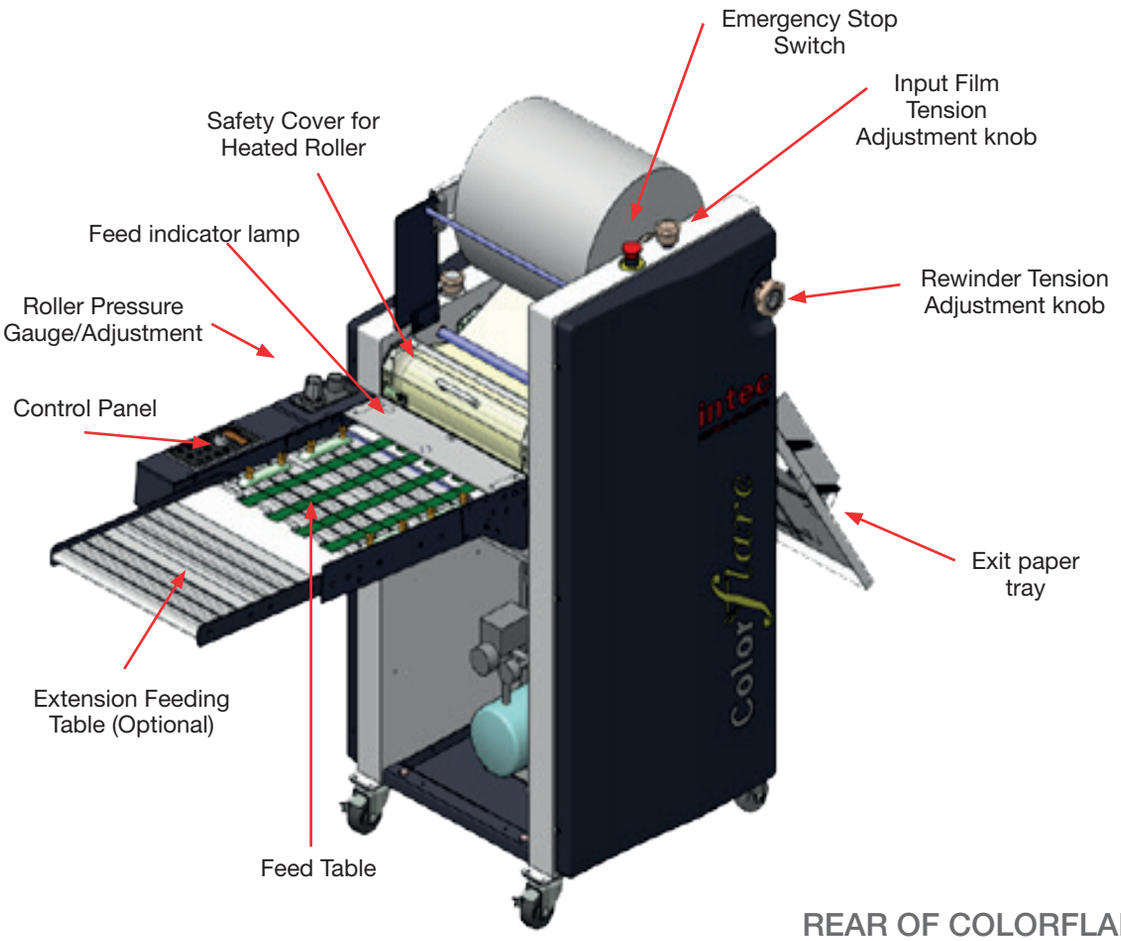
4. OVERVIEW OF CONTROLS & FEATURES

4.1 LOCATING CONTROLS & FEATURES

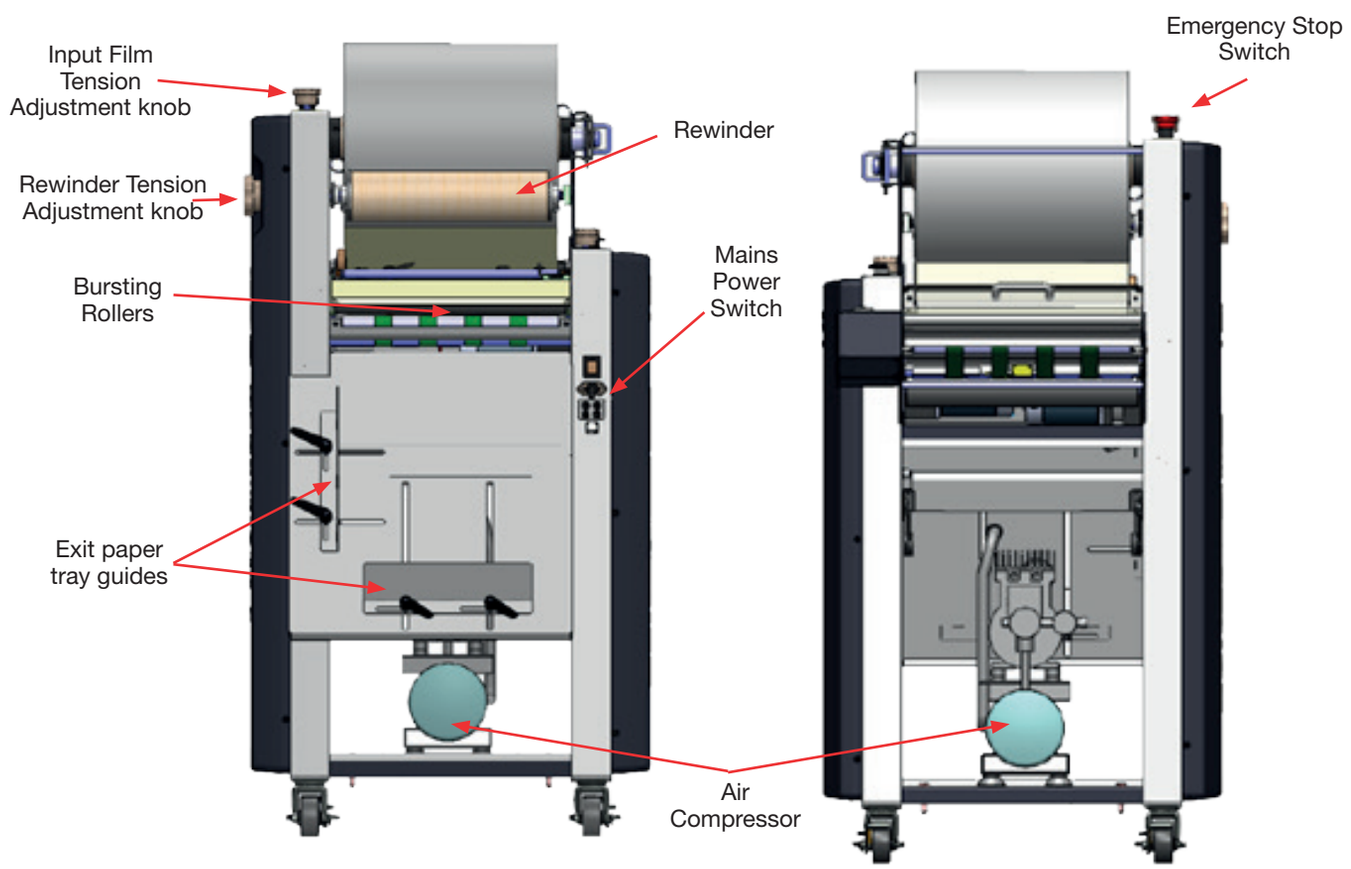




LOCATING CONTROLS & FEATURES (Cont).



REAR OF COLORFLARE



REAR OF COLORFLARE

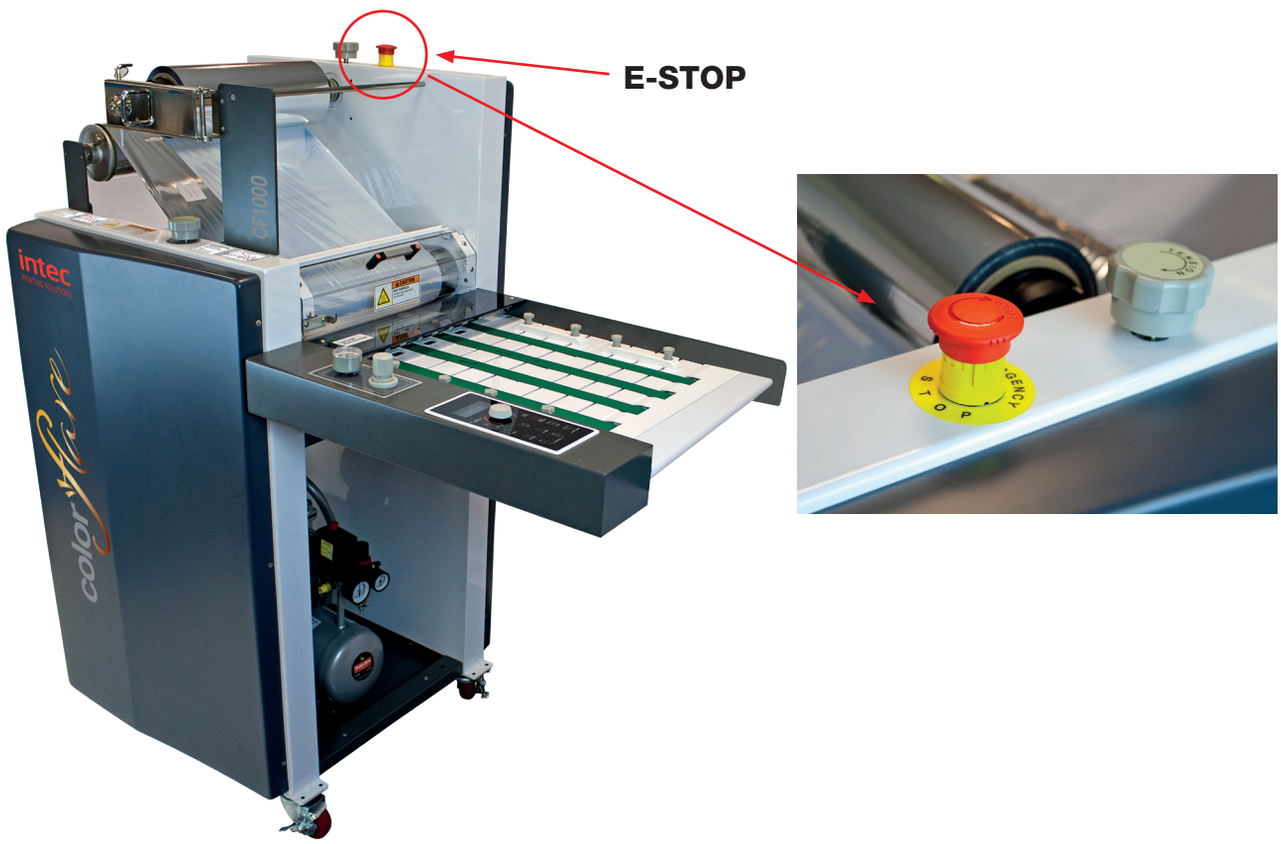
FRONT OF COLORFLARE

4.1 SAFETY FEATURES

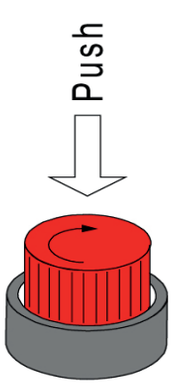
4.1.1 Emergency Stop Switch (E-STOP S/W)

The emergency Stop Switch should be pressed in an emergency situation. Pressing the E-STOP switch, stops the motor(rollers) rotation, halts any feeding or system operation.

Position of E-Stop Switch

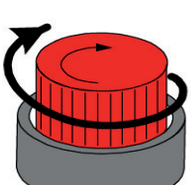


How to use



Press the Red button to operate the Emergency Stop Switch.
The entire system stops when this is pressed.

Turn the switch to the right to release from Emergency Status.



4.2 MAIN CONTROLS

4.2.1 Power Switch

Mains Power Switch

The mains power, is controlled by the Power Switch in the rear of the machine, next to power cord inlet and the exit tray.

Press the Switch to the “I” position, the Power is ON and to the “O” direction to Power OFF.

4.2.2 Pressure Adjustment Control

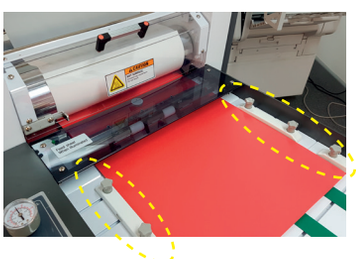
This controls the pressure on main Laminating Roller.

The pressure can be adjusted by turning the Pressure Control dial. The pressure delivered on the rollers is displayed on the pressure gauge above the pressure control dial.

To adjust the pressure, pull the Pressure Control dial up. Turn it to the right to increase its pressure and turn it to the left to decrease the pressure. After the adjustment is completed, press the pressure control dial to finish the adjustment.

NOTE : Different films or different media types require different pressures. The recommended max. pressure is less than 0.6MP.

4.2.3 Paper Guides



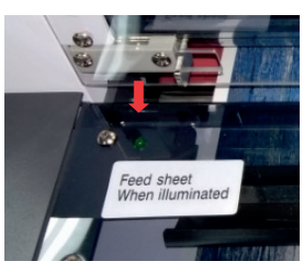
The paper guides are used to feed the media straight and should be adjusted to match your media width.

After the position has been adjusted, secure the guides by tightening the fixing knobs on the paper guides.

For accurate feeding, media alignment is an important factor.

If the guides are too tight against the media, the semi-automated feeding system may not advance the media smoothly and you could end up with a mis-feed error where the machine will stop as the paper has not advanced effectively. Thus, please ensure while the guides are aligned correctly, allowing your media to be able to slide easily without binding on the paper guides.

4.2.4 Feed Indicator Lamp



The feed indicator lamp illuminates to let the operator know when to put the next sheet of media that your wish to laminate or flare (Foil/spot film) on to the feeder. belts When the lamp is ON put the printed media on the feeder table. The feeder calculates the distance of media automatically. The timing of the light is set from the “length” as shown on the LCD panel so it is important to set this correctly.

After the initial sheet has been loaded, the feeder gate/shutter will close, the green light will illuminate showing the user can load the sheet.

The belts on the feeder will advance your next sheet up to the gate/shutter.

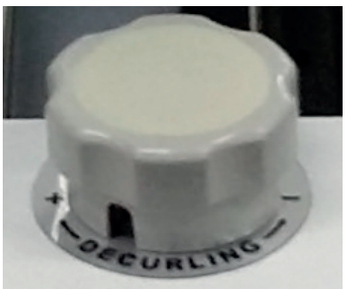
The feeder uses the closed ‘gate’/ shutter to hold the next sheet until it is within 25mm (1 Inch) of the the trail edge of the preceding sheet. At this point the green light will go off (and you should not add another sheet), and the gate/shutter will then open.

The next sheet will then be advanced forwards and at the appropriate overlap it will automatically be advanced into the machine.

Once the feeder starts advancing the media into the machine the gate will close and the light will illuminate to show the next sheet can be loaded. Always check the Feed indicator to determine the feed status.

“LAMP ON” : Feeder is ready for you to place next sheet. (Media placed on Feeder is fed up to the outer gate.)
“LAMP OFF” : Feeder is already feeding. (Media is inside Feeder gate for feeding, don’t add another sheet yet.)

4.2.5 Decurling adjustment control

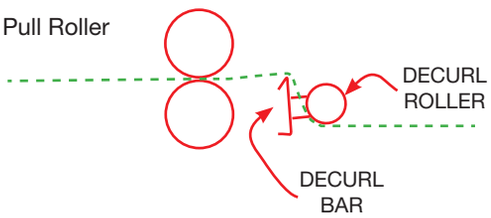


It is normal thing to have curled laminated results after applying lamination. This is not caused by a fault in the machine.

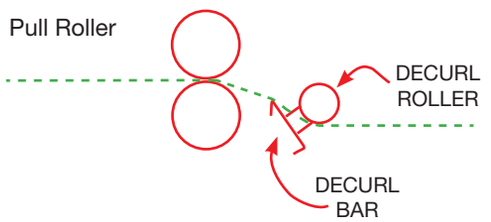
The decurling feature is provided to reduce or where possible eliminate curling on the Laminated sheets after single side lamination.
Adjust the decurling bar by using the decurl control as shown in the following Pictures.

Rotate the de-curing control to the Right to increase the decurling Value and rotate it to the left to decrease it.

When your media is Curled up at the ends as shown above, you need to increase the decurl. rotate the decurl control Clockwise.



When media is Curled down at the ends as shown above, you have applied too much decurl. Decrease the decurl by rotating the decurl control anticlockwise.



THE AMOUNT OF DECURL CAN VARY DEPENDING UPON MEDIA THICKNESS AND TYPE. YOU WILL NEED TO ADJUST THIS CONTROL TO MAINTAIN THE FLATTEST SHEETS POSSIBLE.

TOP TIP

IF the tension on the Laminate Film roller (4.2.6) is too high, then as the laminate cools then the sheet will also curl. Too high tension can not be compensated for, by decurl. So ensure you have not set too much tension on the film before setting the decurl.

4.2.6 Film Tension adjustment knob

The Film tension adjustment knob, is used to adjust film tension on the Input film roller. You may need to adjust the lamination or flaring film tension to remove wrinkle of film at the rollers.

Turn the knob to the right to increase its tension and turn it left to decrease its tension.

Note: Be-careful not to apply too much tension, as It is possible that excessive tension on laminating film will cause your media to curl up at the ends, beyond the natural effect that the decurl feature can compensate for.

FILM TENSION ADJUSTMENT KNOB

REWINDER TENSION ADJUSTMENT KNOB

4.2.7 Rewinder tension adjustment knob

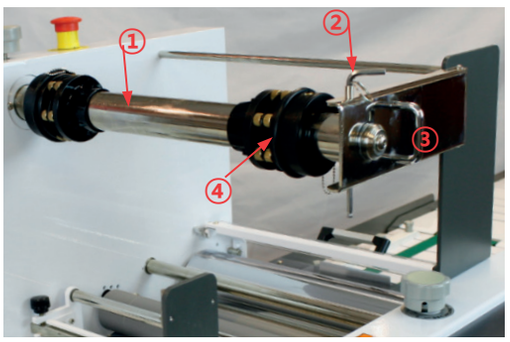
This is used to adjust the tension of film on the rewinder.

Use this handle when film tension is too loose or too tight

When turning Film Tension Control handle to the right, film tension increases and turning to the left, it reduces.

4.3 INPUT FILM ROLL HOLDER

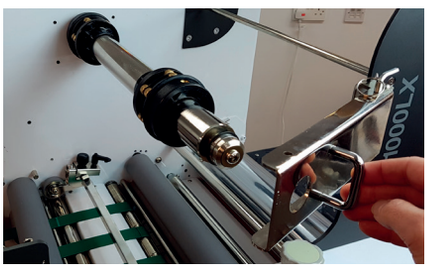
4.3.1 Overview of Film Supply Roller System



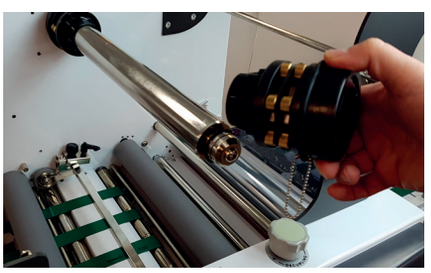
1. Film Shaft : Roll Film is loaded onto this shaft.
2. Film Shaft Holder Fixing Pin : A locking pin to avoid the hinged Film Shaft Holder opening during operation.
3. Film Shaft Holder : Holds the end of the Film Shaft to reduce vertical movement of Film Shaft under operation.
4. Film Core Adaptor: Used for adapting the Laminating or Flaring Roll Film cores to mount on the Film Shaft.

4.3.2 How to load laminating or flaring film rolls

1. Remove the Film Shaft Holder Fixing Pin and open the film shaft holder.



2. Remove the outer film core adaptor with film core fixing pin



3. Load a film roll (refer to the right picture)

4. Insert the Film Core Adaptor into film core and close the film shaft holder.

Then, re-place the film shaft holder fixing pin.

5. Position film Roll (mounted on Film core adaptors) in central area of the Film Shaft, and tighten up the fixing bolt on the end of each Film Core adaptor to prevent the film core from moving.

If you have the second arm assembly (CF1200LX) and do not need to change the width of the Film Code adaptors on the shaft, then once you have set up the Film Core you can change laminating films by removing and replacing the RUBBER RING. (But as Laminating Rolls and Foils are different widths, users who don't have the second arm assembly, will need to adjust the Core shaft between roll changes)

4.3.3 Film width

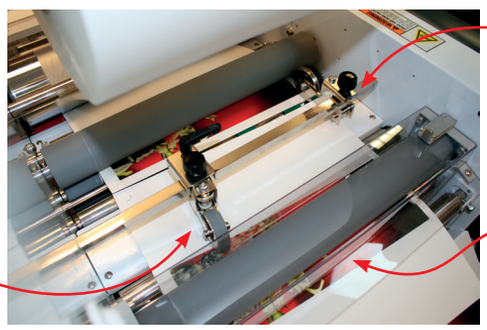
For single or double sided lamination the media you plan to laminate should be wider than the lamination film width by 5~10mm. Otherwise the lower pressure roller can be contaminated / damaged by the adhesive glue from the laminating Film.

4.4 CUTTING SYSTEM FOR LAMINATED SHEETS

4.4.1 Overview of Burst Separation System

Typical lamination systems, leave all the sheets attached in strips for the entire length of the run, after laminating you are required to separate the sheets manually. However, the ColorFlare simplifies laminating sheets by automatically separating your sheets and providing a clean edge on your sheets for subsequent use either in your digital printer or on your guillotine. The separated sheets are then output into a stack on the exit table.

When laminating the ColorFlare uses a BURST separation system to separate your sheets. This consists of a perforation wheel to weaken the side of the lamination film, then a skewing wheel to twist and start to break apart the sheets. Then the sheets are completely separated using pneumatic power in a burst action performed by the rear feed (burst) rollers. This section identifies each part, its installation and function.

