



AQUASEAL<sup>®</sup> Sign Coater

Model 1371

# Owner's Operation Manual







## INTRODUCTION

### AQUASEAL SIGN COATER

Thank you for purchasing the AQUASEAL Sign Coater - Model 1371. As you become familiar with the coater, you will appreciate its high quality of workmanship and excellence in its engineering design.

By following the guidelines for proper care and use of the AQUASEAL Sign Coater you can depend on maximizing your return on investment.

The purpose of this manual is to describe installation, operation and maintenance of your AQUASEAL Sign Coater to enhance signs, displays, and other flexible graphics with professional results.

**Please read and fully understand the entire manual before using your coater.**



**Figure 1: AQUASEAL Sign Coater  
Model 1371**

### STATEMENT OF INTENDED USE

The AQUASEAL Sign Coater is ETL approved to UL standards and CE approved to European standards. The unit has been designed to be used with AQUASEAL Sign Coat and AQUASEAL Liquid Cleaner. When used with these products, you are able to laminate a variety of flexible substrates from 5 to 14 mil thickness.

We highly recommend using only AQUASEAL Sign Coat and AQUASEAL Liquid Cleaner for maximum performance from your new coater.

The AQUASEAL Sign Coater uses a three-step process to coat the graphics and clean the system without having to manually scrub the Meyer Bar Roller. This includes two different liquids and water.

- Step 1 -- AQUASEAL Sign Coat
- Step 2 -- AQUASEAL Liquid Cleaner
- Step 3 -- Neutralizer (Water)

**WARNING: This coater is designed for single sided laminating. Use for other than these purposes may cause damage to the coater or physical harm to the user.**

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

## LIABILITY STATEMENT

Details provided in this manual are based on the most current information available. However, these details may be subject to change at any time. SEAL Graphics retains the right to make changes to the construction or design of our products without accepting any responsibility for modifying earlier versions previously delivered.

**CAUTION:** Pay attention to all passages marked this way. This information is vital to preventing user injury and/or damage to the unit. Failure to follow this information could void the user's warranties and transfer all safety obligations to the user.

## WORKSPACE & INSTALLATION

### WORKSPACE

Place the unit in a well lit, dust free area with plenty of room for laying out wet prints. The coater must be level. Make sure to place the coater in an area with adequate ventilation. Do not place the unit near open flames. Depending on size of the images being coated, drying racks may be appropriate, there are after market racks available. Two examples are Dick Blick Art Materials – [www.dickblick.com](http://www.dickblick.com) and Saturn Rack Company – [www.saturnrack.com](http://www.saturnrack.com).

Space should be available so that there is sufficient feed-in/out area, as well as space in which to place tables for drying and trimming.

### UNPACKING

The AQUASEAL Sign Coater is shipped in two containers. The largest container holds the coating unit, a bag of hardware, and this manual. The smaller container holds the stand assembly, assembly instructions, the casters, and a bag of hardware. It is recommended that you assemble the stand first.

### SETTING UP

- Assemble the stand.
- Place the AQUASEAL Sign Coater over the matching holes in the leg support brackets.
- Fasten the coater to the brackets using screws and washers provided.
- Fasten the storage shelf to the stand.

### ELECTRICAL REQUIREMENTS



**Follow power installation set up instructions below before connecting the supply power.**

Check voltage selector switch position before connecting the supply power. The voltage selector switch is located above the power inlet. Use a straight blade screwdriver to slide voltage selector switch all the way right or left to match the supply power. The correct supply voltage should be visible. Failure to have the voltage selector switch in the correct position could result in poor performance or unit damage.

**CAUTION:** We recommend that the coater be connected to an electrical circuit with a Ground Fault Interrupter (GFI) circuit breaker.



## SAFETY

The AQUASEAL Sign Coater is designed to use water-based lacquer only. Use of solvent based or other manufacturer's lacquers may damage the machine and void the machines warranty.

