Duplo

from print to documents

INSTRUCTION MANUAL

DC-618 Rotary Tool Module

RTM-08

Be sure to read this manual prior to use.
Please leave this manual at the site of use for easy reference.

Introduction

Thank you for your purchase of the DC-618 Rotary Tool Module.
To ensure safe and efficient long-term use of this product, read and thoroughly understand this manual before using the product. After using this manual, be sure to keep it in a handy place for reference.

Pictorial Symbols and Other Notations used in this manual
IMPORTANT : Introduces instructions for correct operation of the product. If these instructions are ignored, the product may not operate at optimum performance or may break down.
REFERENCE : Introduces information that is useful for operation and maintenance of the product, or information about the product's performance, etc.
(→P.00 xxxx): Indicates the page number and item containing related information.

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Notes on Safety (Please Read and Observe)

Safety Precautions

Various symbols and pictures are used in this manual and on the labels affixed to the machine. These symbols and pictures provide warnings and instructions to prevent danger to you or other personnel, and to prevent damage to office property.
The meanings of these symbols and pictures are explained below.

⚠ **WARNING** Indicates a high degree of potential danger. Failure to heed the warning may lead to death or serious injury.

⚠ **CAUTION** Indicates a medium degree of potential danger. Failure to heed the caution may lead to injury or damage to property.

<Examples of Pictorial Symbols>

🚫 A circle with a line through it indicates a prohibited action.
The particular act prohibited is indicated by a picture inside the circle.
(In the example shown here, the prohibited act is disassembly.)

● A black disc indicates an instruction, or sometimes a prohibited action. The instruction itself is indicated by pictorial symbols drawn in white on the disc. (In the example shown here, the instruction is **Remove the plug from the outlet**.)

● Precautions for Use

⚠ WARNING

	● If the machine is used after foreign matter (metal fragments, water, or liquid) has entered the machine, this may result in fire or electric shock. → Turn the main unit's power switch OFF, and then remove the power plug from the outlet. Contact the sales distributor.
	● If the machine is used after heat, smoke, a strange smell, or other abnormality has been detected, this may result in fire or electric shock. → Turn the power switch OFF, and then remove the power plug from the outlet. Contact the sales distributor.
	● Do not insert or drop metal, flammable material, or any other materials through the ventilation holes into the interior of the machine. → Doing so may result in fire or electric shock.
	● Keep the machine away from a pin, wire, or other metallic or foreign objects. Do not allow liquid to enter the machine through its openings or gaps. → Malfunctions and a fire or electric shock may result.
	● Do not place flower vases, flowerpots, cups, or water containers (including metal containers) on top of the machine. → Fire or electric shock may result if liquid spills inside the machine.

● Caution for Cleaning

⚠ **CAUTION**

🔌	● Before cleaning the machine, turn off the power switch and unplug the power cord. → If the machine is activated accidentally, it may cause injury.
🚫	● Do not use flammable sprays or solvents inside or near the machine. → Gas may accumulate inside the machine causing a fire or explosion.

● Preventing Injury to Hands or Fingers

⚠ **WARNING**

✋	● The Rotary Tool Module contains uncovered upper tools. Keep your hands or fingers off inside it.
🔌	● Use pliers or a similar tool to remove jammed document. Be sure to unplug the power cord before removing jammed document in order to prevent an electric shock.

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Chapter 2   Programming a JOB on the Control Panel

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Chapter 6 **Daily Maintenance**

Chapter 7 **Specifications**

MEMO

Chapter 1

Before Using This Module

This chapter contains essential information you should understand such as the part names of the machine and how to remove and install the module.
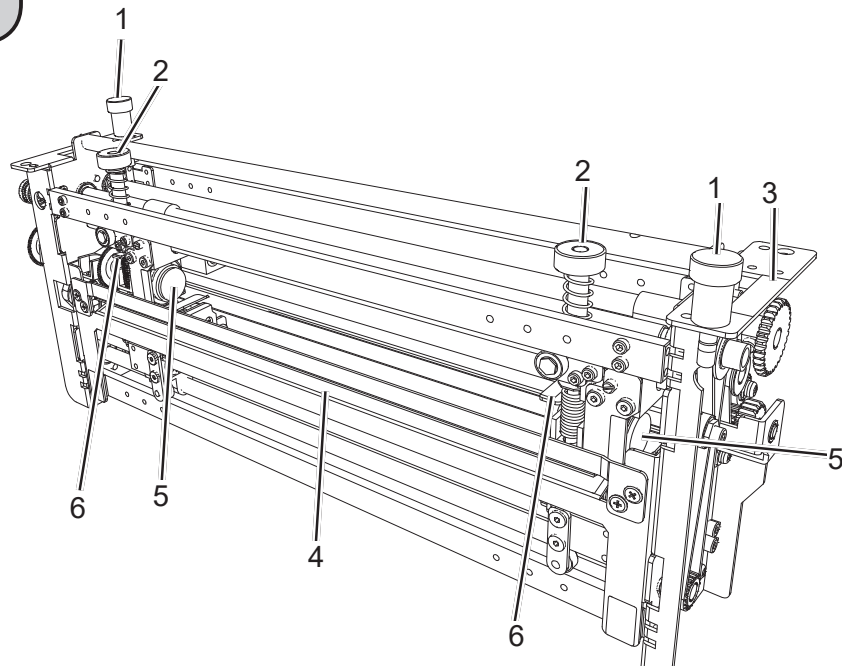
About the RTM (Rotary Tool Module)

Appearance

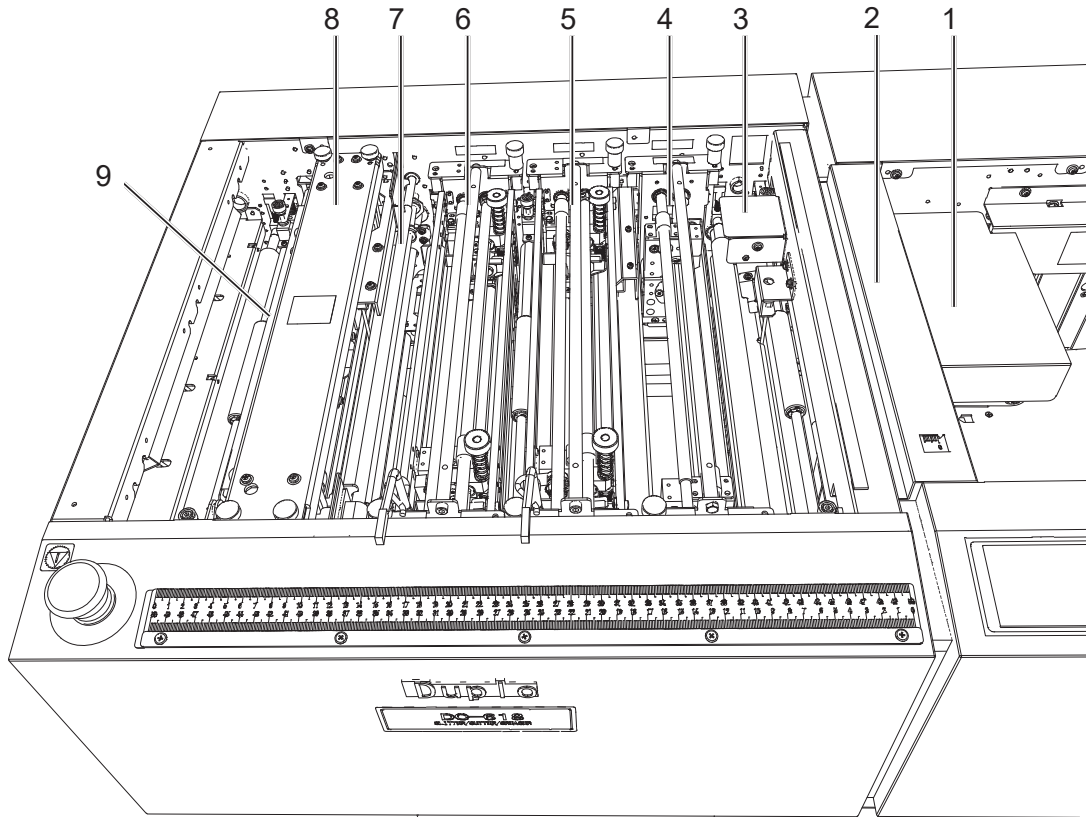| No.	Name	Function
1	Fixing screw	Tighten this when installing the **RTM (Rotary Tool Module)** in the DC-618. Loosen this when removing the **RTM (Rotary Tool Module)** from the DC-618.
2	Adjustment knob	Adjusts the depth of the **rotary tool**. Turning this clockwise makes the depth **deeper** and turning this counterclockwise makes the depth **shallower**. Turn this to adjust the depth of the **rotary tool** depending on the types of it attached to the **rotary too unit**. When replacing the **rotary tool**, turn this counterclockwise until it stops to raise the **rotary tool** to the upper limit position. (→P.10)
3	Color label	Install the **RTM (Rotary Tool Module)** in a slot of the DC-618, to which the **color label** affixed is the same as this on the **RTM (Rotary Tool Module)**. Install the **RTM (Rotary Tool Module)** in slot 2 to slot 3 in order from the document feed side.
4	Guide assy	Supports the conveyance of a document. When replacing the **tool**, remove the **guide assy**. (→ P.7 Removing a Rotary Tool)
5	Hand knob	When removing the **rotary tool** from the **rotary tool unit**, remove this. (→P.7) When attaching the **rotary tool** to the **rotary tool unit**, secure it with this. (→P.9) There are two **rotary tool units** in total attached to the **RTM (Rotary Tool Module)**: one is on the right and the other one is on the left.
6	Lever	When removing the **rotary tool** from the **rotary tool unit** or when attaching it to the **rotary tool unit**, raise this. (→ P.7 How to Replace a Rotary Tool) There are two **levers** in total attached to the **RTM (Rotary Tool Module)**: one is on the right and the other one is on the left.

● Document feed side

RTU (Rotary Tool Unit)

RTU (Rotary Tool Unit)

Adjustment knob

Lever angle

Upper tool
holder assy

Lead shaft

Slide shaft

Guide

Rotary tool

Lower tool

Driving shaft

Lower
tool assy

Slide shaft

Lead shaft
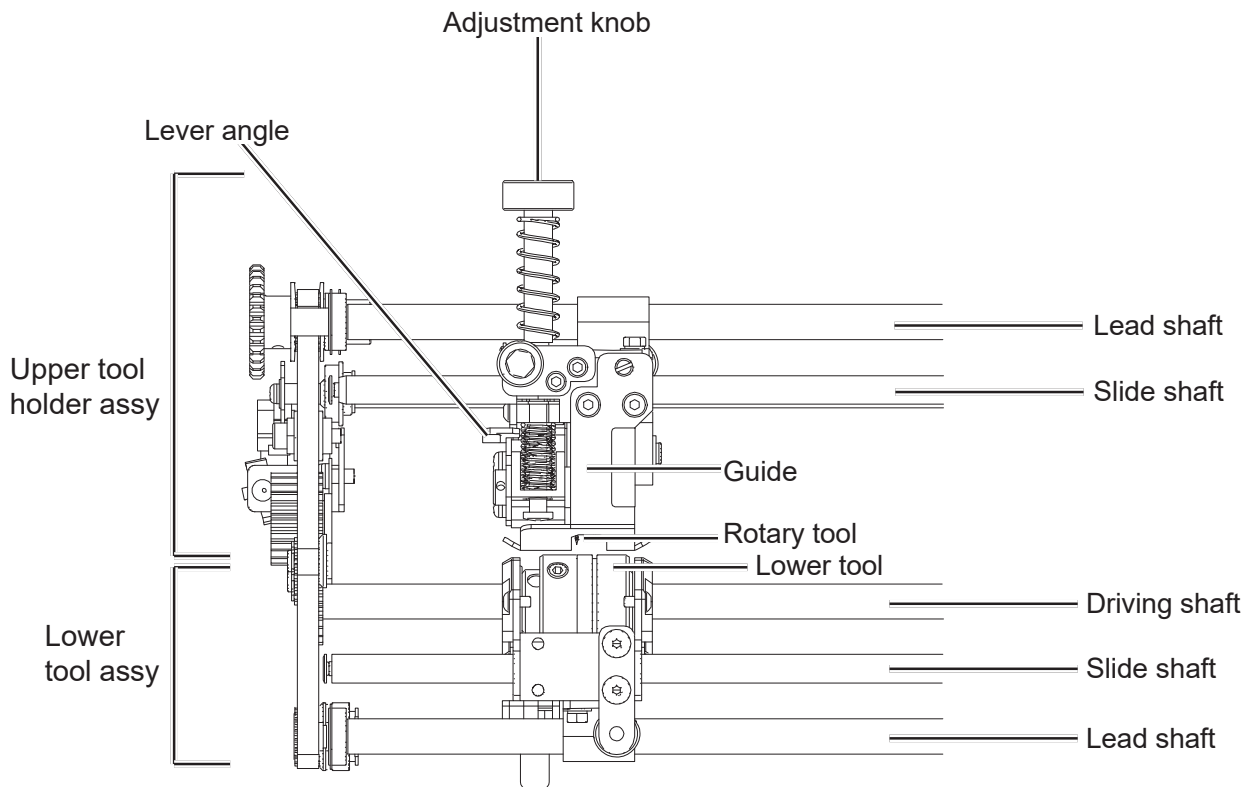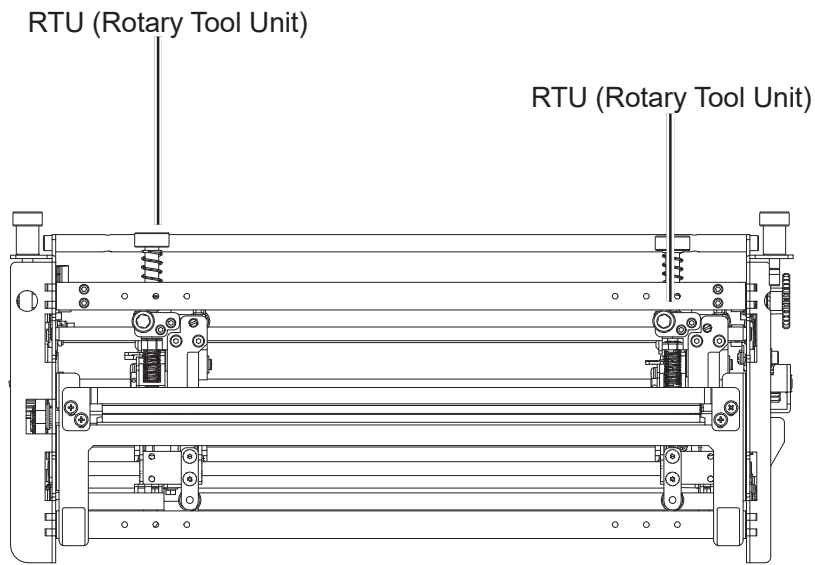
REFERENCE

In this manual, the combination of the **upper tool holder assy** and the **lower tool assy** is called **RTU (Rotary Tool Unit)**.

Inside of the DC-618

| No.	Name	Function
1	Belt suction unit	The suction fan sucks up documents one by one and the feed belt feeds each of them.
2	Double feed detection section	Detects a double feed with the ultrasonic sensor.
3	CCD section	Reads a REG mark and a barcode.
4	Slot 1	Install the **margin slitter module** here.
5	Slot 2	Install the **center slitter module1** or the **RTM (Rotary Tool Module)** here.
6	Slot 3	Install the **center slitter module2** or the **RTM (Rotary Tool Module)** here.
7	Gutter deflector section	The gutter deflectors automatically move according to gutter positions and drop gutter slits in the waste box.
8	Creaser section	Creases a document perpendicularly to the document feed direction.
9	Cutter Section	Cuts a document perpendicularly to the document feed direction.

How to Remove and Install the RTM (Rotary Tool Module)
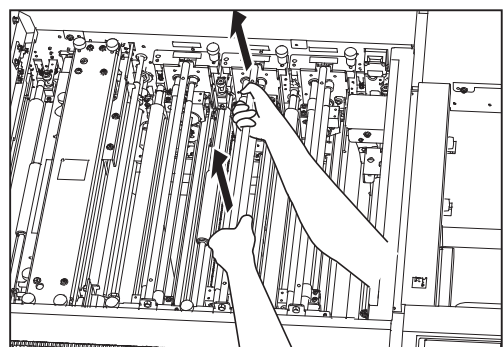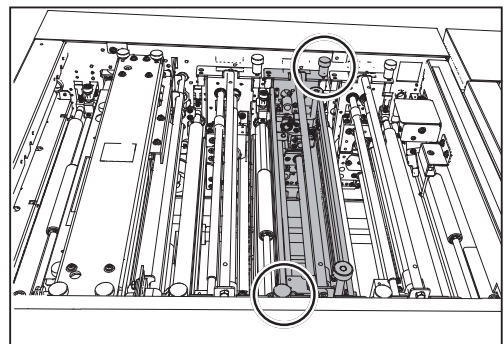
Removing the RTM (Rotary Tool Module)

① Open the **top cover**.

Top cover
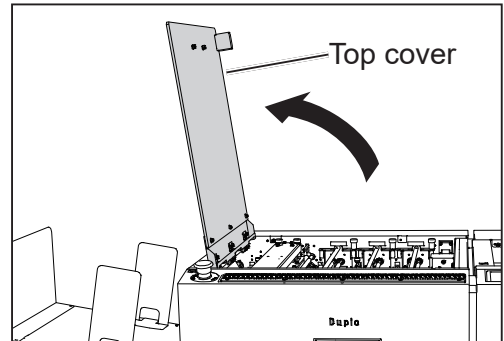
② Disconnect the **connector** of the **RTM (Rotary Tool Module)**.
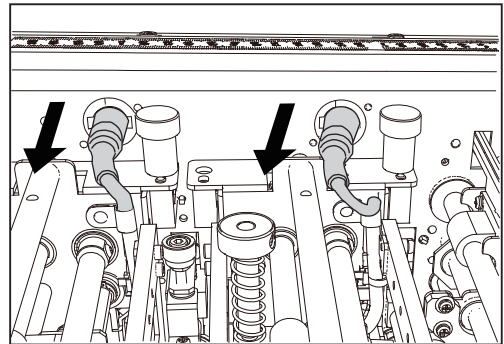
③ Loosen the two **fixing screws** on the **RTM (Rotary Tool Module)**. Grasp the handles to take out the **RTM (Rotary Tool Module)** by lifting it up.
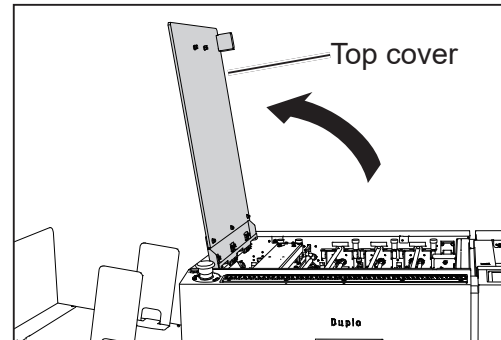
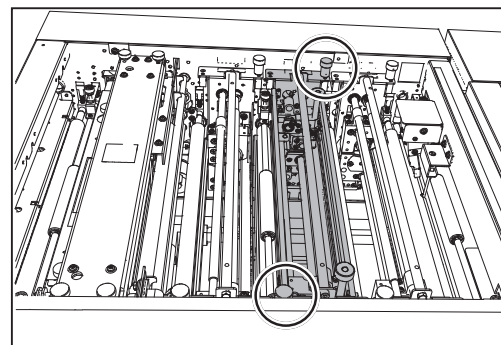# Installing the RTM (Rotary Tool Module)
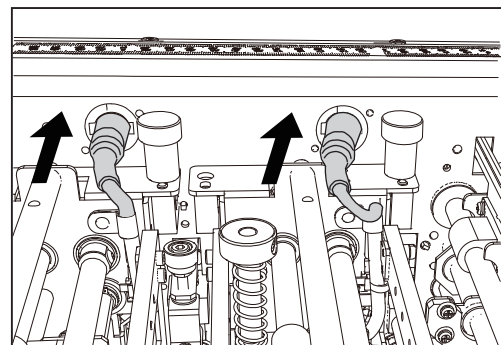
1 Open the **top cover**.

Top cover

2 Install the **RTM (Rotary Tool Module)** in slot 2 or slot 3. Tighten the two **fixing screws**.

> **REFERENCE**
>
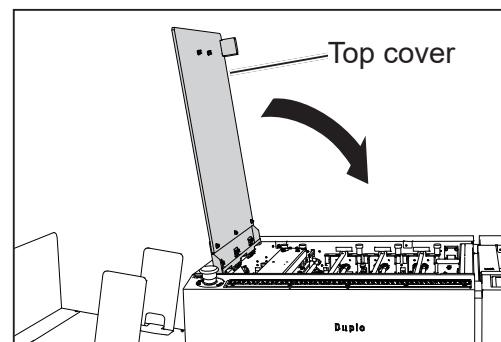> Make sure that the pins on both sides are securely fitted in the module.

3 Connect the **connector** of the **RTM (Rotary Tool Module)**.

4 Close the **top cover**.

Top cover

How to Replace a Rotary Tool

IMPORTANT

Make sure that replacement of the **rotary tool** must be performed only by a trained person in charge of maintenance.
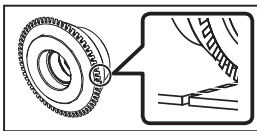
● Types of rotary tools

The **RTM (Rotary Tool Module)** can process documents with the following three types of **rotary tools** attached to the **rotary tool unit**.
Select a proper **rotary tool** and attach it to the **rotary tool unit**.
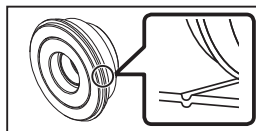
Perforation tool: A tool having cutting blades and grooves that are alternatively arranged. Enables you to perforate a document.

Score tool: Enables you to make scores on a document.

Micro perforation tool: A tool having narrower cutting blades and grooves than the standard type (perforation tool). Enables you to perforate a document.
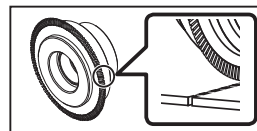
Perforation tool   Score tool   Micro perforation tool

● Positions of the rotary tool and the lower tool

The position of the **lower tool** varies depending on the types of the **rotary tool**.

Perforation tool   Score tool
Micro perforation tool
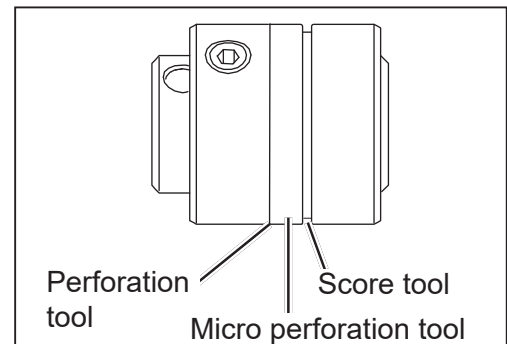
Removing a Rotary Tool

1 Remove the **guide assy** in the direction of the arrows.

REFERENCE

Remove the **guide assy** while holding the circled parts in the figure on the right.

Guide assy

How to Replace a Rotary Tool

2 Turn the **adjustment knobs** counterclockwise until they stop to separate the **rotary tools** and the **lower tools**.
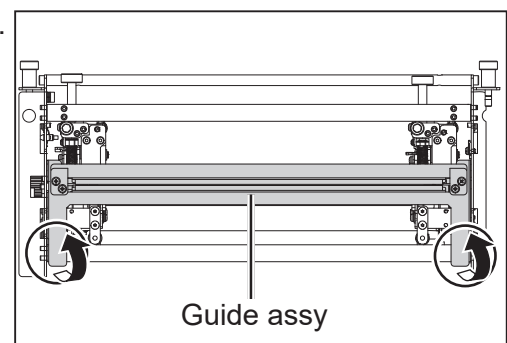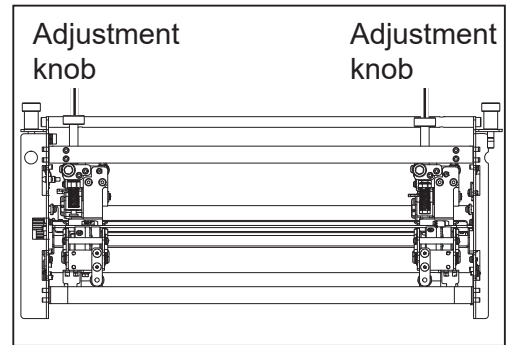

Adjustment knob　　　　Adjustment knob

3 Remove the four **hexagon socket head cap screws** (left unit: 2 pcs., right unit: 2 pcs.) to detach the **guide L** and the **guide R**.