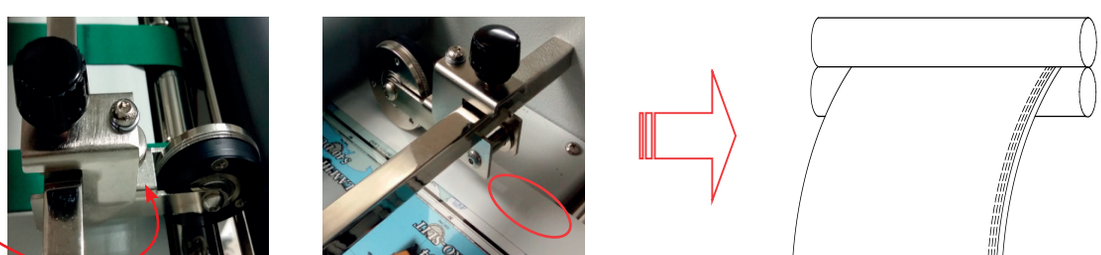


4.4.2 Perforator

To cut the laminated output easily, the perforator makes small holes on the edge of the laminating film after application to your substrate (This is typically outside the finished sheet size, so does not affect your finished result) .

Position the Perforating wheel along the edge of your sheets, approx 1~3mm on the inside.
To make clear holes on films, adjust the perforator Pressure adjustment bolt.

Perforator Pressure Adjustment Bolt



CAUTION : During the initial loading status, if you need to move the perforator, please ensure you loosen the perforator pressure adjustment bolt. If this is not done, the perforating, blade or roller could be damaged.

4.4.3 Skewing Wheel

The Skewing wheel is used during laminating, to aid sheet separation. The skewing wheel helps cut the laminated sheets to avoid “torn film” during the cutting process.
As shown in the picture (right), during operation the laminated sheets develop a light wave as a result of the skewing wheel this is normal and helps sheet separation

IMPORTANT : If skewing wheel is not adjusted correctly, it could leave marks on the laminated sheets, or may create a wave on the sheet before the skewing wheel that becomes too large, and can cause jams.

More detailed instructions are provided in section 6.4 (HOW TO LAMINATE/ USING THE BURST FUNCTION)

4.5 REWINDER SYSTEM FOR FOILS AND HOLOGRAPHIC FILMS

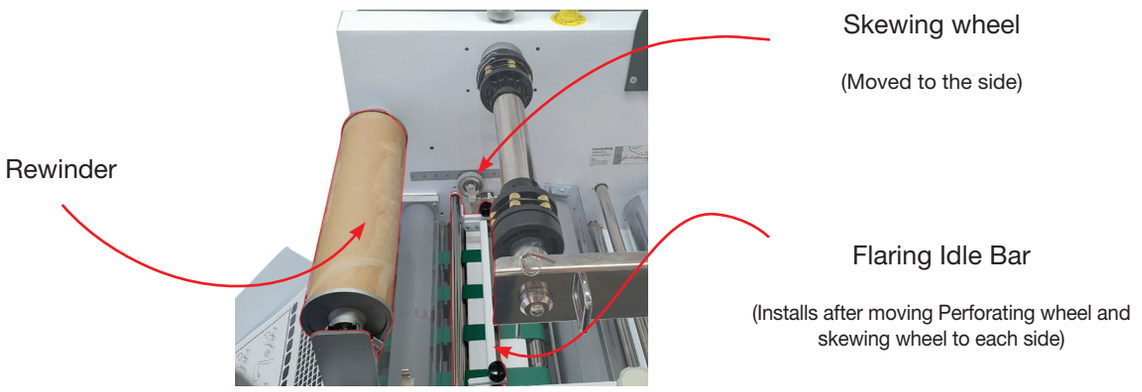
4.5.1 Overview of Rewinder System

Most laminating systems only laminate, however the ColorFlare is a dual purpose machine that can both Laminate AND apply decorative metallic foil effects or Holographic effects, even spot gloss films.

Foils are complex materials with a number of layers. In principle though there is a CARRIER layer (also known as the release layer), a low level bonding agent and then a coloured metallic material with a metallic base.

When foiling the toner acts like a glue, adhering to and removing the metallic coloured material and metallic base from the CARRIER (release layer), once this has happened you need to rewind the CARRIER layer (release layer) along with any unused foil.

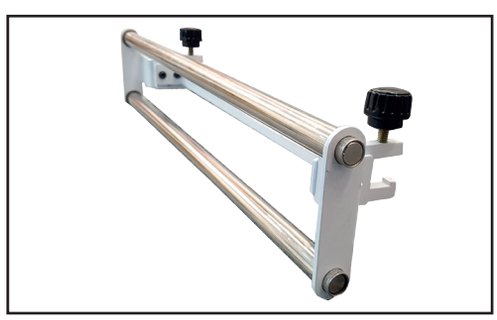
This section identifies each part, its installation and it's function.



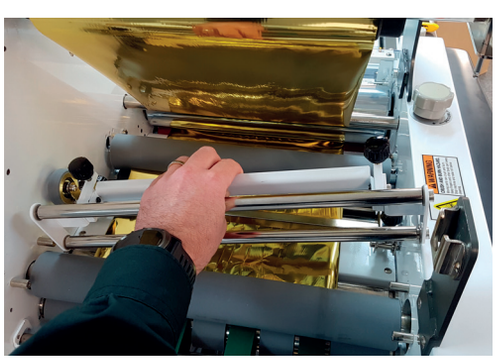
4.5.2 Flaring Idle Bar

To install the Idle Bar Flaring film, please follow the guide below.

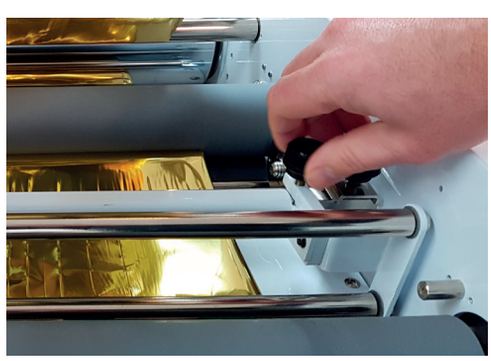
1. Loosen the Perforating wheel and slide it to the side then loosen the Skewing wheel, move that to the opposite side then rotate it 90^{O} to the vertical and tighten it.



2. Locate the flaring idle bar.



3. Install the Flaring Idle bar in between the two tools. NOTE: the Skewing wheel MUST be fixed in the vertical position.



4. Please ensure that you tighten the two black thumb screws at either end of the flaring Idle bar.

More detailed instructions are provided in section 7.2 (HOW TO USE DECORATIVE FLARING EFFECTS)

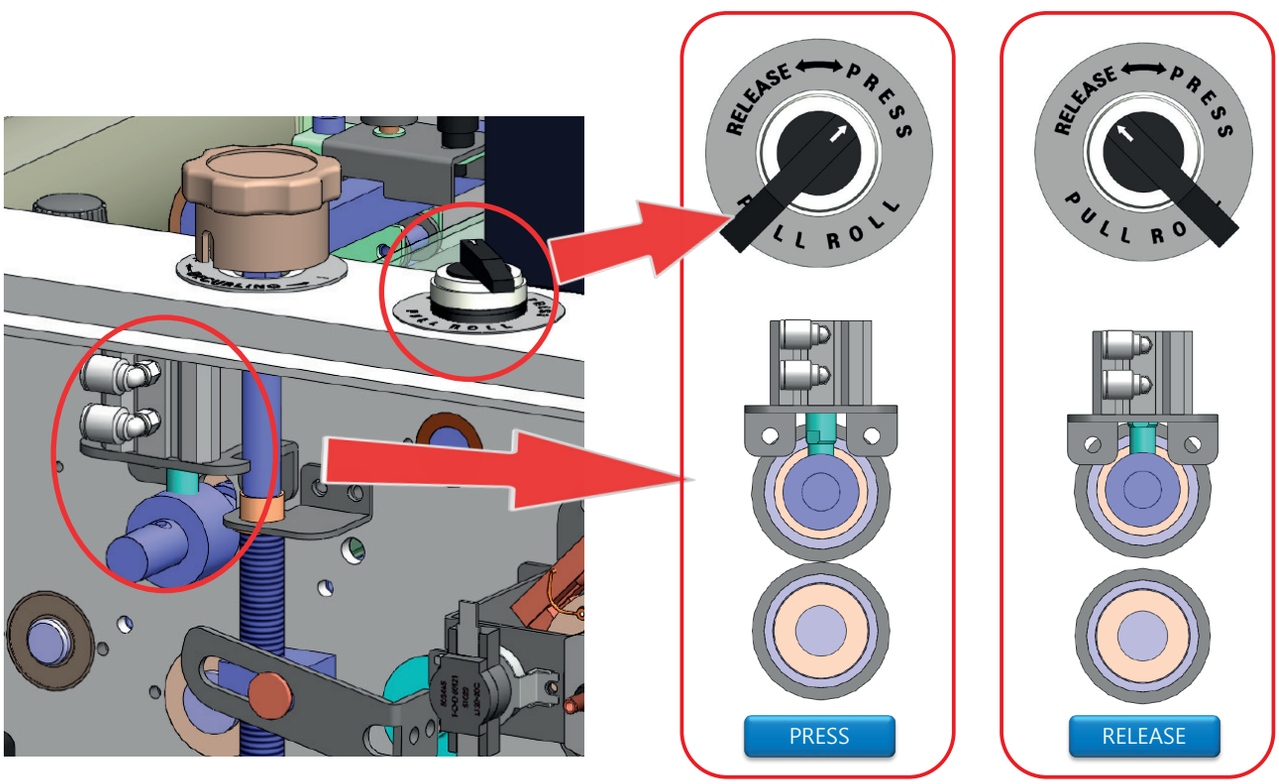
4.5.3 The Pull Roller Control

The Pull Roller is situated in the ColorFlare just after the decurling bar. During laminating it pulls the sheets through the ColorFlare towards the Burst Separation system. This is important for laminated sheets because unlike foils and Holographic films, there is no rewinder being used. (All the laminated film stays on the sheet, whereas with foils and films ONLY the image area is transferred to the sheet, the rest is rewound on the rewinder. This function can be left engaged for foiling most media.

However, for foiling the widest range of materials, it may be necessary to apply some additional heat, but if the foil is 'pulled' from the sheet prior to the toner cooling, then the Image may also be pulled from the sheet and remain on the foil carrier. Therefore, the Intec ColorFlare CF1200 includes a new feature enabling users to disengage the pull roller when foiling.

Due to the fact that the transit of the sheets through the machine is assisted by the foil or the film which is being re-wound, users can use this control to disengage the PULL roller to prevent the pull roller from prematurely pulling the foil from the media sheet and ensuring the highest quality results from foiling.

in the diagram below you can see how switching the PULL roller control to release, releases the pressure applied by the PULL roller, and prevents it from pulling at the foil.



When LAMINATING, the PULL Roller MUST be engaged (Switched to PRESS) . Failure to ensure this is set, will result in the sheets and lamination film being wrapped around the heated mirror roller and the machine operation being halted.

TOP TIP

When foiling you can leave the PULL roller engaged, however if you RELEASE the Pull roller, it will help improve your results with more difficult substrates.

IMPORTANT: **You must always START your foiling production with the pull roller engaged (Set to PRESS),** then as your initial sheet travels PAST the PULL roller, you can disengage the roller. If you start with the roller already released it may not pull the sheets through initially.

4.6 PREMIUM FLARING BAR (CF1200L/LX only)

4.6.1 Overview of Premium Flaring Bar

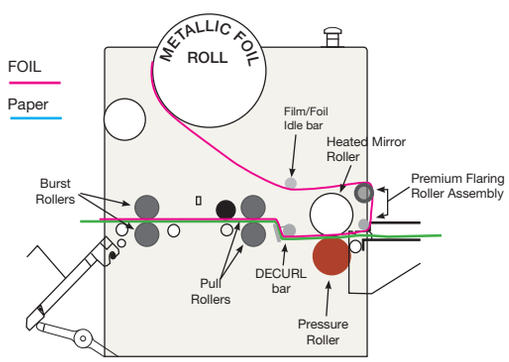
The Premium flaring bar is only used for foiling. The reason for this is that Laminate contains a heat sensitive glue which requires heat to become active and stick to the substrate. The longer dwell time the laminate has on the heated roller the more evenly heated and melted the glue is. Therefore laminators have large circumference heated rollers.

HOWEVER, foils are a metallic backed substrate, containing no glue; they do not require the heat from the roller. The heat from the roller is used to heat the toner on the media, not the foil. Foils, due to their metallic base are susceptible to expansion from heating, and typically aluminium can expand 1mm for each metre at 10C heat increase. As you typically foil at 110C to activate the toner, the foil can see a heat increase of 70C, and therefore can exhibit expansion of 7mm per metre. Typically the tension control is used to try to minimise the effect and reduce the risk of wrinkles. However from time to time you may still see wrinkles or the foil may contract on the media as it cools and the finish is not as smooth.

4.6.2 Advantages of Premium Flaring Roller

The Premium Flaring roller enables the foil to be elevated over the heated roller as opposed to being in contact with it. The Silicon baffles work to smooth the foil and the secondary roller enables the foil to come into contact with the media immediately before the nip of the heating roller, therefore minimising contact with the heated roller and expansion. The result is almost no tension at all is required on the foil, and the foil is perfectly smooth. This improves the smoothness of the prints, they don't suffer from cooling contractions and reduces the wear on your machine.

PREMIUM FLARING ROLLER WEB

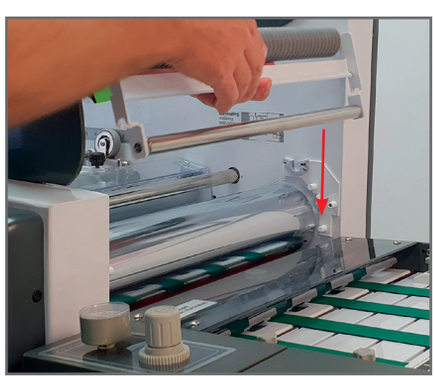


4.6.3 Fitting the Premium Flaring Roller

1. Remove the Hot Roller Safety cover ①.

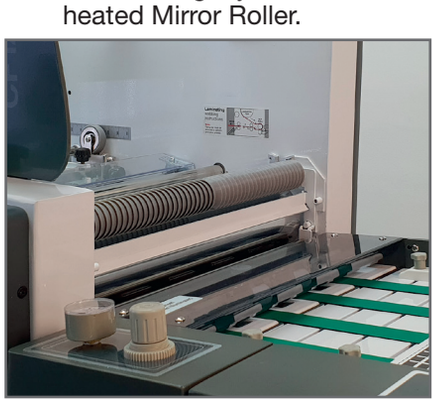
2. Locate the Premium Flaring Bar (Silicon Roller facing up) and ensure the Locating lugs face to the rear. ②

3. Slide the Premium Flaring bar into the brackets on the ColorFlare.



4. Remember the Locating Lugs are rear facing.

5. The Premium Flaring Roller should locate on the rear lugs and be slightly infront of the heated Mirror Roller.



6. Replace the Front Safety Cover, and remember to engage the safety lock.

4.7 The Additional Roller Assembly for Flaring (CF1200LX)

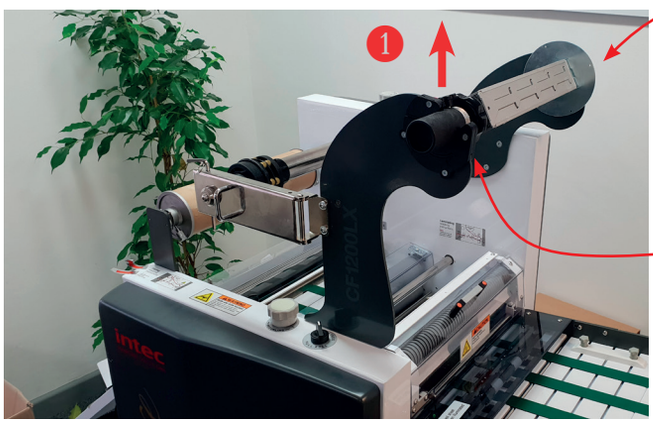
Using the additional Roller/Arm enables you to leave the Laminate Roll loaded on the main input shaft and then load Flaring Foils or Films (Spot or Holographic) on this additional 2nd Roller assembly. There is a significant advantage to doing this as Laminate Rolls tend to be different sizes to Flaring Foils or Films so not having to remove the Laminate Roll reduces change-over time and setting up time dramatically.

The Additional Arm assembly uses a different type of Input Roller, It is much easier to remove to make changing Foils, faster and easier.

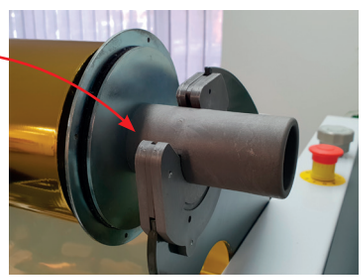
TOP TIP

The Handles of the Input shaft have 2 different Colors, the cups/brackets that the Input Roller sits in are Color Coded to match. When fitting the shaft ensure the Grey handle goes into the Grey cup/brackets on the side of the machine furthest from the control panel, and the Black Handle goes into the Black Cups/Bracket on the side nearest the Operator/Control Panel.

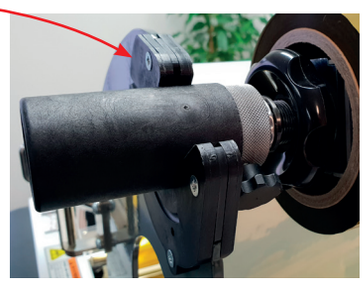
Please find below an overview of the Second Arm / Input Roller Assembly:



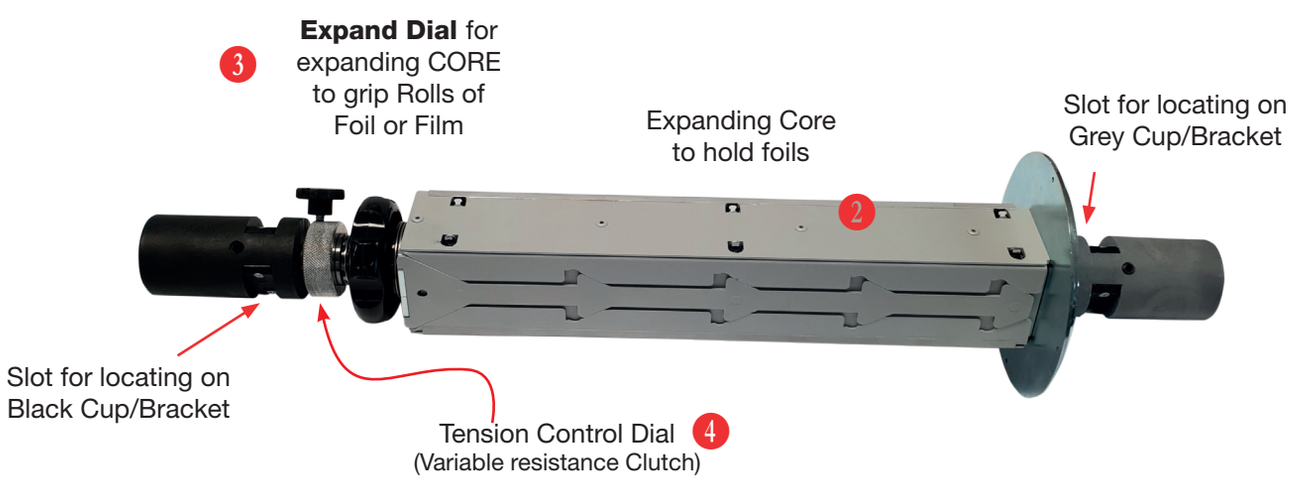
Grey Cup /Bracket



Black Cup / Bracket.



❶ The additional Arm/Input Spool holder, has an easy remove system, simply lift the Roller assembly out of the brackets.



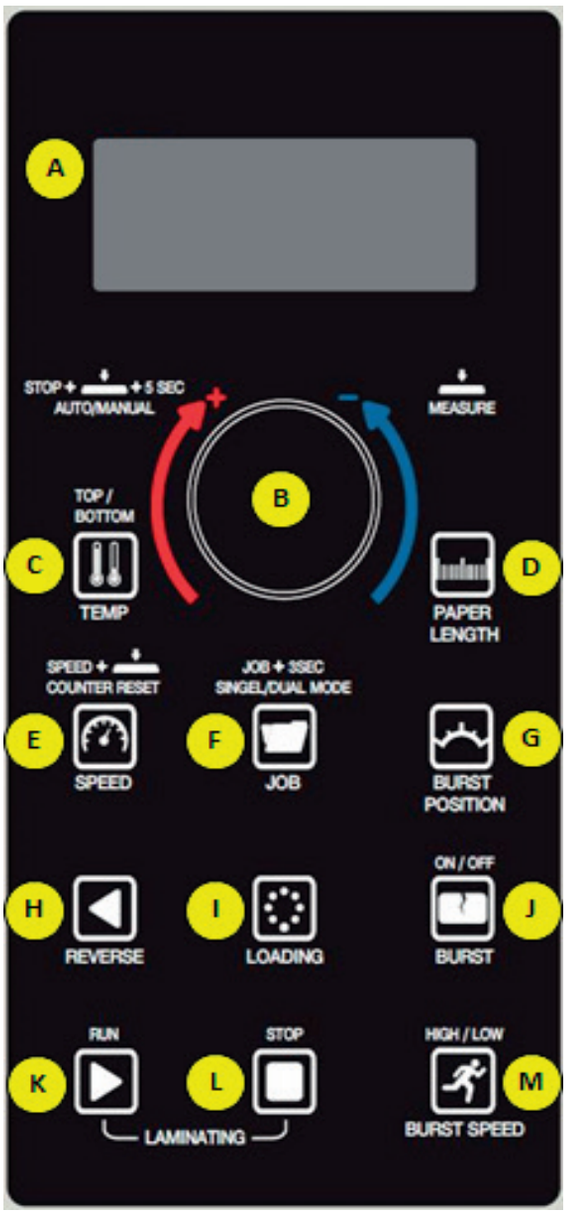
The Expanding CORE ❷ will increase in width to grip any Foil or FILM ROLL you slide on. Simply Turn the EXPAND DIAL ❸ clockwise to make the CORE expand and when removing a roll, turn the expand Dial anti-Clockwise to make the inner CORE reduce in size and release the GRIP of the ROLL.