**WARNING: Whenever using any equipment, always follow manufacturers' instructions to ensure safe operation.**

Become familiar with all operational controls and ensure that all pre-start settings have been established.

Comply with all safety warning signs, labels and instructions.

Ensure that prior to clean-up, eye protection, clean towels, rubber gloves and ventilation devices (such as fans) are available where appropriate.

Whenever filling or emptying the lacquer tray, eye protection should be worn. Ensure that an approved eyewash station is adjacent to the coater.

Avoid contact with uncured lacquer. In case of skin contact, use soap and water to clean the skin.

**DANGER: Do not use solvents to remove lacquer from the skin. Solvents can cause lacquer to penetrate the skin.**

**CAUTION: Prior to handling any chemical product, read the product label for safe handling information. Also review MSDS sheets prior to chemical use to gain a complete understanding of health, safety and environmental information. Observe manufacturers recommendations when handling chemicals.**

To obtain MSDS Sheets for any SEAL products, contact SEAL Technical Services at (800) 486-6502 (USA) or +31 572 345 500 (Europe).

## SAFETY COVERS

The two end safety covers (blue) protect the user from the mechanism used to power the roller assembly. Only qualified maintenance or safety personnel should remove the covers for maintenance upkeep or repair.

**DANGER: FOR ANY SERVICING, ALWAYS UNPLUG THE UNIT BEFORE REMOVING SAFETY COVERS.**

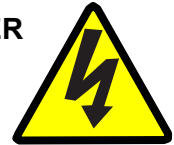
## SAFETY SYMBOLS

**ROTATING PARTS: RISK OF INJURY**



**WARNING: Hazardous moving parts. Keep fingers and other body parts away.**

**ELECTRICAL PARTS: DANGER OF BEING INJURED BY ELECTRICITY**



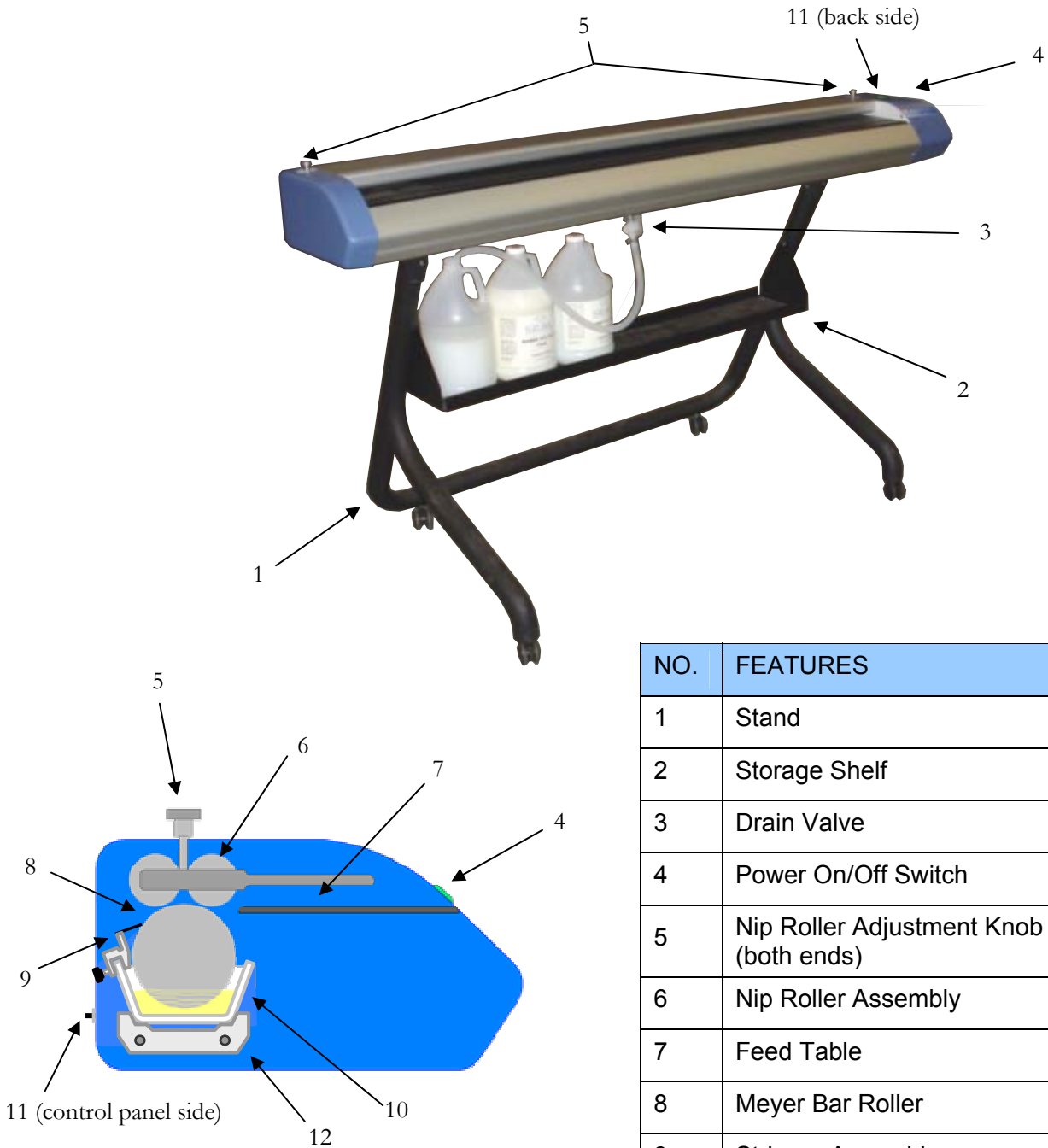
**DANGER: DO NOT ATTEMPT Access TO this area because of the risk of injury by high voltage. Only authorized maintenance OR service technicians SHOULD ATTEMPT repair OF this AREA.**