REFERENCE

Use the hexagon wrench that came with the DC-618.

Guide L　　　　Guide R
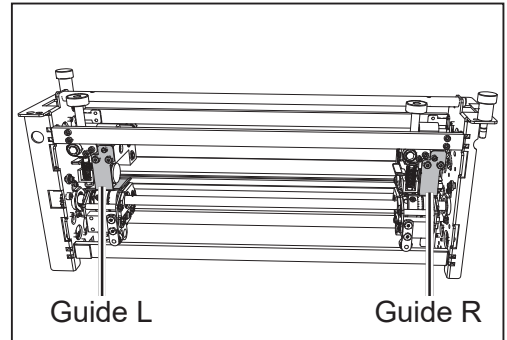
4 Remove the two **hand knobs** (unit L: 1 pce., unit R: 1 pce.).

REFERENCE

Do not lose the **hand knobs**.

Hand knob
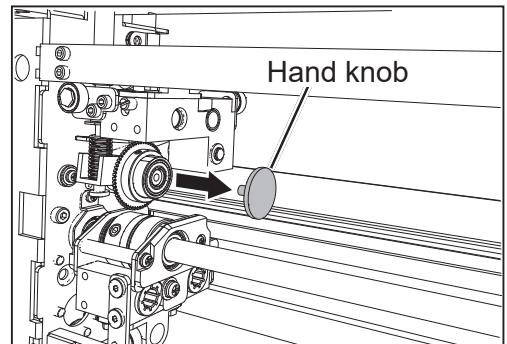
5 Remove the **collar**. While raising the **lever** (**1**), remove the **rotary tool** (**2**). (on both sides)

IMPORTANT

● Do not hold the cutting edge when removing the **rotary tool**.
● When removing the **rotary tool**, be careful not to bring it into contact with the **lower tool** to avoid damaging it.

1
Lever
2
Lower tool
Rotary tool
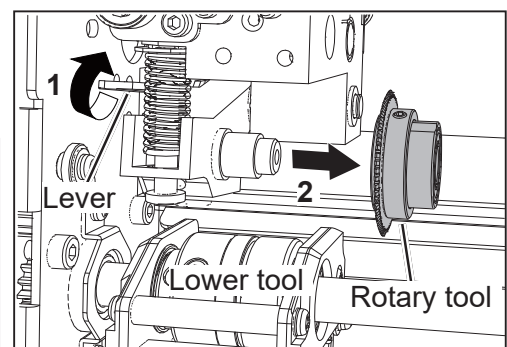
Attaching a Rotary Tool

1 While raising the **lever** (**1**), attach the **rotary tool** (**2**) in the direction of the arrow. (on both sides)

1
Lever

2

Lower tool
Rotary tool
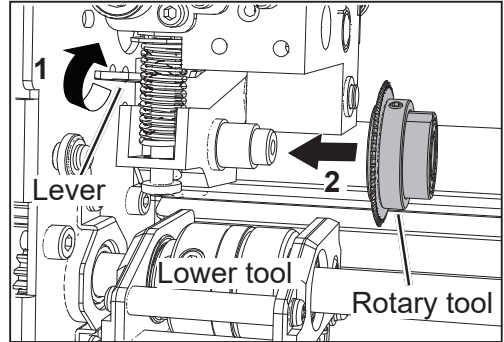
2 Secure the **rotary tools** with the **hand knobs**. (unit L: 1 pce., unit R: 1 pce.).

Hand knob
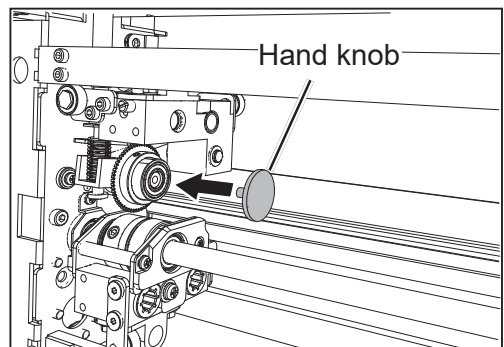
3 Attach the **guide L** and the **guide R** with the four **hexagon socket head cap screws** (two each on both guides).

REFERENCE

Use the hexagon wrench that came with the DC-618.

Guide L   Guide R

REFERENCE

Attach the **guides** so that the bottom faces of the **guide L** and the **guide R** are parallel to the faces of the **lower tools**.

Guide

Lower tool

1

Before Using This Module
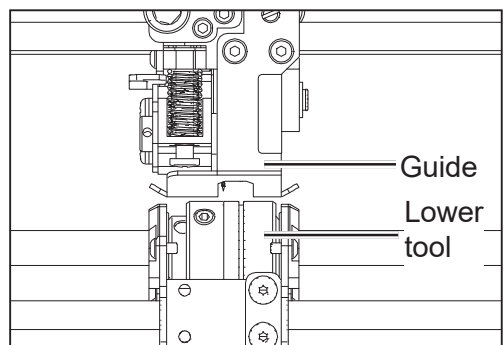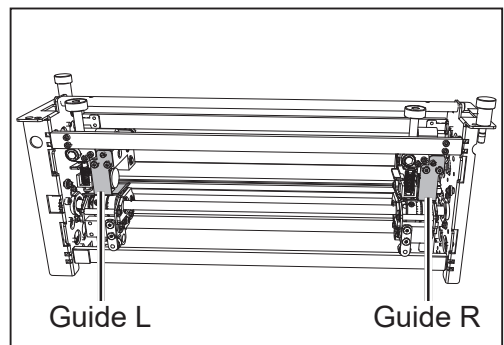
4 Turn the **adjustment knobs** clockwise to lower the **rotary tools** according to the type of the **rotary tool unit**.

Adjustment knob   Adjustment knob

5 Attach the **guide assy** in the direction of the arrows in the figure on the right.

> **REFERENCE**
>
> Attach the **guide assy** while holding the circled parts in the figure on the right.

Guide assy
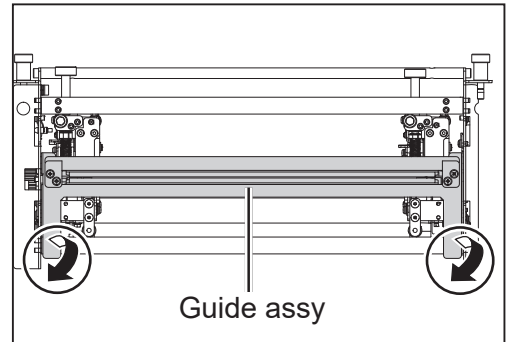
Adjusting the Depth of a Rotary Tool

1 Turn the **adjustment knobs** counterclockwise to raise the **rotary tools** to the upper limit position.
Turn the **adjustment knobs** clockwise to lower the **rotary tools** to the position for the types of the **rotary tools**.
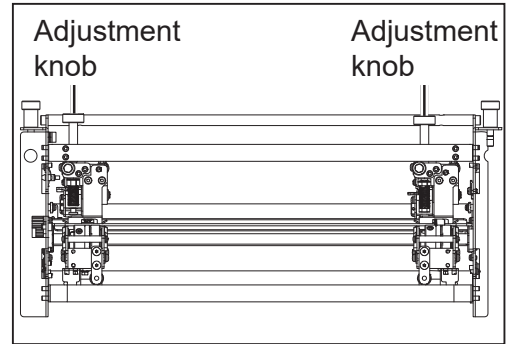
Adjustment knob   Adjustment knob
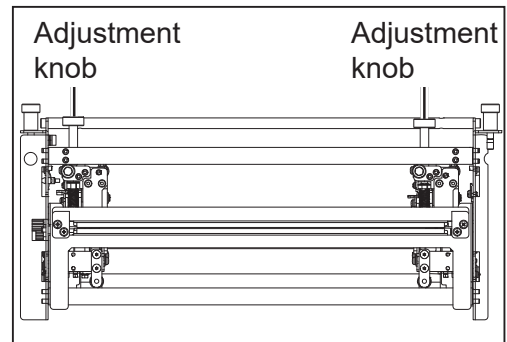
> **REFERENCE**
>
> ● Adjust the **rotary tool** according to the degrees of the arrow position on the **adjustment knob**.
>   • Indication of the depth of each **rotary tool** from the upper limit position
>   **Perforation tool:** 225 to 315 degrees
>   **Micro perforation tool**: 180 degrees
>   **Score tool**: 225 to 270 degrees
> ● The position of the **adjustment knob** may differ depending on the diameter of a **rotary tool** even when the same type of tool is used.
> ● When processing light weight documents, if a **rotary tool** is at a deeper position, it may not be able to perform a document processing straight to a finished product.
>   If this is the case, adjust the depth of the **rotary tool** slightly shallower (toward the upper limit position).

Chapter 2

Programming a JOB on the Control Panel

This chapter describes how to program a JOB on the control panel of the DC-618.

Before Programming a JOB

This section describes items displayed on the control panel which are related to the **RTM (Rotary Tool Module)**.
For other settings, refer to Chapter 2 Programming a JOB - Before Programming a JOB in the DC-618 Instruction Manual.

Standby Screen

① **Details**
1. Touching the 🔍 **details** icon displays the details of the JOB selected.
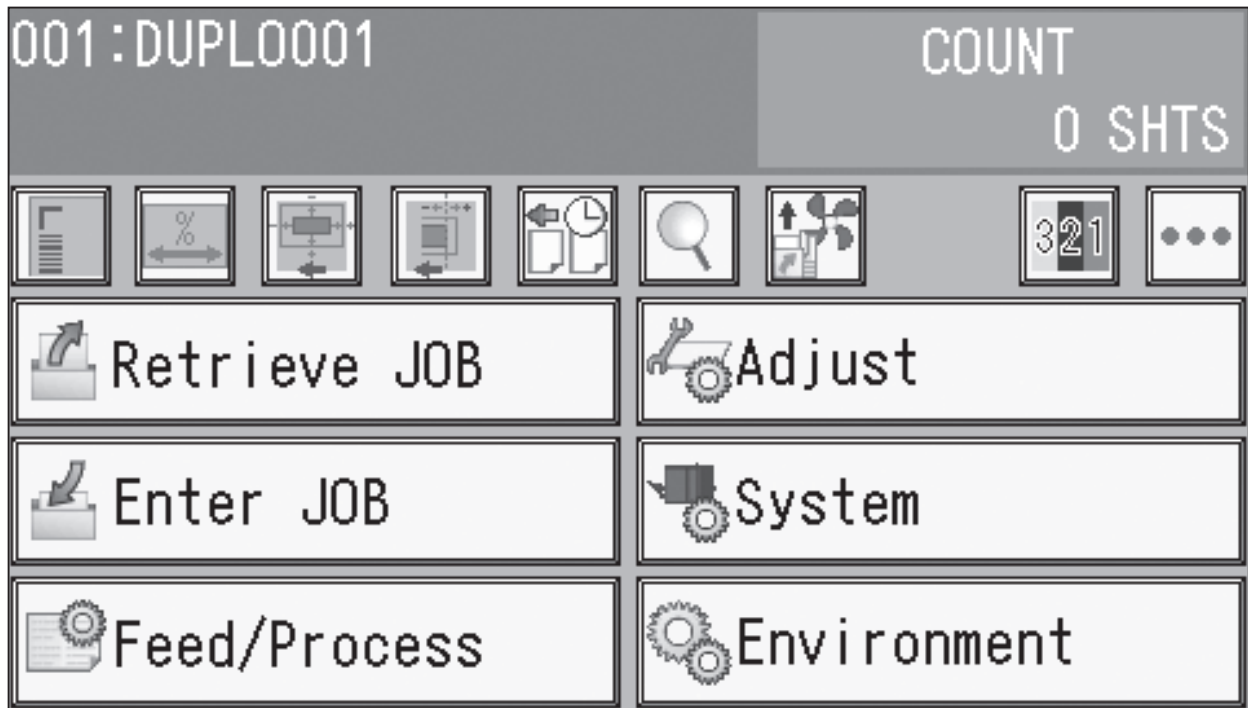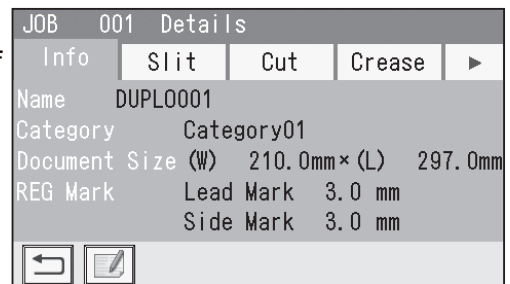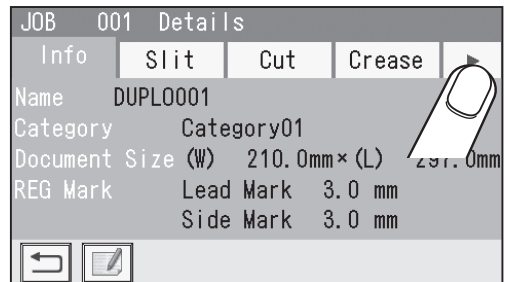

2. Touch the ▶ icon.

3. Touch **RTM**.
 • The screen shown on the right is that for a JOB with **RTM** selected for both **Slot2** and **Slot3**. (**1**: **Slot3**, **2**: **Slot2**)

```
JOB   001  Details      1      2
◄ Settings Modules   RTM    RTM
Air Knife        ON
Suction Power    MAX
Blow Fan         2
Side Air         MAX          ▼
REG Mark         ON
⤺                    🗁
```
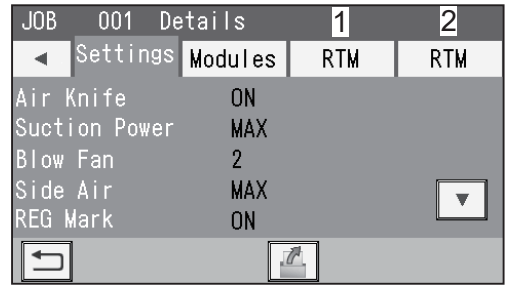
 • The screen shown on the right is that for a JOB with **RTM** selected for **Slot2**. (1: **Slot2**)

```
JOB   001  Details      1
◄ Settings Modules   RTM
Air Knife        ON
Suction Power    MAX
Blow Fan         2
Side Air         MAX          ▼
REG Mark         OFF
⤺                    🗁
```
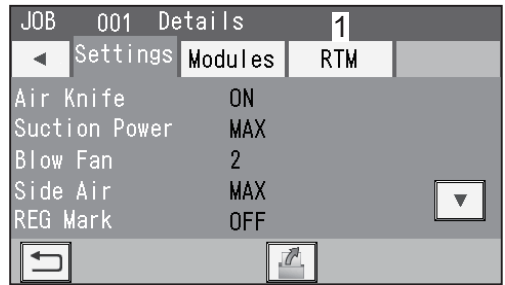
 • The screen shown on the right is that for a JOB with **RTM** selected for **Slot3**. (1: **Slot3**)

```
JOB   001  Details      1
◄ Settings Modules   RTM
Air Knife        ON
Suction Power    MAX
Blow Fan         2
Side Air         MAX          ▼
REG Mark         ON
⤺                    🗁
```
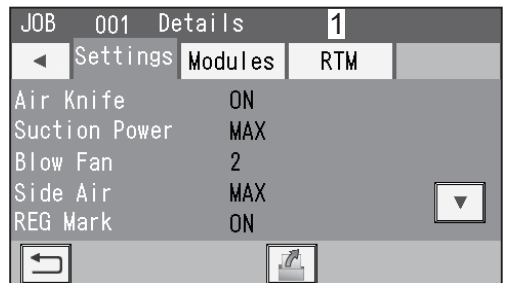
4. **RTM**
 Processing positions of the **RTM (Rotary Tool Module)** for the selected JOB appear.
 Touching the ▶ icon displays the continuity of the processing positions on the next page.
 Touching the ⤺ **return** icon returns to the **standby** screen.

```
JOB   001  Details
◄ Settings Modules    RTM
Slot3  X1
  R :  60.0    L : 130.0
                              ▼
⤺                    🗁
```
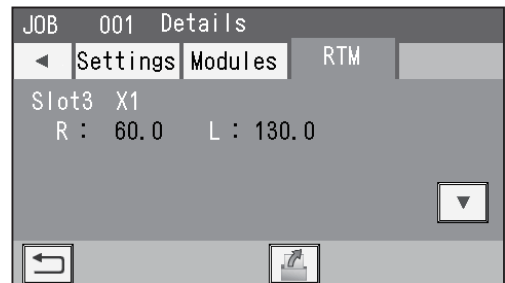
② **Status**
1. Touching the 321 **status** icon displays the status screen.
 The type of the module set for slot 2 appears for **Slot2** (**1**) and that for slot 3 appears for **Slot3** (**2**). Crease (**3**) displays a crease depth (Wider, Standard) in the crease section.
 Touching the ⤺ **return** icon returns to the **standby** screen.

```
Status
      321        1 Slot2   ═ Slitter1
                 2 Slot3   ═ Slitter2
                 3 Crease  ▮▯ ▮▮▯
⤺
```

2

Programming a JOB on the Control Panel
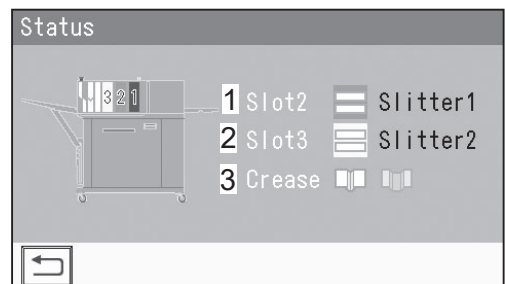
JOB Entry

The DC-618 provides two programming modes, **Wizard** and **Direct**.
There are two programming modes in **Direct**, **Advanced Mode** and **Simple Mode**.

    Wizard
    Direct (Advanced Mode)
    Direct (Simple Mode)

Before programming a JOB, set either mode with **Basic Mode** in **Environment**.
(→ Chapter 3 <u>Basic Operations</u> in the DC-618 Instruction Manual.)

Hints for entering a JOB:
- Touching **SET** goes on to the next step.
- Touching **NEXT** goes on to the next screen.
- Touching the ⤺ **return** returns to the previous screen.
- Pressing the STOP key during JOB entering returns to the **standby** screen.

The following items that appear on the touch panel stand for as below.

Standard: Standard module	**Perf**: Perforation tool
Slitter: Slitter module	**Micro**: Micro perforation tool
RTM: Rotary Tool Module	**Score**: Score tool

Setting for Processing with the RTM (Rotary Tool Module)
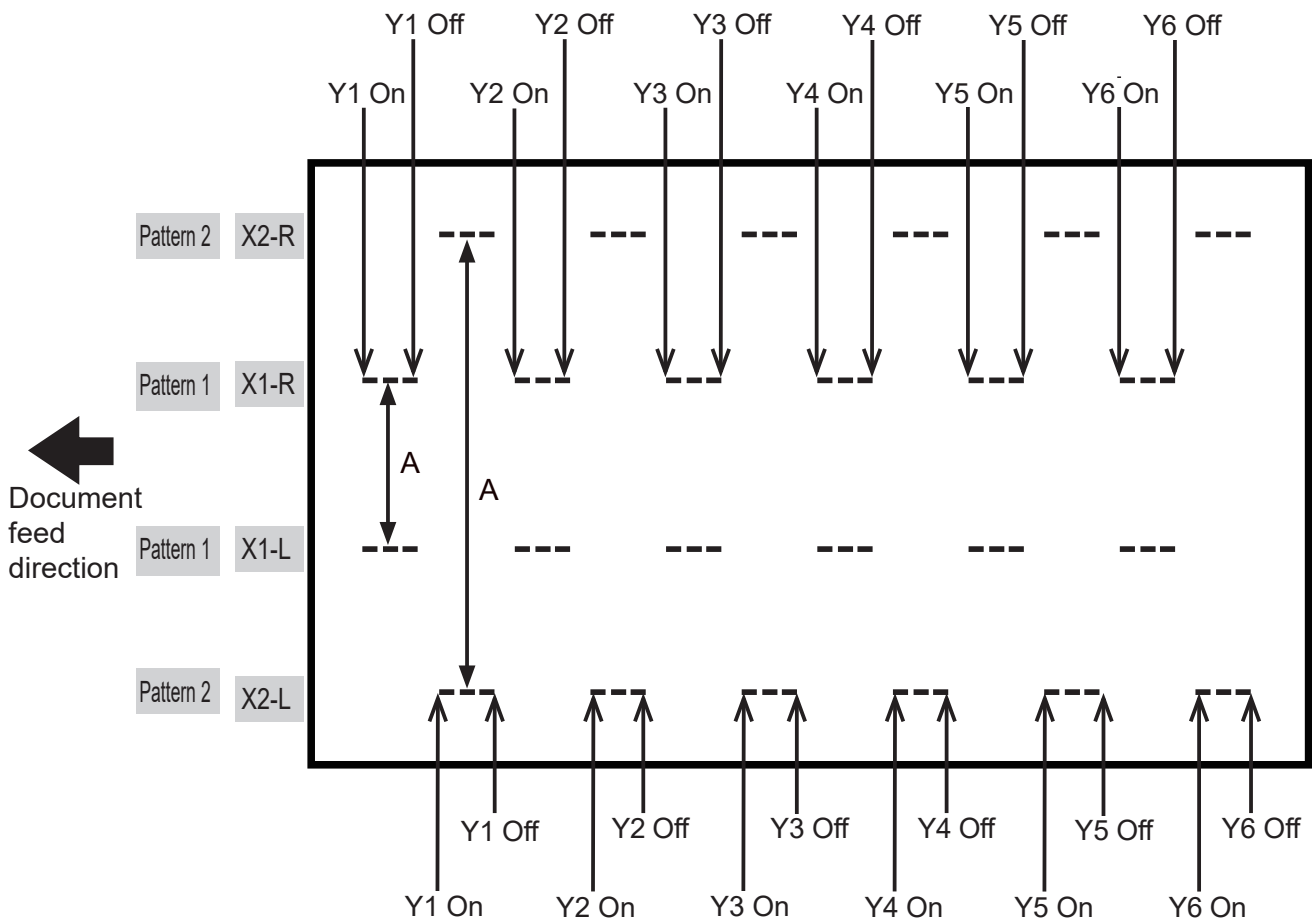
REFERENCE

- You can set two patterns ([X1-R, X1-L] and [X2-R, X2-L]) in the X direction (crosswise) from the right edge of a document.
- The distance between X1-R and X1-L, and that between X2-R and X2-L must be 48.0 mm or more. (**A** in the figure on page 12.)
- You cannot set processing positions within 5.0 mm from the document edge and slit in the X direction.
- The range of values that can be entered is displayed on the LCD panel. You cannot enter any values outside of the range.
- The **unit L** is on the left side and the **unit R** is on the right side of the **RTM (Rotary Tool Module)**.

Document feed direction

Unit L   Unit R
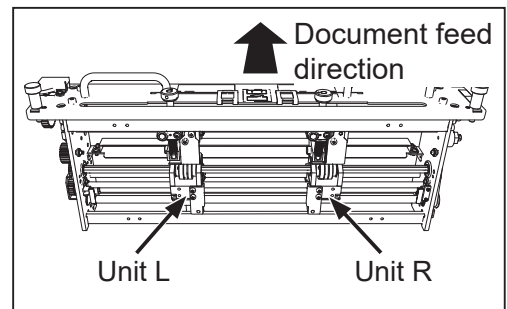
● Patterns of processing with **RTM (Rotary Tool Module)**

		Set 1	Set 2	Set 3	Set 4	Set 5	Set 6
Pattern 2	X2-R						
Pattern 1	X1-R						
Pattern 1	X1-L						
Pattern 2	X2-L						

On   Off

Document feed direction
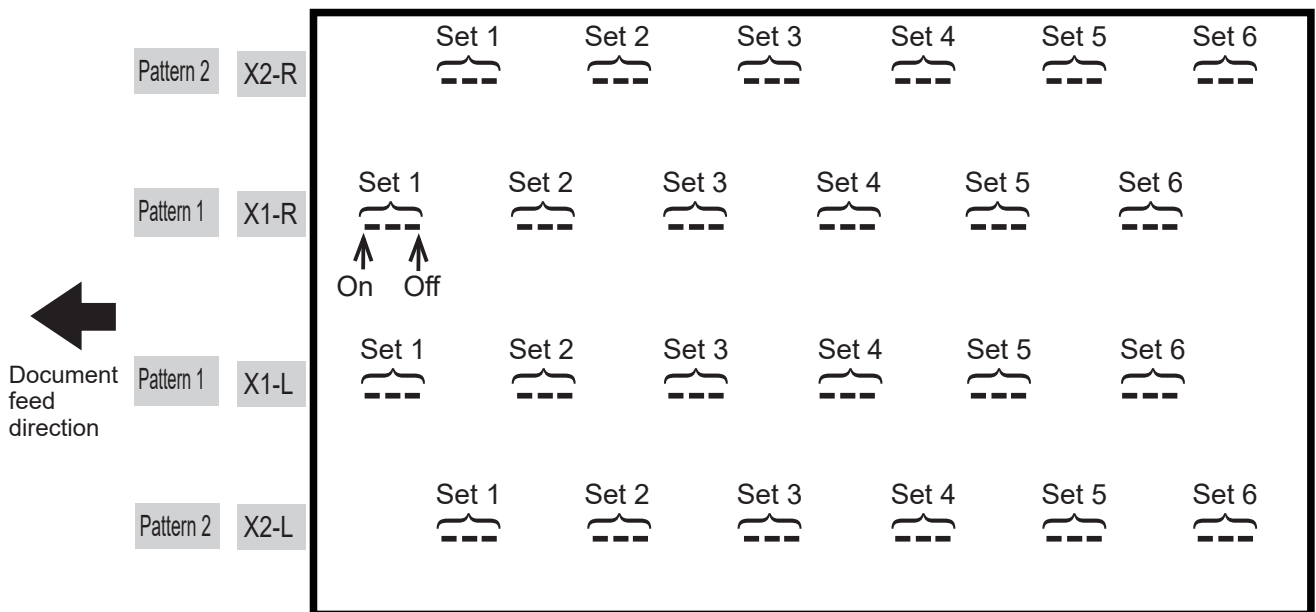
REFERENCE

- You can program up to six sets of **On** (a start position) and **Off** (a stop position) in the Y direction (lengthwise) from the lead edge of a document for each pattern.
  One set consists of **On** position and **Off** position. (See above.)
- **X1** and **X2** cannot be programmed at the same processing positions.