When Loading Foils or Film, tension can be controlled by using the Variable resistance Clutch; simply turn the Tension Control Dial ❹.

5.

EXPLANATION of the CONTROL PANEL

5. OVERVIEW OF CONTROL PANEL DISPLAY



A. “LCD”(Display)
Displays the current settings and values on the ColorFlare. The display only shows when the Power is ON.
Refer to the “Explanation of Display” to understand each display or button function.

B. “MASTER DIAL”
The dial to adjust values of Roller Temp.(C), Paper Length(D), Laminating Speed(E), Job Mode(F), Bursting Point(G), etc.

How to use of MASTER DIAL

1. Press the button corresponding to the item you wish to adjust the value. (i.e Speed or Paper length).
2. Then turn “MASTER DIAL” to the left or right to set the required value.

Turn “MASTER DIAL” to right to increase the value and turn it to left to decrease the value.

Other Functions of MASTER DIAL

1. Briefly press the “MASTER DIAL”, while the dial is pressed, the current temp. is displayed.
2. Press SPEED button and MASTER DIAL at the same time to reset the COUNTER.

C. “TEMP”(Button to set up the Roller Temp. :
Press the Temp button to set up the Roller Temp. The setting range is “0 ~ 150”.
When the “TEMP” button is active, the button will be illuminated “ON” and you can use the “MASTER DIAL” (as above) to set a required (Target) temperature.
The value you select is saved automatically after 5 secs.

D. “PAPER LENGTH”(Button to set up Paper Length) :

Press the Paper Length button to activate (and it will illuminate to show it is active), and set the length of your substrate.
Length set up range is “203 ~ 1,219”mm.

How to set up Substrate Length :

Press “PAPER LENGTH” button and while it is illuminated, set the required length using the MASTER DIAL.

Setting value is saved after 5 secs. automatically.

The ColorFlare’s cutting system is set to use a 3mm overlap on your paper size by default. Please refer to the section “Adjusting the overlap“ later in this manual for how to change the overlap.

5. OVERVIEW OF CONTROL PANEL DISPLAY (Cont.)

E. “SPEED” (Speed Setting Button)

Press the Speed button to set up the Laminating or Foiling Speed. The setting range is “0 ~ 10”.
When the “SPEED” button is pressed it will become active and the button will be illuminated “ON”. Use the “MASTER DIAL” to set a required (Target) Speed.
The value you select is saved automatically after 5 secs.

After a stop, the Start Speed restarts at speed “3”. The speed can not be adjusted while the machine is not running. Only during operation, can the speed be controlled.

F. “JOB” (JOB Mode selection button)

Press the JOB button to save or recall regularly used job conditions from the ColorFlare’s memory to avoid needing to manual set the Job conditions future.
When the “JOB” button is pressed it will become active and the button will be illuminated “ON”. Use the “MASTER DIAL” to set a required JOB to recall.
When making changes to Paper Length, or Temperature, those changes are saved (overwrite the current values) to the Job mode automatically after 5 secs.

Job mode is composed of 13 kinds (Poly-L~User3) See section 5.1.2 following.

IMPORTANT : RESET to Factory Setting
As any change in the Job mode (i.e. Temp or paper length) overides the job mode, it is possible to reset your ColorFlare to factory default settings. To do this, set the JOB mode to “Poly-L” and press the“TEMP” button and “STOP” button at the same time. The display will show “Factory Setting Progress Waiting” blinking for approx 15 secs. This will reset the factory Job settings.

G. “BURST POSITION” (Burst Position Setting Button)

Press the BURST POSITION button to set up the operating position of the Bursting Roller. The setting range is “360 ~ 530mm”.
When the “BURST POSITION” button is pressed it will become active and the button will be illuminated “ON”. Use the “MASTER DIAL” to set a required (Target) Burst Position.
The value you select is saved automatically after 5 secs.

Normally the Burst Position does not need to be changed, however the characteristics of some materials / thickness, height of decurling bar, or laminating speed could require a change to ensure successful bursting/separation of your sheets.

H. “REV”(Button to Reverse Rotation of Roller) :

Press the REV button, to reverse the rotation of the roller. While the “REV” button is pressed, the roller is rotated reversely in roller engaged status, which means it will feed the media backwards and can help with removing some media jams. When the button is released reverse rotation stops and rollers are disengaged.

During the normal machine operation (RUN MODE), the function is not available.

I. “LOADING”(Button for Film loading and restarting from a misfeed) :

When the “LOADING” button is pressed, the rollers rotate to advance media forwards and the feeder gate opens for feeding. Use the LOADING button to raise advance media when loading a roll of media, also after you misfeed.

After a misfed, press the LOADING button to lift the feeding gate which enables you to insert one sheet of media upto the Heated Laminating roller, then release the LOADING button and place one sheet of media up to the feeding gate - ready to restart feeding.

J. “BURST”(Button used to operate/activate the BURST function)

Press the BURST button, to activate the BURSTING /separation function. When the “BURST” button is pressed it will become active and the button will be illuminated “ON”. While the BURST button is illuminated, the ColorFlare will burst separate the sheets at the position defined by the Burst Position setting. To Deactivate Burst, either press the BURST button again so the light is not illuminated, or stop the run.

The BURST function can only be activated while the ColorFlare is running. It cannot be activated in stop mode.

K. “RUN” (START button, Operation button)

Press the RUN button, to start/operate the ColorFlare. When the “RUN” button is pressed it will become active and the button will be illuminated “ON”. While the RUN button is illuminated, the ColorFlare will run the motors, feed and advance media.

L. “STOP” (STOP button)

Press the STOP button, to STOP, Halt operation of the ColorFlare. When the “STOP” button is pressed it will become active and the button will be illuminated “ON”. The feed rollers will stop and media will not be advanced, pressure on the media/substrate is released as the rollers are disengaged.

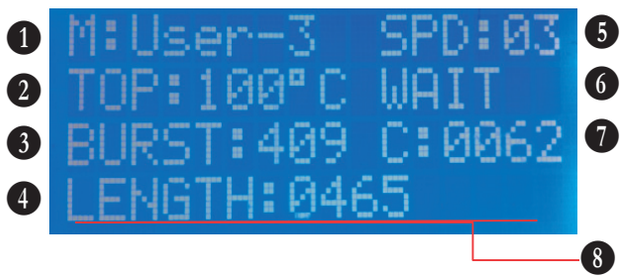
M. “BURST SPEED” (Button to activate high or normal speed bursting function)

When the “BURST SPEED” button is pressed it will become active and the button will be illuminated “ON”. While the BURST SPEED button is illuminated, the ColorFlare will increase the speed of the burst rollers that separate the sheets. To deactivate High Speed Bursting, press the BURST SPEED button again so the light is not illuminated, and bursting will continue at normal speeds.

Higher bursting speed is used for Nylex film and some PET laminating films, to improve the separation.

5.1 EXPLANATION OF CONTROL PANEL DISPLAY

The illuminated control panel/s LCD show Job condition, Setting Status and Machine status are shown on the display.



1. Job Mode
2. Roller Temp.
3. Rear Bursting Position
4. Paper Length
5. Speed
6. Mirror Roller Temp. Status
7. Counter
8. Error Message

5.1.1 Display overview.

❶ **Job Mode Display**- example above shows **"M:User-3"**

This is the current Job settings, a Job setting is a combination of all parameters either, predefined or that you have individually set. Including Page length, Temp and Burst timing.
There are 13 modes, shown below. 10 are predefined for the common media types and 3 are custom for you to define as you wish (Note: You cannot change the name).

5.1.2 JOB MODES

Poly-L : Lower Temp. for Polynex Film (Set Temp. 100°C)	MICRO : Micronex Film Lamination (Set Temp. 120°C)
Poly-H : Higher Temp. for Polynex Film (Set Temp. 120°C)	FOIL-L : Lower Temp. for Flaring Foil (Set Temp. 115°C)
Nylon : Nylonex Film Lamination (Set Temp. 130°C)	FOIL-H : Higher Temp. for Flaring Foil (Set Temp. 130°C)
PET-L : Lower Temp. for Perfex Film (Set Temp. 90°C)	User-1 : Operator Set up Mode 1
PET_H : Higher Temp. for Perfex Film (Set Temp. 110°C)	User-2 : Operator Set up Mode 2
FUS-L : Lower Temp. for Flaring Film (Set Temp. 110°C)	User-3 : Operator Set up Mode 3
FUS_H : Higher Temp. for Flaring Film (Set Temp. 125°C)	

Refer to **"JOB"** to understand how to change the setting value and how to save changes.

5.1.3 Temp Display

❷ **Temp. Display,** example above shows **"TOP:100°C "**

This area of the display will normally show the target Temperature set for the heated laminating roller.
The applicable range is "0~150°C".

This is the target or 'Set' Temp which is shown by default. This is the temperature you have SET the machine to achieve (not necessarily the current temperature).

If you wish to check the current temperature then press "MASTER DIAL". The display will change to show the current temp.

Please refer to the Temp Explanation of Control Panel to set up.

5.1.4 Rear Bursting Position Display

❸ Rear **Bursting Position Display** - example above shows **"BURST:409"**

Do not confuse burst position timing with page length ! The Burst timing, or Burst position is the position at the rear of the machine where the Bursting Roller activates to separate lamination material.
This enables the user to change the bursting point to either before, under or after the skewing wheel, and does not correlate to your page length.

Bursting Point range is "360 ~ 530"mm

NOTE : Refer to the Explanation of Control Panel to set up the Bursting Timing.

5.1.5 Paper Length Display

❹ **Paper Length Display** - example above shows " LENGTH:0465"

This is the length of the media you are currently set to feed. It is used for the semi-automated feeding system.
It is important to set the length of your paper here so that the semi-automated paper feeding gate will open and advance your paper at the correct time. If the length is too short, your next sheet of paper will feed early. If the length is too long, then the machine will have a gap between sheets and the paper-out sensor will see the gap and automatically stop the machine.
Its setting range is "203 ~ 1,219"mm.

NOTE : Refer to the PAPER LENGTH in Explanation of Control Panel to set up.

5.1.6 Speed Display

❺ **Speed Display**, example above shows - "SPD:03"

This is the speed of operation for the machine. The speed is shown in 'Meters per minute'.
The applicable setting range is "1 ~ 10".

Refer to the SPEED in Explanation of Control Panel to set up. The ColorFlare will default to speed 3 when restarting after a stop.

5.1.7 Status Display

❻ **Status Display,** example above shows -"WAIT"

The Status display, provides feedback as to the current status of the machine, and if it is Ready for Lamination or flaring/foiling.
It displays "WAIT" or "READY".

- WAIT : Not suitable for lamination (or flaring Temp. is higher or lower for lamination).
- READY : Good/ready for operation. Start lamination or flaring.

5.1.7 Counter Display

❼ **Counter Display,** example above shows - "C:0062"

The counter is used to count sheets passed through the machine, within a certain time period. It can be reset if it is required.

Counter Reset : Press "SPEED" button & "MASTER DIAL" button at the same time or turn off the power and turn it on again. NOTE: the previous data is not saved.

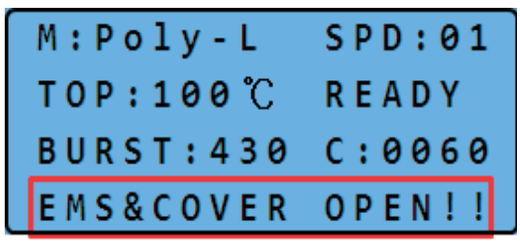
5.1.8 Error Message Display

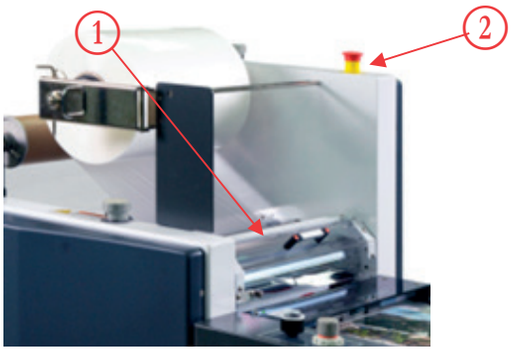
❽ **Error Message Display**

When an error occurs, and the RUN button is pressed, a message is displayed. In an error state, the machine cannot be operated.

NOTE : Refer to the Error Message for display.

5.2 NORMAL OPERATION - ERROR MESSAGES

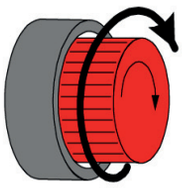




5.2.1 “EMS & COVER OPEN!!”

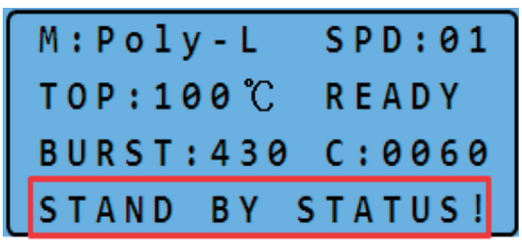
This message is displayed when Roller Safety Cover is open or when E-STOP Switch is pressed.

Roller Safety Cover ① is designed to avoid users from burns caused from touching the high temp. Heated Mirror roller. The safety cover should remain closed and the catch engaged at all times, except when loading films or foils.
If you open the cover, then once the cover has been closed please make sure the switch/catch is re-engaged



In the case of an emergency, pressing the E-STOP ② switch stops Roller operation and prevents System operation. To disengage the emergency stop button, twist it slightly.

This warning message is shown for 3 secs. when the RUN is pressed. To check the message again, simply press RUN again.



5.2.2 “STAND BY STATUS!”

This message means the ColorFlare is in STAND BY mode.

The system has a power save mode, and will enter STAND BY MODE after 2 hrs if the Upper Roller set temp. is higher than 80°C and the system is in system stop status.

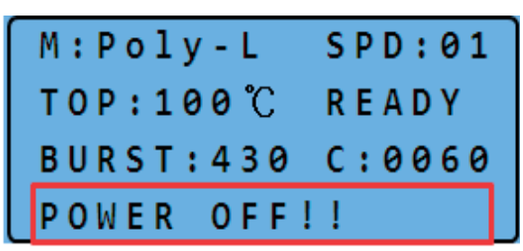
(i.e. You have not used the ColorFlare for 2hrs but left it on)

In this status, the STAND BY STATUS message is displayed blinking on LCD panel.

To cancel the STAND BY MODE, press the RUN button.

TOP TIP

The ColorFlare will need to come back to temperature before you can use it properly again. Check the STATUS on the LCD display and ensure it says “READY” before using it. You can also press and hold down the MASTER DIAL to check current temperature to give you an idea how far from your target temperature it currently is.



5.2.3 “POWER OFF!!”

This message means the ColorFlare is in POWER OFF mode.

POWER OFF mode, occurs 1 hour after STAND BY mode has been activated.

In POWER OFF, the heated roller will automatically be switched off. In addition, the LCD BACKLIGHT is turned off however once the POWER OFF (Power saving mode) is overridden this light will be on back on again as normal.

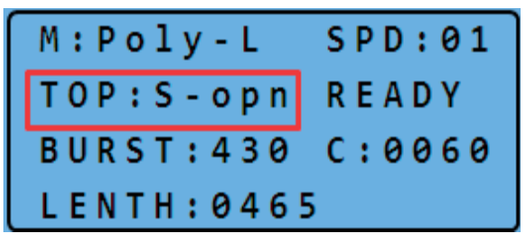
To exit from POWER OFF MODE, press RUN button while you see the POWER OFF message on the display.

TOP TIP

As with STANDBY MODE, the ColorFlare will need to come back to temperature before you can use it properly again. Check the STATUS on the LCD display and ensure it says “READY” before using it. You can also press and hold down the MASTER DIAL, to check current temperature to give you an idea how far from your target temperature it currently is.

5.3 SERVICE CALL - ERROR MESSAGES

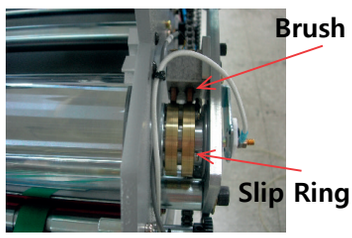
5.3.1 “S-opn”



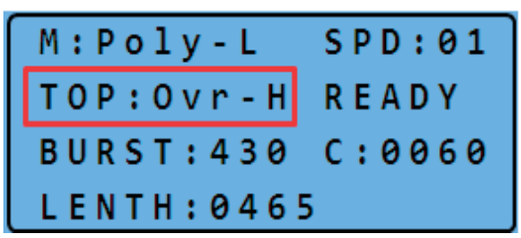
Error is displayed when, Temp. Sensor is shorted or when the connection between Slip Ring & Brush is not good .

If this message is displayed, check the parts shown.

WARNING : Power has to be “OFF” to check the shown parts.



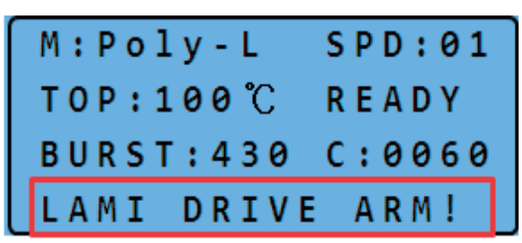
5.3.2 “Ovr-H”



This message is displayed when the Laminating Roller temp. is higher than 170°C. This may be caused by a problem with the Heater Controller.

Please contact your Intec dealer.

5.3.3 “LAMI DRIVE ALARM”

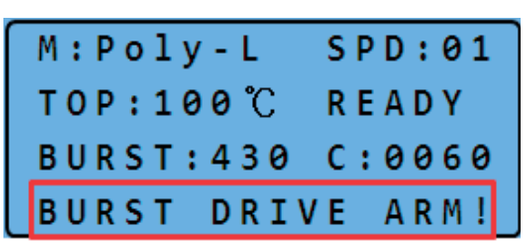


This message is displayed when main motor drive doesn’t generate the input and output voltage or may be overloaded, “LAMI DRIVE ALARM” ocurrs.

This could be either due to a fault or, can be caused when media or laminate may be wrapped around the rollers or jammed in the rollers.

Press STOP button to cancel the alarm. Check for any mis-feeds, jams or media/laminate stuck around the rollers. If there does not appear to be a media related feed issue then please contact your Intec dealer.

5.3.4 “BURST DRIVE ALARM”



This message is displayed, when the Burst motor drive doesn’t generate the input and output voltage or when it is overloaded, BURST DRIVE ALARM is shown.

Press STOP button to cancel the alarm.

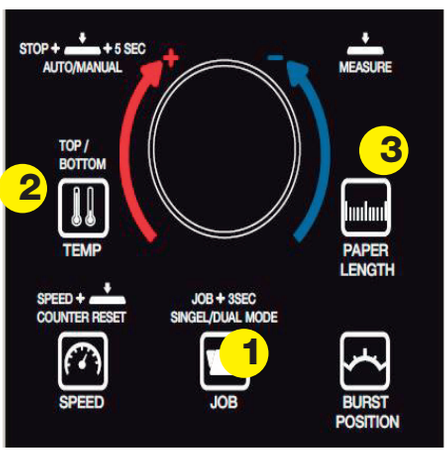
This can occurs when paper is wrapped around the burst rollers (can occur when media has a lot of static or when output tray is overfull) or multiple sheets have been picked up and are trying to be fed through the BURST rollers.

Check for any of these issues and clear the problem. If no obvious issue exists then please contact your Intec dealer.

6.0 HOW TO LAMINATE

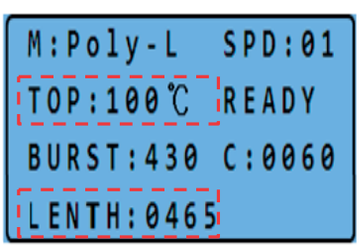
6.1 Preparing for lamination.

6.1.1 Setting the Control Panel



① **Press Job**
Press the “JOB” icon on the control panel and select your chosen job with the Master Dial

② **Temp**
Check the temp on the control panel is correct for your job and it has not been changed.
Default settings can be found here < Sec 5.1.2 >

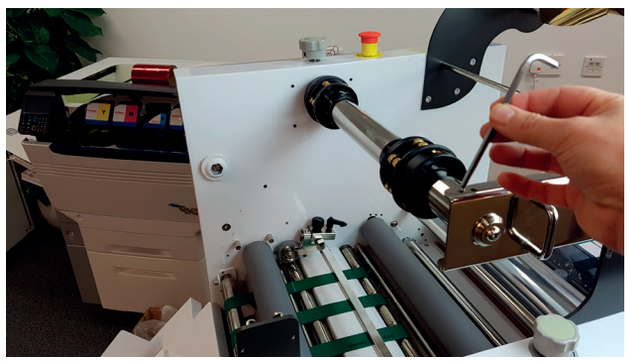


③ **Paper Length**
Ensure your media length is set to the length of the media you are feeding. If length is set to a value shorter than your actual media then the overlap will be more than expected. If it is set to longer than the substrate then there will be a space between sheets, causing the ColorFlare to stop.
If the media length shown on the display does not match your actual media length, press “paper length” and turn the master dial to set the length of your media.

④ **Check display, for READY**
Check the Control Panel display and ensure your settings are correct and the READY message is displayed.
IF READY is not displayed, hold down the MASTER DIAL to check current temp and wait for READY to be displayed.

