



M-T Laminating Machine Specification

1.Perface -----

2.Safety rules-----

3.Specifications-----

4. Features-----

5.Checking and para position-----

6.Operating process-----

7.Debubblers process-----

Perface

ShenZhen M-Triangel Technology CO.,Ltd ,which is specialized in blast phone screen maintain equipemt, integrated design, produce, sales ,R & D as one. The features of small size, light weight, low price and stable quality, etc , was especially used for the communications market and individual mobile phone repair shop. We now supply separation equipment, in addition to dispensing equipment, laminating equipment and glass cover and so on. Provde enquipment and consumables to customers with one-stop shopping, saving a lot of time, it is our concept for “blast phone screen repair , be the technology leader” purpose for “quality first, users best” ,developing with domestic and froeign clients, creates win-win results.

2.Safety rules

For your personal safety, please read the manual carefully, be familiar with the machine's applications and limitations, as well as the related potential danger .

- A. Please read the manual carefully before usage.
- B. Do not start device before closing the doors.

- C. Do not force to open the debubblers door or screwing the screws before eliminating air bubbles or existing cavity pressure.
- D. Using a third ground connection , poor ground line may cause equipment damage or endanger personal safety.
- E. Only professional man can open electrical boxes.

3. Machine technicals

Machine driver : AC220V 1500W

Optional for AC110V /AC220V

Working environment : 20-30°C, clean and dust-free.

Lamination way : Flat-plate lamination type

Efficiency : 90s/1pcs (Separated lamination type) , 1H/80pcs (defoaming assisted type)

Heating mode: constant temperature heating

Used size : All below 7 " model

Device size : 535*425*355mm

Device weight(NT) : 56.5kg

Device power : 800W

Defoaming parameters

Cavity size : H 180mm , Diameter 120mm (put into 15pcs 7-inch screen one-time)

Working temperature : Suggested set 35°C~45°C (can be adjustable according to different OCA temperature)

Defoaming time : Suggested 8~10 minutes (it is best)



4.Features

- *No mould, also can set to be no defoaming or defoaming assisted type to apporve the output.
- *No installation,can be working directly when plug in .
- *Don't need other auxiliary equipment, such as vacuum pump, air compressor.
- *Used standard 6063 aluminum alloy for lamination , durrable, anti-corrosion and no deformation.
- *Debubblers cavity materials is 304 15mm stainless steel,safe.
- *Fitting and debubblers can be operated simultaneously, improve efficiency.
- *The components are imported from Japan.
- *Simple one-touch operation.
- *Japan temperature control, temperature can be accurate to + / - 1 °C.
- *Intelligent constant pressure, laminating and defoaming mode automatically switch.
- *Flat-plate form laminating, stable and even pressure, no bubble, no indentation, easy transportation.

5. Checking and para position



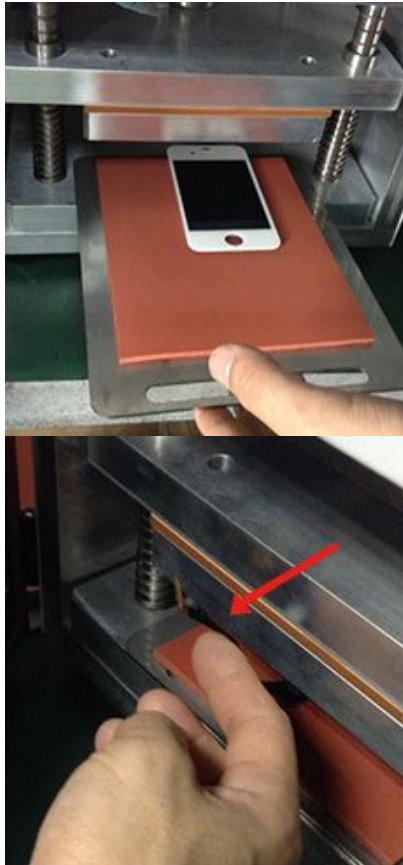
- 1、 Check whether the tray is smooth
- 2、 Check whether there is foreign body on the silicone

pad



3、 Use mould to align

4、 Align the LCD and silicone pad(LCD is on the silicone pad, and the IC is out of the silicone pad. Like the picture showing)



5、 Put the aligned LCD assembly on the operating platform

6、 If the cellphone with long flex cable, let the flex cable be outside of and slightly curved upward.

6.Operating process

Screen pressure process

1. Check the power supply is normal, as well as a platform must be clean.
2. Turn on switch, press the start button and check device is working smoothly.
3. Set up lamination tim in advance , adjust 03M 30S for defoaming automatically type or 13S30Sfor defoaming assisted type.
- 4.Put the LCD with OCA glue onto foam (Note stagger cable foam of IC position)
- 5.Open the door and put into the tray to compartment.
- 6.Close the door .
- 7.Press the start button;

8. Please wait 2~3 minutes.

9. Please take out the product when two buttons light off or lowest vacuum gauge.

10. The whole process was finished, check everything is normal.

11. Set to be 13S 30S for defoaming assisted type, do some debubblers.

7. Debubblers process

Note : The bubble will be larger after fitting, because of OCA glue. we can remove bubbles as following tip.

1 :

1. Put the LCD with OCA glue onto foam (Note stagger cable foam of IC position)

2. Open the door and put into the tray to compartment

3. Close the door

4. Push button

5. Set the time according to remaining bubbles.

6. Push button again and take out.

2 :

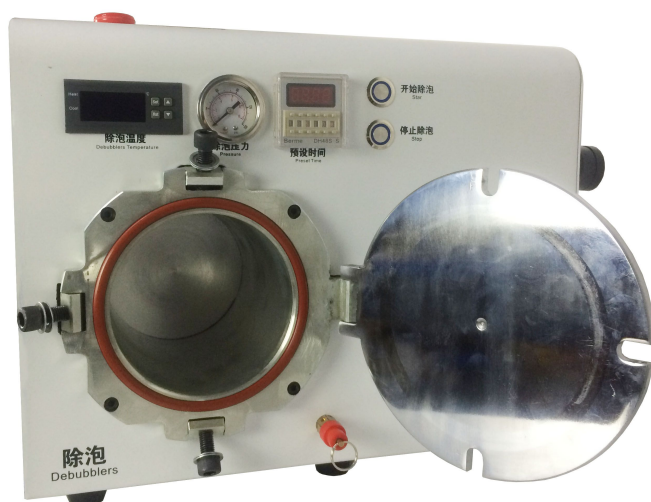
1. Used defoaming assisted type for debubblers.

2. Put product into the debubblers cavity, 15pcs 7-inch screen one-time.

3. Close door, tighten three screws separately.

4. Set the time and press start button for debubblers.

5. Debubblers was deflated completely after setting time, also take out from the door.



Maintenance

Maintenance items	Maintenance notice
Mold base	check and clean odds and ends
Lamination pole and table slide rails	Oiling into the lamination pole and table slide rails,keep working smoothly. (2-3 month will be better)
Radiating net	Keep clean, Non-clogging

The relations of altitude and vacuum degree

Generally, the vacuum pump' s design and testing were processed under standard atmospheric environment. If altitude changed, the actual perofomance will be changed. Please check the following table details.

Altitude (m)	vacuum	
	(-Mpa)	(mmHg)
0	0.1013	760
200	0.0990	742.7
400	0.0968	726.2
500	0.0957	717.9
1000	0.0902	676.7
1500	0.0846	634.7
2000	0.0790	593.3

For example : Chengdu city, Sichuan province Altitude:505.9

Vacuum :93~95 is normal

Yulin city, Shanxi province Altitude:1057.5

Vacuum :88~90 is normal