IMPORTANT

Processing a document in the Y direction of **Pattern 2** can be made between each set of **Pattern 1**.

Set 1 of Pattern 1 Set 2 of Pattern 1 Set 3 of Pattern 1

X2–R
X2–Y2 On X2–Y3 On X2–Y3 Off
X2–Y1 On X2–Y1 Off X2–Y2 Off

Document feed direction

X2–L

X (Crosswise)

------- Perforation RTM processing position

Y (Lengthwise)

● Limitations

The figure below shows that the **unit R** and the **unit L** processing **Pattern 1** are located above a document. (**1**s in the figure)
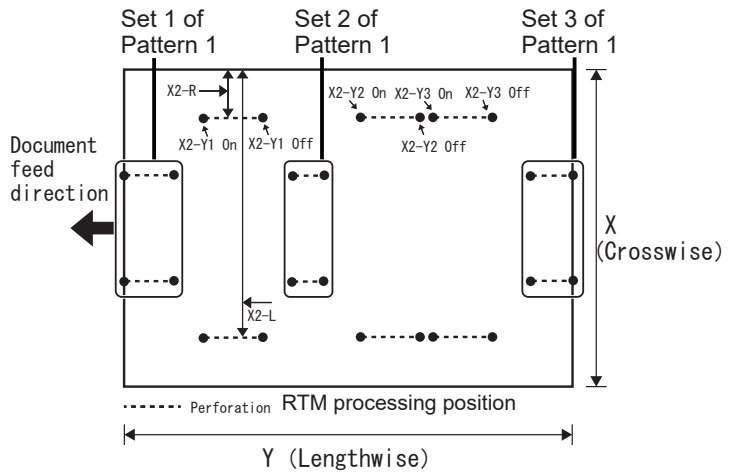
2 in the figure shows that the **unit L** processing **Pattern 2** is located between 5.0 to 47.9 mm from a finished product on the non-operator's side.

When a JOB is programmed with the **unit L** at this position, the **unit R** is located outside of a finished product. If the **unit R** processes **Pattern 2**, it comes into contact with the edge of a finished product and may cause a document jam.

Pattern1 → R **1** R

Non-operator's side

5–47.9mm **2**

Pattern1 → L **1** L

Pattern2

Document feed direction

20mm

X (Crosswise)

Pattern2

Operator's side

------- RTM processing position

Y (Lengthwise)

✕ : A position where the **unit R** comes into contact with the edge of a finished product.

REFERENCE

In the case of **2**, you cannot set processing positions for the trail margin of 20 mm in the Y direction of **Pattern 2**.
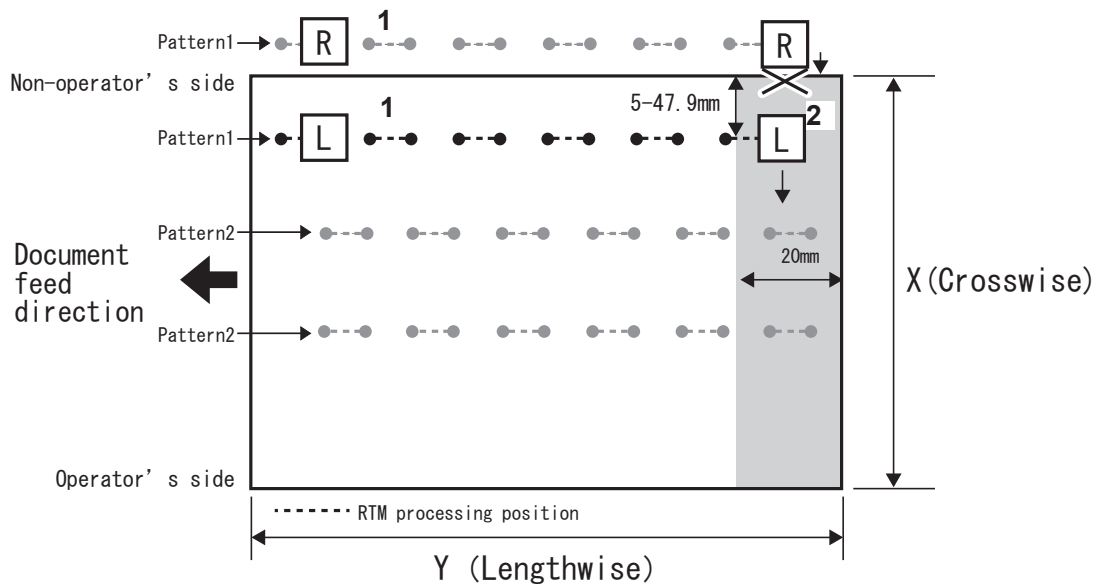
● Limitations
The figure below shows that the **unit R** and the **unit L** processing **Pattern 1** are located above a document. (**1**s in the figure)
2 in the figure shows that the **unit R** processing **Pattern 2** is located between 5.0 to 47.9 mm from a finished product on the operator's side.
When a JOB is programmed with the **unit R** at this position, the **unit L** is located outside of a finished product. If the **unit L** processes **Pattern 2**, it comes into contact with the edge of a finished product and may cause a document jam.

✕ : A position where the **unit L** comes into contact with the edge of a finished product.
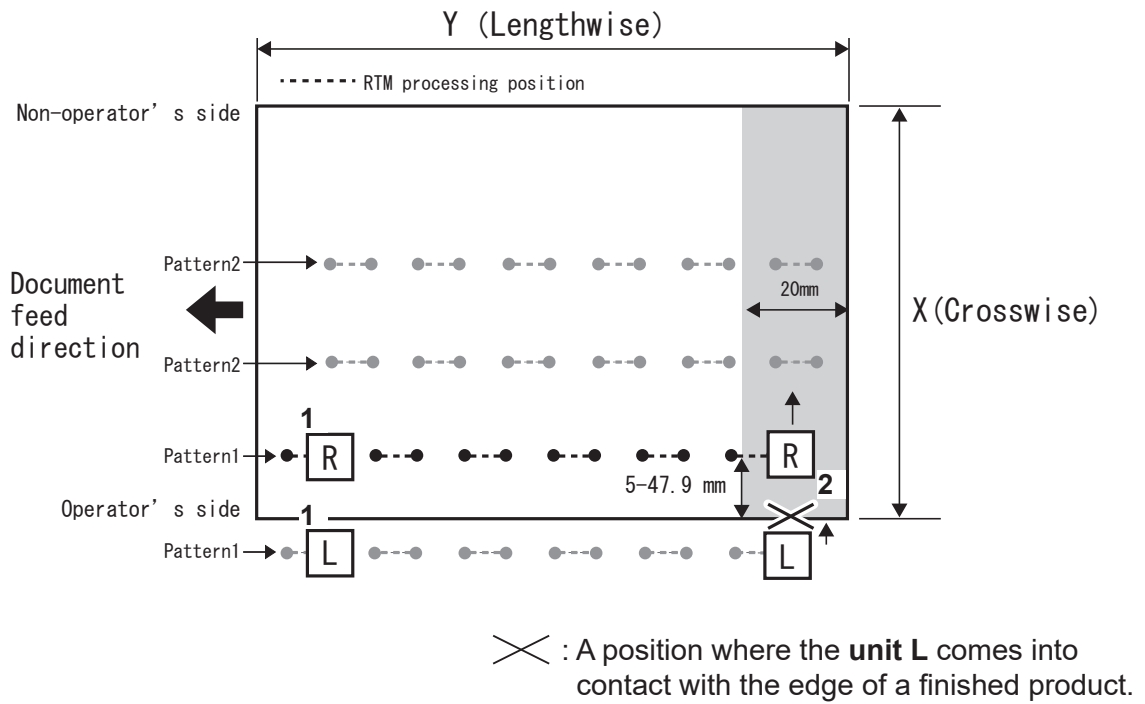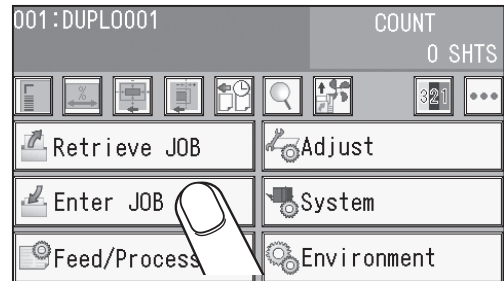
REFERENCE

In the case of **2**, you cannot set processing positions for the trail margin of 20 mm in the Y direction of **Pattern 2**.

2

Programming a JOB on the Control Panel

Wizard

In **Wizard**, you can set processing positions of the rotary tool on one finished product, up to two sets in the **X** direction and up to six sets in the **Y** direction.

① Make sure that the **standby** screen is displayed on the **touch panel**, and then touch **Enter JOB**.

```
001:DUPLO001                    COUNT
                                 0 SHTS

  Retrieve JOB        Adjust
  Enter JOB           System
  Feed/Process        Environment
```
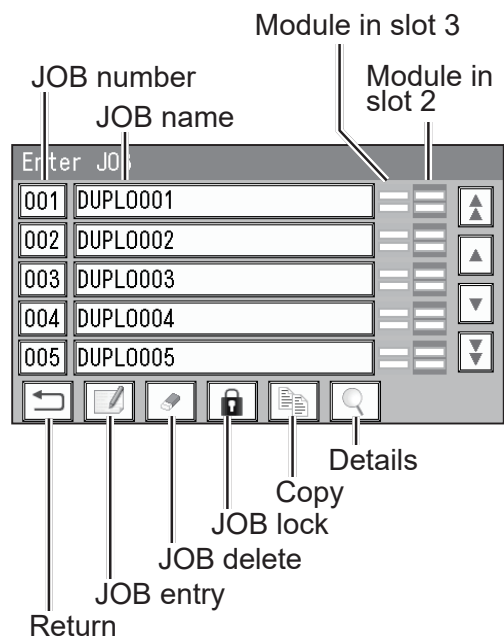
② The **Enter JOB** screen is displayed.
Touch the **JOB name** of a **JOB number** to be programmed and touch the **JOB entry** icon.
One touch of the JOB number proceeds to step 3.

▲▲ : JOBs of the 50th to 55th behind are displayed.

▲ : JOBs of the 5th to 10th behind are displayed.

▼ : JOBs of the 5th to 10th ahead are displayed.

▼▼ : JOBs of the 50th to 55th ahead are displayed.

Module in slot 3
JOB number
JOB name
Module in slot 2

```
Enter JOB
 001  DUPLO001
 002  DUPLO002
 003  DUPLO003
 004  DUPLO004
 005  DUPLO005
```

Details
Copy
JOB lock
JOB delete
JOB entry
Return

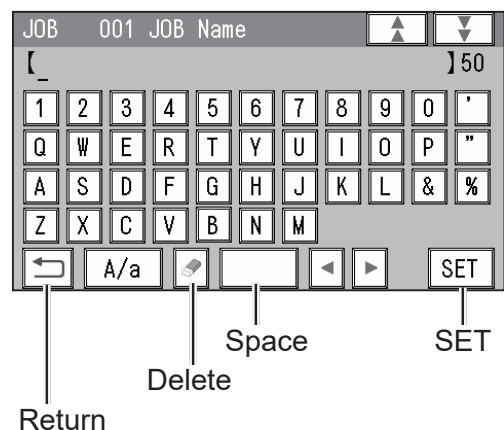**REFERENCE**   Module icons

▤ : Slitter module

▦ : RTM (Rotary Tool Module)

③ Enter a JOB name.
Enter a JOB name by touching numerals and letters.
A/a : This switches between the capital letters and the small letters.
◆ Delete icon: This deletes one character.
◀ : This moves the cursor leftward.
▶ : This moves the cursor rightward.

Touching the space key makes a space between characters/letters.
When you have finished entering a JOB name, touch **SET**.

```
JOB   001  JOB Name              ▲  ▼
[_                              ]50
 1 2 3 4 5 6 7 8 9 0 '
 Q W E R T Y U I O P "
 A S D F G H J K L & %
 Z X C V B N M
 ↵  A/a  ◆      ◀  ▶    SET
```

Space   SET
Delete
Return

4 Select a category in which the programmed JOB is saved. Touch SET.

JOB   001 Category
Category01	Category06
Category02	Category07
Category03	Category08
Category04	Category09
Category05	Category10

REFERENCE

You can retrieve a saved JOB by **Category** under **Retrieve JOB**.
You can change the category name in **Environment**.
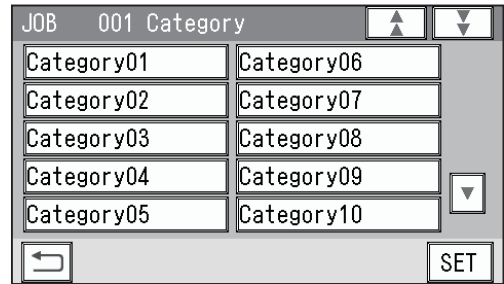
5 **JOB Programming**
Touch **Wizard**.
Wizard: This helps you program a JOB in a user size in a simple way.
Direct: This programs a JOB by entering a value of each item.

| JOB Programming |
|---|
| Wizard | Direct |

REFERENCE

You cannot reprogram the following JOBs in **Wizard**:
• A JOB programmed in **Direct**
• A JOB saved in **Wizard** and edited in **Direct**
• A JOB saved in **Wizard** by using the PC Controller
Save a new JOB as a different JOB number or clear the JOB already saved and then save the new one.
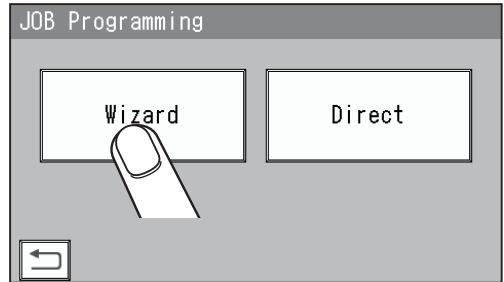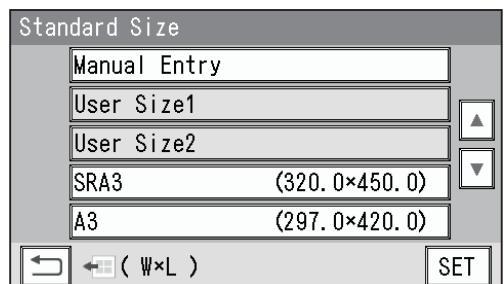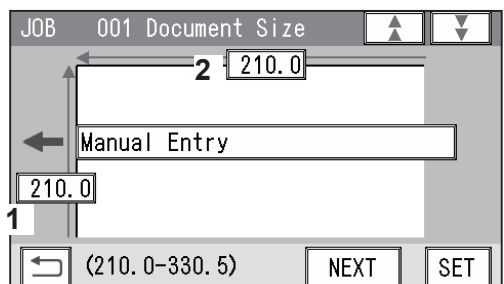
6 **Document Size**
1. Touch **1 (Manual Entry)**.

JOB   001 Document Size
210.0
Manual Entry   **1**
210.0
(210.0–330.5)   NEXT   SET
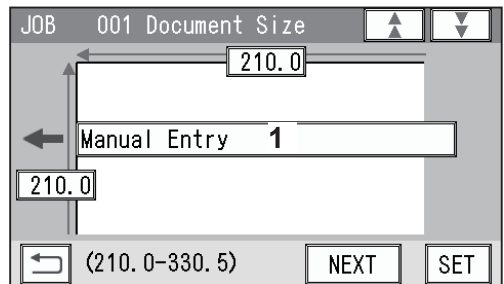
2. Select a document size.
Touching the ▲/▼ icon displays other document sizes.
Touch **SET** to set the selection.

Standard Size
Manual Entry
User Size1
User Size2
SRA3   (320.0×450.0)
A3   (297.0×420.0)
⬅(W×L)   SET

REFERENCE

To select **User Size1** or **User Size2**, set **User Size** under **Environment** in advance.
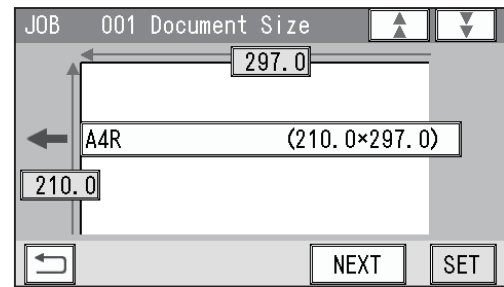(See Chapter 3 Basic Operations in the DC-618 Instruction Manual.)

3. If you have selected document size other than **Manual Entry** in step 2, touch **NEXT** to go to step 7. When you have selected **Manual Entry**, follow these steps to set the document size.
Touch **1** and enter the document width with the NUMERIC keys.
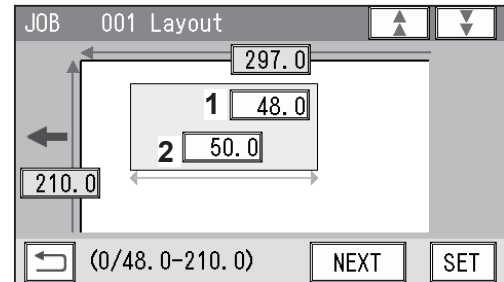Touch **2** and enter the document length with the NUMERIC keys.

JOB   001 Document Size
2 210.0
Manual Entry
210.0
1
(210.0–330.5)   NEXT   SET

2

Programming a JOB on the Control Panel

4. Touch **NEXT**.

```
JOB   001 Document Size   [⊼] [⊻]
            297.0
    A4R              (210.0×297.0)
  210.0
  [↩]                NEXT    SET
```
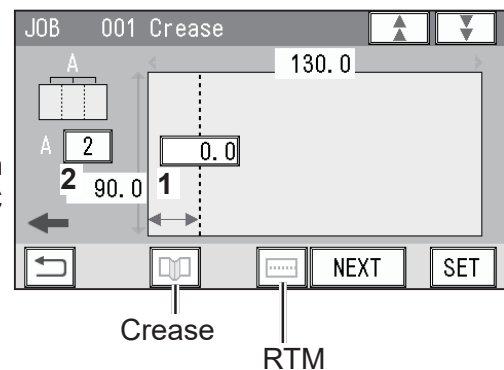
7 **Layout**
Enter the width of the finished product in **1** with the NUMERIC keys and touch **SET**.
Enter the length of the finished product in **2** with the NUMERIC keys.
Touch **NEXT**.

```
JOB   001 Layout   [⊼] [⊻]
            297.0
        1  48.0
        2  50.0
  210.0
  [↩] (0/48.0-210.0)   NEXT    SET
```

8 **Crease**
Touch **1** and enter the distance from the lead edge of the finished product to the position of **Crease1** with the NUMERIC keys.
To allocate creases evenly on finished products, touch **2** and enter the number of creases with the NUMERIC keys. Then touch **SET**.
You can set two to seven creases evenly.
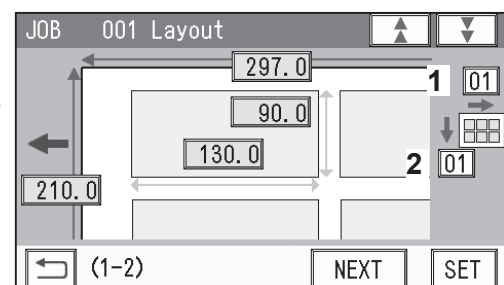When having finished crease setting, touch **NEXT**.

```
JOB   001 Crease   [⊼] [⊻]
 A            130.0
 A  2      0.0
  2  90.0 1
 ←
 [↩]  [📖]  [▭]  NEXT  SET
```
        Crease
              RTM

REFERENCE

You can set up to 20 creases on one document.
You can set up to six creases on one finished product.
To set seven or more creases on one finished product, select **Direct**.

9 **Layout**
Enter the number of finished products in a length direction in **1** with the NUMERIC keys and touch **SET**.
Enter the number of finished products in a width direction in **2** with the NUMERIC keys.
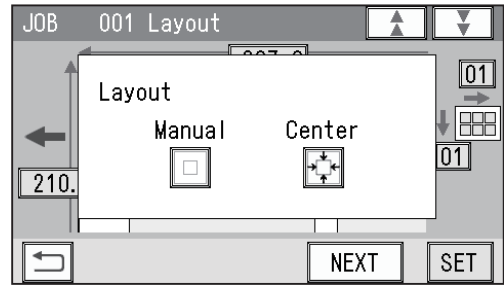Touch **SET**.

```
JOB   001 Layout   [⊼] [⊻]
            297.0         1  01
                90.0        ⊞
           130.0        2  01
  210.0
  [↩] (1-2)          NEXT    SET
```

REFERENCE

To process the finished product with the rotary tool in **Wizard**, you cannot set three or more cards in the X direction.

10 **Layout** - **Layout**
Select and touch a layout of the finished product out of **Manual** or **Center**.
Manual: Enables you to manually enter values of the lead margin, a gutter cut, a gutter slit, and the right margin to set a layout of the finished product. Go to step 11.
Center: Automatically sets a layout of the finished product in the center of the document. Automatically makes settings for the lead margin and the right margin by entering values for a gutter cut and a gutter slit. Go to step 12.

11 **Gutter (Layout - Manual)**
1. Enter a value for the lead margin with the NUMERIC keys and touch **SET**.
2. Enter a value for a gutter cut with the NUMERIC keys and touch **SET**.
3. Enter a value for the right margin with the NUMERIC keys and touch **SET**.
4. Enter a value for a gutter slit with the NUMERIC keys and touch **SET**.

Gutter (**Layout** - **Center**)
1. Enter a value for a gutter cut with the NUMERIC keys and touch **SET**.
2. Enter a value for a gutter slit with the NUMERIC keys and touch **SET**.

**12** **Finished Product (Free entry screen)**
1. Touching SET moves the cursor to the items set in steps 7 to 11.
Check the values.
You can re-enter values if necessary by touching each item.
When you use **Read REG Mark**, enter the distance (**1**) between the right edge of the document and the side mark with the NUMERIC keys. Touch **SET**.
Enter the distance (**2**) between the lead edge of the document and the lead mark with the NUMERIC keys. Touch **SET**.
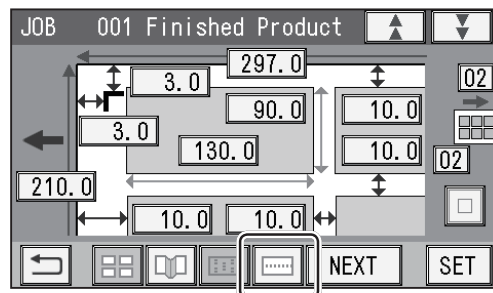
2. Touching **3** changes **Layout** setting that washave been set in step 10.