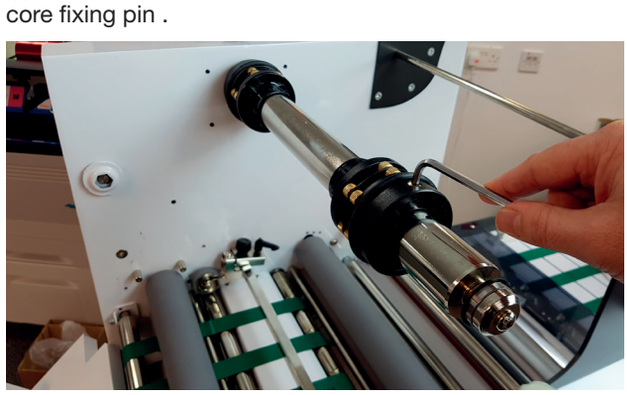
6.1.2 Loading the Laminating Film

① Remove film shaft Locking pin/allen key

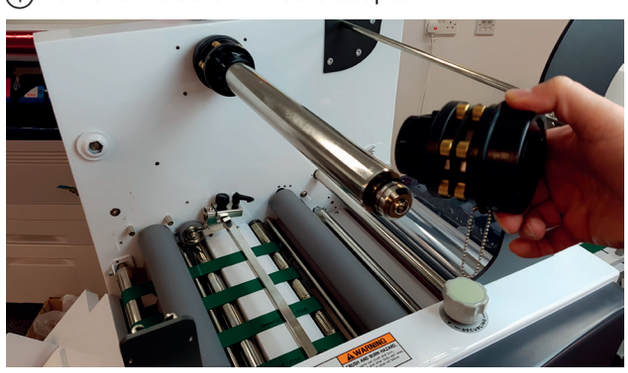


② Open the film shaft holder

③ Use the Locking pin/allen key to loosen the outer film core fixing pin .



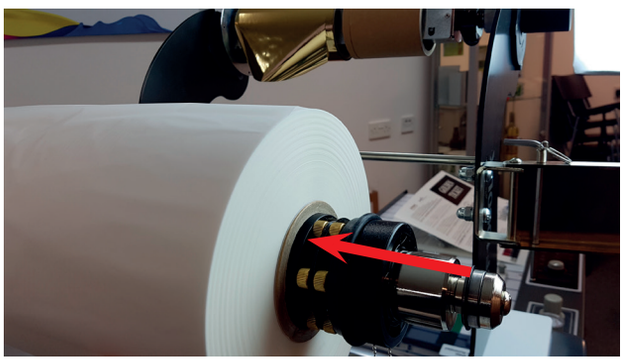
④ Remove the outer film core adapter.



Loading the Laminating Film (Cont)

⑤ Load the roll of lamination film

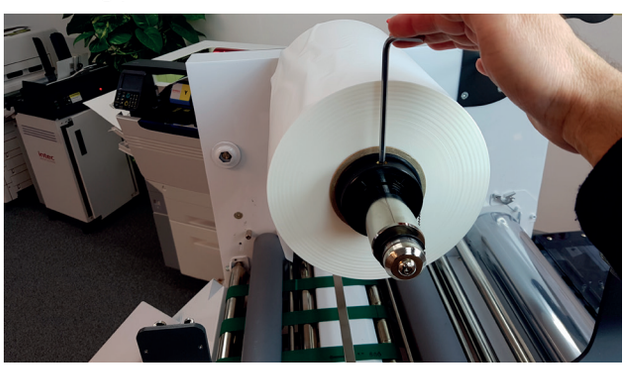
⑥ Slide the film core adapter back on to the film core shaft.



TOP TIP

⑦ CHECK, that the Lamination film is loaded correctly. as shown below, and that the film drops vertically down from the rear. Loading the film incorrectly will cause the adhesive to stick to the Heater Mirror Laminating Roller.

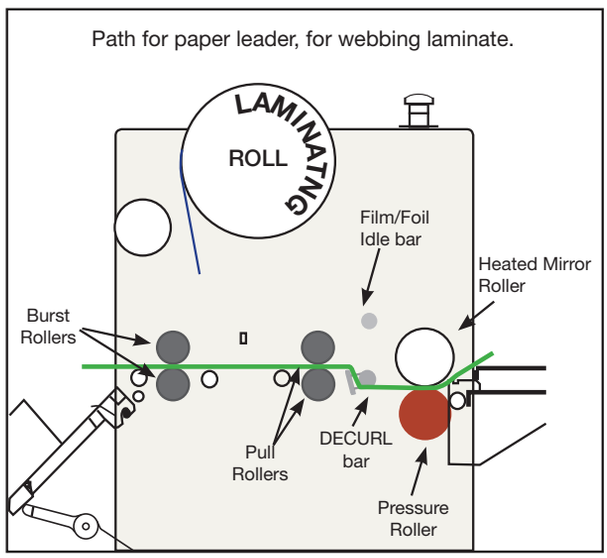
⑧ Use the Locking pin/allen key to tighten the outer film core fixing pin .



⑨ Close the Film Shaft holder and replace the locking pin/allen key.

6.2 WEB Laminating Material

6.2.1 Pre-loading the paper path



⑩ See the diagram above showing the paper path used to WEB a 'leader' for loading your laminate. The green line indicates the media/substrate path through the machine.

TOP TIP

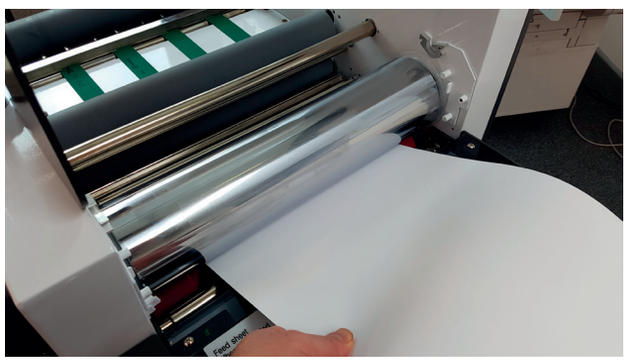
If the perforating and skew wheel are installed, ensure that they are moved to the sides to enable easy loading of media and lamination film during setup)

Follow the guide below to pre-load your paper substrate to help you web your laminate material through the machine.

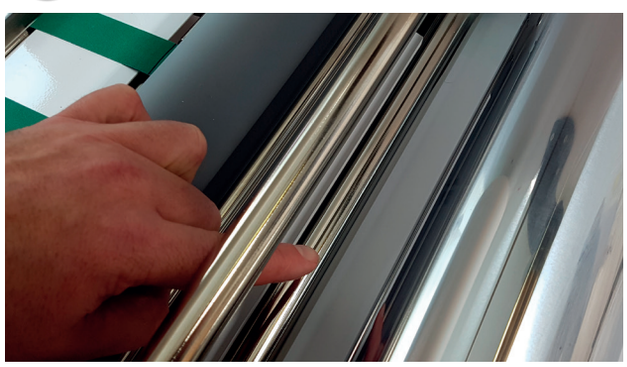
⑪ Remove the Heated Roll safety cover

⑫ Using a long sheet of spare paper, curl the front edge (We suggest a thick paper preferably 630mm in length).

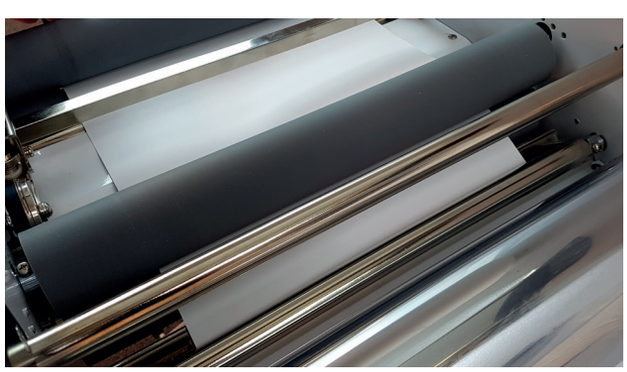
⑬ Guide the paper under the heated Mirror laminating roller. (Be careful it will be hot) .



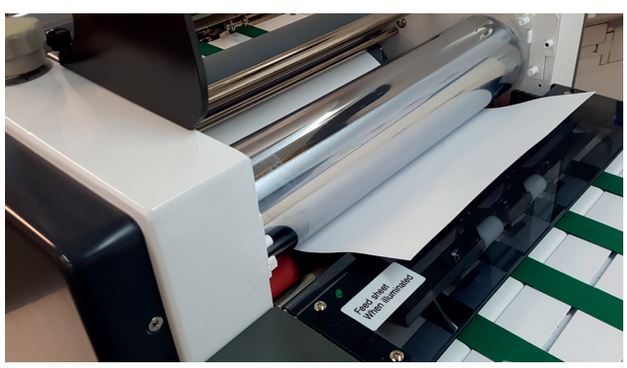
⑭ Be specially careful to pass the paper **UNDER** the DECURL roller shown here.



⑮ Feed the paper through the machine past the feed roller if using 620mm material you will be able to pass all the way through the machine making it easier to start.

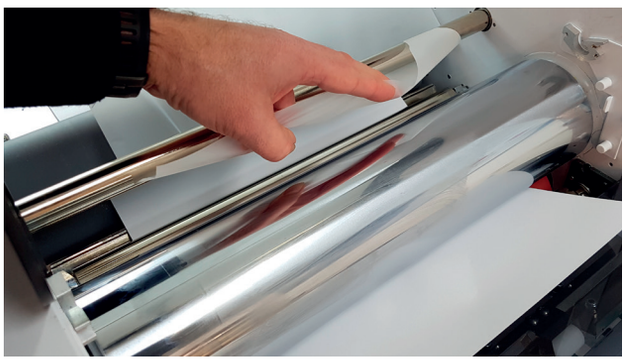


⑯ Stop when you have 120 - 150mm of paper left in front the heated mirror roller.



6.2.2 Attach laminate to paper ‘leader’

⑰ Pull the lamination film down, and under the idle bar behind the top of the heated mirror roller.



⑱ Pull the lamination film over the heated roller, as shown below. The adhesive on the laminating film will melt (Sticky side up).

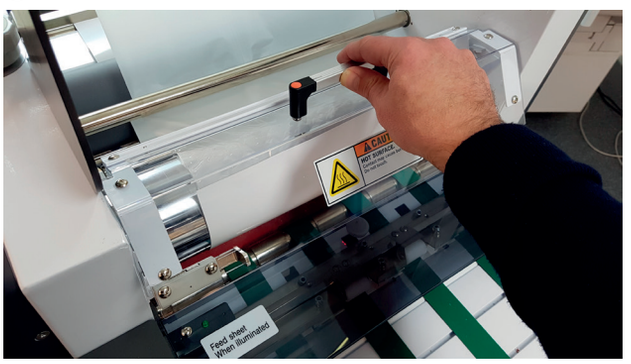
TOP TIP if it is sticky side down, then you loaded the roll incorrectly, (Step ⑦), Clean the Heated Mirror roller and start again with the film correctly loaded.

IMPORTANT: The Laminating film width should be 5 -10mm narrower than your media you are planing to laminate. If the laminating film is wider than your media then the adhesive glue will stick to your rollers and cause contamination or potentially damage. It will also cause problems with cutting / separation of sheets.

⑲ The laminating film is webbed adhesive side out, therefore the heat from the laminating roller will have melted the adhesive. The adhesive is face up on the heated mirror laminating roller.

⑳ Press the paper loaded onto the heated laminate, the paper will bond to the laminate).)

㉑ Install the roller safety cover .



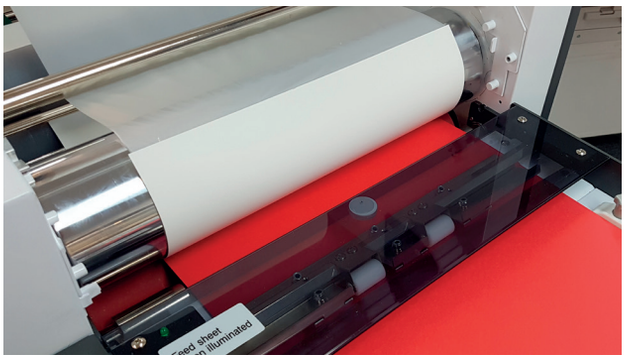
㉒ Be sure to remember to engage the interlock latch.

㉓ Place a sheet of paper on the table to load and briefly press the ‘**LOADING**’ icon on the touch panel, while sliding the sheet of paper forwards.

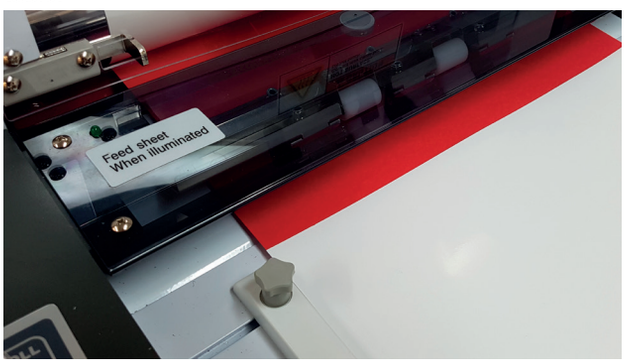
TOP TIP Pressing the ‘**LOADING**’ icon on the touch screen, will open the ‘feeding gate’ to enable the paper to slide underneath. - If nothing happens when you press the ‘**LOADING**’ icon on the panel, then check both safety catches are closed on front and rear covers.

6.2.3 Web the laminate

㉔ In the below image we used red paper to make it easier to see. Load your 'waste' or spare sheet of media, under the feeding gate and directly under the heated mirror roller.



㉕ Now place another spare/waste sheet of paper on the table.



㉖ Slide it under the feeding gate until it stops.

The feeding gate is automated; it opens at the front to allow the first sheet of paper in, but stops it at the back of the gate. When in use, the automatic gate will only allow paper to pass after the '**LENGTH**' set on the display has passed. For feeding to work correctly the LENGTH set on the display MUST match your paper size. Timing is calculated from the **START** of the second sheet, and the gate will not open automatically, until after the second sheet has passed through.

TOP TIP

If restarting from a paper-out condition ALWAYS place one sheet of paper under the heat roller, and another sacrificial sheet on top of this but up to the gate; this will enable the timing to restart correctly.

6.2.4 Perform a TEST lamination

Once the temperature on the laminating roller has reached the set temperature, it is important to check the settings, feed and laminating quality.

㉗ Press **RUN** to start the ColorFlare feeding your 'paper leader' through the machine and then to feed additional paper to continue with your test lamination.

㉘ When the **GREEN LED** (A) illuminates, place the next sheet of paper **ON TOP** of the sheet feeding into the ColorFlare. You do not need to be too accurate with this sheet, simply place it 25 - 100mm from the gate (B). Make sure to place it on top of the current sheet.

㉙ The semi-automatic feeding system will advance the sheet forwards then STOP it automatically at the start of the gate. Then when approx 75mm of the current sheet remains, the gate will open advancing the next sheet to the 'hold' area inside the gate. (Almost looking like the sheet starts to feed then stops). At this point the GREEN feed LED (C) will no longer be illuminated.

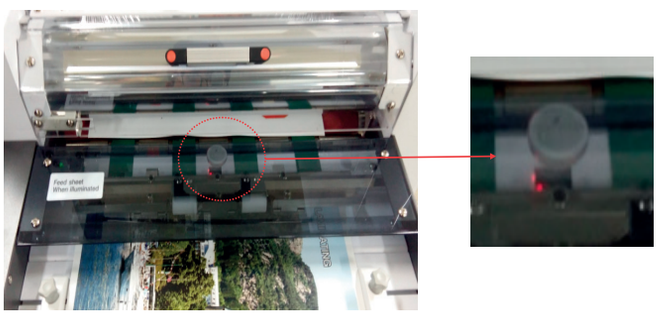
When the sheet under (the sheet currently feeding) is almost at the end (at the 'pre -set overlap') the semi-automated feeder will advance the sheet into the ColorFlare.

㉚ Continue to fed 3 -4 sheets of paper, to check for feeding gap errors, and the correct overlap. Also check the alignment of your sheets against the edge of the laminate.
For test lamination a speed of 2 - 5 m/min (yd/min) is recommended.

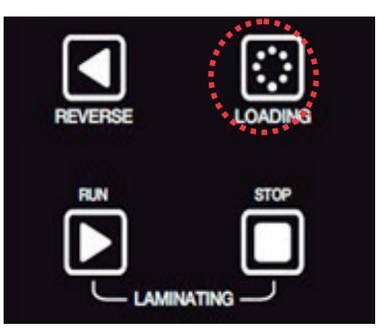
6.2.5 What to do if there is a misfeed

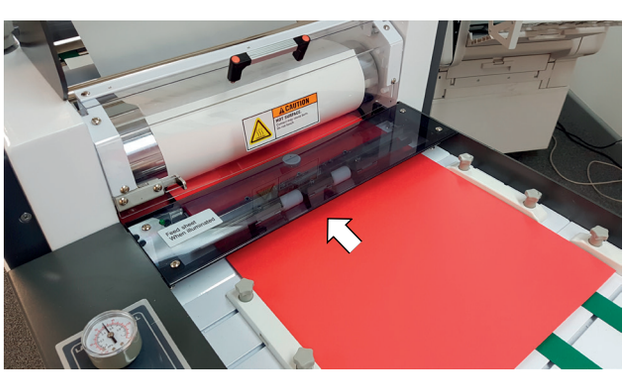
If there is a feeding error or the length is set incorrectly and the gap is too large between sheets, then the machine will stop automatically to prevent the adhesive on your laminate from sticking to the lower roller.

The ***Misfeeding sensor*** will illuminate when there is a paper feed error.



① Insert a sheet of paper into the machine under the heated mirror laminating roller while opening the shutter by pushing the '**LOADING**' button..

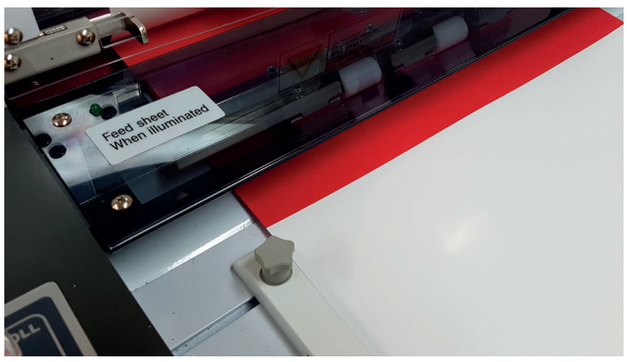




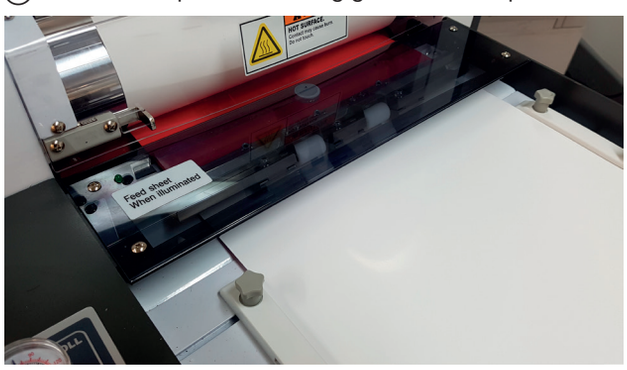
You should ensure that this sheet goes OVER the tail of the last sheet which should still be visible just under the heated roller and after the misfeeding sensor.

TOP TIP It is easier to ensure it goes ***OVER*** the last sheet, if you slightly curl the lead edge on one corner before sliding it in.

② Now place another spare/waste sheet of paper on the table.



③ And slide it up to the feeding gate until it stops.



It is important always to use **two** sheets during a restart. One that goes under the heated roller, the other that goes up to the gate.

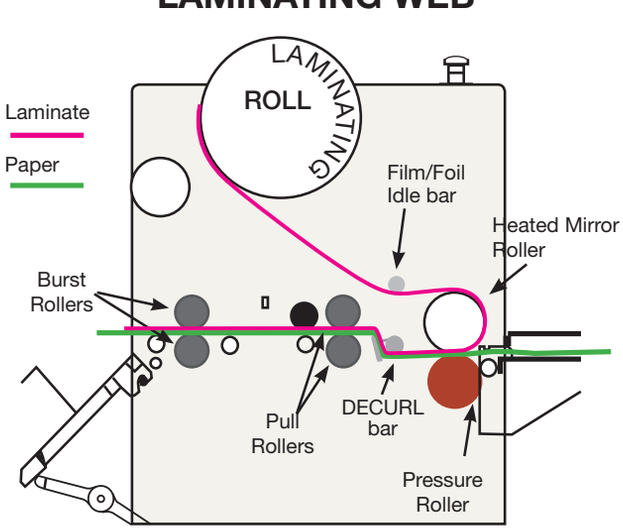
TOP TIP The second sheet starts feeding immediately and will significantly overlap the first, it can not be used, so always use a 'spare' or waste for these two sheets. The second sheet is used to restart the timing calculation for the overlap.

Finally check your paper length to ensure it is set correctly for your paper size, adjust if necessary and click '**RUN**' again.

6.2.6 Laminate correctly Webbed

After you have used the first sheets to carry your laminate through the machine, your machine should be webbed as follows:

LAMINATING WEB



You can now set up the bursting/sheet separation.

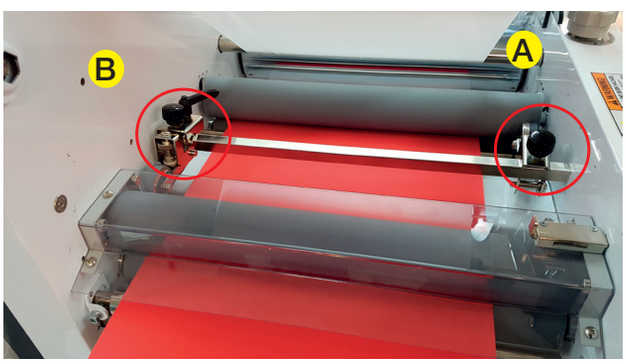
6.3 Setting up the Laminating Burst Separation System

The ColorFlare includes a sheet separation system which uses the pneumatic drive to 'burst' the sheets apart. To facilitate this the sheets are perforated along one edge to enable the lamination to split (the Perforation wheel achieves this function), then pressure is applied at a slight angle to help the sheets separate away from the weakened edge. The skewing wheel performs this function. Finally the burst rollers separate the sheet cleanly at the overlap.

Once you have verified that there are no substrate feeding issues you should set up the perforating wheel and skewing wheel in order to enable the burst mode.