## PREVENTIVE MEASURES

Be careful not to feed objects such as staples, paper clips and rough or abrasive materials into the nip opening. Keep objects such as tools, rulers, pens, markers or knives clear of the nip opening.

**DO NOT** leave these items on the table to avoid accidentally feeding them into the machine.

## FEATURES



NO.	FEATURES
1	Stand
2	Storage Shelf
3	Drain Valve
4	Power On/Off Switch
5	Nip Roller Adjustment Knob (both ends)
6	Nip Roller Assembly
7	Feed Table
8	Meyer Bar Roller
9	Stripper Assembly
10	Lacquer Tray
11	Voltage Selector Switch
12	Lacquer Tray Bracket

**Figure 2 AQUASEAL Sign Coater Features**



## CONTROLS AND OPERATION

### POWER ON/OFF

The function of the Power On/Off switch is to enable the coater for operations.

### NIP ROLLER ADJUSTMENT KNOBS

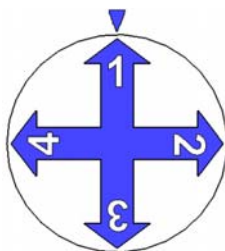
The two Nip Roller Adjustment Knobs control the gap between the Meyer Bar Roller and the Nip Rollers. The gap can be adjusted from a maximum of .06" (clockwise, until tight) to a minimum of .04" by turning both knobs counterclockwise one full turn.

The chart below reflects typical settings. The setting position of 1 is a .06" gap (fully tightened). Settings 2-4 are alternate adjustment positions, set by turning the knobs counterclockwise, up to a  $\frac{3}{4}$  revolution from the tightened position.

**NOTE: Any additional rotation of the knobs counterclockwise beyond one full turn has no affect.**

SUGGESTED NIP SETTINGS	
MEDIA	SETTING
Banner Vinyl – 8oz	4
Banner Vinyl – 12oz	3
Banner Vinyl – 16oz	2
Banner Vinyl – 20oz	1
Cast PSV	3
Calandared PSV	2
Canvas 250 gram	3
Canvas 310 gram	2
Wet Strength Paper	4
The settings are suggested only. Final setting may be different according to materials used and manufacturing tolerances. Seal suggests logging a reference table according to materials you used.	