3. Touching **4** or **5** changes the number of cards on one sheet lengthwise or crosswise.
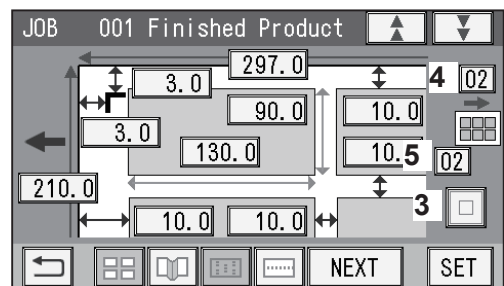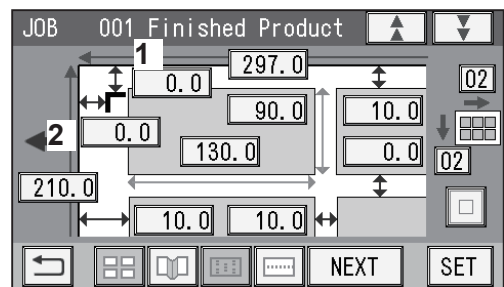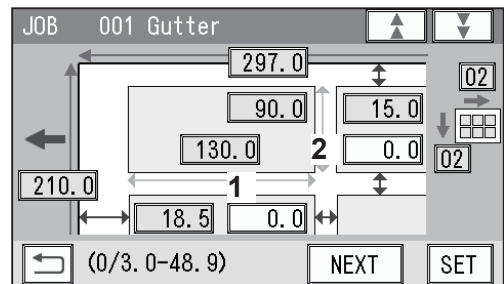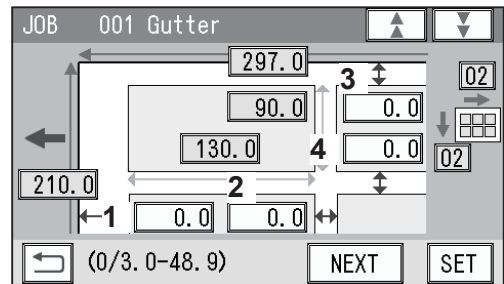
13 On the screen in step 12, touch the [⬚] **RTM** icon to set processing positions of the **RTM (Rotary Tool Module)**.

```
JOB    001 Finished Product  [▲][▼]
           297.0
    3.0                          [02]
            90.0        10.0
    3.0                          [▦]
         130.0          10.0  [02]
210.0
         10.0   10.0            [□]
  [↩][▦][▥][▦][⬚]  NEXT    SET
```

14 Pattern 1 in the X direction (crosswise) **X1**

REFERENCE

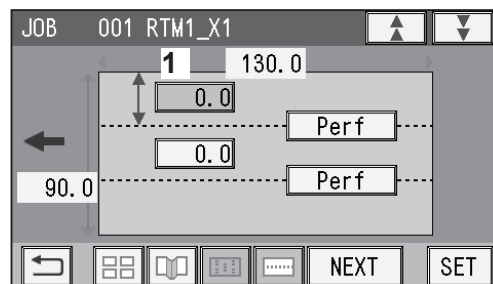You can set up to two sets of two patters in the X direction on one document.
In **Wizard**, the number of sets that can be set varies depending on the number of cards in the X direction.
Even if two **RTM (Rotary Tool Module)s** are installed, a total of processing positions for one **RTM (Rotary Tool Module)** is as shown in the table on the right.
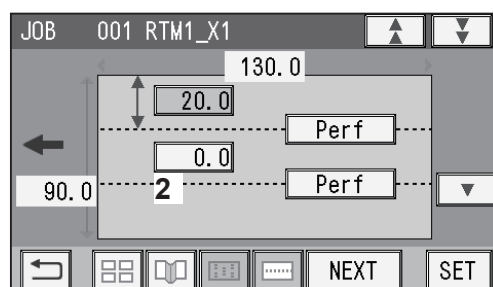
The number of cards crosswise (X direction)	Processing positions of rotary tool
1	2 sets of X1 and X2
2	1 sets of X1 and X2
3 or more	Cannot be entered

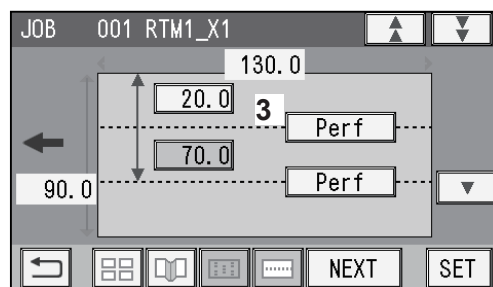● When setting one **RTM (rotary Tool Module)** and one card in the X direction
1. Enter the distance between the right edge of the finished product and the processing position (**1**) in the X direction with the NUMERIC keys. Touch **SET**.

```
JOB    001 RTM1_X1       [▲][▼]
          1    130.0
         0.0
                      Perf
         0.0
                      Perf
  90.0
  [↩][▦][▥][▦][⬚]  NEXT    SET
```

2. Enter the distance between the right edge of the finished product and the processing position in the X direction (**2**: **X1-L**) with the NUMERIC keys. Touch **SET**.

```
JOB    001 RTM1_X1       [▲][▼]
            130.0
        20.0
                      Perf
         0.0
  90.0   2             Perf    [▼]
  [↩][▦][▥][▦][⬚]  NEXT    SET
```

3. Touch **3** and select a type of **rotary tool** that is used for **X1-R** (**1**).
Every time **3** is touched, **Perf**, **Micro**, or **Score** is displayed.

```
JOB    001 RTM1_X1       [▲][▼]
            130.0
        20.0    3
                      Perf
        70.0
                      Perf    [▼]
  90.0
  [↩][▦][▥][▦][⬚]  NEXT    SET
```

4. Touch **4** and select a type of **rotary tool** that is used for **X1-L** (**2**).
Every time **4** is touched, **Perf**, **Micro**, or **Score** is displayed.
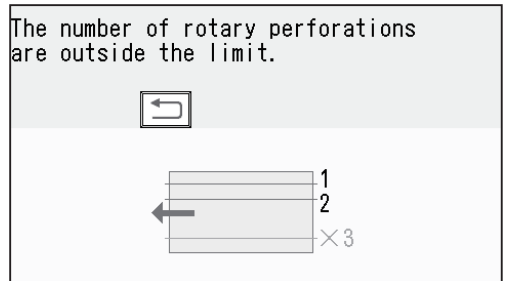Proceed to step 15.
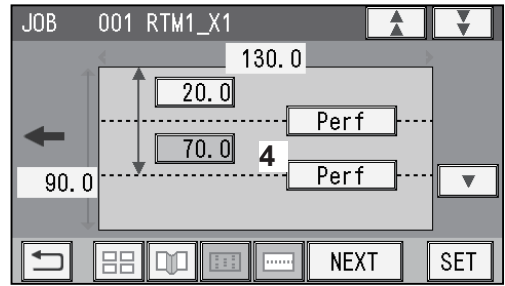
5. Touch the ▼ icon.
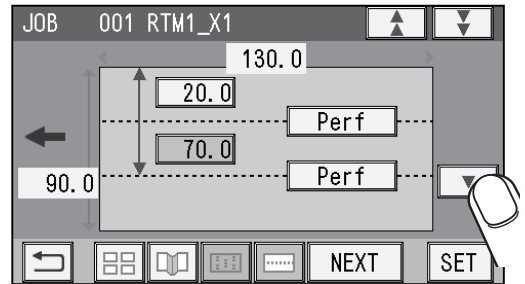
Touching **NEXT** may display the screen as shown on the right.
The third processing position in the **X** direction on the finished product is set.
Touch ↰ to return to the previous screen.

The number of rotary perforations are outside the limit.

- When setting one **RTM (Rotary Tool Module)** and two cards in the X direction
1. Enter the distance between the right edge of the finished product and the processing position (**1**) in the X direction with the NUMERIC keys. Touch **SET**.
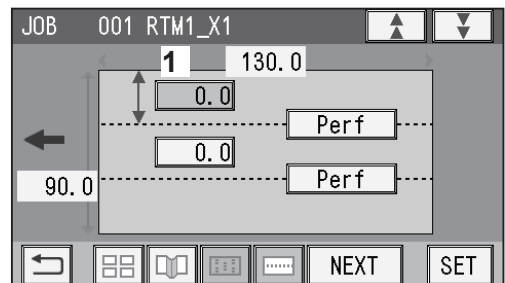
REFERENCE

If the number of cards in the X direction is **2**, entering the processing position (**1**) in the X direction processes the same position in the X direction on the other finished product. (The rotary tool on the right side of the **RTM (Rotary Tool Module)** processes the finished product on the right and the finished product on the left side processes that on the left.)
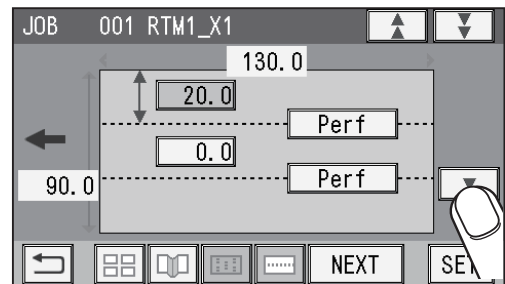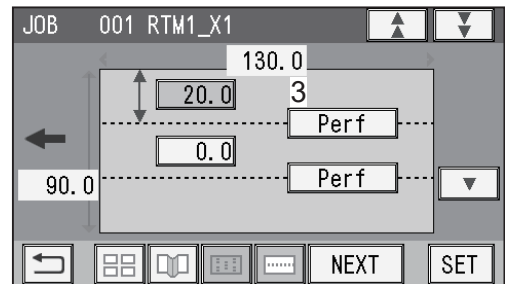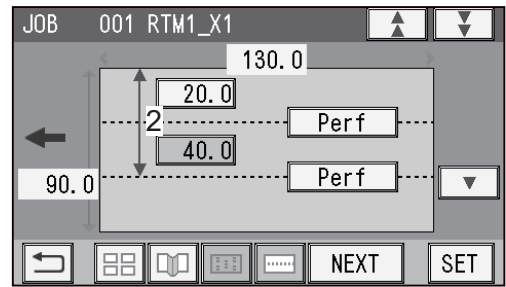
Document feed direction

L   R

2

Programming a JOB on the Control Panel
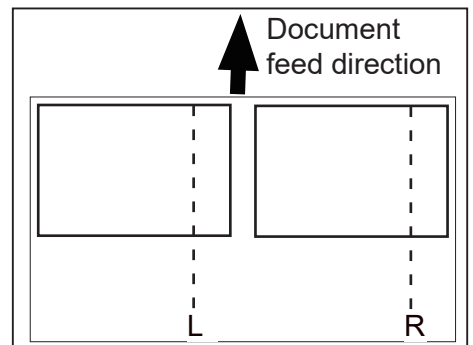
REFERENCE

If the number of cards in the X direction is **2**, entering the processing position (**2**) in the X direction displays the value in red, which shows that an invalid value is entered because two cards are programmed to be processed with one **RTM (Rotary Tool Module)** in the X direction.
Enter **0** for (**2**).

```
JOB   001 RTM1_X1        [⬆][⬇]
              130.0
           ┌──────┐
           │ 20.0 │
     ┌─ 2 ─┼──────┼──── ┌──────┐
     │     │ 40.0 │     │ Perf │ ───
     ←     └──────┘     └──────┘
    90.0              ┌──────┐
                      │ Perf │ ───  [▼]
                      └──────┘
    [↰][⊞][📖][▦][┅]  NEXT    SET
```

2. Touch **3** and select a type of **rotary tool** that is used for **X1** (**1**).
   Every time **3** is touched, **Perf**, **Micro**, or **Score** is displayed.

```
JOB   001 RTM1_X1        [⬆][⬇]
              130.0
           ┌──────┐     3
           │ 20.0 │   ┌──────┐
     ┌─────┼──────┼── │ Perf │ ───
     │     │ 0.0  │   └──────┘
     ←     └──────┘
    90.0              ┌──────┐
                      │ Perf │ ───  [▼]
                      └──────┘
    [↰][⊞][📖][▦][┅]  NEXT    SET
```

3. Touch the [▼] icon.

```
JOB   001 RTM1_X1        [⬆][⬇]
              130.0
           ┌──────┐
           │ 20.0 │     ┌──────┐
     ┌─────┼──────┼──── │ Perf │ ───
     │     │ 0.0  │     └──────┘
     ←     └──────┘
    90.0              ┌──────┐
                      │ Perf │ ───  [▼]
                      └──────┘
    [↰][⊞][📖][▦][┅]  NEXT    SE
```

⑮ **RTM1_X1_Y** (Settings in the Y direction of Pattern 1 on the X side)
1. Enter the distance between the lead edge of the finished product and **1** (**On** position: the processing start position of the rotary tool) of **Y1** (**Set 1** in the Y direction) with the NUMERIC keys.
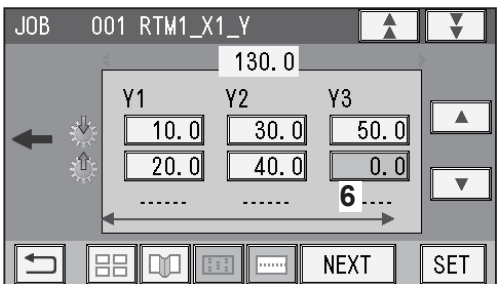   Touch **SET**.

```
JOB   001 RTM1_X1_Y      [⬆][⬇]
              130.0
        Y1
     ┌  ⬇ 1 ┌──────┐       [▲]
     │  ⬆   │ 0.0  │
     ←      └──────┘
            ┌──────┐       [▼]
            │ 0.0  │
            └──────┘
        ↔  ------
    [↰][⊞][📖][▦][┅]  NEXT    SET
```
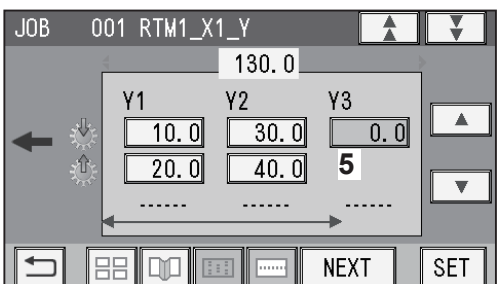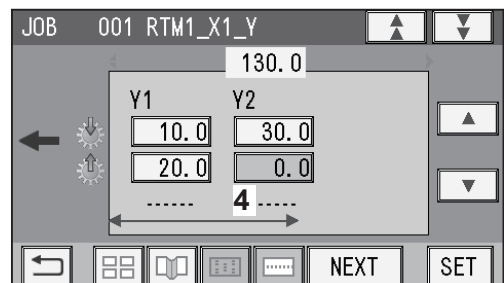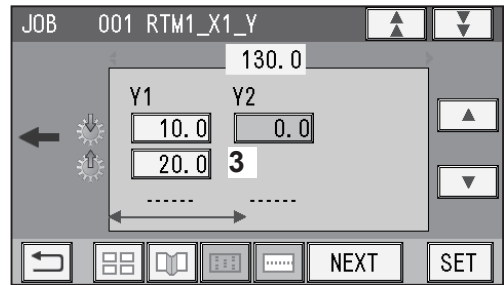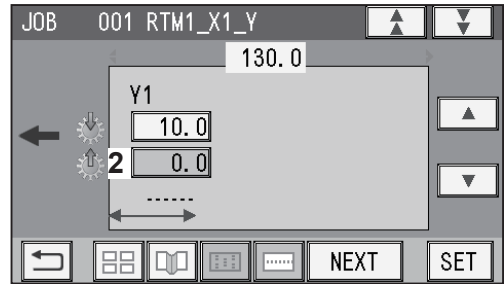
REFERENCE

If the number of cards in the Y direction is any of **2** to **6**, entering a processing position (**1**) in the Y direction sets the **On** position of **Y1** at the same position in the Y direction on another finished product.
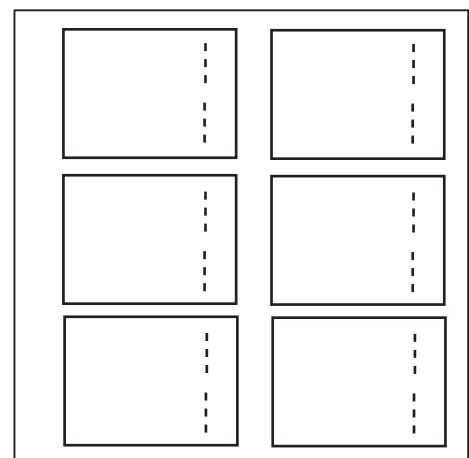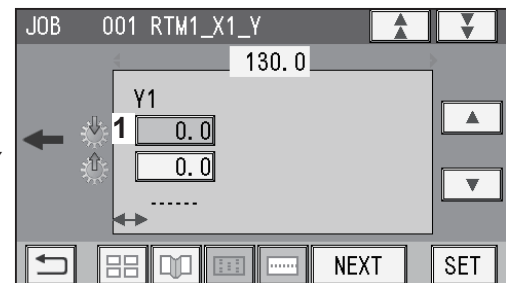
You can set up to six sets on one document in the Y direction.
In **Wizard**, the number of sets that can be set varies depending on the number of cards in the Y direction.
Even if two **RTM (Rotary Tool Module) s** are installed, the total of processing positions for one **RTM (Rotary Tool Module)** is as shown in the table on the right.

The number of cards in the Y direction	Processing positions of rotary tool
1	Y1 to Y6 6 sets
2	Y1 to Y3 3 sets
3	Y1 to Y2 2 sets
4	Y1 1 set
5	Y1 1 set
6	Y1 1 set

2. Enter the distance between the lead edge of the finished product and **2** (**Off** position: the processing stop position of the rotary tool) of **Y1** (**Set 1** in the Y direction) with the NUMERIC keys.
Touch **SET**.
If the number of cards in the Y direction is 4 to 6, go to step 17.

JOB	001 RTM1_X1_Y
130.0	
Y1	
10.0	
2 0.0	
------	

3. Enter the distance between the lead edge of the finished product and **3** (**On** position: the processing start position of the rotary tool) of **Y2** (**Set 2** in the Y direction) with the NUMERIC keys.
Touch **SET**.

JOB	001 RTM1_X1_Y
130.0	
Y1	Y2
10.0	0.0
20.0	**3**
------	------

4. Enter the distance between the lead edge of the finished product and **4** (**Off** position: the processing stop position of the rotary tool) of **Y2** (**Set 2** in the Y direction) with the NUMERIC keys.
Touch **SET**.
If the number of cards in the Y direction is 3, go to step 18.

JOB	001 RTM1_X1_Y
130.0	
Y1	Y2
10.0	30.0
20.0	0.0
------	**4** -----

5. Enter the distance between the lead edge of the finished product and **5** (**On** position: the processing start position of the rotary tool) of **Y3** (**Set 3** in the Y direction) with the NUMERIC keys.
Touch **SET**.

JOB	001 RTM1_X1_Y
130.0		
Y1	Y2	Y3
10.0	30.0	0.0
20.0	40.0	**5**
------	------	------

6. Enter the distance between the lead edge of the finished product and **6** (**Off** position: the processing stop position of the rotary tool) of **Y3** (**Set 3** in the Y direction) with the NUMERIC keys.
Touch **SET**.
If the number of cards in the Y direction is 2, go to step 17.

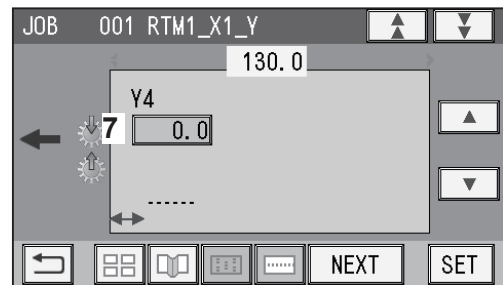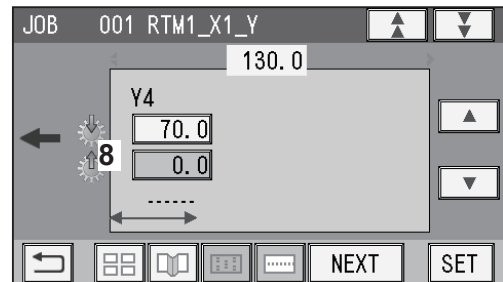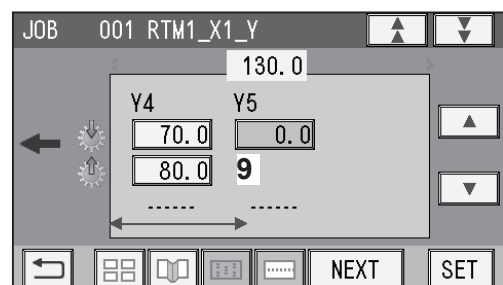| JOB	001 RTM1_X1_Y
130.0		
Y1	Y2	Y3
10.0	30.0	50.0
20.0	40.0	0.0
------	------	**6** ----

2

Programming a JOB on the Control Panel

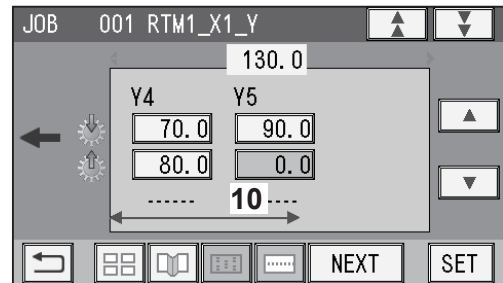7. If the number of cards in the Y direction is **1**, **Y4** to **Y6** are displayed.
   Enter the distance between the lead edge of the finished product and **7** (**On** position: the processing start position of the rotary tool) of **Y4** (**Set 4** in the Y direction) with the NUMERIC keys.
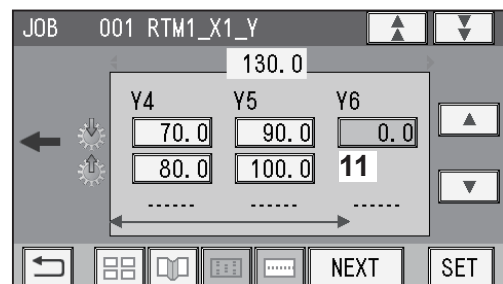   Touch **SET**.

```
JOB    001 RTM1_X1_Y         [⬆][⬇]
              130. 0
         Y4
    ←   ⬇  7 [  0. 0 ]               [▲]
        ⬆
                                     [▼]
         ------
         ↔
   [↩][⊞][📖][⊞][⋯]  NEXT    SET
```

8. Enter the distance between the lead edge of the finished product and **8** (**Off** position: the processing stop position of the rotary tool) of **Y4** (**Set 4** in the Y direction) with the NUMERIC keys.
   Touch **SET**.
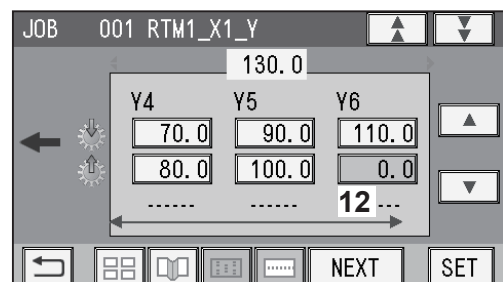
```
JOB    001 RTM1_X1_Y         [⬆][⬇]
              130. 0
         Y4
    ←   ⬇    [ 70. 0 ]              [▲]
        ⬆ 8  [  0. 0 ]
                                     [▼]
         ------
         ←——————→
   [↩][⊞][📖][⊞][⋯]  NEXT    SET
```

9. Enter the distance between the lead edge of the finished product and **9** (**On** position: the processing start position of the rotary tool) of **Y5** (**Set 5** in the Y direction) with the NUMERIC keys.
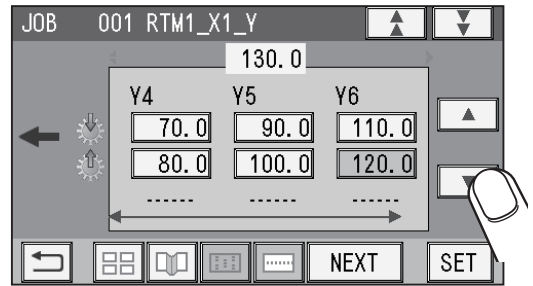   Touch **SET**.

```
JOB    001 RTM1_X1_Y         [⬆][⬇]
              130. 0
         Y4        Y5
    ←   ⬇ [ 70. 0 ] [  0. 0 ]      [▲]
        ⬆ [ 80. 0 ]  9
                                     [▼]
         ------   ------
         ←————————————→
   [↩][⊞][📖][⊞][⋯]  NEXT    SET
```

10. Enter the distance between the lead edge of the finished product and **10** (**Off** position: the processing stop position of the rotary tool) of **Y5** (**Set 5** in the Y direction) with the NUMERIC keys.
    Touch **SET**.

```
JOB    001 RTM1_X1_Y         [⬆][⬇]
              130. 0
         Y4        Y5
    ←   ⬇ [ 70. 0 ] [ 90. 0 ]      [▲]
        ⬆ [ 80. 0 ] [  0. 0 ]
                        10 ----      [▼]
         ------
         ←————————————→
   [↩][⊞][📖][⊞][⋯]  NEXT    SET
```