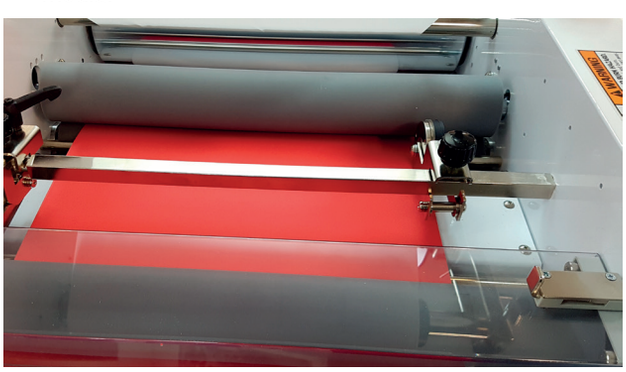
6.3.1 Positioning the Perforating Wheel

① The perforating wheel **(A**) and skewing wheel **(B)** are located after the pull roller and before the final set of rollers (the bursting rollers). When using flaring foil or performing the initial webbing of laminate, these would have been moved to the side on the of the machine on the rear accessories bar. (See below)

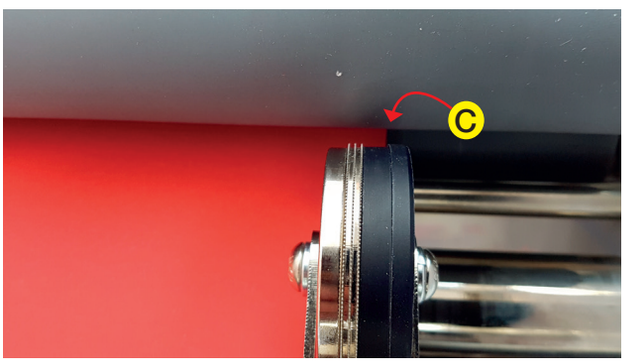


② Loosen the fixing thumb screw to enable you to slide the perforating wheel towards the edge of your substrate.

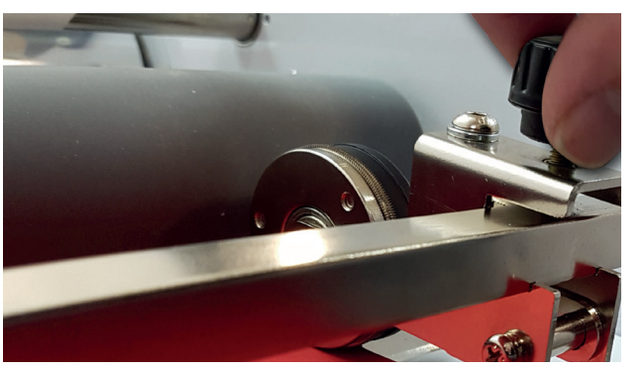
③ Position the perforating wheel on the edge of the media.



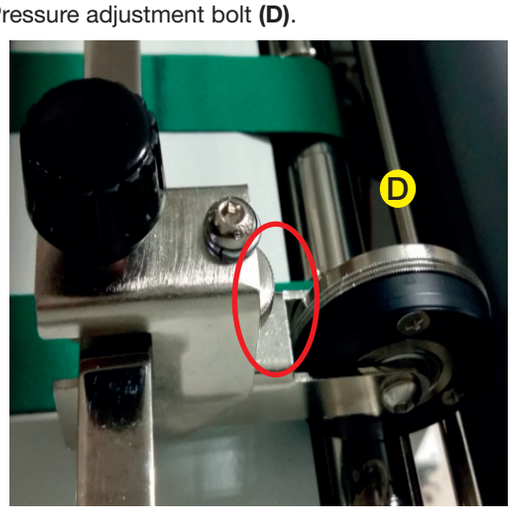
④ The perforating wheel should be 1-3mm on the inside edge of the laminating film. As seen below the edge of the perforating wheel provides a guide, the raised shoulder **(C)** should run outside the paper while the black shoulder runs over the edge of your paper, allowing the perforating wheel to perforate your film just inside the edge.



⑤ Having located the perforating wheel, tighten the fixing thumb screw to lock it in position.

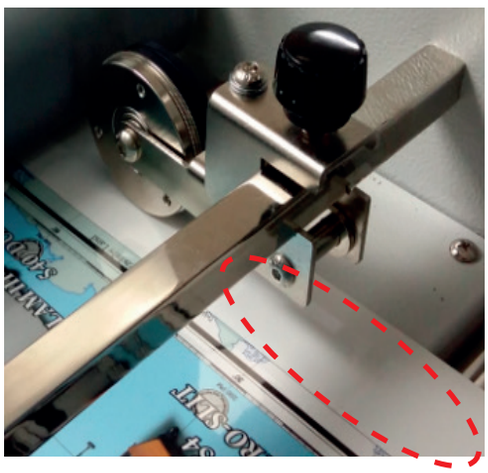


⑥ To make clear holes on films adjust the perforator Pressure adjustment bolt **(D)**.



CAUTION : After use remember to loosen the Perforator adjustment bolt (D) or the blade on the perforating roller could be damaged. Specifically when moving to the side for initial webbing or foil flare webbing.

⑦ In operation it should be possible, using a loupe, to see a tiny row of holes, where the edge of the laminate is being perforated, this is normal.



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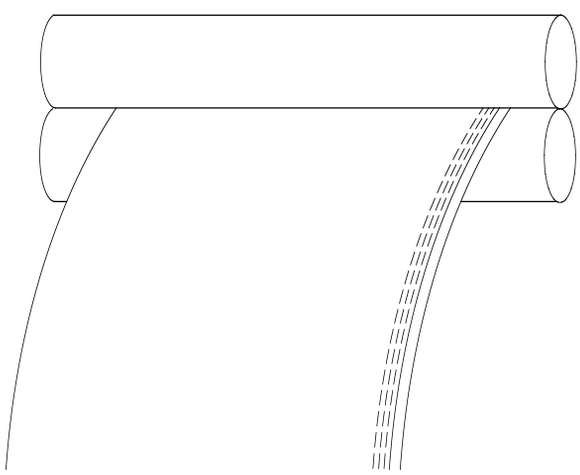
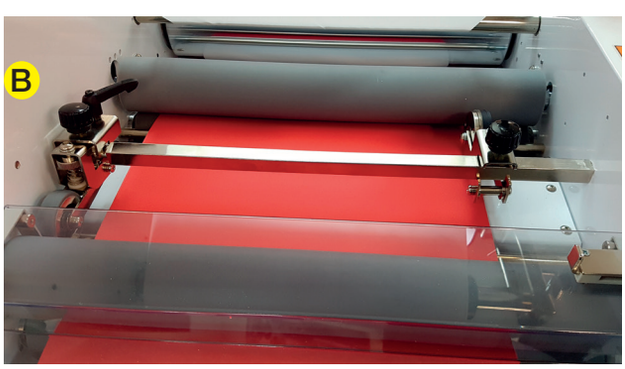


6.3.2 Positioning the Skewing Wheel

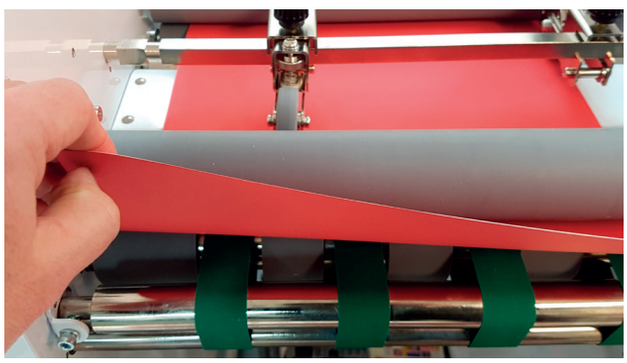
⑧ Locate the 'Skewing Wheel' **(B)**. Loosen the fixing thumb screw (Not the black lever) and slide it over the substrate.



The skewing wheel is used to provide a light twist/wave in the laminated sheet to help cut the laminated results, and to avoid 'torn' edges

⑨ Position the wheel approx 50 - 75mm inside the edge of the sheet.

⑩ The skewing wheel, should be positioned in-between the two far left green belts. Take care not to position it directly over one of the belts.



⑪ To operate correctly, there should be a light angle on the wheel so that it can 'lightly' skew the media as it passes. In operation, it is normal to see a light wave or ripple in the media behind the wheel.

WARNING: An excessive angle may mark the print and cause a large wave which may jam, or crease the substrate.

TOP TIP

The angle of the skew can be controlled, by adjusting the black lever at the rear of the skewing wheel. The lever is sprung, and so, can be lifted and turned to a new position if there is no radius available for it to turn in its current orientation.

6.4 Using the Burst function

The Burst function uses the timing from the page length set on the control panel to accelerate the Burst rollers, at a fixed point, and separate the sheets.

6.4.1 Activating Burst

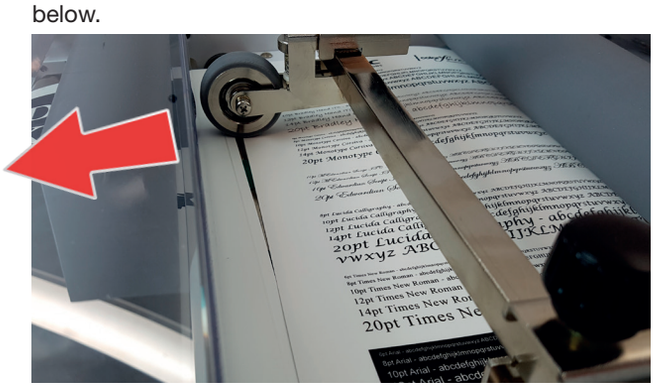
① Burst cannot be activated when the machine is not running. To activate the Burst mode, press 'RUN' and start feeding your sheets.

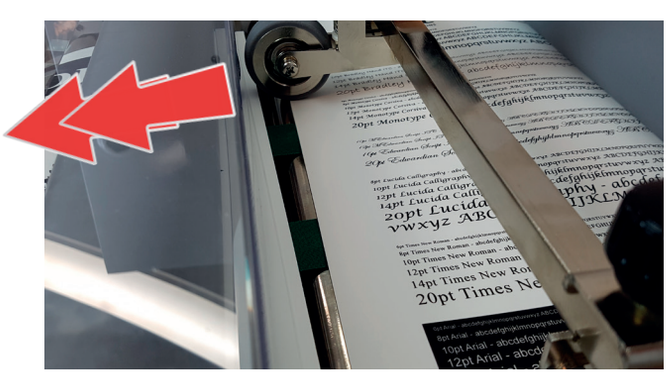
After the first sheet has reached the rear of the machine, you can enable Burst by clicking the the BURST ON/OFF icon on the touch panel (A). (See below)

TOP TIP

If restarting after a paper misfeed, allow the first sheet under the Heated mirror lamination roller AND the subsequent timing sheet to pass through the machine. Enable Burst on the front panel after the front edge of your first 'LIVE' sheet has reached the Pull rollers just after Heated Mirror laminating roller.

② In Burst mode, as the Burst rollers accelerate you can see the sheet start to separate in these high-speed photos below.





6.4.2 Burst Position

The Burst position is NOT related to sheet size. Burst position is a measurement taken from the front feed gate of the machine, and measured to the position at the rear of the ColorFlare where the burst will happen.
Typically the default setting is 479mm. (Which is just under the skewing wheel).

TOP TIP

If this value is reduced, the Burst / sheet separation will occur BEFORE the skewing wheel. Under some circumstances this may be desired, and can prevent the wave created from the skewing wheel from becoming too excessive. However, with lighter papers, and IF the decurl has not been adjusted correctly, the paper will curl up BEFORE the skewing wheel and may jam.

Setting it too far after the skewing wheel can result in the effect of the skewing wheel, being nullified.

③ To adjust the BURST position, press the BURST POSITION (B) ICON on the Control Panel (just above the Burst ON/OFF button which you used to activate the Burst). Use the MASTER DIAL to adjust the value.

6.5 Check points during operation.

① Overlapped distance : Ideally the sheets should overlap by 3~5mm. If the overlapped distance is too short, a gap could appear between the sheets and you will not get a clean edge on your separated sheets.
Adjust the OverLap (See section 6.6 following)

② Curling on Substrate : Check the curling status of substrate and adjust curling either by reducing the tension on the laminate or adjusting with the decurler.
(See sec 6.7 following)

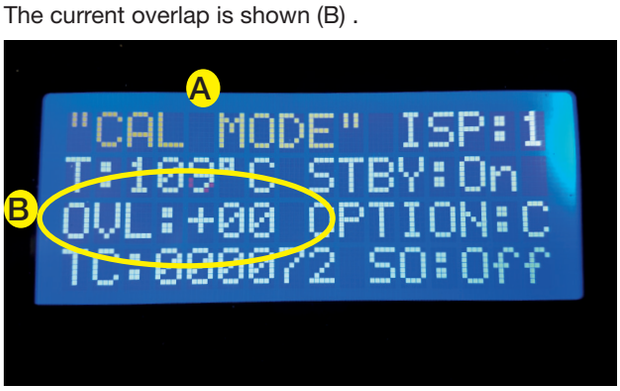
Remember, that it is a natural thing to have curled laminated results for single side lamination. This is not caused by a fault in the machine and is why the Decurl function is important..

6.6 Adjusting the overlap

6.6.1 Enter the 'CAL' Mode

① Press and hold the [PAPER LENGTH] button, for 5 seconds.

② The display will change to show the '**CAL MODE**' screen where you can change the **OVERLAP**. In "**CAL MODE**" the top of the display will show '**CAL MODE**' (A). The current overlap is shown (B) .

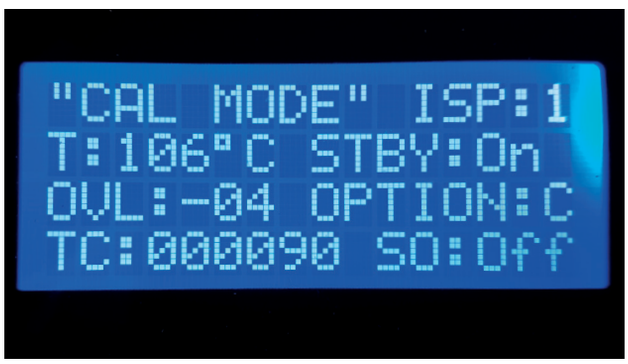


6.6.2 Set the Overlap

③ Turn the MASTER DIAL while in '**CAL MODE**' to adjust the overlap value.

Ideally the sheets should overlap by 3~5mm. If the overlapped distance is too short, a gap could appear between the sheets and you will not get a clean edge on your separated sheets.

④ Adjust the overlap to '- 3 ' or ' - 4mm'.
You SHOULD set the overlap to a 'minus' number. Which will deduct from your page length, i.e. the overlap will be your page length minus the value here.



NOTE: It is possible to set the overlap to a POSITIVE value, such as + 3 or +4, which will ADD to the paper length and create gap (which is typically undesired).

6.6.3 Return to Normal Mode

⑤ Once the overlap has been set, press and hold the **[PAPER LENGTH]** button for further 5 seconds to return to the normal operating menu.

Ensure you have your paper length set correctly, or this will also affect the overlap. Paper length is set in the standard mode so once you have returned to standard menus, double check your paper length in the display.

TOP TIP **Be aware:** Incorrect bursting can cause a vibration which will interfere with the overlap. If sheets don't separate or the burst delivers a noisy/loud separation, then adjust your perforating wheel or Skewing wheel. A quiet operation indicates a correctly set Burst (Skewing wheel and Perforating wheel). A loud burst indicates these need to be adjusted.

6.7 Adjusting for CURL on the substrate

It is perfectly normal that laminating can result in the substrate being curled after lamination.

This is not caused by a fault in the machine.

The ColorFlare includes a Decurling Feature to help minimise or eliminate any curling on your Laminated Results after single side lamination.

6.7.1 The Cause of Curl

When the laminate is stretched over the substrate and bonded to the substrate (The laminating process), the laminate will contract when cooling, resulting in a curl. In addition certain substrates/papers will naturally curl when heated.

IF the tension on the laminate is very high (The laminate is over stretched), then the effect of the curl will be increased.

If the paper is particularly susceptible to curling with heat, then the effect is increased.

TOP TIP

Curl tends to affect SINGLE SIDED lamination only. Typically speaking, any curl is reversed by double sided lamination (where you manually put the sheets back to laminate the opposite side of the sheet). So if you plan to Laminate both sides of the sheet, then you don't need to worry about adjusting the Decurl.

6.7.2 Setting the laminate tension.

The tension applied on the Input Film Shaft will need to be altered/be different when changing between Foil or lamination and in addition will also be different, when changing between large or small rolls of laminate or foil.

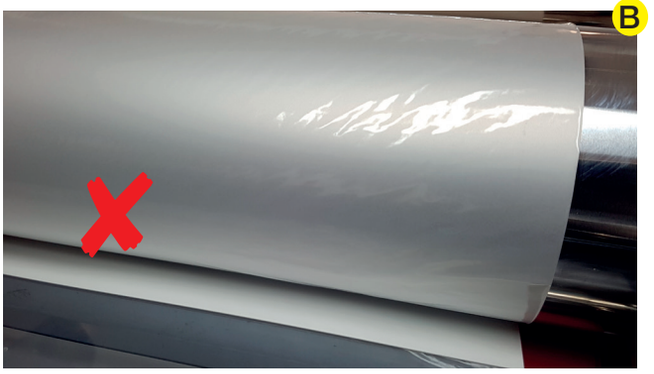
A little tension is required on the input roll shaft, to prevent the laminate roll from gathering momentum as it turns, and getting loose. A loose laminate passing over the heated Mirror roller may create wrinkles in your laminated result.

Conversely too much tension, will stretch the laminate, creating excessive curl. The ideal scenario is to have the lowest tension possible on the Laminating roller's input shaft while also maintaining a smooth output on the laminated substrate.

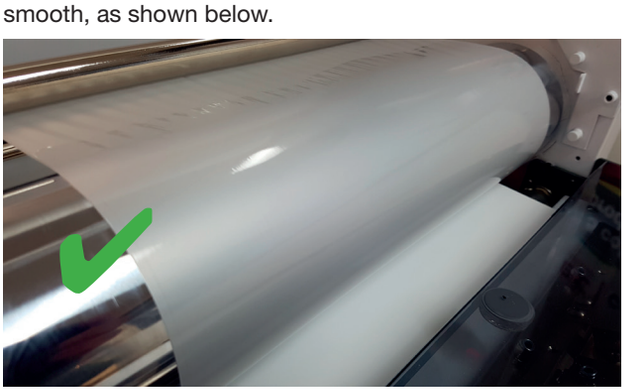
① **You can adjust the tension applied to the input film shaft by adjusting the tension control knob (A) , shown below .**

A larger (Full) roll of laminate is heavier and creates more inertia, therefore more tension may be required, compared to a smaller roll.

Check the tension on the laminating roller, in the image below you can see wrinkles **(B)** on the Laminate over the Heated Mirror Laminating Roller. - This tension is too low.



② The tension should be adjusted during operation or running of the machine to slowly increase tension so that the laminate over the Heated Mirror Laminating Roller is smooth, as shown below.



WARNING: Increasing the tension beyond this point, will still provide a smooth surface across the Heated Mirror Laminating Roller but, will cause the Laminate to shrink across the roller and cause excessive curl, which you may not be able to compensate for with the decurling device.

Take care to only apply enough tension to smooth the laminate and not to increase it unnecessarily.

6.7.3 Using the Decurl Bar.

The ColorFlare is fitted with a decurl bar, to minimize the effect of curl on your laminated substrate. The decurl bar, implements a reverse curl directly after the heated mirror laminating roller, designed to counter the curl created by the heat or laminate.

③ You can adjust the amount of decurl applied, by adjusting the DECURLING control knob (A) , shown below

When a low level of DECURL is applied (Fig 1 below) , the paper passes under the DECURL ROLLER and gently over the attached DECURL BAR.

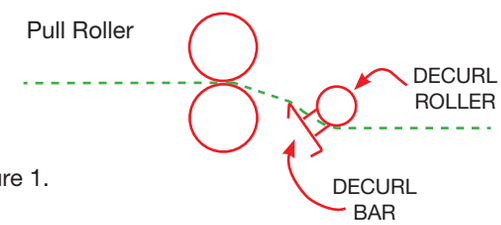


Figure 1.

⑤ The substrate as it passes through the decurl bar can be seen below.

⑥ The aim is to achieve a light curl down on the ends, and lightly up in the middle, directly as the substrate leaves the ColorFlare.

As the substrate cools, the Laminate will contract fractionally and this will become flatter.
If the substrate is completely flat, as it comes out of the ColorFlare, it may curl up at the ends as the media cools.

⑦ If the media is curled from the machine as shown below.

You must compensate for CURL by turning the DECURLING adjustment knob to increase the level of decurl. (See fig 2. below).

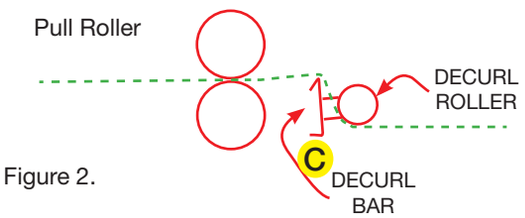
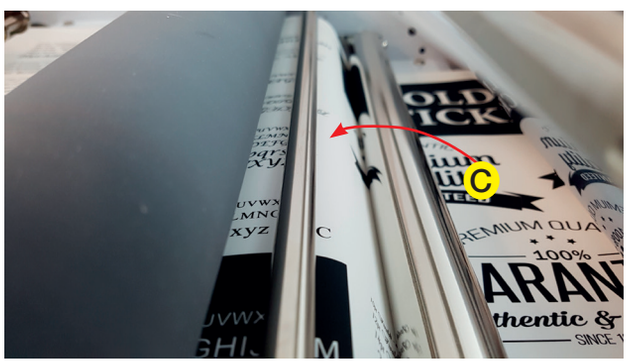


Figure 2.

As you turn the DECURLING adjustment knob towards the '+', (Clockwise), the DECURL BAR is raced, creating a sharper reverse curl on the substrate.



When the DECURL adjustment is very significant, you must ensure that as you load sheets when feeding that each sheet goes ON TOP of the last sheet or when you start after a misfeed, that you place the 'restart' sheet ON TOP of the last sheet. Otherwise sheets may reach the DECURL bar and be directed down. If you find sheets under your machine then this is the likely cause.

The decurling feature needs to be adjusted each time you change substrate thickness, and laminate thickness. Also, decurling is not typically required for double sided lamination, as the effect of placing the substrate back through again and laminating the second side will reverse the effect of the first side being laminated..