Nip Gap Adjustment Knob (see figure 2)



### OPERATION

#### MATERIALS NEEDED

Prior to operation, make certain the following materials are available:

- Face shield or safety glasses
- Absorbent towels – clean, lint-free and disposable.
- Rubber gloves

#### PRE-START CHECKS

Plug the coater into a standard outlet (see page 7 for model voltage requirements) and turn the coater ON to start the rollers turning.

Remove stripper assemblies and fill the lacquer tray, being sure not to exceed the lines labeled “Do Not Fill Above” located inside the tray.

**NOTE: The lacquer will evaporate over time. Have plenty of lacquer available at all times.**

Allow sufficient time (a few minutes) before starting operations to ensure the Meyer Bar Roller gets evenly coated with lacquer. There will be a visible white film over the entire width of the Roller when coated.

Once the Meyer Bar Roller is thoroughly coated apply the stripper assemblies. You may begin operations.

**DANGER: Do not operate the coater with the roller cover open.**

### PROCESSING IMAGES

It is important to “batch” your jobs and run them one after the other.

1. Place the image face down and feed it into the nip roller assembly with a smooth and consistent approach at a right angle with the rollers. **TIP: if possible leave a 1 in. border around the image to be coated to prevent a build up of lacquer on the edge of the image.**

2. As the image is fed beneath the nip rollers, lacquer is applied from the Meyer Bar Roller to the face of the image.

**NOTE: The image may not propel itself through the coater on its own. You may need to assist the print through the coater by pulling on the image as it exits the coater.**

3. As the image exits the rollers, grab the top edge on each side and pull up over the coater in a smooth and even motion, being careful not to drip coating on the coater itself. Larger images may require someone on the exit side of the coater pulling up and away from the coater.
4. Turn the image over, coated side up and lay flat on a drying table. TIP: using an oversized soft substrate to lay the print on and tacking the edges down can eliminate uneven coating of the edges.

**NOTE: The coating should be dry to the touch in 15 to 30 minutes, but may not be fully cured for up to an additional 24 hours.**

## CLEANING THE COATER

### GENERAL CLEANING INSTRUCTIONS

**Do not** use spray-on cleaners.

**Do not** immerse any part of the coater in water or other liquids.

**Do not** use an abrasive cleaner, which can damage painted surfaces.

**Do not** allow water or other liquids to enter the electrical circuits, this may cause personal injury and/or damage to the equipment when power is applied.

**NOTE: Leave machine on during the cleaning process.**

After you are finished laminating prints for the day, simply place the drain tube back into the original bottle of liquid coating and open the drain valve.

Next, close the drain valve, and filling the lacquer tray to a depth close to the maximum depth line with AQUASEAL Liquid Cleaner. Let the cleaner “work” in the tray for approximately 10 minutes before draining back into the original bottle in which the cleaner was contained.

**CAUTION: Be sure to transfer the drain tube from the coating bottle to the cleaner bottle before draining cleaner.**

Next, close the drain valve and fill the tray reservoir with water (we recommend filling an empty one gallon jug with normal tap water to facilitate this process). Let the water “work” to neutralize the cleaner for approx. 10 minutes before draining. You can now switch off the power and blot the transfer roller with a dry, clean cloth. The tray may be removed to facilitate this process, and the tray may be rinsed in a utility sink if available.

**NOTE: If you blot the roller while still turning, be sure not to allow any loose ends of the cloth to wrap around the roller. Should this occur, immediately switch off the power and carefully pull to remove the cloth.**

The final step is to use a clean cloth and rubbing alcohol to wipe down the roller to get any last lacquer that may be remaining.

### SERVICE & REPLACEMENT PARTS

Service and maintenance must be performed fully in accordance with the instructions. Servicing by any unauthorized technician voids the warranty. Service Technician must use replacement parts as specified by SEAL Graphics.