11. Enter the distance between the lead edge of the finished product and **11** (**On** position: the processing start position of the rotary tool) of **Y6** (**Set 6** in the Y direction) with the NUMERIC keys.
    Touch **SET**.

```
JOB    001 RTM1_X1_Y         [⬆][⬇]
              130. 0
         Y4        Y5        Y6
    ←   ⬇ [ 70. 0 ] [ 90. 0 ] [  0. 0 ]  [▲]
        ⬆ [ 80. 0 ] [ 100. 0 ]  11
                                          [▼]
         ------   ------   ------
         ←————————————————————→
   [↩][⊞][📖][⊞][⋯]  NEXT    SET
```

12. Enter the distance between the lead edge of the finished product and **12** (**Off** position: the processing stop position of the rotary tool) of **Y6** (**Set 6** in the Y direction) with the NUMERIC keys.
    Touch **SET**.

```
JOB    001 RTM1_X1_Y         [⬆][⬇]
              130. 0
         Y4        Y5        Y6
    ←   ⬇ [ 70. 0 ] [ 90. 0 ] [ 110. 0 ] [▲]
        ⬆ [ 80. 0 ] [ 100. 0 ] [  0. 0 ]
                              12 ---       [▼]
         ------   ------
         ←————————————————————→
   [↩][⊞][📖][⊞][⋯]  NEXT    SET
```

16 Touch the ▼ icon.

```
JOB    001  RTM1_X1_Y        ▲  ▼
              130. 0
        Y4      Y5      Y6
    ←   70. 0   90. 0   110. 0    ▲
        80. 0   100. 0  120. 0    ▼
        ------  ------  ------
    ⤺  ⊞ ▯ ▦ ⋯    NEXT    SET
```
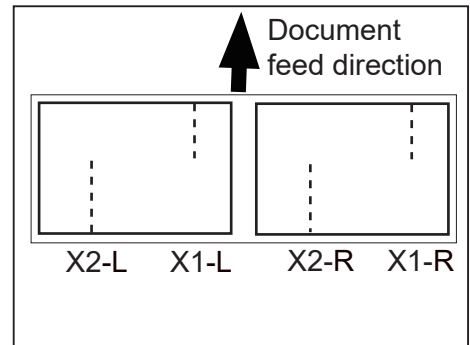
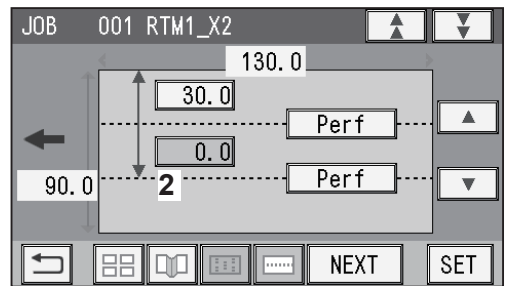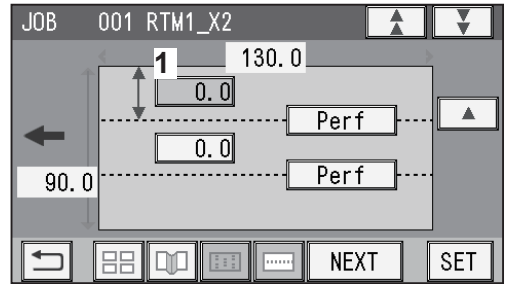**17** ● **Pattern 2 in the X direction (crosswise) X2**
1. Enter the distance between the right edge of the finished product and the processing position in the X direction (**1**: X2-R) with the NUMERIC keys. Touch **SET**.
   If the number of cards in the X direction is **1**, go to step 18-2.
   If the number of cards in the X direction is **2**, go to step 19.

```
JOB    001  RTM1_X2          ▲  ▼
        1      130. 0
            0. 0
                        Perf      ▲
            0. 0
    ←                   Perf
    90. 0                         ▼
    ⤺  ⊞ ▯ ▦ ⋯    NEXT    SET
```

REFERENCE

If the number of cards in the X direction is **2**, entering the processing position (**1**) in the X direction processes the same position in the X direction on the other finished product. (The rotary tool on the right side of the **RTM (Rotary Tool Module)** processes the finished product on the right and that on the left side processes that on the left.)

```
                    ↑  Document
                       feed direction
    ┌──────────┐   ┌──────────┐
    │  ┊    ┊  │   │  ┊    ┊  │
    │  ┊    ┊  │   │  ┊    ┊  │
    └──────────┘   └──────────┘
    X2-L   X1-L    X2-R   X1-R
```

2. Enter the distance between the right edge of the finished product and the processing position in the X direction (**2**: X2-L) with the NUMERIC keys. Touch **SET**.

```
JOB    001  RTM1_X2          ▲  ▼
              130. 0
            30. 0
                        Perf      ▲
            0. 0
    ←                   Perf      ▼
    90. 0    2
    ⤺  ⊞ ▯ ▦ ⋯    NEXT    SET
```

3. Touch the ▼ icon.

```
JOB    001  RTM1_X2          ▲  ▼
              130. 0
            30. 0
                        Perf      ▲
            80. 0
    ←                   Perf      ▼
    90. 0
    ⤺  ⊞ ▯ ▦ ⋯    NEXT    SET
```

2

Programming a JOB on the Control Panel
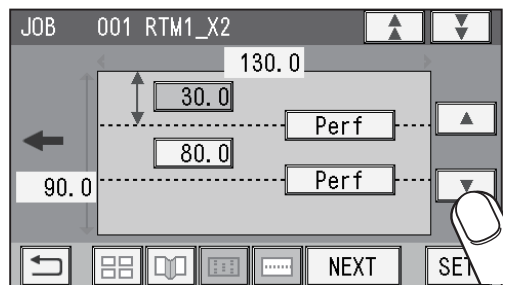
18 **RTM1_X2_Y** (Settings in the Y direction of Pattern 2 on the X side)
Set the processing start and the stop positions of the rotary tool for Pattern 2 with the **RTM (Rotary Tool Module)** in similar ways to steps 16-1 to 16-12.
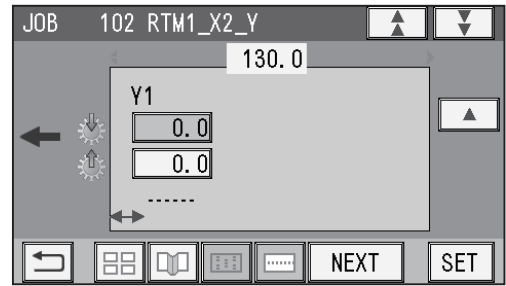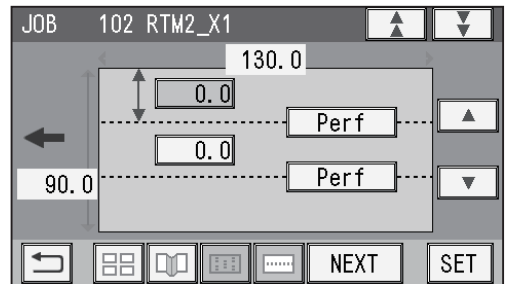
19 Touch **NEXT**.
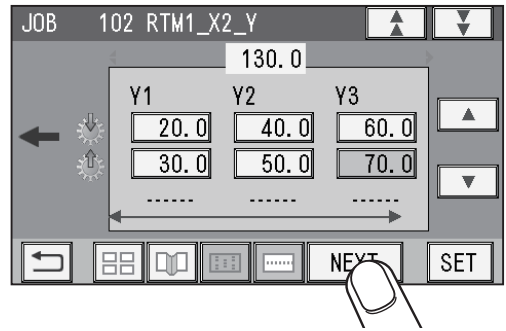
1. If you use two **RTM (Rotary Tool Module)s**, touch the ▼ icon.
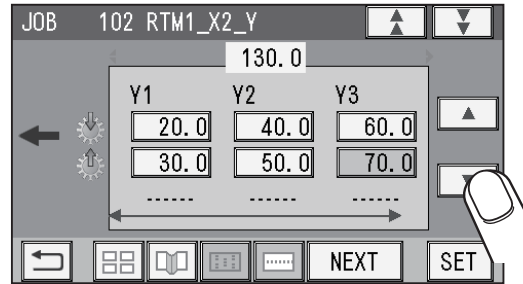
2. Enter values for processing positions of **RTM2** (the second **RTM (Rotary Tool Module)** in similar ways to steps 14 to 19.
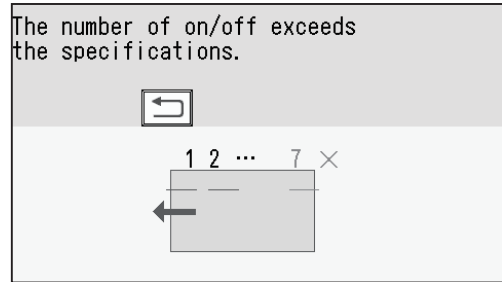
REFERENCE

The upper screen on the right appears.
Touching ⏎ may display the lower screen on the right.
The value on the screen is displayed in red.
In this case, the values for **R** and **L** were entered in step 14 even though 2 was entered for the number of the finished products on the X side in step 9.
To clear the error, touch the value for **R** or **L** and then enter **0**. Or enter **1** for the number of finished products on the X side in step 9 and then touch NEXT.

28
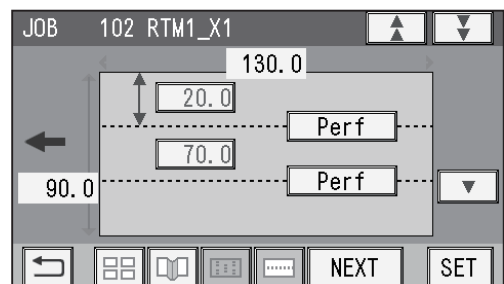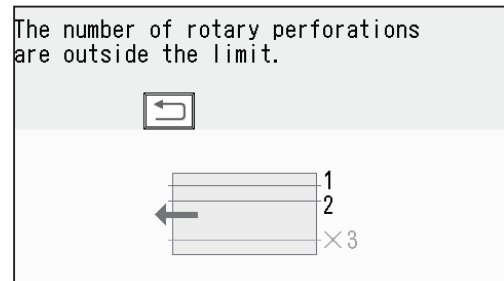
REFERENCE

The figure on the right appears if seven or more sets of **On** position and **Off** position in the Y direction with the **RTM** have been programmed. Touch [⮐] to check the processing positions of the **RTM (Rotary Tool Module)**.

```
The number of on/off exceeds
the specifications.
         [⮐]
      1 2 ··· 7 ✕
    ←─────────
```

20 **Settings-1**
1. Air Knife
If a document double feed occurs frequently, touch **ON**. If not, touch **OFF**.

```
JOB   001 Settings-1      [⤒] [⤓]
1  Air Knife              [ON]  [OFF]
2  Suction Power   [MIN] [MID] [MAX]
3  Blow Fan         [◄] 2 [►] (0-3)

4  REG Mark               [ON]  [OFF]
   [⮐]                          [SET]
```

REFERENCE

When processing light weight documents, select **OFF**.
When processing documents with excessive static electricity or processing heavy weight documents, select **ON**.

2. Suction Power
A document skew is adjusted with a document suctioned to the **conveyance belt**.
Select and touch suction level out of **MIN**, **MID**, or **MAX**.

REFERENCE

When using light weight documents, select **MIN** to prevent document jams.

3. Blow Fan
Air is blown out from the front of documents to loosen them. This prevents a double feed.
Touch the [◄]/[►] icon to select air level out of **0** to **3**.

4. REG Mark
When using the REG mark reading function, select and touch **ON**. When not using this function, select and touch **OFF**.
You can select **ON** or **OFF** only when a REG Mark position is set.
When you have completed the setting in **Settings-1**, touch **SET**.
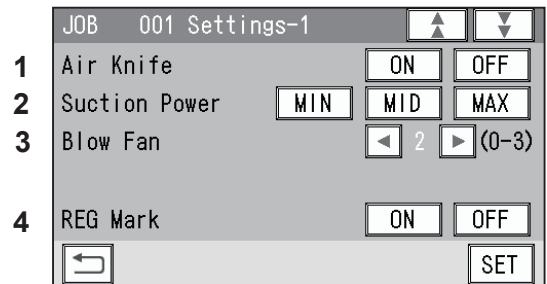
21 **Settings-2**
1. Slitter Guide
This enables you to use the **slitters** as document guides to stabilize the document conveyance if you do not use them to process a JOB.
It is recommended that you select **ON** when processing light weight documents.
Select and touch **ON** or **OFF**.

```
JOB   001 Settings-2      [⤒] [⤓]
1  Slitter Guide          [ON]  [OFF]
2  Crease Depth    [MIN] [MID] [MAX]
3  Cut Trim Setting  Full Bleed Mode [►]
4  Trail Cut Mode        Auto       [►]
5  Cutter Speed         [SLOW] [FAST]
   [⮐]                          [SET]
```

2. Crease Depth
Select and touch **MIN**, **MID**, or **MAX**.
Select **MAX** for heavy weight documents and **MIN** for light weight documents.
You can select a crease depth only when crease positions are set.
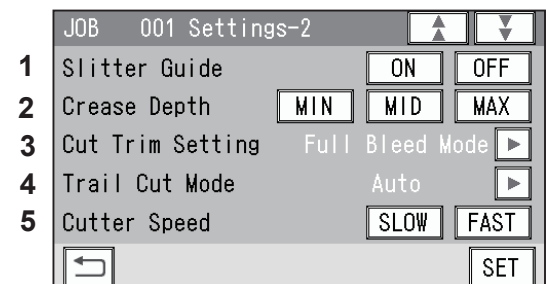
3. **Cut Trim Setting**
The lead margin, the trail margin, and any other gutters are chopped up and dropped into the waste box.
Touch ◀ / ▶ icon to select **Full Bleed Mode**, **No Bleed Mode**, or **Process All**.
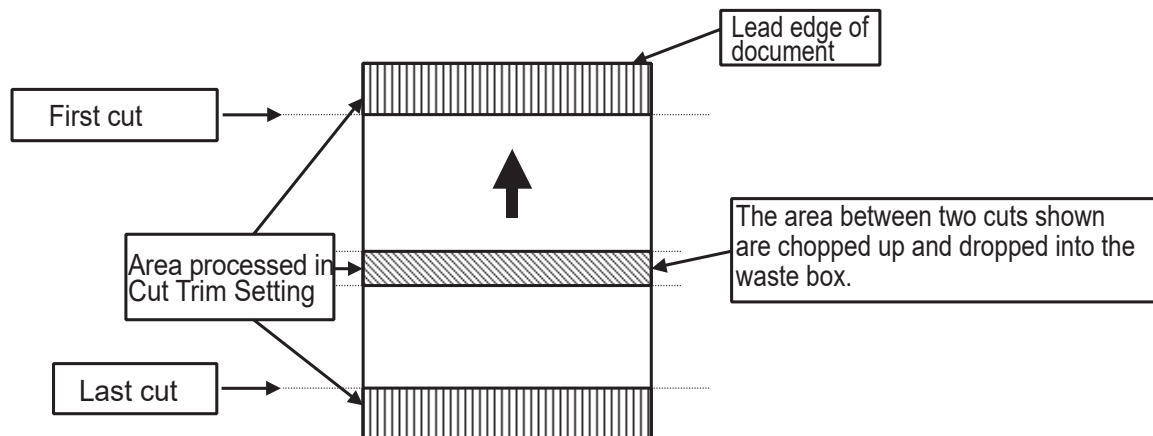
Full Bleed Mode: The lead margin and the trail margin are chopped up and dropped into the waste box. Any other gutter cuts shorter than 49.0 mm in width are also chopped up and dropped into the waste box.

No Bleed Mode: Gutter cuts shorter than 49.0 mm in width are chopped up and dropped into the waste box. Trail margin shorter than 60.0 mm is chopped up and dropped into the waste box.
If a document is processed without either of the lead margin or the trail margin, make sure to select **No Bleed Mode**.

Process All: All of the cut pieces are ejected to the **exit tray**.
Gutter cuts shorter than 30.0 mm in width are chopped up and dropped into the waste box. Trail margin shorter than 60.0 mm is chopped up and dropped into the waste box.

First cut

Area processed in Cut Trim Setting

Last cut

Lead edge of document

The area between two cuts shown are chopped up and dropped into the waste box.

Full Bleed Mode

↑ Document feed direction

| 0–48.9 mm | Chopped up |

| 0–48.9 mm | Chopped up |

| 0-59.9 mm | Chopped up |

↑ Document feed direction

| 49.0 mm or more | Chopped up |

| 49.0 mm or more | Not chopped up |

| 60.0 mm or more | Chopped up |

No Bleed Mode

↑ Document feed direction

| 0–48.9 mm | Chopped up |

| 0–48.9 mm | Chopped up |

| 0-59.9 mm | Chopped up |

↑ Document feed direction

| 49.0 mm or more | Not chopped up |

| 49.0 mm or more | Not chopped up |

| 60.0 mm or more | Not chopped up |

Process All

↑ Document feed direction

| 0-29.9 mm | Chopped up |

| 0-29.9 mm | Chopped up |

| 0-59.9 mm | Chopped up |

↑ Document feed direction

| 30.0 mm or more | Not chopped up |

| 30.0 mm or more | Not chopped up |

| 60.0 mm or more | Not chopped up |

2

Programming a JOB on the Control Panel

4. **Trail Cut Mode**
   This sets whether dummy cut for the trail margin is processed or not.
   Touch the ◀ / ▶ icon to select **Auto** or **OFF**.
   Auto: Performs dummy cut one time for the trail margin.
   OFF: No dummy cut is performed.

REFERENCE

• Dummy Cut:
   The DC-618 performs cutting operation without
   a document to be cut at the position where
   the document is fed for the distance of the trail
   margin plus extra length.
   This is effective for dropping a document, such
   as when the trail margin is jammed between the
   roller and the lower tool in the cutter section.
• Trail margin:
   Means a margin of the trail edge of a document
   produced when the last cut is processed.
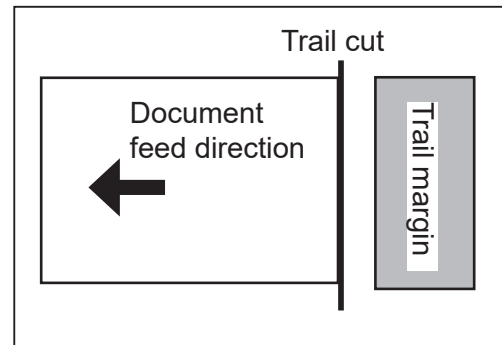
5. **Cutter Speed**
   Select and touch cutter speed out of **SLOW** or **FAST**.
   Select **SLOW** when processing documents that cannot be processed at **FAST** speed.
   When you have completed the setting in **Settings-2**, touch **SET**.

㉒ **Settings-3**
1. Speed
   Select processing speed our of **SLOW** or **FAST**.
   Selecting **SLOW** improves finishing accuracy.
   When you have completed the setting in
   Settings-3, touch **SET**.

㉓ **Settings-4**
The details of **Apply Shrinkage**, **Adjust All**, and/
or **Last Cut Adj.** are displayed only when either
of them is programmed in the JOB with **Adjust**.
Check the details of **1 Apply Shrinkage**, **2
Adjust All**, and **3 Last Cut Adj.**
Touch **Clear** to clear the settings.
Touch **Not Cleared** not to clear the settings.
Touch the ▼ icon.
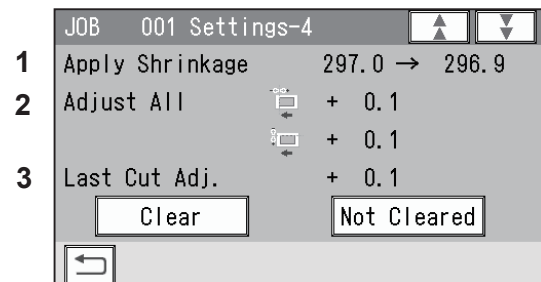
㉔ Touch **Entry**.
It saves the settings currently programmed and returns to the **standby** screen.

```
JOB    001 Entry

        ┌─────────────┐
        │    Entry    │
        └─────────────┘

┌──┐
│↩ │
└──┘
```

REFERENCE

• If you are selecting an already saved JOB and overwrite it, touch **Overwrite**.

```
JOB    001 Entry


        ┌─────────────┐
        │  Overwri    │
        └─────────────┘
        ┌──────────────────────┐
        │ Save as Different JOB No. │
        └──────────────────────┘
┌──┐
│↩ │
└──┘
```

• To save the settings as a different JOB number, touch **Save as Different JOB No.**

```
JOB    001 Entry


        ┌─────────────┐
        │  Overwrite  │
        └─────────────┘

        ┌──────────────────────┐
        │ Save as Different J    │
        └──────────────────────┘
┌──┐
│↩ │
└──┘
```

1. The **Enter JOB** screen is displayed.
   Select and touch a JOB number in which the programmed JOB is saved.

```
Enter JOB
┌───┬────────────────┐      ┌──┐
│006│ No Data        │      │⏫│
├───┼────────────────┤      ├──┤
│007│ No Data        │      │▲ │
├───┼────────────────┤      ├──┤
│   │ No Data        │      │▼ │
├───┼────────────────┤      ├──┤
│   │ o Data         │      │⏬│
├───┼────────────────┤      └──┘
│010│ No Data        │
└───┴────────────────┘
┌──┐ ┌──┐              ┌──┐
│↩ │ │✎ │              │🔍│
└──┘ └──┘              └──┘
```

2. Touch **Entry**.
   It saves the settings currently programmed and returns to the **standby** screen.

```
JOB    001 Entry


        ┌─────────────┐
        │    Entry    │
        └─────────────┘


┌──┐
│↩ │
└──┘
```

2

Programming a JOB on the Control Panel
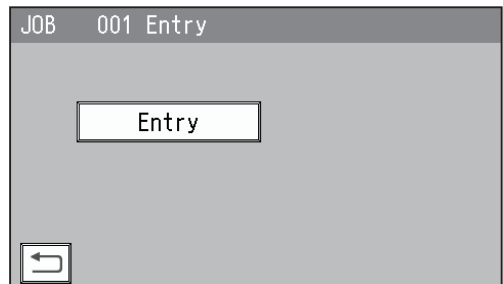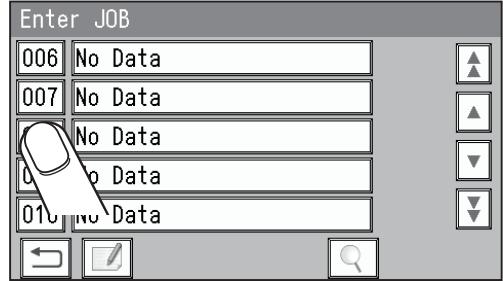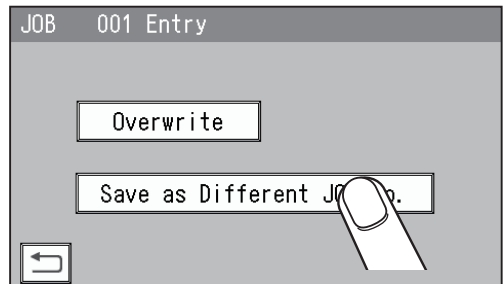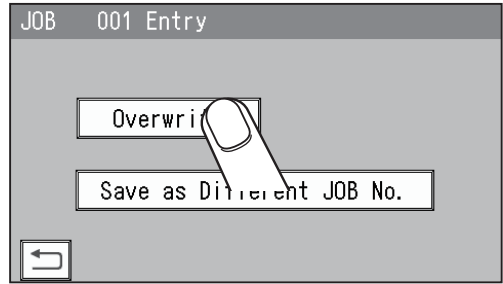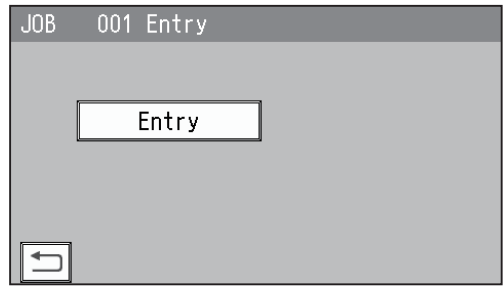
Direct - Advanced Mode

There are two programming modes in **Direct**, **Advanced Mode** and **Simple Mode**.
On the **Environment - Environment** screen, select **Advanced Mode** for **Basic Mode**.

1 Follow steps 1 to 4 in <u>Wizard</u>. (→P.18)

> **REFERENCE**
> The settable values are displayed in the lower left part of the screen.