6.8 Soft Accelerate System & Temperature control program

6.81 Delayed speed change.

This machine contains a special speed and temperature control program to improve lamination quality.

The soft-accelerate feature changes of the job speed after 4secs after which the job speed is rapidly increased.

This delayed speed change enables the temperature control program (below) to adjust the Heated Roller temperature to compensate for the increased cooling effect of running at the higher speed and helps reduce/ prevent detrimental effects caused by low laminating temperatures which can cause deterioration of laminating quality

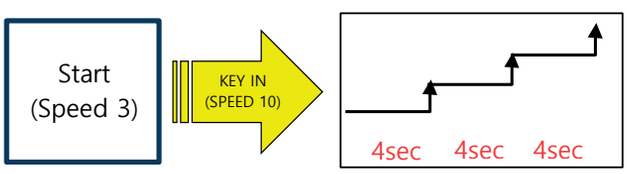
6.8.2 Temperature control program.

To maintain optimum laminating quality the heated laminating Roller is linked with the speed control in order to compensate for the heat reduction that occurs when the user changes the speed while running a job.

Your media will absorb and reduce heat from the roller as it comes into contact with the roller; the quicker the roller rotates (i.e. the higher the running speed), the quicker temperature will drop.

When operating at higher speeds, the temperature control program will compensate for this heat loss. In addition the temperature control program will provide compensation as the speed is increased during operation by creating a delay of approx 4 secs for each step up in speed the user makes.

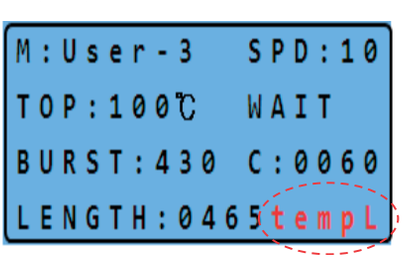
Example: Starting job with a speed of 3 and increase the speed to 10



The speed message will blink while changing the speed.

The message will stop blinking when the speed reaches the set speed.

When increasing the speed, if the actual temperature of the Heated Mirror laminating roller has not reached the temperature set on the display panel, then a “tempL” message will appear on the display and the speed will not increase. (The speed increase will not be accepted).



This message will disappear when the temperature set has been reached. You will be able to increase the speed again after the “L-TEMP” message disappears.

6.8.3 Laminating Speed and Temperature

The media that you laminate acts as a heat sink, and lowers roller temperature during laminating. The thicker your media, the more effective it is at removing heat from the laminating roller and the thinner it is, the less heat it will absorb.

Please be aware that due to this, the thicker your media is, then the higher the temperature you will require to offset the loss of heat into the media.
Slower speeds or increased temperature settings can be used to achieve a higher temperature.

The opposite is true of thinner media; as this absorbs less heat. Therefore when changing to thinner substrates, use faster speed and /or lower temperatures.

You should always run a test lamination with the media you are planning to laminate, however if you only have the exact number of sheets you are planning to laminate with no / few test materials, then you should test the lamination conditions with similar materials first.
Then when starting the job, check the estimated conditions created with the similar materials are working correctly.

If there is a misfeed and laminating stops, or if you PAUSE Lamination, while a lamination job is under the heated roller, it is very likely that the heated roller could leave a mark on the laminated results after restarting. Therefore you may need to discard any sheets that were held under the heated mirror lamination roller during a stop or pause.

7.0 DIGITAL DECORATIVE EFFECTS - FLARING

7.1 Introduction to the decorative effects available by flaring.

7.1.1 Range of effects available

The Intec ColorFlare is a dual purpose / hybrid product that combines advanced laminating technology with ground-breaking decorative effect capabilities, all from one machine. Various decorative effects including foiling can be delivered using a process we call 'Flaring'.

FILM FLARING techniques, are **translucent**, that is to say, you can see the image through them. Any image or color is shown through which is ideal for clear spot gloss to enhance images or holographic effects to grab attention to the original image.

FOIL FLARING techniques are **opaque**, that is to say, you cannot see the original toner under the foil. i.e. A black toner/ digital image will become solid Gold or the White pigment foil can be used on dark stocks, including black.

In both cases, addition 'FLARE' can be achieved as background images and full color elements can be combined with Foil fusing when the image is protected by Intec's special overprintable laminate.

7.1.2 SPOT Film Flaring

The Intec ColorFlare uses the integrated Heated Mirror roller (normally used during lamination) with pneumatic pressure to activate the toner on the digitally printed sheet. The activated toner works like an adhesive which adheres to Intec's specially constructed film (Either Gloss or Matt).

Unlike Laminating which adheres to the entire sheet.

Film Flaring adheres to ONLY the image area, therefore it is also known as SPOT Flaring FILM. This approach leaves your background substrate/ non-image area, untouched.

In addition to this, for further special effects SPOT FILM Flaring can be combined with lamination when used in conjunction with Intec's special SOFT TOUCH/SILK high temperature Corona treated digital laminate.

When combining SPOT FILM Flaring with a Digital printer capable of printing CLEAR toner, users can create part of the image with a GLOSS finish and part with a MATT finish.

7.1.3 Holographic Film Flaring.

Similar to Spot Film Flaring, the Intec ColorFlare uses the integrated Heated Mirror roller (normally used during lamination) with pneumatic pressure to activate the toner on the digitally printed sheet. The activated toner works like an adhesive which adheres to Intec's specially constructed Holographic film.

A choice of holographic effects are available, including:-

SPARKLE
MILKY WAY/ SHIMMER
CARBON FIBER EFFECT
SHATTERED CRYSTAL EFFECT

Unlike Laminating, which adheres to the entire sheet, holographic flaring, adheres to ONLY, the image area. Holographic flaring will apply a holographic pattern effect over single, spot or full color text and graphics.

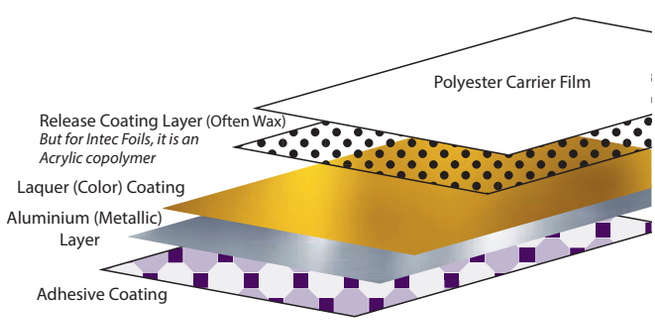
When combining HOLOGRAPHIC FLARING and Intec's Digital overprintable laminate along with a Digital printer capable of printing CLEAR toner, users can select individual parts of the image specifically for the Holographic treatment.

7.1.4 Metallic FOIL Flaring.

With Metallic Foil Flaring, the Intec ColorFlare uses your Digital print engine to act as your 'master' for laying down metallic decorative effects.

The Colored metallic foil separates from the base and adheres to any toner that is on the surface of the sheet being passed through the ColorFlare.

Whilst sounding simple, Intec foils are quite advanced and consist of five layers to enable you to achieve the best foiling results.



There is a Polyester carrier, and then a release layer. These are rewound on to the rewinder at the rear of the ColorFlare.

Using heat from the integrated Heated Mirror roller (normally used during lamination) and pneumatic pressure, the digital image from your printer or copier works like an adhesive which binds to the adhesive and metallic particles on Intec's specially constructed Metallic Foil. The foil will only bind to the toner area on your sheet.

In the ColorFlare's automated process, as the foil is lifted the colored metallic particles separate from the carrier, leaving an opaque, bright shinny metallic finish. Any Foil in the non imaging areas is rewound along with the Carrier film and release layer.

Not all foils are equal and different brands of foil work in very different ways, giving different resolution, varying release capabilities and smoothness. Intec foils are designed to deliver premium results with the highest resolution and the least resistance to releasing from the carrier, ensuring the widest range of media can be foiled.

7.1.3 Range of Metallic Foils

The premium range of foils for the best finish with the quick release and high resolution finish as described previously are available from your Intec dealer.

Foils are split into 2 types:-

Metallic (listed below), and Pigment (listed after).

Each roll is 300m (985 feet) in length.

The standard Metallic foil range of finishes are available, including:-

Intec Gold Metallic Flaring Foil (320mm / 12.6")*
Intec Silver Metallic Flaring Foil (320mm / 12.6")*
Intec Red Metallic Flaring Foil (320mm / 12.6")*
Intec Blue Metallic Flaring Foil (320mm / 12.6")*
Intec Green Metallic Flaring Foil (320mm / 12.6")*

In addition to this there are some Exclusive Metallic Colors for more premium effects including:

Intec Rose Gold Metallic Flaring Foil (320mm / 12.6")*
Intec Copper Metallic Flaring Foil (320mm / 12.6")*
Intec Bronze Metallic Flaring Foil (320mm / 12.6")*
Intec Fuchsia Pink Metallic Flaring Foil (320mm / 12.6")*
Intec BubbleGum Violet Metallic Foil (320mm / 12.6")*

Metallic Foil flaring, can be used:

Directly on to Digital images

(Turning all of the image area into a metallic image, such as Wedding Invites, Swing Tickets ect)

OR

It can be combined with Full Color images and backgrounds

(By combining Intec's special SOFT TOUCH/SILK high temperature Corona treated digital laminate to seal your full color image and then overprint the laminated sheet with your FOIL FLARING MASTER IMAGE. (Suitable for packaging prototypes and premium invites etc).

7.1.4 GLOSS PIGMENT FOIL Flaring.

Similar to Metallic Foil Flaring, GLOSS PIGMENT Flaring, is an opaque foil with PIGMENTED Particles. These adhere to your toner image, and replace the toner image with a GLOSS PIGMENTED FOIL of your choice.

A choice of GLOSS PIGMENT FOIL effects are available, including:-

GLOSS BLACK

SOLID WHITE

7.1.5 Range of Foiling effects

Flaring with metallic foils provides the ability to create a number of premium effects on the printed sheet.

There are 3 principle ways to use Foil Flaring

1. PRINT THEN FOIL

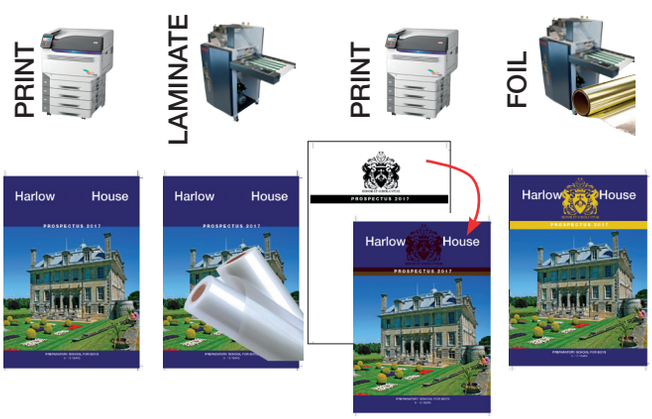
ALL TONER becomes foiled.

2. PRINT THEN FOIL THEN PRINT

The initial print is foiled, and the sheet is then placed back into a printer, where image can be placed around , next to or over the foil.

3. PRINT THEN LAMINATE THEN PRINT & FOIL

A full Color background image is created then the print is laminated using a special High Temperature, over-printable laminate. The laminated sheets are then placed back into the printer, where the image to foil is overprinted on the sheet. This sheet is then foiled (The original image protected by the laminate, is not foiled).



TOP TIP

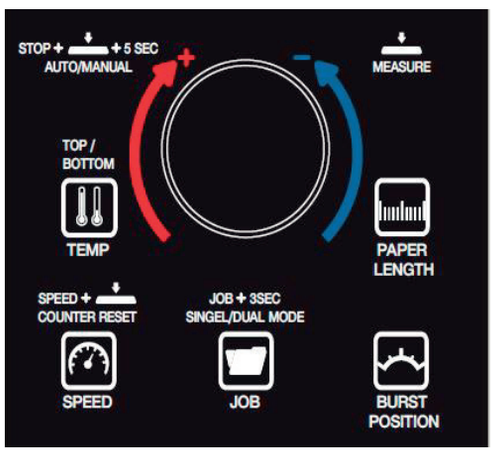
Foil only sticks to 'available' toner. So, you can actually combine these principles. i.e. Laminating 'hides' the toner so it is not available to foil. But so does foiling, as it covers the available toner. This means you can apply multiple foils to a sheet by using multiple passes through a printer to add additional toner image areas to foil.

7.2 Preparing for flaring (ColorFlare CF1000 / CF1000L).

The below guide assumes you have just finished laminating and shows how to change from Laminating to Flaring.

When flaring, it is necessary to remove the laminating tools (Skewing wheel and perforating wheel) from the substrate path and to install the Flaring bar so that unused film or foil can be recovered on the rewind flaring spool.

7.2.1 Setting the Control Panel



① **Press Job**
Press the “JOB” icon on the control panel and select your chosen job with the Master Dial
For using Spot Clear or Holographic Films select the program:

FUS-L : Lower Temp. for Flaring Film (Set Temp. 105 -110°C / 220-230F)

For using Metallic or Pigment Foils select the program:

FOIL-H : Higher Temp. for Flaring Foil (Set Temp. 115°C / 239F)

② **Temp**
Check the temp on the control panel is correct for your job and it has not been changed.

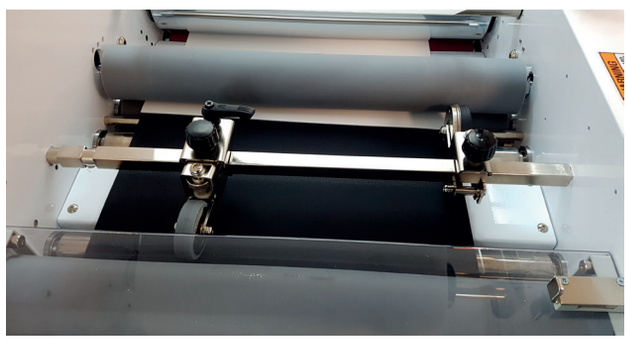
NOTE: For thicker substrates when foiling Metallic FOILS, you may need to increase the temp to 120C to 125C (248F-260F)

③ **Paper Length**
Ensure you paper length is set to the media you are feeding. If this is shorter than your substrate then the overlap will be more than expected. If it is set to longer than the substrate, there will be a space between sheets, causing the ColorFlare to stop.

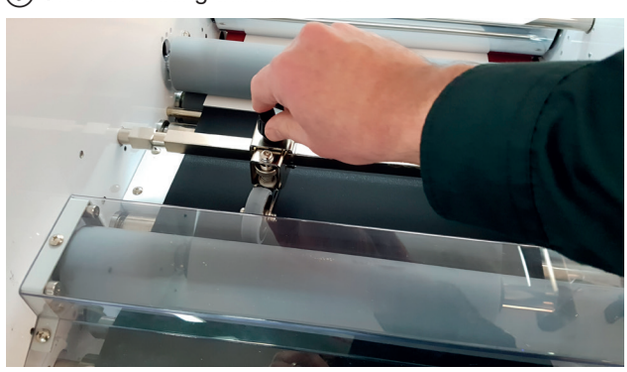
④ **Check display - for READY**
Check the Control Panel display and ensure your settings are correct and the READY message is displayed.
IF READY is not displayed, hold down the MASTER DIAL to check current temp and wait for READY to be displayed.

7.2.2 Moving out the Skewing Wheel

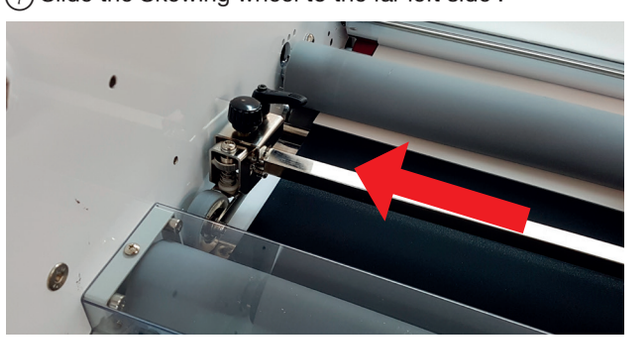
⑤ Viewing the machine from the exit table you will see the skewing wheel on the left.



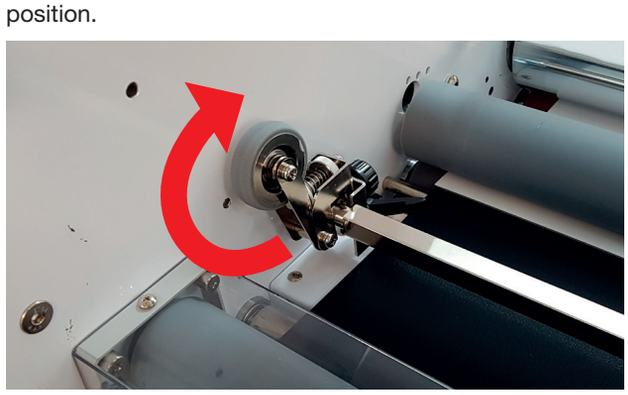
⑥ Undo the Fixing thumb screw



⑦ Slide the Skewing wheel to the far left side .



⑧ Rotate the Skewing wheel 90 degrees to the vertical position.



⑨ Lock the skewing wheel in the vertical position by tightening the fixing thumb screw.

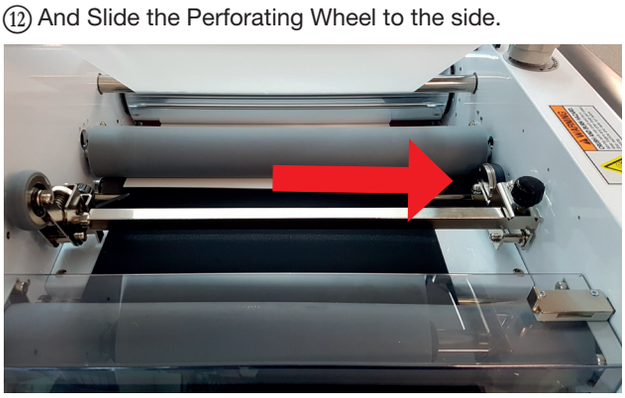
7.2.3 Move the Perforating Wheel

⑩ Now locate the perforating wheel and make sure you reduce the pressure by adjusting ‘up’ the pressure thumb screw .

CAUTION: When moving the Perforating wheel, you MUST loosen the perforator Pressure adjustment bolt. Otherwise the perforating blade or roller could be damaged.

⑪ Now loosen the fixing thumb screw on the top

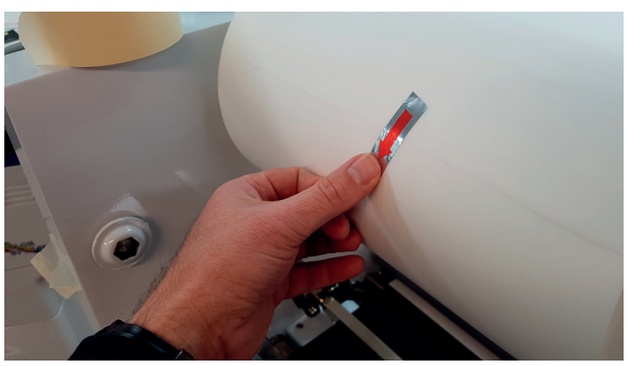
⑫ And Slide the Perforating Wheel to the side.



7.2.4 Remove the Laminate roll

⑬ Next, cut the laminate, just after the idle bar, allowing the laminate to drop - staying / resting on the heated roller.

⑭ Tape your Laminate roll to prevent it becoming unraveled .

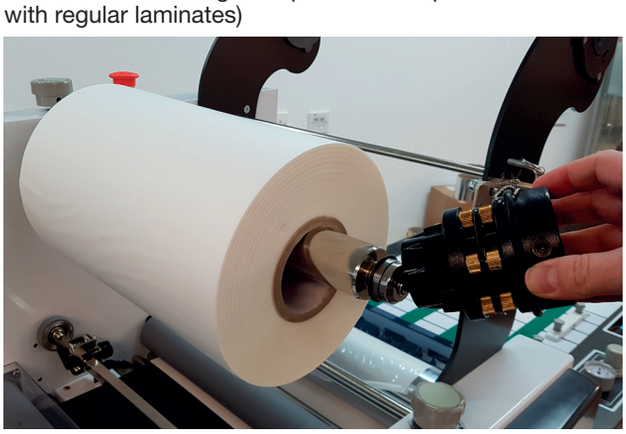


⑮ Remove film shaft Locking pin/allen key.

⑯ Open the film shaft holder.

⑰ Use the Locking pin/allen key to loosen the outer film core fixing pin.

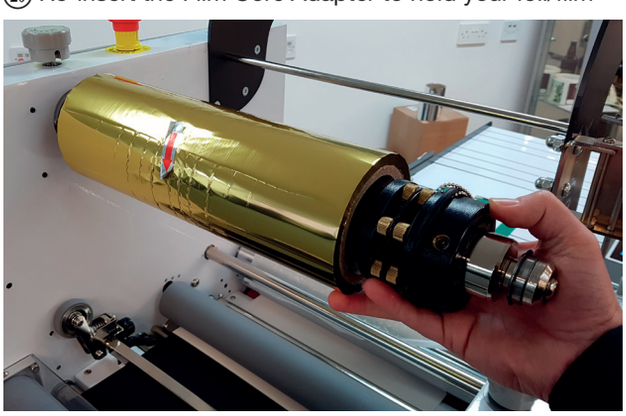
⑱ Remove the Outer Film Core holder, and slide off the roll of laminate. (Ensure your laminate is labeled, and you don't confuse the high temperature overprintable laminate with regular laminates)



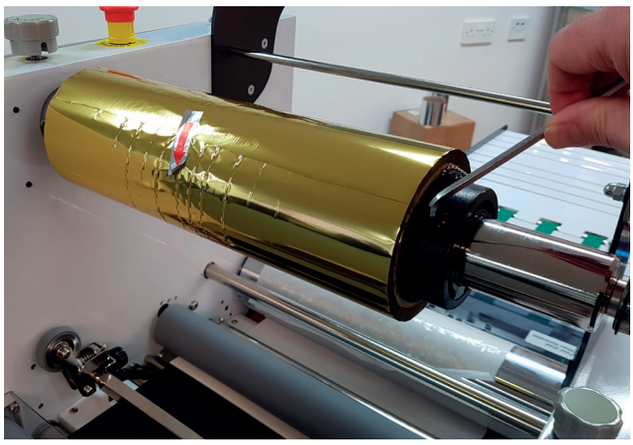
7.2.5 Load the Foil roll

⑲ Slide your roll of flaring film or foil onto the input core shaft.

