

*AKILES*

# ProLam *ULTRA-X6 / XL*

6 Roller Heavy Duty  
Pouch Laminator



## Operation Manual

Make sure you read this manual before using the machine.  
Store this guide safely, so that you can use it in the future.

# 1. Specifications

Max. Laminating Width	13" (330 mm)	18.9" (480mm)
Max. Laminating Speed	59" / min	47" / min
Max. Pouch Thickness	14 mil (350 mic)	
Max. Laminating Thickness	1/8" (3 mm)	
Heating System	4 Heated Rollers	
Q'ty of Roller	6	
Operating Temp	32°F - 284°F	
Temperature & Speed Control	9 Settings	
Preheating Time	6 mins	
Power Consumption	1,050 watt	
Rating	100V, 50/60Hz, 9.3A 110-120V, 50/60Hz, 10A or 220-240V, 50/60Hz, 5.5A (check label)	
Dimension	21"x10-1/2"x5"	27"-1/4"x10-1/2"x5"
Weight	33 lbs (15Kg)	44 lbs (22Kg)

# 2. Electrical Safeguards

## WARNING

1. Do not operate with a damaged power supply cord or plug, after it malfunctions, or after it has been damaged in any manner.
2. The pouch laminator must be connected to a supply voltage corresponding to the electrical rating of the machine as indicated.
3. Unplug the pouch laminator before moving it, or when it is not in use for an extended period of time.
4. Do not overload electrical outlets beyond their capacity as this can result in fire or electrical shock.
5. Do not alter attachment plug, plug is configured for the appropriate electrical supply.
6. The unit is intended for indoor use only.

### 3. Safety Precautions

#### **WARNING**

1. Do not allow neckties, scarves, or other objects near the machine, as they could get caught by the rollers and be pulled inside, causing serious personal injury.
2. To prevent possibility of electrical shock, do not immerse machine in water or permit liquid to spill inside.
3. Close supervision is necessary when any appliance is used by or near children.
4. Do not open the cover (or back) without an authorized technician.
5. The socket-outlet shall be installed near the equipment and shall be easily accessible. Disconnect the attachment plug from the receptacle to which it is connected and keep the power supply cord in your possession while moving the laminator.

### 4. Laminating Precautions

#### **WARNING**

1. Insert pouches with the sealed side first.
2. Please use standard film sizes.
3. Do not use film that has been cut.
4. Please follow the recommended heat & speed settings.
5. Hot surface : Do not touch the bottom of the machine while in use.

## 5. Lamination Guide

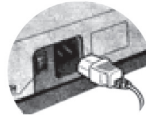
Temperature and Speed Settings			
Film	Paper (20lb)	Temp (°F)	Speed
3mil	Copy	212	6
5mil	Copy	230	5
7mil	Copy	239	5
10mil	Copy	248	4
14mil	Copy	266	4

\* These are recommended settings. Temperature & speed adjustments may be required for different melting pouches, substrates, or carriers.

## 6. How to Use

1. Turn the switch on behind the machine.

2. If it is not the first use,  
Hold the **POWER** button.



3. **Hot Lamination**

Press the **HOT** button.

Initial setting is 212°F and speed 6.

The machine will start to heat up and the hot icon will flicker.

4. When the machine reaches the set temperature, it will beep 3 times.

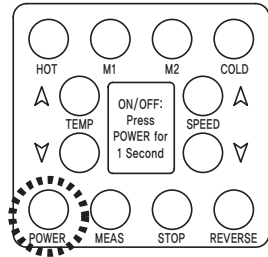
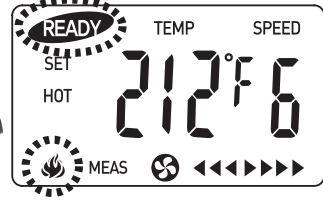
Now you can start to laminate.

**⚠ Warning-Always insert the sealed side first.**

5. **Adjusting Temperature and Speed**

You can adjust the speed settings (1~9) if you wish to laminate faster.