2 **JOB Programming**
Touch **Direct**.
Wizard: This helps you program a JOB in a user size
      in a simple way.
Direct: This programs a JOB by entering a value of
      each item.

```
JOB Programming

    ┌──────────┐   ┌──────────┐
    │  Wizard  │   │  Direct  │
    └──────────┘   └──────────┘

    ┌──┐
    │↩ │
    └──┘
```
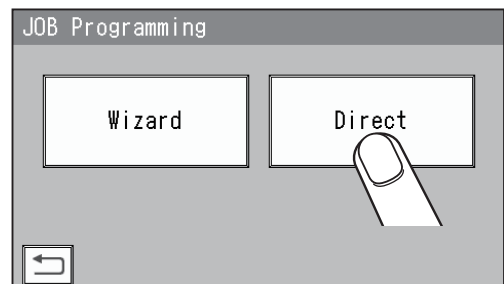
> **REFERENCE**
> You cannot reprogram the following JOBs in **Wizard**:
> • A JOB programmed in **Direct**
> • A JOB saved in **Wizard** and edited in **Direct** • A JOB saved in **Wizard** by using the PC
>   Controller
> Save a new JOB as a different JOB number or clear the JOB already saved and then save
> the new one.

3 **Module (Slot2) / Select Tool**
Touch ◀ / ▶ to select **RTM** out of **Slit**, **RTM**, or
Standard for a module in slot. Touch **SET**.
(A module which is not programmed by a service
person when installed is not displayed.)

```
Modules2 / Select Tool       [▲] [▼]
        2        Slit   [▶]  ←=
        _ _ _ _ _ _ _ _ _ _



    ┌──┐                          ┌─────┐
    │↩ │                          │ SET │
    └──┘                          └─────┘
```
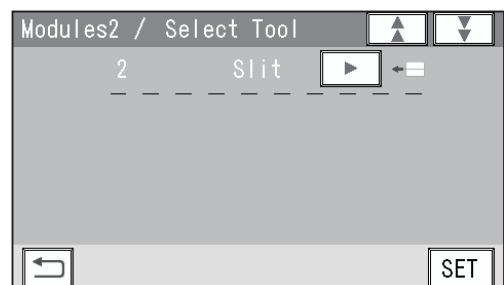
4 1. Touching ◀ / ▶ displays **Perf**, **Micro**, and **Score**.
   Select a rotary tool on the right side (**R**) in **slot 2**.

```
Modules2 / Select Tool       [▲] [▼]
        2   [◀]    RTM        ←▣
    ┌─────────────────────────────────┐
    │   R        Perf    [▶]    ◁      │
    └─────────────────────────────────┘
        L        Perf    [▶]    ◁

    ┌──┐                          ┌─────┐
    │↩ │                          │ SET │
    └──┘                          └─────┘
```
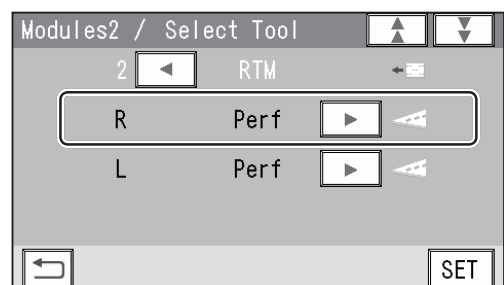
2. Touching ◀ / ▶ displays **Perf**, **Micro**, and **Score**.
   Select a rotary tool on the left side (**L**) in **slot 2**.
   Touch **SET**.

```
Modules2 / Select Tool       [▲] [▼]
        2   [◀]    RTM        ←▣
        _ _ _ _ _ _ _ _ _ _
        R        Perf    [▶]    ◁
    ┌─────────────────────────────────┐
    │   L        Perf    [▶]    ◁      │
    └─────────────────────────────────┘

    ┌──┐                          ┌─────┐
    │↩ │                          │ SET │
    └──┘                          └─────┘
```
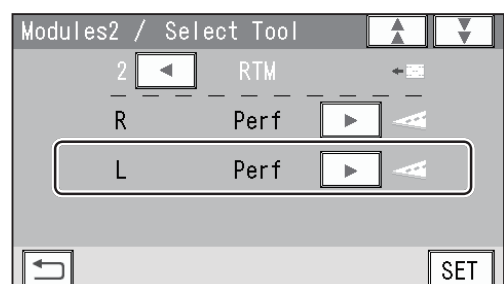
⑤ Module (Slot3) / Select Tool
If the **RTM (Rotary Tool Module)** is also installed in **slot 3**, select rotary tools for both **R** and **L** in **slot 3** as well in similar way to steps 3 and 4.

```
Modules3 / Select Tool    [⌃] [⌄]
   3  [◄]      RTM        ←▣
   R          Perf    [►]  ◄
   L          Perf    [►]  ◄

[↰]                        [SET]
```
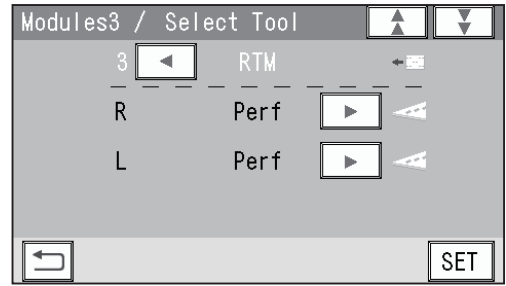
⑥ Document Size
Follow step 6 in <u>Wizard</u>. (→P.19)

```
JOB  008 Document Size   [⌃] [⌄]
          210.0
    ◄  User Size1   (210.0×210.0)
 210.0

[↰]                        [SET]
```
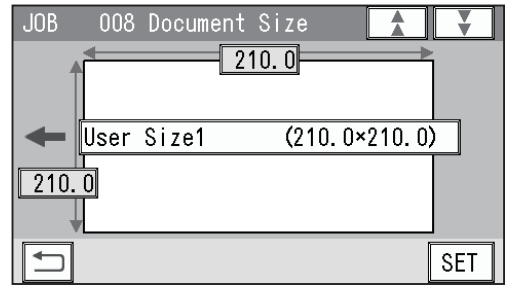
⑦ REG Mark
1. Enter the distance (**1**) between the right edge of the document and the side mark with the NUMERIC keys. Touch **SET**.

2. Enter the distance (**2**) between the lead edge of the document and the **lead mark** with the NUMERIC keys. Touch **SET**.

```
JOB  001 REG Mark        [⌃] [⌄]
                    1
                    [ 0.0 ]
    ◄  2
       [ 0.0 ]

[↰]  (3.0-15.0)            [SET]
```
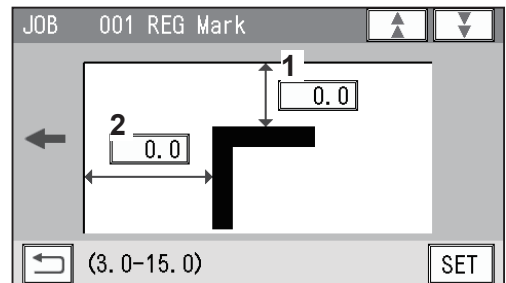
⑧ Select and touch **REG Mark Spec** out of **Standard** or **Bold**.
Touch **SET**.

```
JOB  001 REG Mark        [⌃] [⌄]




  □  □  REG Mark   [Standard] [Bold]
          Spec
[↰]                        [SET]
```
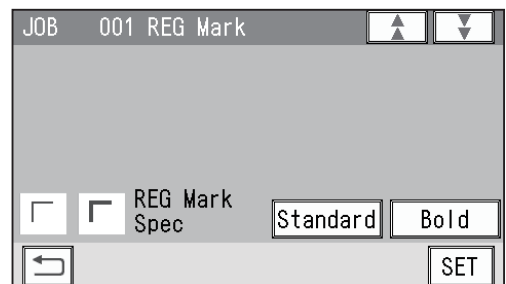
⑨ Slit
1. Set processing positions of the **margin slitter module** installed in **slot 1**.
Enter the distance between the right edge of the document and slit1 for **Slit1** with the NUMERIC keys. Touch **SET**.

```
JOB  001 Slit            [⌃] [⌄]

              ▲1                ▲1
       ▼5                       ▼5
    ◄    3              1        6
       ▲4                Slit1 0.0mm
        6                       ▼2
       ▼2
[↰]     (0/3.2-55.0)       [SET]
```

2. Enter the distance between the right edge of the document and slit2 for **Slit2** with the NUMERIC keys. Touch **SET**.

```
JOB  001 Slit            [⌃] [⌄]
 1:  10.0

              ▲1                ▲1
       ▼5                       ▼5
    ◄    3                       6
       ▲4                Slit2 0.0mm
        6                       ▼2
       ▼2
[↰]    (0/155.0-206.8)     [SET]
```

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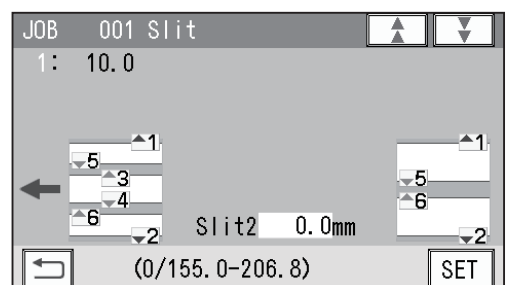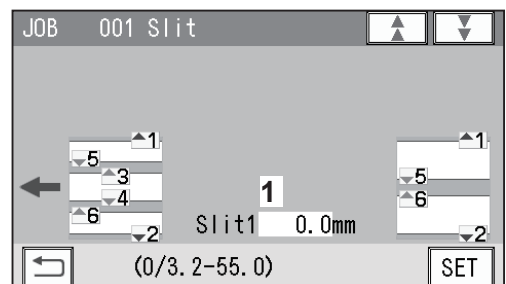
3. If settings were made for two **RTMs (Rotary Tool Module)** in steps 4 and 5, go to step 10.
If one **RTM (Rotary Tool Module)** is installed and a **center slitter module** is installed in **slot 2** or **slot 3**, set processing positions of the **center slitter module**.
Enter the distance between the right edge of the document and slit5 for **Slit5** with the NUMERIC keys. Touch **SET**.

```
JOB    001 Slit                    [▲] [▼]
 1:   10.0  2: 200.0  3:   0.0  4:   0.0
[5:    0.0] 6:   0.0
        ▲1                           ▲1
   ▼5                           ▼5
      ▲3                           ▲6
      ▲4
   ▲6         Slit5   0.0mm
          ▼2                      ▼2
 [↰]      (0/58.0-152)              [SET]
```
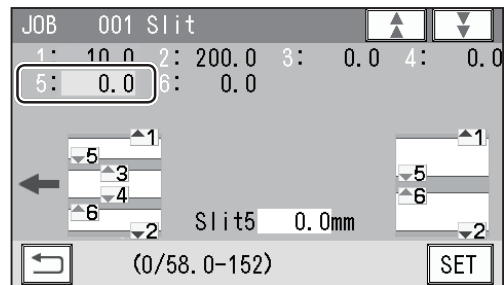
4. Enter the distance between the right edge of the document and slit6 for **Slit6** with the NUMERIC keys in a similar way to step 9-4. Touch **SET**.

```
JOB    001 Slit                    [▲] [▼]
 1:   10.0  2: 200.0  3:   0.0  4:   0.0
 5: 100.0 [6:    0.0]
        ▲1                           ▲1
   ▼5                           ▼5
      ▲3                           ▲6
      ▲4
   ▲6         Slit6   0.0mm
          ▼2                      ▼2
 [↰]      (0/105.0-152.0)           [SET]
```
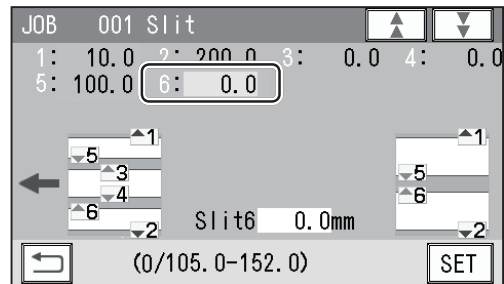
REFERENCE

Slit position setting order:
• **Simple mode**: Slits are set in alphabetical order from **SlitA** to **SlitF**.
• **Advanced mode**: Slits are set in numerical order as shown in the figure on the right.
1, **2**: Margin slitter module
5, **6**: Center slitter module
3, **4**: Center slitter module
e.g. If one **RTM (Rotary Tool Module)** and one **center slitter module** are installed, **A**, **B**, **C**, and **D**, or **1**, **2**, **5**, and **6** are displayed.
If two **RTM (Rotary Tool Module)s** are installed, **A** and **B**, or **1** and **2** are displayed.

```
  ↑ Document feed direction
   F   E   D   C   B   A
   2   6   4   3   5   1
  ┌───┬───┬───┬───┬───┬───┐
  │   │   │   │   │   │   │
  │   │   │   │   │   │   │
  │   │   │   │   │   │   │
  └───┴───┴───┴───┴───┴───┘
```
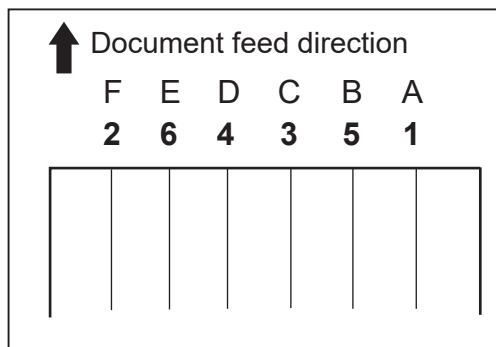
⑩ **Cut**
Enter the distance between the lead edge of the document and the first cut position (**1**) with the NUMERIC keys. Touch **SET**.
You can set up to 30 creases.
If you finish the setting with fewer than 30 cuts, enter the last cut position and touch **SET**. Then enter **0** in the next cut position and touch **SET**.

```
JOB    001 Cut                     [▲] [▼]



                          1
  ←    ▌▌        Cut1      0.0mm
 [↰]  (0/3.0-292.0)                 [SET]
```
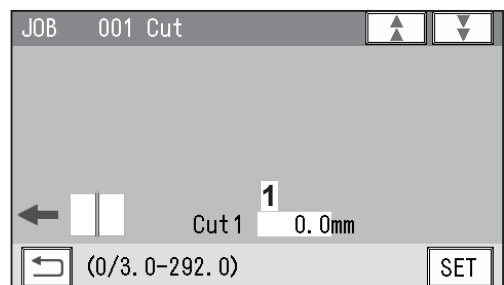
⑪ **Crease**
Enter the distance between the lead edge of the document and the first crease position (**1**) with the NUMERIC keys. Touch **SET**.
You can set up to 20 creases.
If you finish the setting with fewer than 20 creases, enter the last crease position and touch **SET**. Then enter **0** in the next crease position and touch **SET**.

```
JOB    001 Crease                  [▲] [▼]



                          1
  ←    ▌        Crease1    0.0mm
 [↰]  (0/10.0-297.0)                [SET]
```
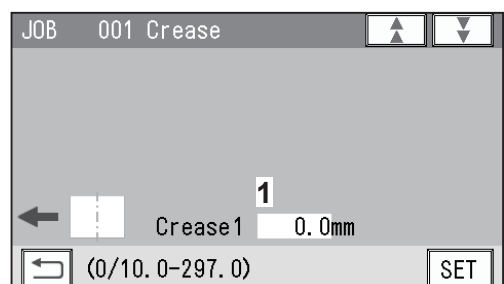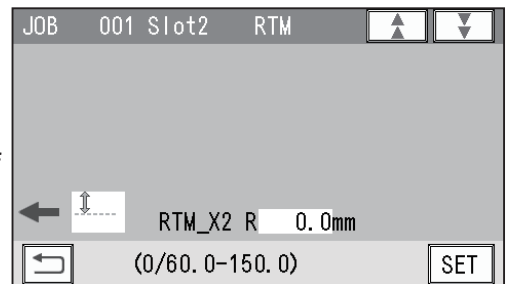
⑫ Slot2 RTM
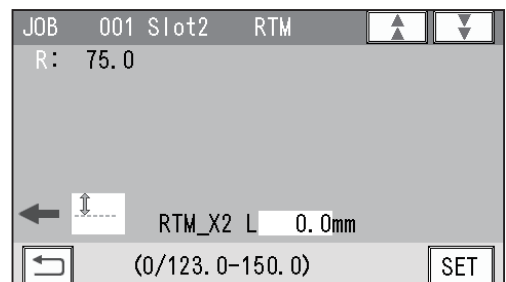**X1** (Pattern 1 in the X direction)
1. **RTM_X1 R**
Enter the distance between the right edge of the document and the rotary tool on the right side (**R**) of the **RTM (Rotary Tool Module)** with the NUMERIC keys. Touch **SET**.
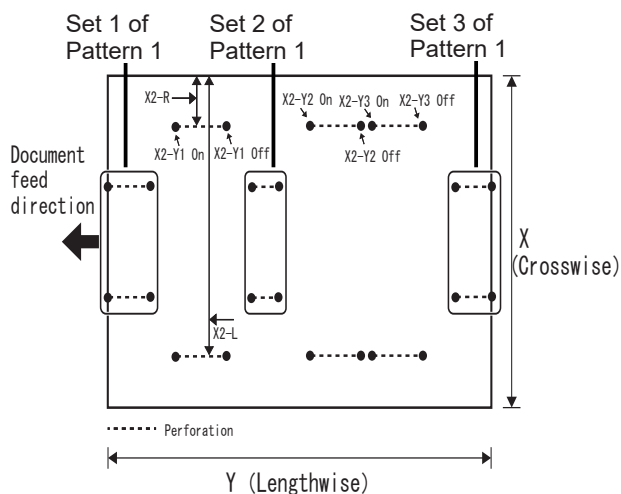
> **REFERENCE**
>
> If you have set gutter slit(s) in step 9, touching ◀ / ▶ switches the value that can be entered for the positions of the rotary tool for the finished product on the right and for those on the left.
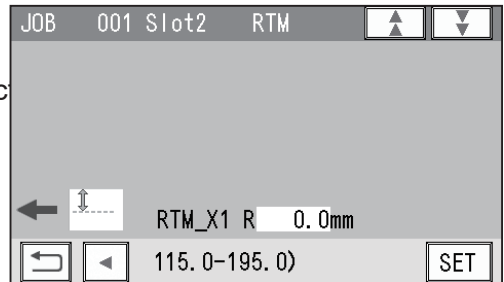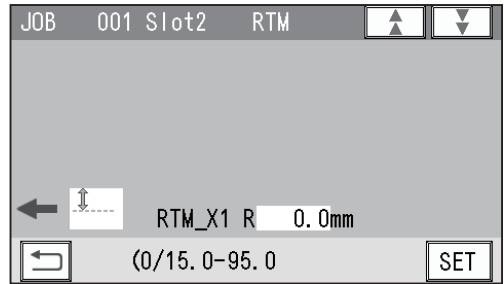
```
JOB   001 Slot2   RTM    ⤒ ⤓

              ↕
         ←  ⤒----    RTM_X1 R    0.0mm
         ↩          (0/15.0-95.0)        SET
```

```
JOB   001 Slot2   RTM    ⤒ ⤓



              ↕
         ←  ⤒----    RTM_X1 R    0.0mm
         ↩  ◀       115.0-195.0)        SET
```

2. **RTM_X1 L**
Enter the distance between the right edge of the document and the rotary tool on the left side (**L**) of the **RTM (Rotary Tool Module)** with the NUMERIC keys. Touch **SET**.

```
JOB   001 Slot2   RTM    ⤒ ⤓
  R:   65.0



              ↕
         ←  ⤒----    RTM_X1 L    0.0mm
         ↩          (0/113.0-150.0)      SET
```
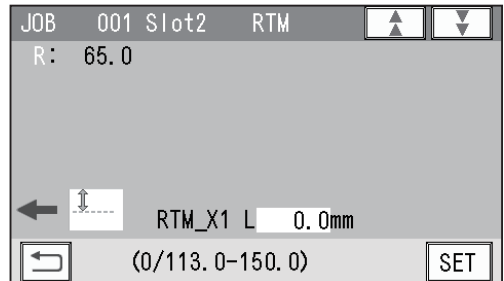
⑬ Slot2 RTM
1. **X1_Y1↓**
Enter the distance between the lead edge of the document and the **On** position (the processing start position of the rotary tool) of **Y1** (**Set 1** in the Y direction) with the NUMERIC keys. Touch **SET**.

```
JOB   001 Slot2   RTM    ⤒ ⤓



         ←  ⬍----    X1_Y1 ↓    0.0mm
         ↩          (0.0-296.9)         SET
```

> **REFERENCE**
>
> The tools on the left side (**L**) and the right side (**R**) skip at the same time.
> You can program up to six sets (**Y1** to **Y6**) in the Y direction each for **X1** (Pattern 1 in the X direction) and **X2** (Pattern 2 in the X direction).
> To finish setting for the Y direction with less than six sets, enter a value for the last processing position and touch **SET**.
> Then touch **SET** again, which proceeds to the screen in step 16.