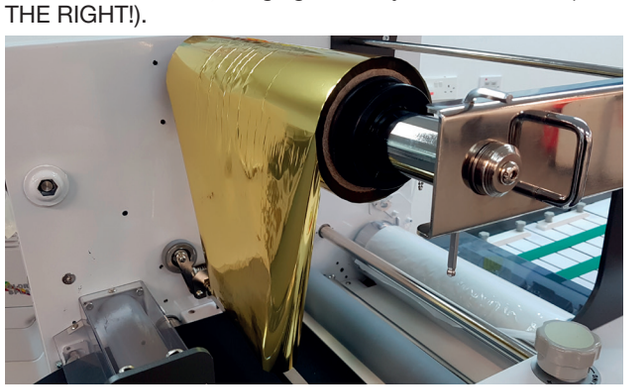
⑳ Re-insert the Film Core Adapter to hold your foil/film



㉑ Tighten the fixing pin on the film core adapter, and close the film shaft holder.



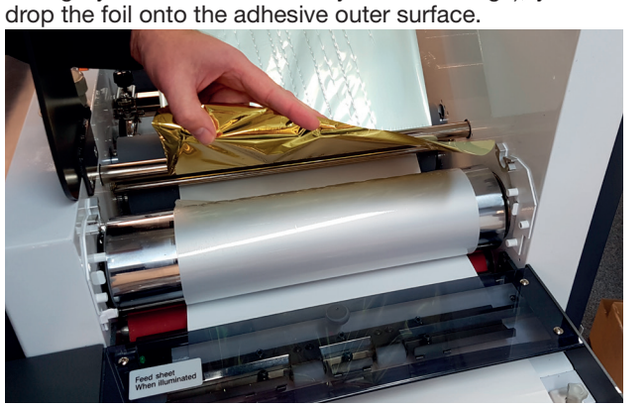
㉒ Your foil should be mounted as shown, with the COLOR to be foiled, hanging vertically on the left side (NOT THE RIGHT!).



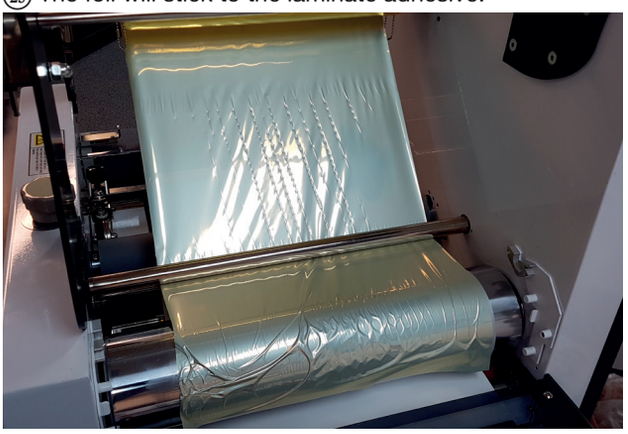
㉓ Feed the foil under the idle bar just behind the heated mirror laminating roller.

7.2.6 Attach Foil to end of Laminate

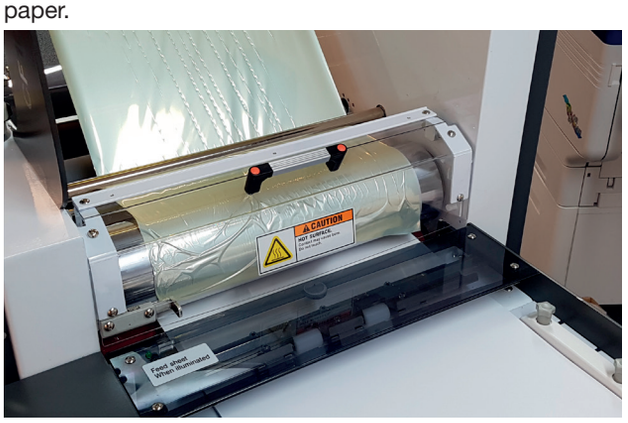
㉔ You can use the laminate (which is already webbed through your machine to feed your foil through), you can drop the foil onto the adhesive outer surface.



㉕ The foil will stick to the laminate adhesive.



㉖ Replace the front safety cover, and load a sheet of paper.

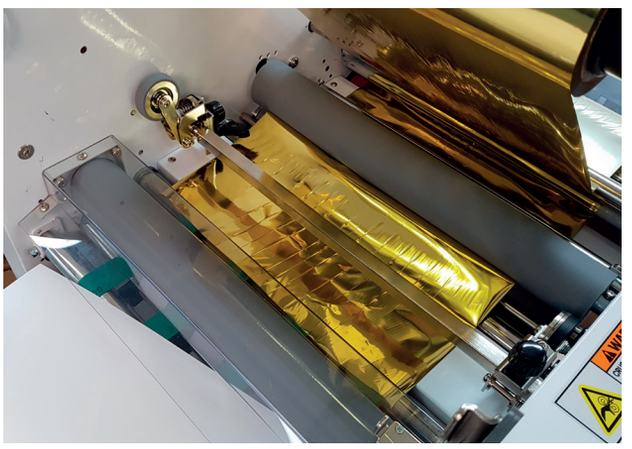


7.2.7 Use RUN to feed foil through

㉗ Press [RUN] and as with laminating, feed 2 - 3 sheets of paper.

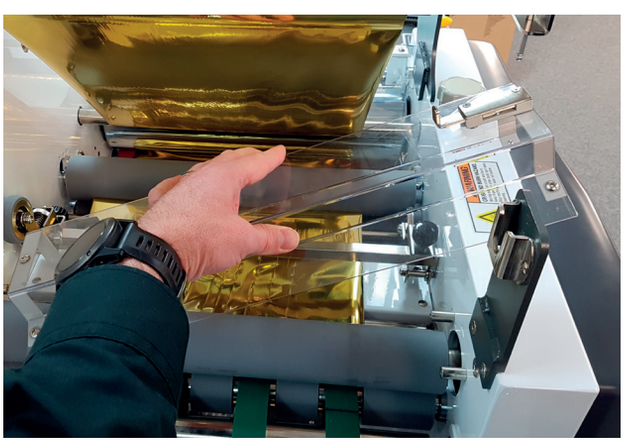
㉘ **Press** Stop when the foil passes the burst rollers at the rear of the machine. Then slit/cut the foil just behind the burst rollers (cut only the foil, and avoid cutting the substrate so you don't damage the belts underneath).

㉙ Now remove the sheet of paper leaving the foil end near the burst roller.



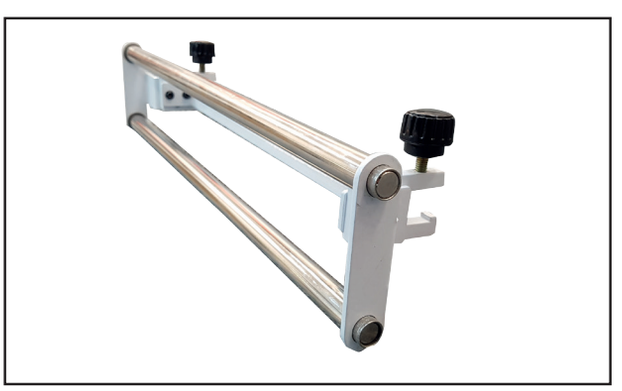
㉚ Unlatch the safety catch on the rear safety cover.

㉛ And remove the rear safety cover, (it goes up and slightly backwards - do not force it!).

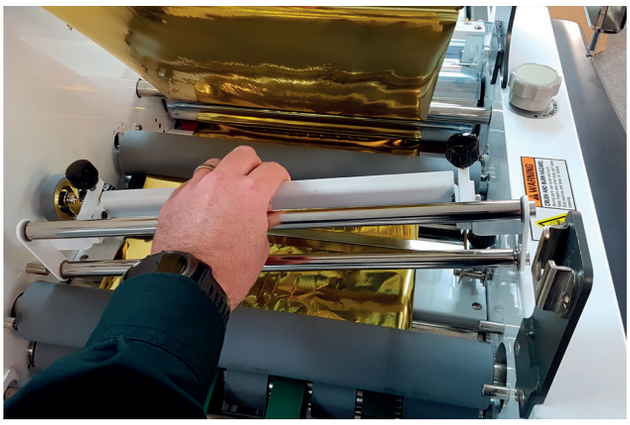


7.2.8 Install Flaring bar

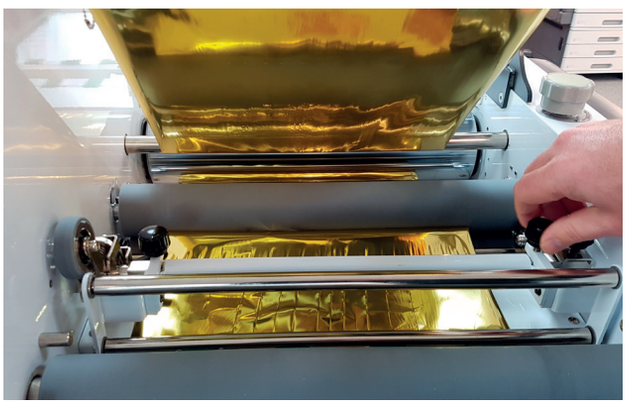
㉜ Locate the Flaring Bar, which is used to aid recovery of the carrier film and the unused foil or film.



(33) Attach the Flaring bar to the Accessories idle bar. This must be done without the rear safety cover on, otherwise you will not have the space to attach the bar.

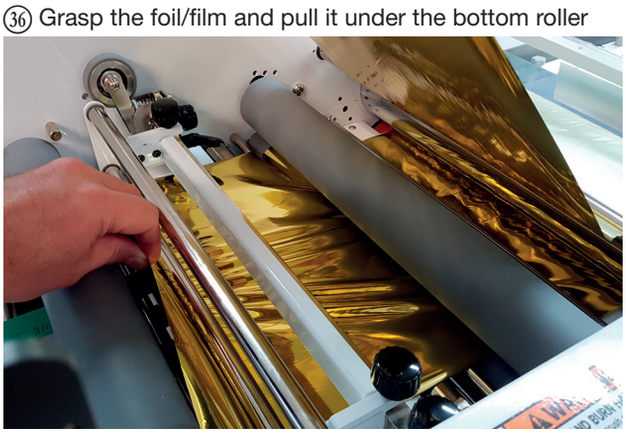


(34) Lock the Flaring bar in place using the fixing thumb screws at either end.

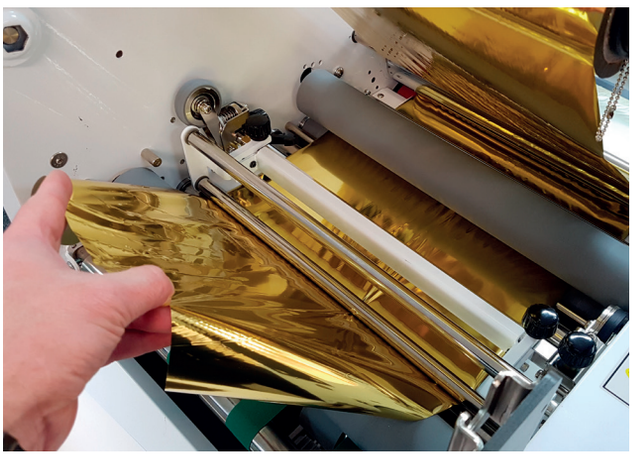


(35) Reduce the tension on the foil film shaft so that it moves easily for feeding the media through.

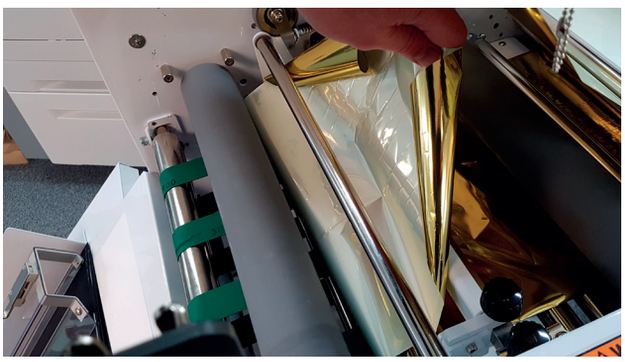
(36) Grasp the foil/film and pull it under the bottom roller



(37) Pull approx 150mm of flaring foil/film out, under the lower Flaring bar roller.



(38) Then feed it back under the upper roller, and lay it over the mounting bar, while you re-fit the rear safety cover.



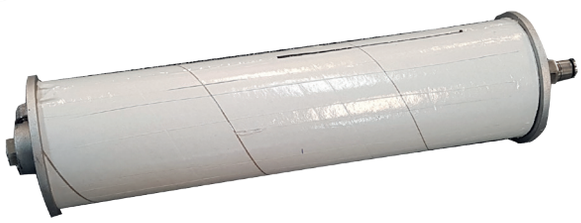
(39) Now, refit the rear safety cover.

7.2.8 Fit Rewind Spool Holder

TOP TIP

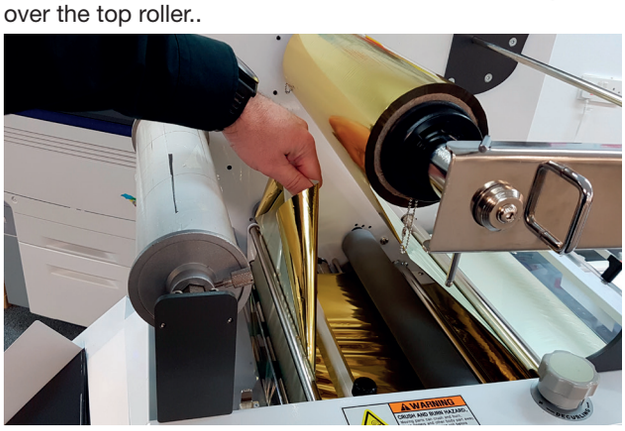
You must fit the rear safety cover BEFORE attaching the flaring foil/film to the rewind spooler because the rear cover is fitted at a slight angle from the bar side, and this is not possible once you have attached the film/foil to the rewind spooler.

(40) Locate the Flaring foil/film rewind spooler.



(41) Install the Rewind spool holder at the rear of the machine. Insert it at a slight angle on the left and drop the right side into the holder .

(42) Now grasp the film ensuring it still is feed through the flaring bar (Under the lower roller, then back through and over the top roller..



(43) Feed the flaring foil/film over the rewind spool holder And tape it in place.

7.2.9 Adjust FOIL Tensions

(44) Adjust the tension/pressure to the rewind spool holder to provide a light pressure on the rewind spooler.

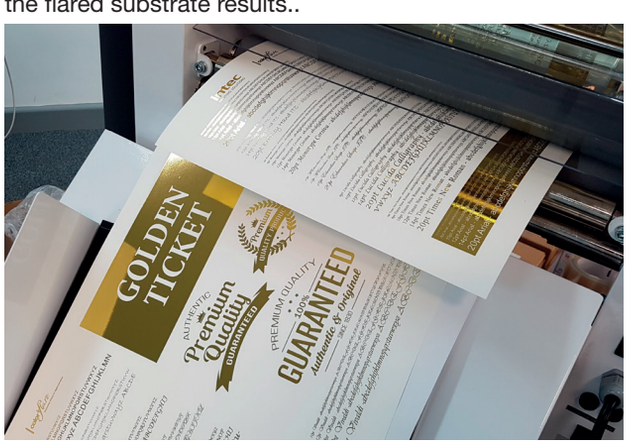
(45) Finally lightly increase the Flaring Film shaft tension.

7.3 Start Foiling

(46) Load your substrate to Flare (Foil / Film). Press LOADING on the Control Panel. Place one waste sheet under the heater roller and one up to the gate.

(47) Timing starts from the second Waste sheet then you can place your jobs in. As your print is foiled, the rewind spooler will collect the waste foil, and you should be able to see a reverse of the foiled area as the waste is removed.

(48) Check the rear of the machine on the output tray for the flared substrate results..

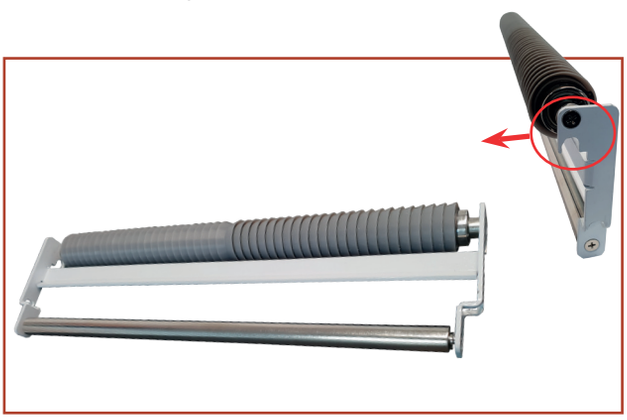


7.4 Using the Premium Flaring Bar (CF1000L / CF1000LX).

As described in section 4.6.1, the Premium Flaring bar delivers a smoother foil onto your prints and requires less tension.
It is recommended to fit the Premium Flaring Bar for ALL foiling applications. As it is often easier to change over to Foil (From laminate) without the Premium Flaring Bar installed, this guide shows how to add the Premium flaring bar once foil has already been loaded and webbed in your ColorFlare.

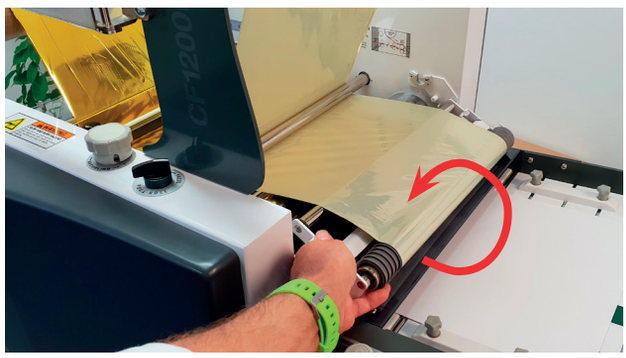
① Open the front Safety Cover and remove it. Being careful of the heated roller (If it is on, then it will be hot!), Pull forward some foil.

② Locating the Premium Flaring Roller, and ensure the Locating brackets face towards the machine when the Silicon Roller is up.

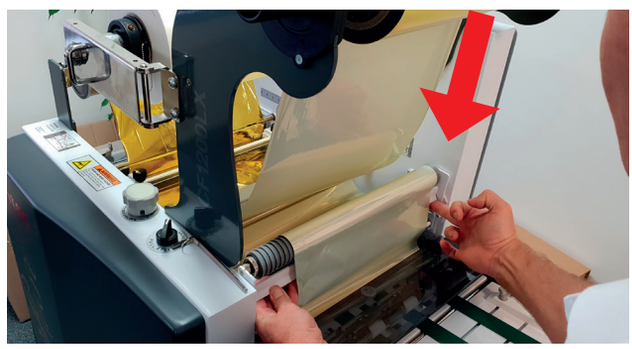


③ Flip the Premium Flaring Roller upside down (180°) so the Silicon Waffles don't catch/snag on the foil), then slide the premium flaring roller (upside down) under the foil you have extended forwards.

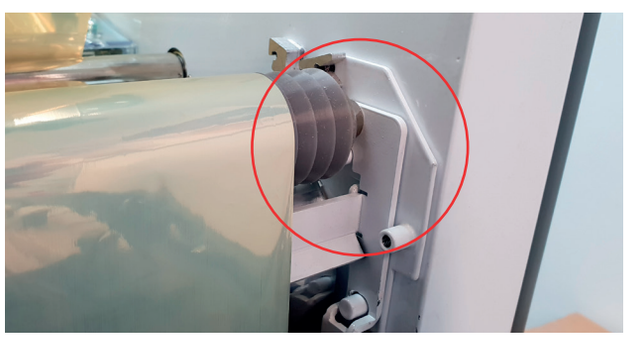
④ Now rotate the Premium Flaring Roller back to the right way up (Silicon Waffles at the top).



⑤ Carefully slide the ends of the Premium Flaring roller into the mounting guides on either side at the front.



⑥ Ensure the locating lugs meet, and the Premium Flaring Roller assembly is fully sat home as shown below.



⑦ Wind back any slack foil on the Input Roll then replace the Safety cover and remember to engage the Safety Lock.

7.5 Using the PULL ROLLER control for improved flaring

As described in section 4.5.3, the Pull Roller pulls laminated media through the ColorFlare. For most flaring it is okay to leave it engaged. However for heavy media or media that is not entirely smooth, the foiling effect can be improved by releasing the Pull Roller.

The PULL ROLLER is required to start feeding media through the machine therefore it is important to remember to set the PULL ROLLER to 'PRESS' at the start of a run. After the first 2 waste sheets, when your first Job sheet is passing under the Heated roller, you should RELEASE the pull roller.

❶ Set the PULL Roller to PRESS

❷ Press RUN on the Control Panel

❸ Wait for the first sheet under the mirror roller to reach the exit tray (Your seconf sheet will be halfway through the ColorFlare and the third sheet (normally your first job sheet) will just have been picked up.

❹ Turn the PULL ROLLER control to RELEASE. But be-careful to watch the media behind the heated mirror roller to make sure it feeds still correctly.

TOP TIP

If the Decurl bar is elevated, this may cause sheets to not be pulled through the ColorFlare by the rewind spooler, either reduce the decurl bar or turn the PULL Roller back to Press.

❺ When stopping, OR after a misfeed remember to turn the PULL Roller control back to PRESS.