### TECHNICAL SERVICE

For technical assistance, please contact SEAL Technical Service Department. (See rear cover.) When calling for technical service please have the Coater serial number available (located on the identification plate on the bottom of main housing)



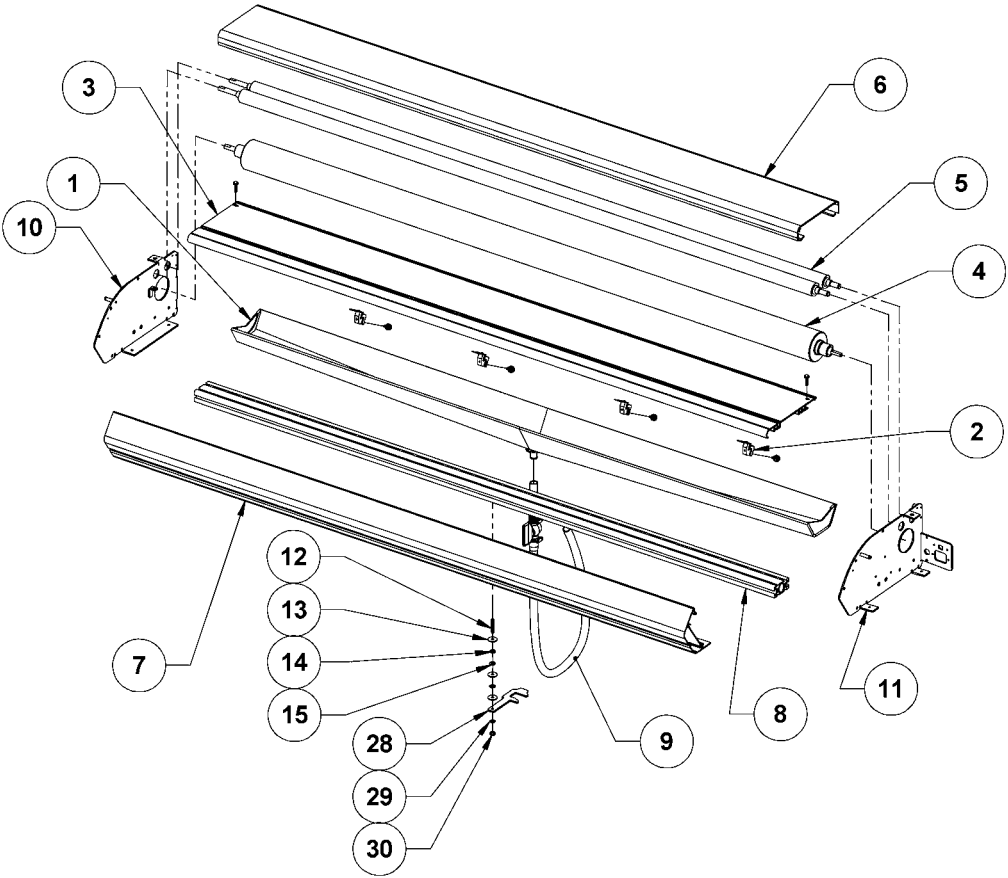


**TECHNICAL SPECIFICATIONS**

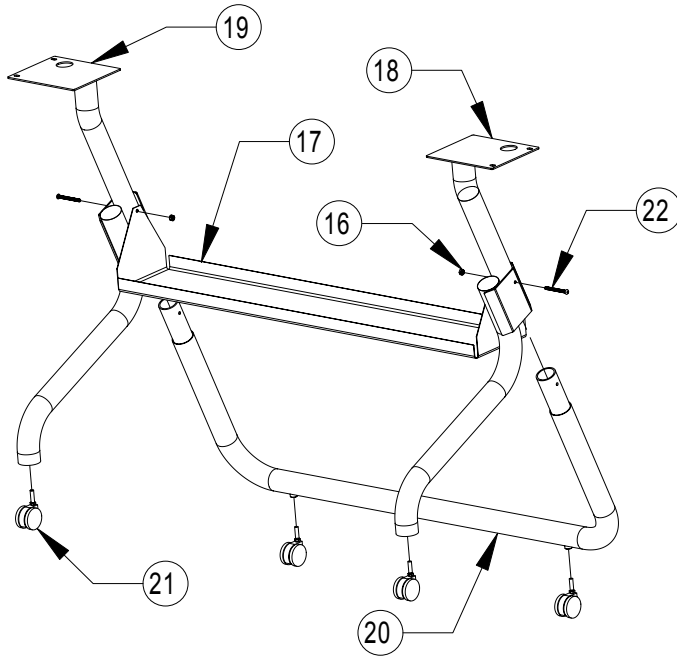
Dimensions (Coater only)	65 in. x 11 5/8 in. x 6 in. (1.65 M x 29.5 cm x 15.25 cm)
Shipping Dimensions (Coater only)	73 in. x 14 in. x 15 in. (1.85 M x 35.5 cm x 38 cm)
Net Weight (Coater only)	75 lbs. (165 kg)
Shipping Weight	80 lbs. (176 kg)
Nip Settings (Coater only)	0.020 in. (0.5 mm)
Electrical	115 VAC/1A/60Hz 230VAC/1A/50Hz
Order Code	64441

Each AQUASEAL Sign Coater has a Serial Number Label. This label indicates the model type, the electrical requirements, and the coater serial number (important for reference if any servicing is required). The Serial Number Label is located on the bottom of the coating unit.