2. **X1_Y1 ↑**
Enter the distance between the lead edge of the document and the **Off** position (the processing stop position of the rotary tool) of **Y1** (**Set 1** in the Y direction) with the NUMERIC keys. Touch **SET**.

```
JOB   001 Slot2   RTM    ⤒ ⤓
  1↓   10.0



         ←  ----⇧    X1_Y1 ↑    0.0mm
         ↩          (10.1-297.0)        SET
```

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3. **X1_Y2 ↓**
   Enter the distance between the lead edge of the document and the **On** position (the processing start position of the rotary tool) of **Y2** (**Set 2** in the Y direction) with the NUMERIC keys. Touch **SET**.

```
JOB    001 Slot2    RTM      ⊼  ⊻
1↓   10.0  ↑  20.0

        ⇓----    X1_Y2 ↓    0.0mm
  ↰          (0/20.0-296.9)         SET
```

4. **X1_Y2 ↑**
   Enter the distance between the lead edge of the document and the **Off** position (the processing stop position of the rotary tool) of **Y2** (**Set 2** in the Y direction) with the NUMERIC keys. Touch **SET**.

```
JOB    001 Slot2    RTM      ⊼  ⊻
1↓   10.0  ↑  20.0  2↓   30.0

        ----⇑    X1_Y2 ↑    0.0mm
  ↰          (30.1-297.0)          SET
```

5. **X1_Y3 ↓**
   Enter the distance between the lead edge of the document and the **On** position (the processing start position of the rotary tool) of **Y3** (**Set 3** in the Y direction) with the NUMERIC keys. Touch **SET**.

```
JOB    001 Slot2    RTM      ⊼  ⊻
1↓   10.0  ↑  20.0  2↓   30.0  ↑   40.0

        ⇓----    X1_Y3 ↓    0.0mm
  ↰          (0/40.0-296.9)         SET
```

6. **X1_Y3 ↑**
   Enter the distance between the lead edge of the document and the **Off** position (the processing stop position of the rotary tool) of **Y3** (**Set 3** in the Y direction) with the NUMERIC keys. Touch **SET**.

```
JOB    001 Slot2    RTM      ⊼  ⊻
1↓   10.0  ↑  20.0  2↓   30.0  ↑   40.0
3↓   50.0

        ----⇑    X1_Y3 ↑    0.0mm
  ↰          (50.1-297.0)          SET
```

7. **X1_Y4 ↓**
   Enter the distance between the lead edge of the document and the **On** position (the processing start position of the rotary tool) of **Y4** (**Set 4** in the Y direction) with the NUMERIC keys. Touch **SET**.

```
JOB    001 Slot2    RTM      ⊼  ⊻
1↓   10.0  ↑  20.0  2↓   30.0  ↑   40.0
3↓   50.0  ↑  60.0

        ⇓----    X1_Y4 ↓    0.0mm
  ↰          (0/60.0-296.9)         SET
```

8. **X1_Y4 ↑**
   Enter the distance between the lead edge of the document and the **Off** position (the processing stop position of the rotary tool) of **Y4** (**Set 4** in the Y direction) with the NUMERIC keys. Touch **SET**.

```
JOB    001 Slot2    RTM      ⊼  ⊻
1↓   10.0  ↑  20.0  2↓   30.0  ↑   40.0
3↓   50.0  ↑  60.0  4↓   70.0

        ----⇑    X1_Y4 ↑    0.0mm
  ↰          (70.1-297.0)          SET
```

9. **X1_Y5** ↓
   Enter the distance between the lead edge of the document and the **On** position (the processing start position of the rotary tool) of **Y5** (**Set 5** in the Y direction) with the NUMERIC keys. Touch **SET**.
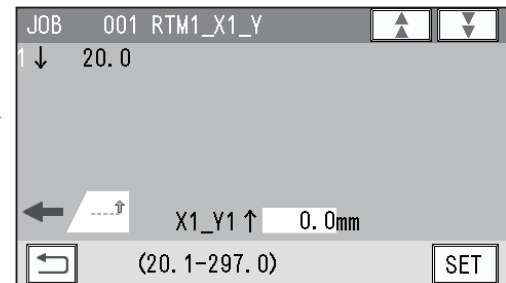
```
JOB    001 Slot2    RTM      [▲] [▼]
1↓   10.0  ↑   20.0  2↓   30.0  ↑   40.0
3↓   50.0  ↑   60.0  4↓   70.0  ↑   80.0



←    ⟱----
              X1_Y5↓    0.0mm
↰           (0/80.0-296.9)          [SET]
```
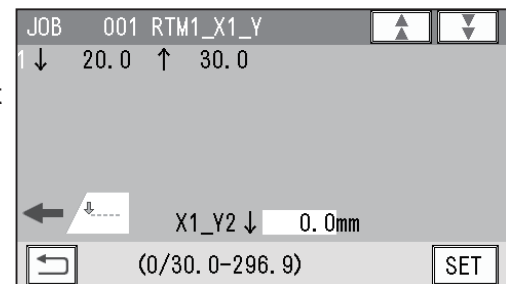
10. **X1_Y5** ↑
    Enter the distance between the lead edge of the document and the **Off** position (the processing stop position of the rotary tool) of **Y5** (**Set 5** in the Y direction) with the NUMERIC keys. Touch **SET**.

```
JOB    001 Slot2    RTM      [▲] [▼]
1↓   10.0  ↑   20.0  2↓   30.0  ↑   40.0
3↓   50.0  ↑   60.0  4↓   70.0  ↑   80.0
5↓   90.0


←    ----⟰
              X1_Y5↑    0.0mm
↰           (90.1-297.0)          [SET]
```
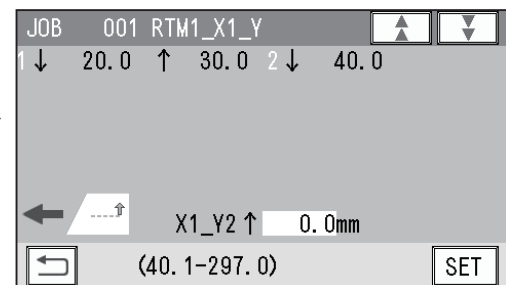
11. **X1_Y6** ↓
    Enter the distance between the lead edge of the document and the **On** position (the processing start position of the rotary tool) of **Y6** (**Set 6** in the Y direction) with the NUMERIC keys. Touch **SET**.

```
JOB    001 Slot2    RTM      [▲] [▼]
1↓   10.0  ↑   20.0  2↓   30.0  ↑   40.0
3↓   50.0  ↑   60.0  4↓   70.0  ↑   80.0
5↓   90.0  ↑  100.0


←    ⟱----
              X1_Y6↓    0.0mm
↰          (0/100.0-296.9)         [SET]
```
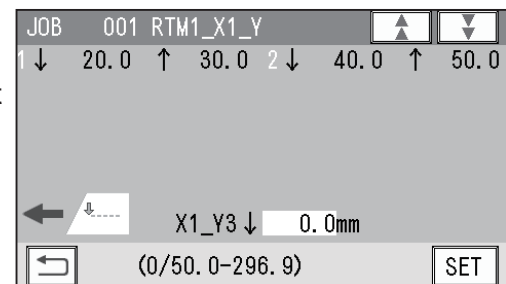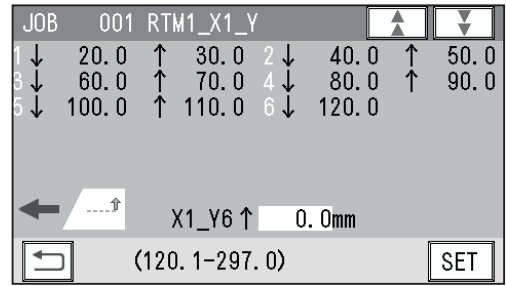
12. **X1_Y6** ↑
    Enter the distance between the lead edge of the document and the **Off** position (the processing stop position of the rotary tool) of **Y6** (**Set 6** in the Y direction) with the NUMERIC keys. Touch **SET**.

```
JOB    001 Slot2    RTM      [▲] [▼]
1↓   10.0  ↑   20.0  2↓   30.0  ↑   40.0
3↓   50.0  ↑   60.0  4↓   70.0  ↑   80.0
5↓   90.0  ↑  100.0  6↓  110.0


←    ----⟰
              X1_Y6↑    0.0mm
↰           (110.1-297.0)          [SET]
```

⑭ **Slot2 RTM**
X2 (Pattern 2 in the X direction)
1. **RTM_X2 R**
   Enter the distance between the right edge of the document and the rotary tool on the right side (**R**) of the **RTM (Rotary Tool Module)** with the NUMERIC keys. Touch **SET**.

```
JOB    001 Slot2    RTM      [▲] [▼]




←    ↕----
              RTM_X2 R    0.0mm
↰           (0/60.0-150.0)         [SET]
```

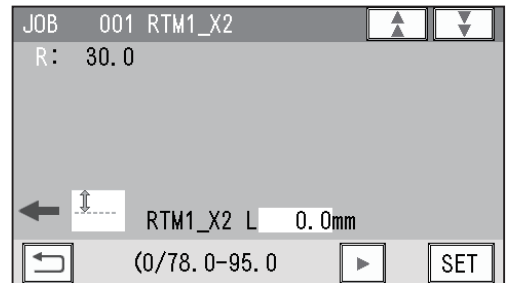2. **RTM_X2 L**
   Enter the distance between the right edge of the document and the rotary tool on the left side (**L**) of the **RTM (Rotary Tool Module)** with the NUMERIC keys. Touch **SET**.
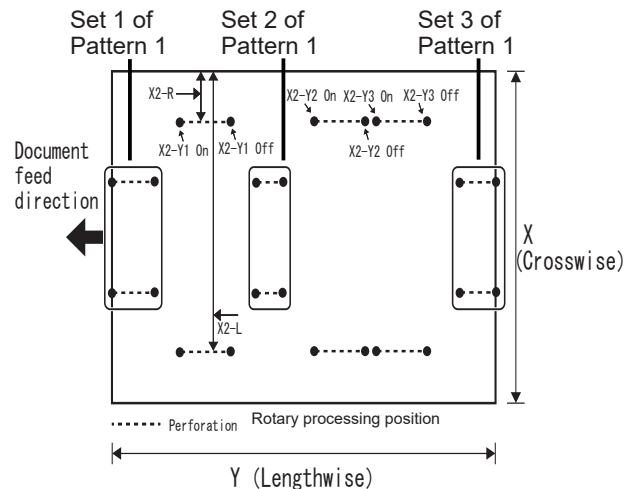
```
JOB    001 Slot2    RTM      [▲] [▼]
R:   75.0




←    ↕----
              RTM_X2 L    0.0mm
↰          (0/123.0-150.0)         [SET]
```

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15 **Slot2 RTM**
Enter values for **X2_Y1↓** to **X2_Y6↑** in a similar way to step 13.

```
JOB    001 Slot2    RTM       [⤒] [⤓]




          ↓
          ⌐‥‥      X2_Y1 ↓    0.0mm
    [↩]        (0.0-9.9        [▶]    [SET]
```

┌─────────────────────────────┐
│ **IMPORTANT**   │
│   │
│ Processing a document in the Y │
│ direction of **Pattern 2** can be made │
│ between each set of **Pattern 1**. │
└─────────────────────────────┘

Set 1 of Pattern 1　Set 2 of Pattern 1　Set 3 of Pattern 1

X2-R→
X2-Y2 On　X2-Y3 On　X2-Y3 Off
Document feed direction
X2-Y1 On　X2-Y1 Off
X2-Y2 Off
X2-L
X (Crosswise)
‥‥‥ Perforation
Y (Lengthwise)

16 If you have selected the **RTM (Rotary Tool Nodule)** in **slot 3**, go to step 17.
If you have selected another module, go to step 18.

17 **Slot 3 RTM**
If the **RTM (Rotary Tool Module)** is set in **slot 3** in step 5, enter processing positions in similar ways to steps 12 to 15.
You can set the second set in the X direction and the sixth set in the Y direction.

```
JOB    001 Slot3    RTM       [⤒] [⤓]




          ↕
          ⌐‥‥      RTM_X1 R    0.0mm
    [↩]        (0/15.0-195.0)         [SET]
```
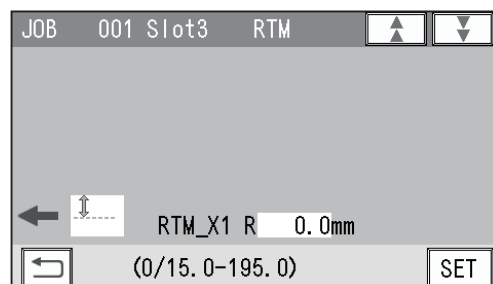
18 The function setting screen appears.
Follow steps 20 to 24 in <u>Wizard</u>. (→P.29)

```
JOB    001 Settings-1         [⤒] [⤓]
Air Knife                  [ON]  [OFF]
Suction Power        [MIN] [MID] [MAX]
Blow Fan              [◀] 2 [▶] (0-3)
Side Air        [OFF] [MIN] [MID] [MAX]
REG Mark                   [ON]  [OFF]
    [↩]                          [SET]
```
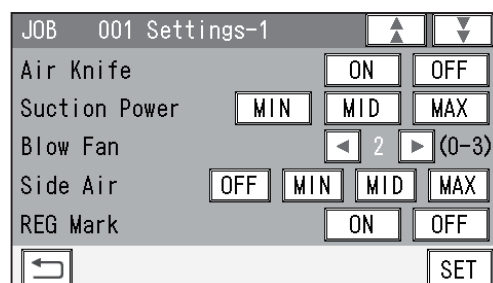
Direct - Simple Mode

There are two programming modes in **Direct**, **Advanced Mode** and **Simple Mode**.
On the **Environment - Environment** screen, select **Simple Mode** for **Basic Mode**.

① Follow steps 1 to 4 in <u>Wizard</u>. (→P.18)

> **REFERENCE**
>
> The settable values are displayed in the lower left part of the screen.

② **JOB Programming**
Touch **Direct**.
Wizard: This helps you program a JOB in a user size in a simple way.
Direct: This programs a JOB by entering a value of each item.

```
JOB Programming

    Wizard          Direct

↩
```
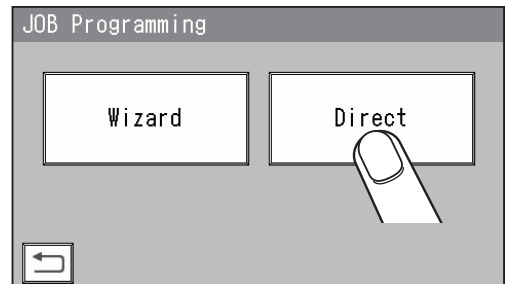
> **REFERENCE**
>
> You cannot reprogram the following JOBs in **Wizard**:
> • A JOB programmed in **Direct**
> • A JOB saved in **Wizard** and edited in **Direct**
> • A JOB saved in **Wizard** by using the PC Controller
> Save a new JOB as a different JOB number or clear the JOB already saved and then save the new one.

③ Follow steps 6 to 8 in <u>Direct - Advance Mode</u>. (→P.35)

④ **Slit**
Set processing positions for a **slitter module**:
Enter the distance from the right edge of the document to the position for **SlitA** using the NUMERIC keys.
A **margin slitter module** is installed in **slot 1**.

```
JOB   001 Slit        ⯅  ⯆



            ← [    ]   SlitA  0.0mm
  ↩          (0/3.2-206.8)        SET
```
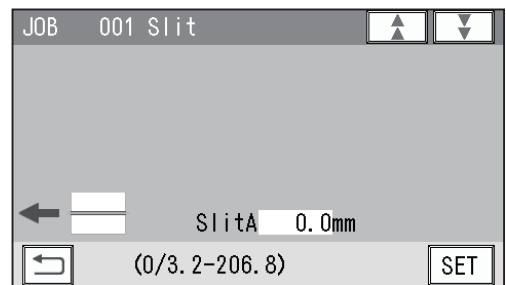
If one **RTM (Rotary Tool Module)** is installed in **slot 2** or **slot 3**, enter values for processing positions (**SlitA**, **SlitD**) of the margin slitters and those (**SlitA**, **SlitB**) of the center slitters.

```
JOB   001 Slit        ⯅  ⯆
A:  10.0  B: 100.0  C: 110.0  D: 200.0



            ← [    ]   SlitE  0.0mm
  ↩          (0)                  SET
```

Programming a JOB on the Control Panel

2
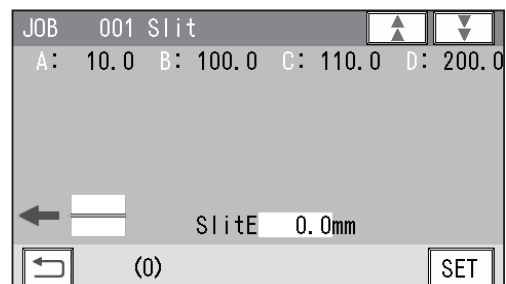
If two **RTMs (Rotary Tool Module)** are installed, set margin positions (**SlitA**, **SlitB**) on both sides of the document.

```
JOB    001 Slit                    ▲  ▼
A:  90.0   B: 180.0



                        SlitC    0.0mm
  ↩        (0)                           SET
```
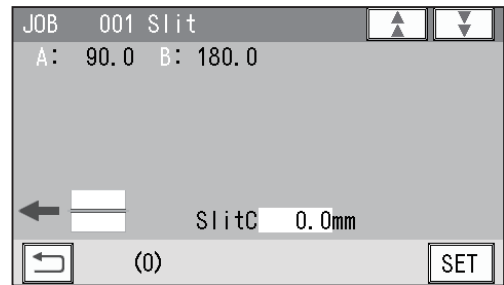
REFERENCE

- **Simple mode**: Slits are set in alphabetical order from **SlitA** to **SlitF**.
- **Advanced mode**: Slits are set in numerical order as shown in the figure on the right.
- Entry limit
  Margin slit width: 3.2 to 55.0 mm
  Minimum finished product: 48.0 mm
  Gutter slit: 5.0 to 15.0 mm

```
↑ Document feed direction
  F   E   D   C   B   A
  2   4   6   5   3   1
```
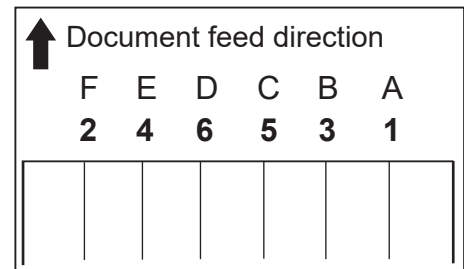
5 To program cuts and creases, follow steps 10 to 11 in <u>Direct - Advance Mode</u>. (P.36)

6 **RTM1_X1**
   X1 (Pattern 1 in the X direction)

REFERENCE

- Limitation on entry (X direction)
  Enter a value so that there is 5.0 mm or more of distance between the right edge of the finished product and a slit.
  Enter a value so that there is 48.0 mm or more distance between the tools (**R** and **L**) of the **RTM (Rotary Tool Module)**.
- If **RTM (Rotary Tool Module)s** are set for both **Slot2** and **Slot3**, **RTM1** is set for **Slot2** and **RTM2** is set for **Slot3**.
  If only **RTM1** is set, **RTM1** is set for a slot for which no other module is used.
  If the **CPM (Cross Tool Module) (option)** is set, **RTM1** is set for **Slot3**.

1. Enter the distance between the right edge of the document and the rotary tool on the right side (**R**) of the **RTM (Rotary Tool Module)** with the NUMERIC keys. Touch **SET**.

```
JOB    001 RTM1_X1                 ▲  ▼




           RTM1_X1 R      0.0mm
  ↩        (0/15.0-95.0       ▶       SET
```

2. Enter the distance between the right edge of the document and the rotary tool on the left side (**L**) of the **RTM (Rotary Tool Module)** with the NUMERIC keys. Touch **SET**.
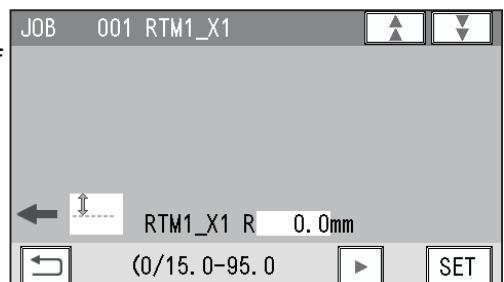
```
JOB    001 RTM1_X1                 ▲  ▼
R:   20.0




           RTM1_X1 L      0.0mm
  ↩        (0/68.0-95.0       ▶       SET
```
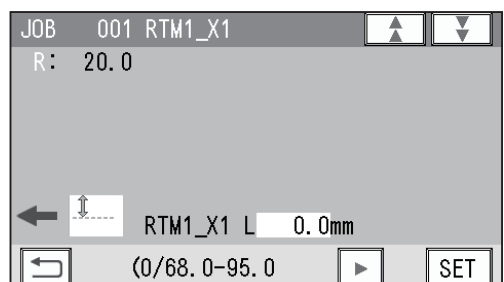
7 **RTM1_X1_Y**

1. **X1_Y1↓**

   Enter the distance between the lead edge of the document and the **On** position (the processing start position of the rotary tool) of **Y1** (**Set 1** in the Y direction) with the NUMERIC keys. Touch **SET**.

```
JOB    001 RTM1_X1_Y       [↑][↓]




←  [↙----]   X1_Y1 ↓    0. 0mm
[↩]      (0. 0-296. 9)         [SET]
```

REFERENCE

The tools on the left side (**L**) and the right side (**R**) skip at the same time.
You can program up to six sets (**Y1** to **Y6**) in the Y direction each for **X1** (Pattern 1 in the X direction) and **X2** (Pattern 2 in the X direction).
To finish setting for the Y direction with less than six sets, enter a value for the last processing position and touch **SET**.
Then touch **SET** again, which proceeds to the screen in step 8.

2. **X1_Y1 ↑**

   Enter the distance between the lead edge of the document and the **Off** position (the processing stop position of the rotary tool) of **Y1** (**Set 1** in the Y direction) with the NUMERIC keys. Touch **SET**.

```
JOB    001 RTM1_X1_Y       [↑][↓]
1↓   20. 0




←  [----↑]   X1_Y1 ↑    0. 0mm
[↩]      (20. 1-297. 0)        [SET]
```

3. **X1_Y2 ↓**

   Enter the distance between the lead edge of the document and the **On** position (the processing start position of the rotary tool) of **Y2** (**Set 2** in the Y direction) with the NUMERIC keys. Touch **SET**.

```
JOB    001 RTM1_X1_Y       [↑][↓]
1↓   20. 0  ↑   30. 0




←  [↙----]   X1_Y2 ↓    0. 0mm
[↩]      (0/30. 0-296. 9)      [SET]
```

4. **X1_Y2 ↑**

   Enter the distance between the lead edge of the document and the **Off** position (the processing stop position of the rotary tool) of **Y2** (**Set 2** in the Y direction) with the NUMERIC keys. Touch **SET**.

```
JOB    001 RTM1_X1_Y       [↑][↓]
1↓   20. 0  ↑   30. 0  2↓   40. 0




←  [---↑]   X1_Y2 ↑    0. 0mm
[↩]      (40. 1-297. 0)        [SET]
```

5. **X1_Y3 ↓**

   Enter the distance between the lead edge of the document and the **On** position (the processing start position of the rotary tool) of **Y3** (**Set 3** in the Y direction) with the NUMERIC keys. Touch **SET**.

```
JOB    001 RTM1_X1_Y       [↑][↓]
1↓   20. 0  ↑   30. 0  2↓   40. 0  ↑   50. 0




←  [↙----]   X1_Y3 ↓    0. 0mm
[↩]      (0/50. 0-296. 9)      [SET]
```

2

Programming a JOB on the Control Panel

6. **X1_Y3 ↑**
   Enter the distance between the lead edge of the document and the **Off** position (the processing stop position of the rotary tool) of **Y3** (**Set 3** in the Y direction) with the NUMERIC keys. Touch **SET**.

```
JOB    001 RTM1_X1_Y          [⤒] [⤓]
1↓   20.0  ↑  30.0  2↓   40.0  ↑  50.0
3↓   60.0

         ┌---⇧          X1_Y3 ↑    0.0mm
    [↩]         (60.1-297.0)              [SET]
```

7. **X1_Y4 ↓**
   Enter the distance between the lead edge of the document and the **On** position (the processing start position of the rotary tool) of **Y4** (**Set 4** in the Y direction) with the NUMERIC keys. Touch **SET**.

```
JOB    001 RTM1_X1_Y          [⤒] [⤓]
1↓   20.0  ↑  30.0  2↓   40.0  ↑  50.0
3↓   60.0  ↑  70.0

         ┌⇩---          X1_Y4 ↓    0.0mm
    [↩]         (0/70.0-296.9)            [SET]
```

8. **X1_Y4 ↑**
   Enter the distance between the lead edge of the document and the **Off** position (the processing stop position of the rotary tool) of **Y4** (**Set 4** in the Y direction) with the NUMERIC keys. Touch **SET**.

```
JOB    001 RTM1_X1_Y          [⤒] [⤓]
1↓   20.0  ↑  30.0  2↓   40.0  ↑  50.0
3↓   60.0  ↑  70.0  4↓   80.0

         ┌---⇧          X1_Y4 ↑    0.0mm
    [↩]         (80.1-297.0)              [SET]
```

9. **X1_Y5 ↓**
   Enter the distance between the lead edge of the document and the **On** position (the processing start position of the rotary tool) of **Y5** (**Set 5** in the Y direction) with the NUMERIC keys. Touch **SET**.

```
JOB    001 RTM1_X1_Y          [⤒] [⤓]
1↓   20.0  ↑  30.0  2↓   40.0  ↑  50.0
3↓   60.0  ↑  70.0  4↓   80.0  ↑  90.0

         ┌⇩---          X1_Y5 ↓    0.0mm
    [↩]         (0/90.0-296.9)            [SET]
```

10. **X1_Y5 ↑**
    Enter the distance between the lead edge of the document and the **Off** position (the processing stop position of the rotary tool) of **Y5** (**Set 5** in the Y direction) with the NUMERIC keys. Touch **SET**.

```
JOB    001 RTM1_X1_Y          [⤒] [⤓]
1↓   20.0  ↑  30.0  2↓   40.0  ↑  50.0
3↓   60.0  ↑  70.0  4↓   80.0  ↑  90.0
5↓  100.0

         ┌---⇧          X1_Y5 ↑    0.0mm
    [↩]         (100.1-297.0)             [SET]
```

11. **X1_Y6 ↓**
    Enter the distance between the lead edge of the document and the **On** position (the processing start position of the rotary tool) of **Y6** (**Set 6** in the Y direction) with the NUMERIC keys. Touch **SET**.

```
JOB    001 RTM1_X1_Y          [⤒] [⤓]
1↓   20.0  ↑  30.0  2↓   40.0  ↑  50.0
3↓   60.0  ↑  70.0  4↓   80.0  ↑  90.0
5↓  100.0  ↑ 110.0

         ┌⇩---          X1_Y6 ↓    0.0mm
    [↩]         (0/110.0-296.9)           [SET]
```

12. **X1_Y6** ↑
Enter the distance between the lead edge of the document and the **Off** position (the processing stop position of the rotary tool) of **Y6** (**Set 6** in the Y direction) with the NUMERIC keys. Touch **SET**.

```
JOB    001 RTM1_X1_Y        ⤒  ⤓
1↓   20.0  ↑   30.0  2↓  40.0  ↑  50.0
3↓   60.0  ↑   70.0  4↓  80.0  ↑  90.0
5↓  100.0  ↑  110.0  6↓ 120.0

            ⬦--⇧    X1_Y6 ↑   0.0mm
   ↩         (120.1-297.0)           SET
```

⑧ RTM2_X2
X2 (Pattern 2 in the X direction)
1. **RTM_X2 R**
Enter the distance between the right edge of the document and the rotary tool on the right side (**R**) of the **RTM (Rotary Tool Module)** with the NUMERIC keys. Touch **SET**.

```
JOB    001 RTM1_X2          ⤒  ⤓

          ↕
          ⬦----   RTM1_X2 R   0.0mm
   ↩         (0/15.0-95.0)     ▶   SET
```

2. **RTM1_X1 L**
Enter the distance between the right edge of the document and the rotary tool on the left side (**L**) of the **RTM (Rotary Tool Module)** with the NUMERIC keys. Touch **SET**.
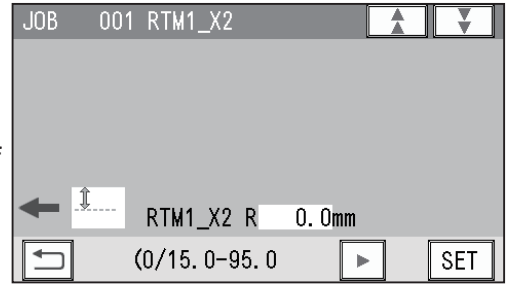
```
JOB    001 RTM1_X2          ⤒  ⤓
 R:  30.0

          ↕
          ⬦----   RTM1_X2 L   0.0mm
   ↩         (0/78.0-95.0)     ▶   SET
```

⑨ RTM1_X2_Y
X2 (Pattern 2 in the X direction)
Enter values of **On** position(s) and **Off** position(s) for **Y1** to **Y6** of **X2** in a similar way to step 7.
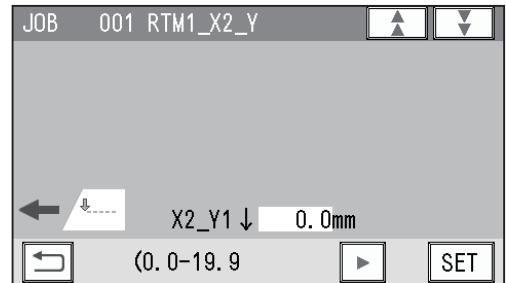
```
JOB    001 RTM1_X2_Y        ⤒  ⤓

          ⬦----   X2_Y1 ↓   0.0mm
   ↩         (0.0-19.9       ▶   SET
```

IMPORTANT

Processing a document in the Y direction of **Pattern 2** can be made between each set of **Pattern 1**.