-When the seal of the pouch is not satisfactory,  
increase the temperature..



6. **Auto Shut Off**

Hold the **POWER** button until Cool is shown on the display.

Once the machine reaches below 149°F the power will automatically shut off.  
(Keep the temperature 158°F and speed 2 for “STAND BY” mode.)

**⚠ Warning**

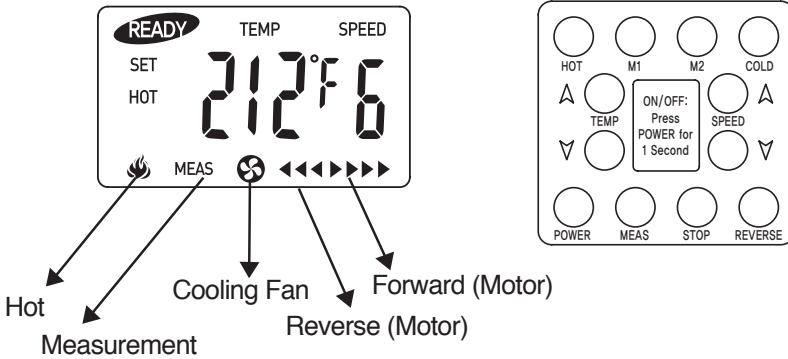
**Do not turn off the Power Switch as soon as you are done laminating  
to prevent overheating the rollers.**

7. **Cold lamination**

**Press the COLD button.**

-The machine will start to cool down. It will beep 3 times and display “READY”  
when it is cool enough for cold lamination.

## 7. Description of Control Panel



- **HOT** : Start Hot Lamination
- **COLD** : Start Cold Lamination
- **TEMP ▲▼** : Modify temperature ( 32°F ~ 284°F )
- **SPEED ▲▼** : 1 ~ 9 Steps
- **M1, M2** : Memory function
  - How to modify memory settings
  - 1. Hold M1 or M2 until the temperature starts flashing.
  - 2. Set temperature and set speed.
  - 3. Press M1 or M2 again to save the setting.
- **MEAS** : Display actual roller temp.
- **STOP** : Stop roller operation
- **REV** : Reverse
- **READY** : Ready to laminate

## 8. Trouble Shooting Guide

Problem	Cause	Solution
Machine has no power or rollers are not rolling	<ul style="list-style-type: none"> <li>Power cord is not properly plugged in</li> <li>Power switch is off</li> </ul>	<ul style="list-style-type: none"> <li>Check that the power cord is properly plugged in</li> <li>Check that the power switch is turned on or contact support</li> </ul>
Excessive noise	<ul style="list-style-type: none"> <li>Operation of gears is not smooth</li> </ul>	<ul style="list-style-type: none"> <li>Turn off the machine, and contact support</li> </ul>
Bad lamination	<ul style="list-style-type: none"> <li>Laminated document is wrinkled, damp, or folded</li> </ul>	<ul style="list-style-type: none"> <li>Adjust the temperature lower or higher and / or adjust speed</li> </ul>
No increase of Temperature	<ul style="list-style-type: none"> <li>Check the power plug</li> </ul>	<ul style="list-style-type: none"> <li>Check that the power plug and switch is turned on or contact support</li> </ul>
Frequent curling of film	<ul style="list-style-type: none"> <li>The temperature may be too hot</li> </ul>	<ul style="list-style-type: none"> <li>Lower the temperature</li> </ul>
Edge of document is not sealed	<ul style="list-style-type: none"> <li>Document is too thick to seal the edges of the film</li> </ul>	<ul style="list-style-type: none"> <li>Use a thinner document or leave more space around the edges (approx. 5mm)</li> </ul>
Emergency state	<ul style="list-style-type: none"> <li>Something may be stuck between the heated rollers or they are out of position</li> </ul>	<ul style="list-style-type: none"> <li>Turn off the switch and contact support</li> </ul>

## 9. After Sales Service Information

If you have any problem that can't be solved on your end, please contact Akiles technical support (909)923-7778 or [www.akiles.com](http://www.akiles.com)