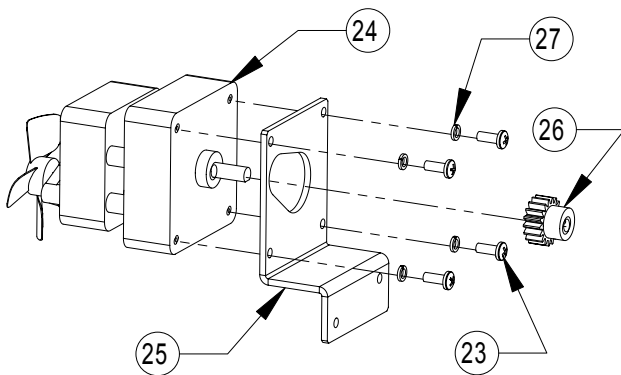
**ROLLER ASSEMBLY**



## STAND ASSEMBLY

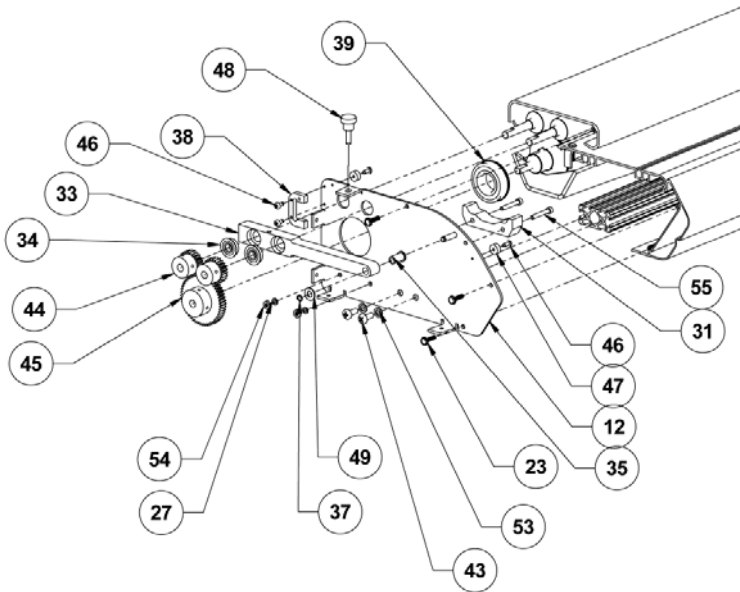


## MOTOR ASSEMBLY

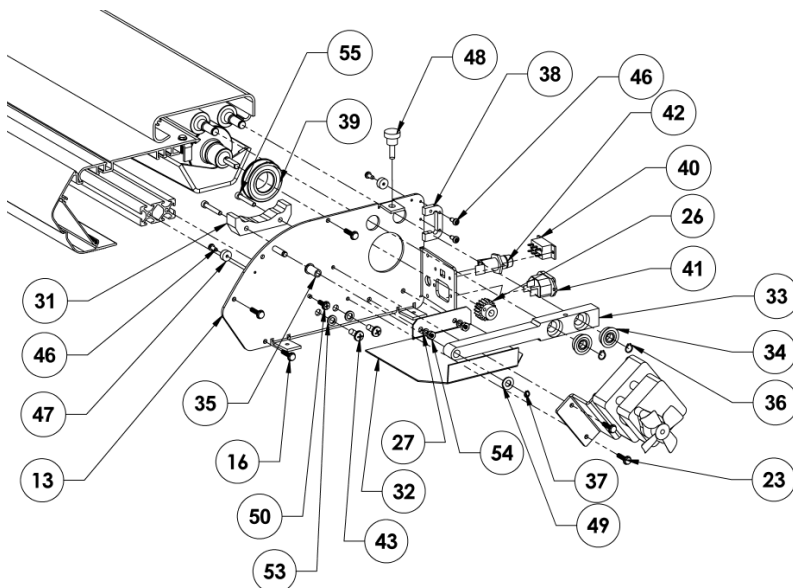


ITEM NO.	PART NO.	DESCRIPTION	QTY
1	7000235	LACQUER TRAY	1
2	7000255	STRIPPER ASSEMBLY	4
3	7000101	TABLE FEED-IN EXT	1
4	7000151	MEYER BAR ROLLER WIRE WRAP	1
5	7000110	ROLL NIP	2
6	7000103	TOP LID EXTRUSION	1
7	7000102	FRONT BAR EXTRUSION	1
8	7000122	RAIL EXTRUDED	1
9	7000179	HOSE ASSEMBLY W/BALL VALVE & CLAMP	1
10	7000205	PLATE ASSEMBLY LEFT SIDE	1
11	7000208	PLATE ASSEMBLY RIGHT SIDE	1
12	7000243	THREADED ROD	1
13	89000137	3/16 FENDER WASHER	3
14	A405100	10-32 NUT	1
15	7000244	DISC SPRING	2
16	7000210	1/4-20 KEPS NUT BLACK ZINC	2
17	7000139	SHELF STAND	1
18	7000191	LEG WELDMENT RIGHT HAND SIDE	1
19	7000192	LEG WELDMENT LEFT HAND SIDE	1
20	7000193	LEG WELDMENT STAND FRONT	1
21	7000196	CASTER TWIN WHEEL SWIVEL	4
22	7000198	1/4-20 X 2.5" BHC BLACK ZINC	2
23	7000209	SCREW, THREAD FRMNG 10-32X3/4"	18
24	7000175	MOTOR, DUAL VOLTAGE	1
25	7000143	PLATE MOUNTING MOTOR	1
26	7000121	GEAR 18T SPUR	2
27	A410101	#10 LOCK WASHER	8
28	7000242	LATCH	1
29	A410100	#10 FLAT WASHER	1
30	A405110	#10-32 NYLOCK NUT	1