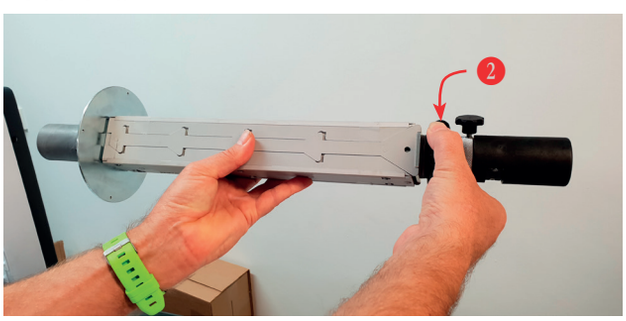
7.6 Using the Additional Roller Assembly for Flaring (CF1200LX)

This guide shows you how to load a roll of foil using the second arm assembly already detailed in section 4.7. It is assumed you have already removed the Skewing Wheel and Perforating wheel, as described in section 7.2 and that the Flaring Bar has been installed to recover the waste foil.

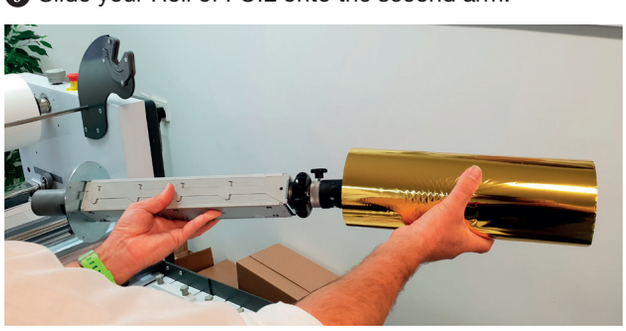
As the instruction in 7.2 shows how to Web the Foil when Laminate has just been used, this guide will show how to web the foil if NO Laminate or Foil have been used. Either method is is fine, this is simply shown to provide a contrast.

❶ Remove the 2nd Roll Holder by lifting it out of the support cups/brackets.

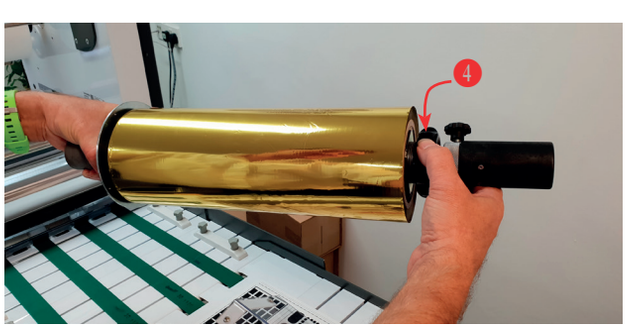
❷ Loosen the Expand Dial to make the CORE of the Roll Holder small.



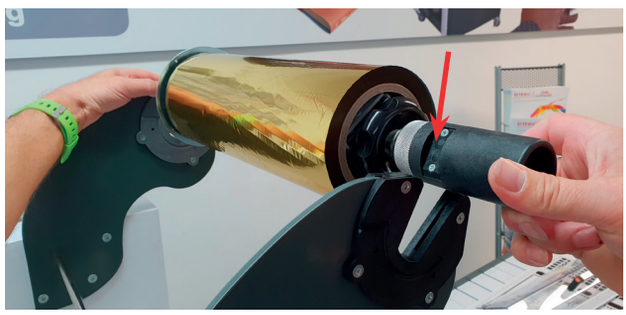
❸ Slide your Roll of FOIL onto the second arm.



❹ Turn the EXPAND DIAL ❹ to grip the roll, and check it is gripped.



❺ Place the Roll Holder back in the Support Cups/ Brackets on the additional Arm assembly.

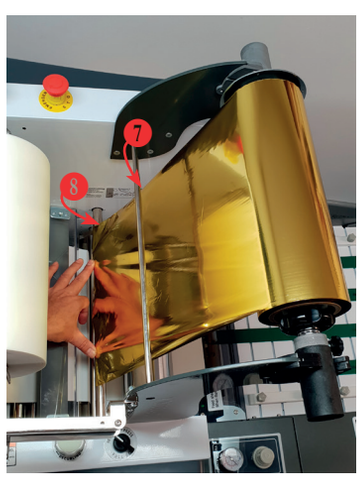


❻ Pull some foil and leave it hanging from the roll of foil. If you have mounted the roll correctly, the Foil should hang down the rear of the foil roll as shown in the image to the right.

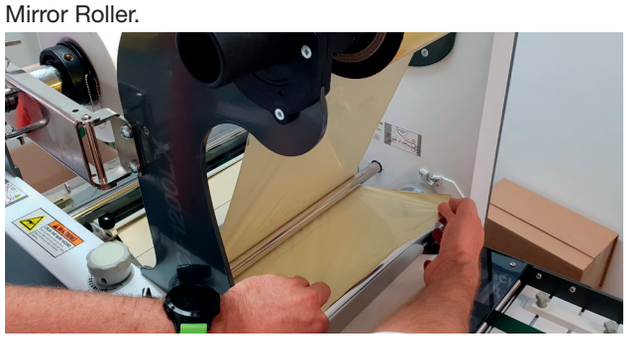
❼ The Foil should go IN FRONT of the support bar shown (7).

And then BEHIND and UNDER the IDLE Bar ❼ The same as Laminate.

This can be seen from a different angle in the next image.

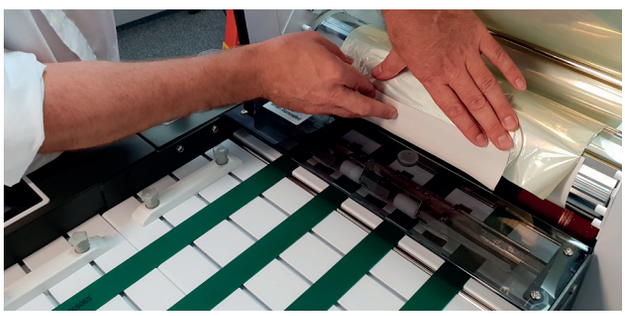


❾ Pull the Foil under the IDLE Bar and over the heated Mirror Roller.



7.6 Additional Roller Assemby for Flaring (CF1200LX) Cont.

❾ Pre-load the ColorFlare with a sheet of paper to act as leader and to help web the foil (as detailed in the laminate section - Pre-Load paper path 6.2.1) . Then using some adhesive tape, stick the Foil to the backside of the Paper you have webbed through the machine.



TOP TIP

If you do this with the HEATED ROLL on (At heat), then make sure you use a non-heat sensitive glue on the adhesive tape, or the heat of the roller can make the glue loose tack and the foil cannot be pulled through the machine; when you pull the paper, the adhesive tape will just come off.

❿ Release any tension applied to your FOIL roll to make it easier to pull your paper leader through the machine.

⓫ Pull the paper leader through the machine and UNDER the Flaring Idle Bar's lower roller.

⓬ Now pass the paper leader back behind the UPPER bar on the Flaring Idle bar assembly.

⓭ Pull the paper leader through the ColorFlare, so thatt eh Foil passes through the Flaring Idle bar (as you routed the paper and as shown).
Continue to pull foil through machine 150mm more (6").

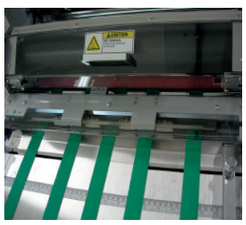
⓮ Replace the rear safety cover If you removed it when fitting the Flaring Idle bar. Then using some adhesive tape stick the end of the foil that has been webbed through the machine onto the rewind spooler.

⓯ Now close the front Safety Cover (Fit the PREMIUM FINISH FLARING BAR first - as detailed in section 7.4). Now you can start foiling.

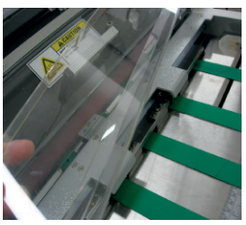
8. MAINTENANCE.

8.1.1 Adjusting pressure on Feeder

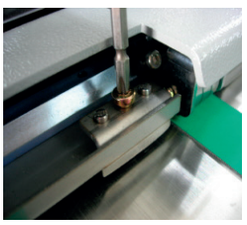
The thickness / surface status of the media substrate may require adjustment on Feeder Stopper Shutter. Different pressure on the green belts by the shutter could be a cause of twisted paper fed, miss feeding, etc. for error in feeding.
Below is the method to adjust the pressure.



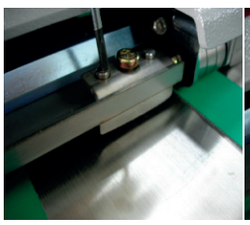
1. Remove Cover Bolts

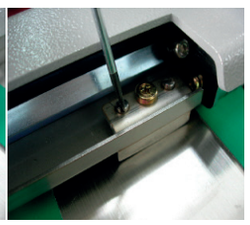


2. Remove Cover



3. Remove Fixing Bolt





4. Adjust height of pressure adjustment bolt

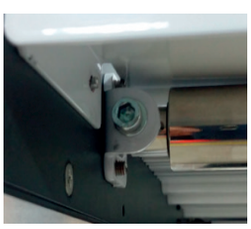
NOTE : After the pressure adjustment is done, make a test lamination to ensure pressure is satisfactory.

8.1 2 Adjusting Tension of Conveyor Belt

Over the life of the ColorFlare it is natural that the conveyor belt may loose tension.

Under such circumstances, as the belt looses tension, the feeding may no longer work properly.

You can adjustt the conveyor belts tension with Tension Adjustment Bolts that are under the Feed Table.
Turn the adjustment bolt to the right to increase tension and turn it to the left to decrease it.



(Adjust it with 5mm Wrench.)

9 TROUBLE SHOOTING

9.1 FEEDING ISSUES

Feed does not start when you press RUN	Safety Switch on the Heated Mirror roller cover is open.	Close front safety cover catch
	Safety Switch on the rear roller cover is open.	Close rear safety cover catch
	Feed Table incorrectly assembled (Short fixing bolts used on left side so micro-switch not engaged)	3. Re-fix front feed table according to instructions
	Faulty Controller	Contact Intec Dealer
	Faulty Main motor	Contact Intec Dealer
	Faulty Timing belt	Contact Intec Dealer
	Fuse disconnected	Check / Replace fuse
ColorFlare does not open Feeding Gate to feed next sheet of paper, and stops with paper out error.	Initial start feed sequence incorrect	At initial start, there must be a sheet of paper under the heated mirror roller AND one placed ALL the way up to the gate. The feed timing is ONLY taken from the lead edge of the second sheet, so always restart with a 'waste' sheet under the mirror roller and one in the gate.
	Paper size set incorrectly	Using "PAPER LENGTH" button on control panel, set the right paper length For an explanation on the function button, refer to the function button "PAPER LENGTH"
	Paper sizes are not consistent.	Gate timing assumes a fixed, consistent paper size. Use all the same size sheets.
Feeding interval is irregular	Paper size set incorrectly	Using "PAPER LENGTH" button on control panel, set the right paper length For an explanation on the function button, refer to the function button "PAPER LENGTH"
	Paper sizes are not consistent.	Gate timing assumes a fixed, consistent paper size. Use all the same size sheets.
Paper does not feed/advance	The edge of the paper is curled down and catches on feed table.	Try to reverse curl the paper and try feed again.
	The edges of the paper curl up and either catch the feed gate or do not make sufficient contact with the feeding belts.	Try to reverse curl the paper and try feed again.
	The paper guides are too tight	Move the paper guides further apart
	Conveyor tension is not good	Refer to the Maintenance Section (sec: 8) in the ColorFlare manual "Conveyer belt tension control"
During operation, the ColorFlare suddenly stops	Emergency Stop switch was pressed	Unlock the emergency switch, Refer to other device "Emergency Switch"
	Feeding error, front/rear paper feeding interval is larger, system stops	Using "LOADING" button, feed the new paper Refer to button "LOADING" (Section 5)

9.2 LAMINATING MATERIALS

Good lamination is where the adhesive of the laminating film has penetrated the paper. So, that the paper, image and film have become one. Therefore if you attempt to peel the laminated film from the paper, you can see the paper is also torn out with the film. (This is known as high bonding strength). Laminating has 3 influencing factors.

1) Paper surface
2) Adhesive
3) Anything that may block the adhesive from penetrating the paper (such as the Image

Due to factor 3 (the type of Image being laminated) there are 3 main types of Laminate. (Litho, Digital Toner or Digital Indigo)

With Litho Prints, there is no wax or oil in the ink, and the ink has in many cases partially penetrated the paper. Therefore a standard laminating film, requires very little adhesive.

Basic Litho Laminates: Typically the adhesive is 8% - 12%, and no additives are required. This adhesive is quite cheap, therefore Litho (OPP) basic laminates are quite cheap. But note, low cost OPP Laminates or laminates with low adhesive are unlikely to bond well to digital prints

Digital Laminate for Toner based prints: A toner based digital printer creates an image with an oily surface or other ingredients (Waxes) for their higher print quality , in this case the normal amount of 8 - 12% of EVA found in regular laminates for litho applications cannot penetrate through the image and bond in to the paper. So often on cheap laminates you can see the image area 'silvering' or the laminate lifting on high toner coverage image areas. Therefore the MegaBond DIGITAL version of Intec's laminates contain a massive 28% EVA, (with 18% of Vinyl Acetate) Plus Intec Digital laminates also include an additional "special additive" in the MegaBOND adhesive that penetrates the waxes and oils in toner, enabling the adhesive to reach deeper into the paper.

Digital Laminate for Indigo Ink: Indigo Ink also requires a 3rd and different adhesive again, Indigo images are neither a Litho print NOR a Waxy silicon based toner print. This is a kind of "Digital Liquid ink". With heatthe ink melts and binds to the laminate rather than allowing the laminate to become one with the media/ substrate. Therefore with Indigo prints, you require higher adhesive levels than the standard Adhesives, plus due to the liquid effect of the Indigo Ink, laminates used on Indigo prints require the adhesive to melt at a lower temperature, enabling binding to the image and substrate prior to the liquid image lifting.

Always make sure you select the right type of Laminate for the print you will be Laminating.

9.2.1 LAMINATING ISSUES

Laminating results are not good - Laminate does not bond to media or High toner areas (Silvering)	Laminating Roller pressure is low.	Using pressure controller, increase the pressure - Refer to Laminating "Roller Pressure control"
	Laminating temperature is low	Increase Temperature or Decrease the speed
	Laminating Speed is too high for the temperature	Decrease the speed or Increase Temperature
	Laminate type used is not appropriate for the imaging device	Check the laminate used is correct for your image (See note above). Try alternative laminate with higher bond adhesive.
Laminating results' curling	Decurling Value is lower	
	Paper thickness is thin	
	Tension too high on Laminating Input Roller	
Crease on the laminating results	Paper Humidity is too high	Use sufficiently dried paper
	Paper is too thin for laminating	Don't use paper below.(80~120g/)
	Temperature is too high	Decrease the laminating temp
	Paper width is >30mm wider than the film	Use laminating film that reaches 3 - 5mm from the paper edge
	Laminating Roller pressure uneven	Contact Intec Dealer
	Laminating Roller is damaged	Check roller for adhesive or paper stock to it and remove, if damaged then Contact dealer

9.3 Separation / Bursting Issues

Bursting roller does not work	Bursting roller motor is faulty	Contact Intec Dealer
	Fuse has blown	Check Fuse and replace
	Compressor has malfunctioned	Check compressor connections, Contact Intec Dealer.
Laminated sheets do not separate/Burst	Cutting edge of perforator is not sharp	Adjust the cutting edge using height control bolt - Refer to the Perforator "Perforator Control" If necessary replace perforating wheel.
	Bursting roller pressure is not good	Adjust the height of rollers using Cutting roller height control Knob - Refer to the "Cutting roller height control Knob"
	Burst timing is not regular	Timing resetting using "BURST POSITION" button on control panel
	Bursting inconsistent	Using "BURST SPEED" button on control panel, rotate the cutting roller at high speed.

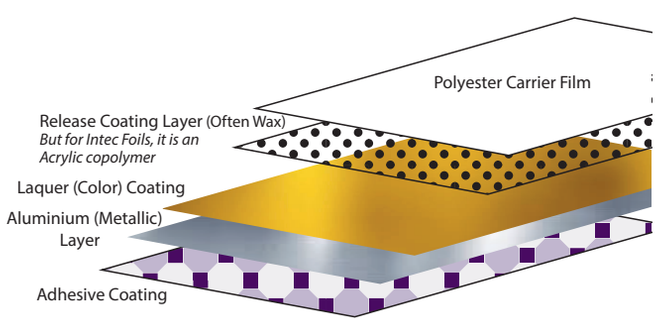
9.4 FLARING FOIL & SPOT FILM or HOLOGRAPHIC MATERIALS

A good foil is a complex material, with multiple layers. In principle, the colored aluminum particles are suspended on a carrier film. As toner is heated, it becomes tacky (Glue like) and as the foil comes into contact with the toner, the toner adheres to the foil.

On a good foil, the release layer will let go of the foil very easily and it will adhere to the toner as the toner cools again.

But foils are very complex and there are many different brands and types.

Please be aware that changing your supplier of foil can create significant foil quality issues.



Intec foils have microfine crushed aluminum particles, which provides a cleaner, finer and sharper edge to characters. In addition Intec foils are premium construction foils and use an adhesion multiplier coated to the base of the foil to significantly improve the toner's bonding power with the foil. Finally cheaper foils often use a wax to hold the Colored Aluminum particles onto the release layer/carrier film. However, the wax is left on top of the foil and can contaminate high end digital print devices, so Intec premium foils use a light Acrylic co-polymer, that releases very easily but then leaves a printable surface so the foils can be over-printed.

Always make sure you select the right type of Foil for the print you will be Foiling.

9.4.1 FOILING / FILM ISSUES

Foil not smooth, wrinkles or creases through flat areas	Paper too thin, and is wrinkling with heat under foil.	Use a thicker paper. 120g - 150gm
	Temperature too high, Foil is distorting due to heat.	Reduce temperature, most toners melt at 110 - 120C (230F - 248F) We recommend using 115C in most cases. (239F)
	Premium Flaring Roller Assembly Not fitted, and so increased tension on foil is required.	Install the Premium Flaring Roller, and use low tension on the film. If you do not have the Premium Flaring Roller, then adjust the tension to remove the wrinkles. In some cases this is quite high tension, in other cases a low tension and the Mirror roller may iron out most ripples.
	Foil was not webbed straight and is being re-wound at an angle to front foil.	Check the position of the edge of the foil on the front roller, measuring to the back chassis. Then measure the rear roller to the back chassis. Reposition the rolls in the same place (It takes 3 or 4 sheets after moving the foils for the change to work through).
	Pressure too high	The shape of the lower roller means that when foiling your pressure should be : 0.5mpa - max 0.6mpa. Running above this pressure, means the lower roller will distort due to pressure, and cause wrinkles, So reduce the pressure. However, very thin stock may also benefit from pressure down to 0.25mpa.
Foil does not cover toner, holes in foil coverage (Toner can be seen through foil)	Temperature too low	Check the temperature, and ensure the machine has reached temperature. most toners melt at 110 - 120C (230F - 248F) We recommend using 115C in most cases. (239F)
	Toner Density is too low	Toner works like glue; if you have a low toner coverage, then try to increase your toner density or double hit the area to be foiled with 200% toner.
	Speed is too high	Reduce the speed, typically best results are achieved foiling at speed 2 - 5, we recommend foiling at speed 3.
	Pull Roller is not released	After starting the foiling run, ensure you RELEASE the Pulll Roller, Section 7.5 in this manual.
	Paper is not smooth	If the paper has too much texture, then the foil can not deform to match the paper surface, and will break. Try using more toner to fill the voids, OR increasing pressure. Also try a smoother paper.
	Media is too thick	Max media thickness to foil is 450g or 450micron, use thinner media.
	Laminating or Pressure Roller is Dirty	Check the Laminating roller and remove any Glue Residues, also check the lower pressure roller and clean this if necessary.
	Insufficient Pressure	Increase the pressure. Too little pressure and the foil will not be pressed onto the toner. When foiling your pressure should be : 0.5mpa - max 0.6mpa.
	Foil is not webbed correctly and goes OVER Decurling Roller.	Check the Webbing guide and ensure the foil goes UNDER the Decurl roller, (But over the decurl bar), sometimes, the media can be webbed to pass over both and this causes the foil to be pulled off before the toner has cooled.
	Paper dust or debris on Media	use in a clean environment with clean media.

Some of the Image is missing after foiling (Toner is not on printed sheet)	Temperature is too high	When the temperature is too high, the toner is stick liquid when the foil is being pulled off, if the toner has not started to cool, and harden then the toner will stick to the foil's release layer and be pulled off the sheet. Reduce the temperature, or increase the speed. Most toners melt at 110 - 120C (230F - 248F) We recommend using 115C in most cases. (239F)
	Speed too slow	If the speed is too slow, the temperature effect will be too high, hen the temperature is too high, the toner is stick liquid when the foil is being pulled off, if the toner has not started to cool, and harden then the toner will stick to the foil's release layer and be pulled off the sheet. Increase the speed OR reduce the temperature.
Foiled image has rough edges	Incorrect Foil (You are not using a high resolution Intec Foil)	Use Intec Foils, these are high resolution for a cleaner image and sharper release on character edges.
	The image is not crisp (JPEG compression artefacts are to see, will foil)	The image to foil may not be sharp, and may be a JPEG logo with very light compression artefacts that are not easily seen by eye as they are 1- 3% in tint, but these will foil and become 100% dots so very easy to see, check your artwork.
Dots or Foil in background	Print uses security marking in Y channel (Difficult to see by eye) but this foils making it easy to see	May printers image a security code in the background of the image on the Y channel, this can not be seen by eye, only under a glass, but when foiled, it is more obvious Change the printer MODE to MONOCHROME, in most printers this deactivates the Y channel and removes this security mark.
	Media not suitable, and attracts Toner	Some media have a coating that becomes tacky when heated, this may attract the foil. Use a clean sheet (that has not been through the printer, and see if the background is clean, if not then reduce temp slightly , if still not clean , then the media may not be suitable.
	Printer suffers from significant background toner scatter.	Different media settings use different electrical properties in your printer. An incorrect setting can create an exceess of toner in the background on your sheet, and this may foil. To check if this is the case, use a CLEAN sheet of media that has not been in the printer and try to pass it through the machine. if it is clean, then adjust your printer settings to reduce backgrounding.

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PRINTING SOLUTIONS

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