## LEFT SIDE GEAR ASSEMBLY



## RIGHT SIDE GEAR ASSEMBLY



ITEM NO.	PART NO.	DESCRIPTION	QTY
31	7000239	TRAY BRACKET	2
32	7000202	SHIELD MOTOR	1
33	7000105	ARM, ADJUSTMENT	2
34	7000203	BEARING, BALL 3/8 ID X 7/8" OD	4
35	7000107	BUSHING, FLANGED 0.250" ID	2
36	7000158	RING EXTERNAL RETAINING	2
37	7000149	RING EXTERNAL RETAINING	2
38	7000104	STOP ADJUSTING ARM	2
39	7000204	BEARING, 1.0" ID X 2.0" OD	2
40	7000182	SWITCH, VOLTAGE SELECTOR	1
41	7000183	CONNECTOR, POWER ENTRY	1
42	88700509	FUSE HOLDER (FUSE - PN 7000164)	1
43	7000161	1/4-20 X 5/8" PHMS	4
44	7000111	GEAR 24T	2
45	7000112	GEAR 50T	1
46	7000155	SCREW 4 X 3/8"	8
47	7000109	BUMPER RECESSED RUBBER	4
48	7000108	KNOB ADJUSTMENT SS	2
49	79036	1/4" SAE FLAT WASHER	2
50	7000162	GROUND SCREW	1
51	7000129B	END COVER - RHS (NOT SHOWN)	1
52	7000126B	END COVER - LHS (NOT SHOWN)	1
53	A410103	1/4" LOCK WASHER	4
54	A405112	#10-32 HEX NUT	4
55	A430183	#10-32 X 1.25" BOLT	4

## LIMITED WARRANTY

SEAL Graphics warrants to the original consumer purchaser that each new AQUASEAL Sign Coater made by SEAL, which proves defective in materials or workmanship within the applicable warranty period, will be repaired or, at our option, replaced without charge.

Effective November 1st, 2002 the applicable warranty period for New Equipment shall be one year (parts) from date of purchase.

This warranty extends to and is enforceable only by the original consumer purchaser, and only for the period (during the applicable term), which the product remains in the possession of the original consumer purchaser. "Original consumer purchaser" means the person who first purchased the product covered by this warranty other than for purpose of resale. This warranty does not apply if it is found that at any time the equipment has not been used for its intended purpose.

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

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

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

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# AQUASEAL<sup>®</sup> Sign Coater Model 1371



## SEAL<sup>®</sup> Technical Service

(For technical assistance & service)

Tel: 1-800-486-6502

Fax: 1-800-966-4554

## SEAL<sup>®</sup> Technical Service – Europe and Asia Pacific

(For technical assistance & service)

For UK: Tel: +31 572 345 500

Fax: +31 572 345 501

For NL: Tel: +31 572 345 500

Fax: +31 572 345 501

## SEAL<sup>®</sup> Customer Service

(For information and placing orders)

Tel: 1-800-257-7325

Fax: 1-800-966-4554

## SEAL<sup>®</sup> Customer Service – Europe and Asia Pacific

(For information and placing orders)

Tel: +31 572 345 500

Fax: +31 572 345 501

**Note: SEAL Graphics recommends that a licensed electrician in accordance with electrical codes in your area install your main power.**

**Seal Graphics  
Americas Corporation**  
7091 Troy Hill Drive  
Elkridge, MD 21075  
Tel: 410-379-5400  
Fax: 410-579-8960

**Seal Graphics Canada**  
1601 Matheson Blvd. E.  
Unit #4  
Mississauga, Ontario  
Canada, L4W 1H9  
Tel: 905-212-9232  
Fax: 905-212-9313

**Seal Graphics U.K. Ltd**  
1, Watkins Close  
Burnt Mills Industrial Estate  
Basildon, Essex SS13 1TL  
United Kingdom  
Tel: +44 1268 722 400  
Fax: +44 1268 725 864

**Seal Graphics Europe BV**  
Kanaaldijk O.Z.3  
P.O. Box 29,  
8100 AA Raalte  
The Netherlands  
Tel: +31 572 345 500  
Fax: +31 572 345 501

**Seal Graphics Pacific  
Limited**  
Unit A, 13<sup>th</sup> Floor, Block 1  
Leader Industrial Centre  
Tsuen Wan,  
New Territories, Hong Kong  
Tel: +852 2407 3738  
Fax: +852 2408 0973



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