Set 1 of Pattern 1 Set 2 of Pattern 1 Set 3 of Pattern 1

X2-R
X2-Y2 On X2-Y3 On X2-Y3 Off
X2-Y1 On X2-Y1 Off X2-Y2 Off

Document feed direction

X2-L

X (Crosswise)

------ Perforation Rotary processing position

Y (Lengthwise)

10 **Select Tool**
RTM1

1. Touch the ◀ / ▶ icon to select a rotary tool for **R** (right side) of **RTM1** out of **Perf**, **Micro**, and **Score**.

```
Select Tool              [▲] [▼]
              RTM2      ←▤
      R       Perf    [▶]  ◁
      L       Perf    [▶]  ◁
  [↩]                        [SET]
```
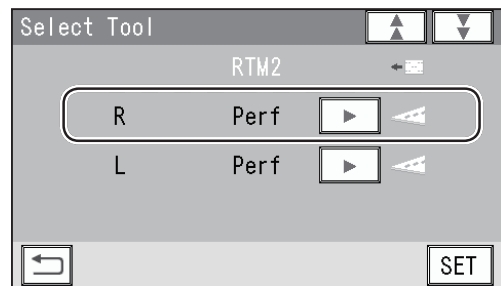
2. Touch the ◀ / ▶ icon to select a rotary too for **L** (left side) of **RTM1** out of **Perf**, **Micro**, and **Score**. Touch **SET**.

```
Select Tool              [▲] [▼]
              RTM2      ←▤
  _ _ _ _ _ _ _ _
      R       Perf    [▶]  ◁
      L       Perf    [▶]  ◁
  [↩]                        [SET]
```
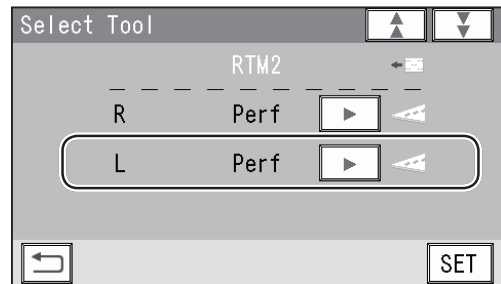
11 **RTM2_X1**
Follow steps 6 to 10.

```
JOB    001 RTM2_X1       [▲] [▼]



  ←    ↕
          RTM2_X1 R    0.0mm
  [↩]    (0/15.0-195.0)       [SET]
```
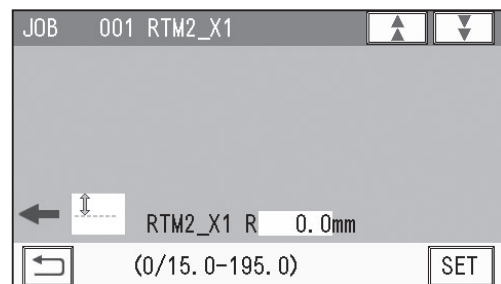
12 **Select Tool RTM2**
Select type of the rotary tools on the right side (**R**) and the left side (**L**) of **RTM2** in a similar way to step 10.

```
Select Tool              [▲] [▼]
              RTM2      ←▤
  _ _ _ _ _ _ _ _
      R       Perf    [▶]  ◁
      L       Perf    [▶]  ◁
  [↩]                        [SET]
```
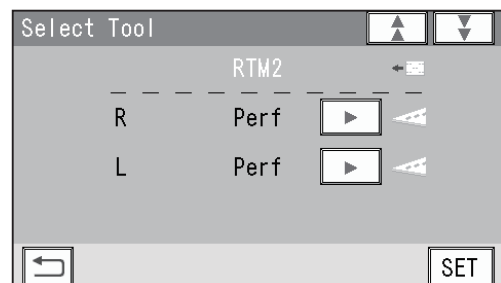
13 The function setting screen appears.
Follow steps 20 to 23 in <u>Wizard</u>. (→P.29)

14 **Tool Setup**
1. Each type of the rotary tools on the right side (**R**) or the left side (**L**) of the **RTM (Rotary Tool Module)** in **slot 2** appears.
Check each of them and touch SET.
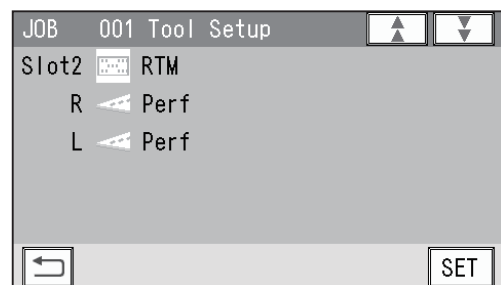
```
JOB    001 Tool Setup    [▲] [▼]
Slot2 ▤ RTM
   R ◁ Perf
   L ◁ Perf



  [↩]                        [SET]
```

2. Each type of the rotary tools on the right side (**R**) or the left side (**L**) of the **RTM (Rotary Tool Module)** in **slot 3** appears.
Check each of them and touch **SET**.

```
JOB    001 Tool Setup   [⬆] [⬇]
Slot3 [▦] RTM
    R  ◁ Perf
    L  ◁ Perf


[↩]                          [SET]
```
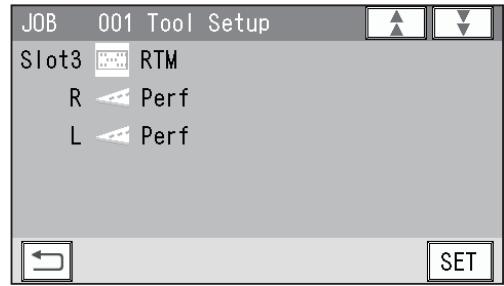
⑮ **Modules**
Modules in **slot 2** and **slot 3** appear.
Check them and touch SET.

```
JOB    001 Modules      [⬆] [⬇]


Slot2 [▦] RTM
Slot3 [☰] Slit



[↩]                          [SET]
```
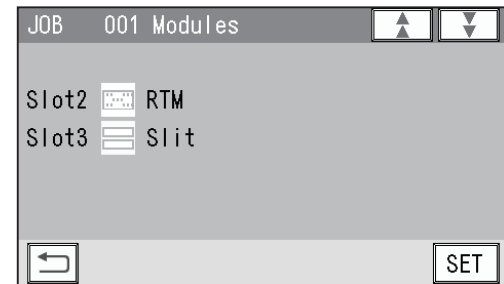
⑯ Follow step 24 in <u>Wizard</u>. (→P.33)

```
JOB    001 Entry



        [  Entry  ]



[↩]
```

2

Programming a JOB on the Control Panel
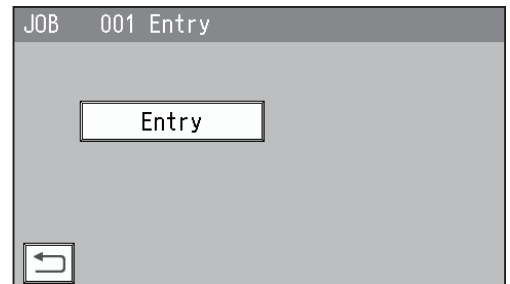
Processing Documents by Retrieving a Saved JOB

This section describes the procedure for processing documents by retrieving a JOB from **JOB No.** or **JOB Log**.

1 Follow steps 1 to 12 in Chapter 3 <u>Basic Operations</u> - <u>Processing Documents by Retrieving a Saved JOB</u> in the DC-618 Instruction Manual.

● If the tool check screen appears, follow the procedure below.
(The tool check screen on the right appears when the **RTM (Rotary Tool Module)** is installed in **slot 2**.)

```
RTM : Check the setup of
micro perf tools.

  ◇ Continue        ▽ to clear
                        Slot2
                        R  ↑
                        L  ↓
                        Slot3
                        R  −
                        L  −
```
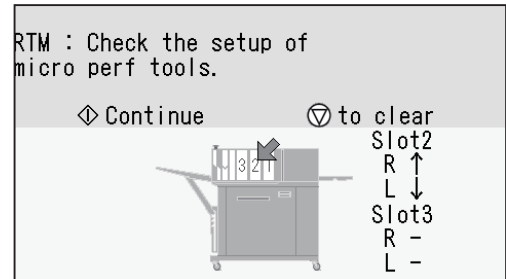
1. Open the **top cover**.

2. Raise or lower the tools of the **RTM (Rotary Tool Module(s)** according to the direction of the arrows displayed on the screen.
   - R: Tool on the non-operator's side
   - L: Tool on the operator's side
   - ↑: Raise the tool.
   - ↓: Lower the tool.
   - −: No rotary tool is used.

Adjustment knob

Rotary tool
Lower tool
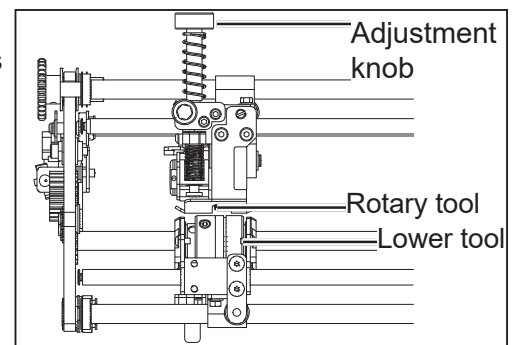
REFERENCE

● Tool raising position
Turn the **adjustment knob** counterclockwise until it stops to separate the **rotary tool** and the **lower tool**.
● Tool lowering position
Turn the **adjustment knob** clockwise to adjust the tool depth.

3. Close the **top cover**.
   The tool check screen disappears.

4. Touch any key below.
   - ◇ START key: To continue
   - ⬦T TEST key: To continue
   - ▽ STOP key: To clear
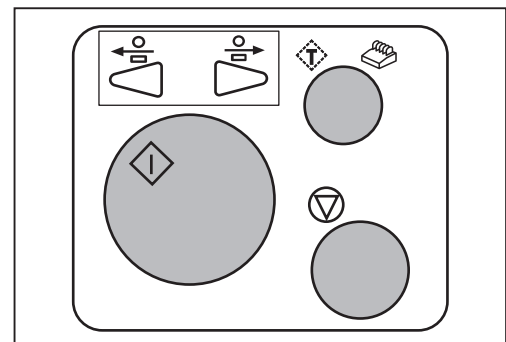
REFERENCE

If you have started processing a JOB with the START key, the ◇ START key appears. If started with the TEST key, the ⬦T TEST key appears.

● If the tool check screen as shown on the right appears during a barcode is being read, follow the procedure below.
(The screen on the right appears when the **RTM (Rotary Tool Module)** is installed in **slot 2**.)

```
RTM : Check the setup of
micro perf tools.

   ◇ Continue        ▽ to clear
                          Slot2
                          R ↑
                          L ↓
                          Slot3
                          R –
                          L –
```
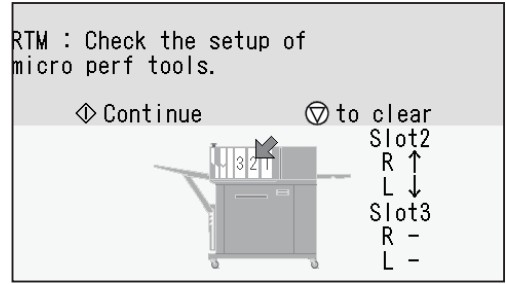
1. Press the STOP key to clear the message.

2. Press the JOG (backward) key to eject the document.
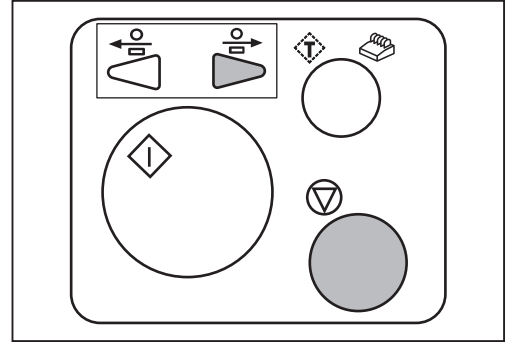
3. Press the START key to restart the JOB.

2

Programming a JOB on the Control Panel

MEMO

Chapter 3

Basic Operations

This chapter describes function settings of the **RTM (Rotary Tool Module)**.

3

Basic Operations

Process

This section describes the functions which relate to the **RTM (Rotary Tool Module)**.
For other settings, refer to Chapter 3 Basic operations - Process in the DC-618 Instruction Manual.

Select Tool
This sets the tools on the right and the left of the modules installed in slot 2 and slot 3.

REFERENCE

Change Tool Setting is automatically set as programmed when a JOB is retrieved.
Settings for a JOB that are changed after the JOB is retrieved are active until the power is turned **OFF** or another JOB is retrieved.

1 Make sure that the **standby** screen is displayed on the **touch panel**, and then touch **Feed/Process**.

```
008:DUPLO008                    COUNT
                                0 SHTS
```
Retrieve JOB   Adjust
Enter JOB   System
Feed/Proc   Environment

2 Touch the ▶ icon.

```
Feed          – Feed              ▼
Cut   Crease  Slit      Feed      ▶
Air Knife                  ON    FF
Suction Power         MIN  MID  MAX
Blow Fan              ◀   2   ▶  (0-3)
                                 SET
```
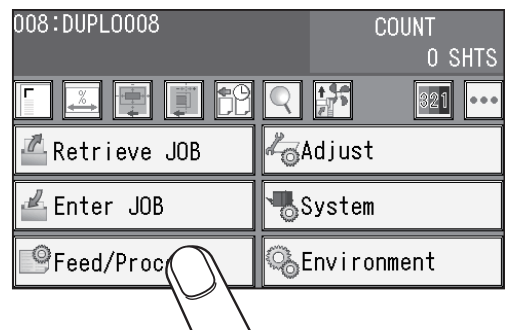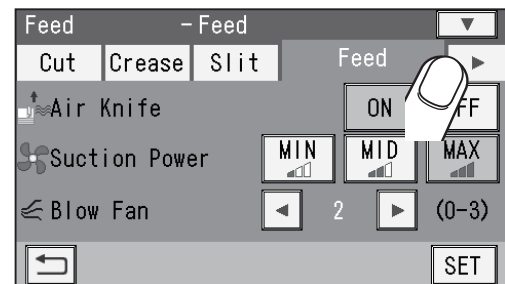
3 **Select Tool**
Change Tool Setting
1. Select and touch **Slot2** or **Slot3**.

```
Process    – Select Tool
◀       Select Tool
Change Tool Setting
  Slot3      Slot2
RTM      R        Perf    ▶
         L        Perf    ▶
                         SET
```
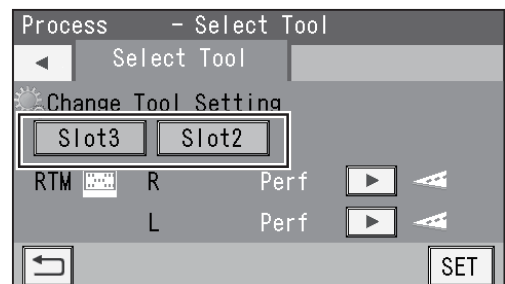
2. Touch the ◀/▶ icon to select a **rotary tool** on the right side (**R**) of the slot that was selected in step 3-1 out of **Perf**, **Micro**, and **Score**.

```
Process    – Select Tool
◀       Select Tool
Change Tool Setting
  Slot3      Slot2
RTM      R        Perf    ▶
         L        Perf    ▶
                         SET
```
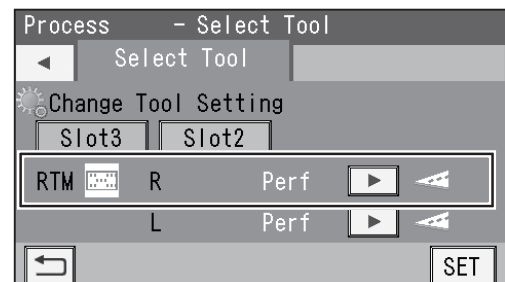
3. Touch the ◀/▶ icon to select a **rotary tool** on the left side (**L**) of the slot that was selected in step 3-1 out of **Perf**, **Micro**, and **Score**.

```
Process    - Select Tool
 ◀      Select Tool
 Change Tool Setting
   Slot3    Slot2
 RTM      R       Perf    ▶  ◀
          L       Perf    ▶  ◀
 ↰                        SET
```

REFERENCE

If only one **RTM (Rotary Tool Module)** is set to be used, the other slot for which **RTM (Rotary Tool Module)** is not set is displayed in a grayout state. You cannot enter any values for the slot.

```
Process    - Select Tool
 ◀      Select Tool
 Change Tool Setting
   Slot3    Slot2
 RTM      R       Perf    ▶  ◀
          L       Perf    ▶  ◀
 ↰                        SET
```

④ Touch **SET**.

```
Process    - Select Tool
 ◀      Select Tool
 Change Tool Setting
   Slot3    Slot2
 RTM      R       Perf    ▶  ◀
          L       Perf    ▶  ◀
 ↰                        SET
```

3
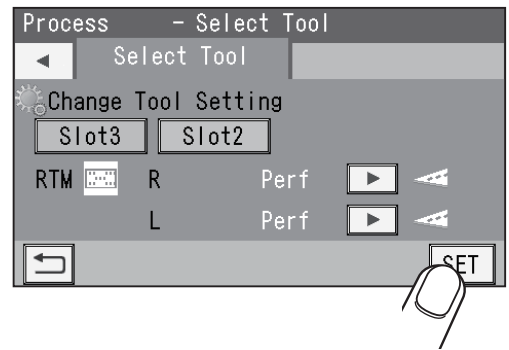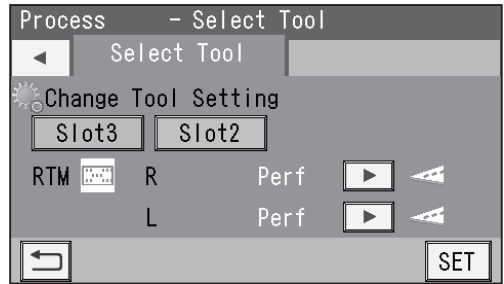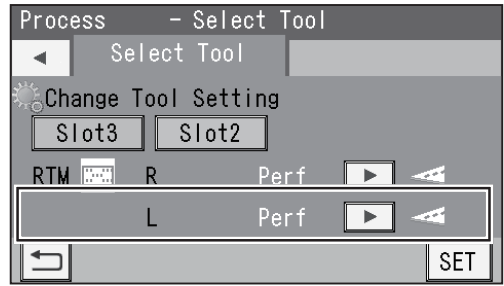
Basic Operations

Adjust

This section describes the functions which relate to the **RTM (Rotary Tool Module)**.
For other settings, refer to Chapter 3 Basic operations - Adjust in the DC-618 Instruction Manual.

RTM On Pos. Adj. (RTM On Position Adjustment)
This adjusts the processing start position of the **RTM (Rotary Tool Module)**.

RTM Off Pos. Adj. (RTM Off Position Adjustment)
This adjusts the processing stop position of the **RTM (Rotary Tool Module)**.

REFERENCE

Settings for **RTM On Pos. Adj.** and **RTM Off Pos. Adj.** are active after the power is turned **OFF** as well.

1 Make sure that the **standby** screen is displayed on the **touch panel**, and then touch **Adjust**.
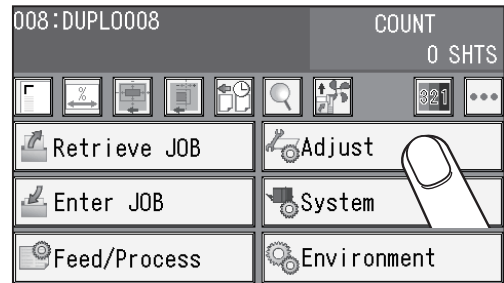
2 Touch **RTM**.
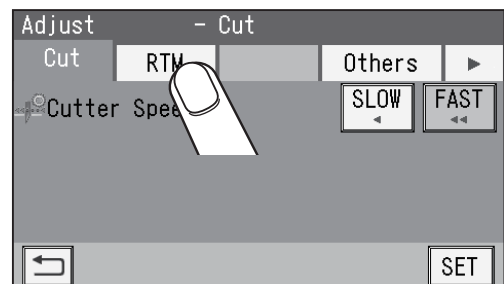
3 **RTM**
RTM Pos Adj.
1. **On**
This adjusts the processing start position (lowering the tool) of the **rotary tool**.
Touch the ◀/▶ icon to adjust the value.
You can make an adjustment in the range of -9.9 to +9.9 mm.
+: Moves the processing start position toward the document rear edge.
−: Moves the processing start position toward the document lead edge.
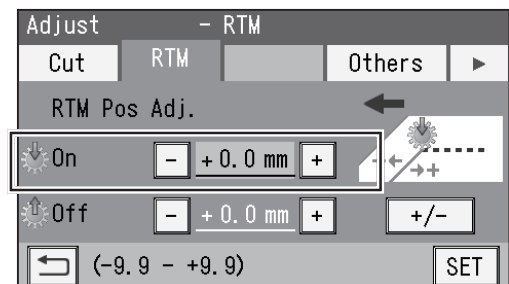
2. **Off**
   This adjusts the processing stop position (raising
   the tool) of the **rotary tool**.
   Touch the ◀ / ▶ icon to adjust the value.
   You can make an adjustment in the range of -9.9
   to +9.9 mm.
   +: Moves the processing stop position toward the
   document rear edge.
   −: Moves the processing stop position toward the
   document lead edge.
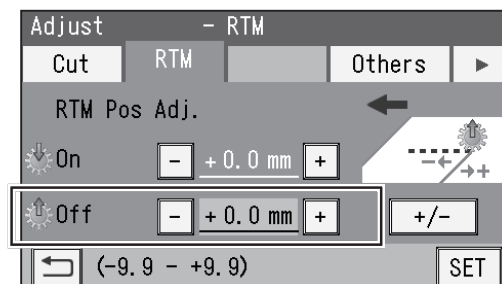
④ Touch **SET**.
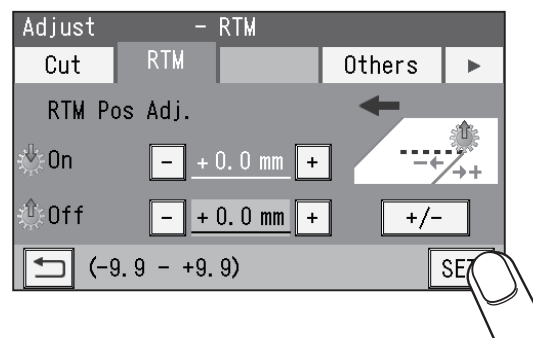
**For more information, refer to Chapter 3 Basic operations - Adjust in the DC-618
Instruction Manual.**

MEMO

Chapter 4

Programming a JOB on a Computer

JOB contents can be programmed either via computer or on the control panel. This chapter describes how to setup a JOB from your computer through the PC Controller.

PC Controller Setting

Main Menu

The main screen appears when the PC Controller is launched.
Select items on the main screen and make settings for a JOB.
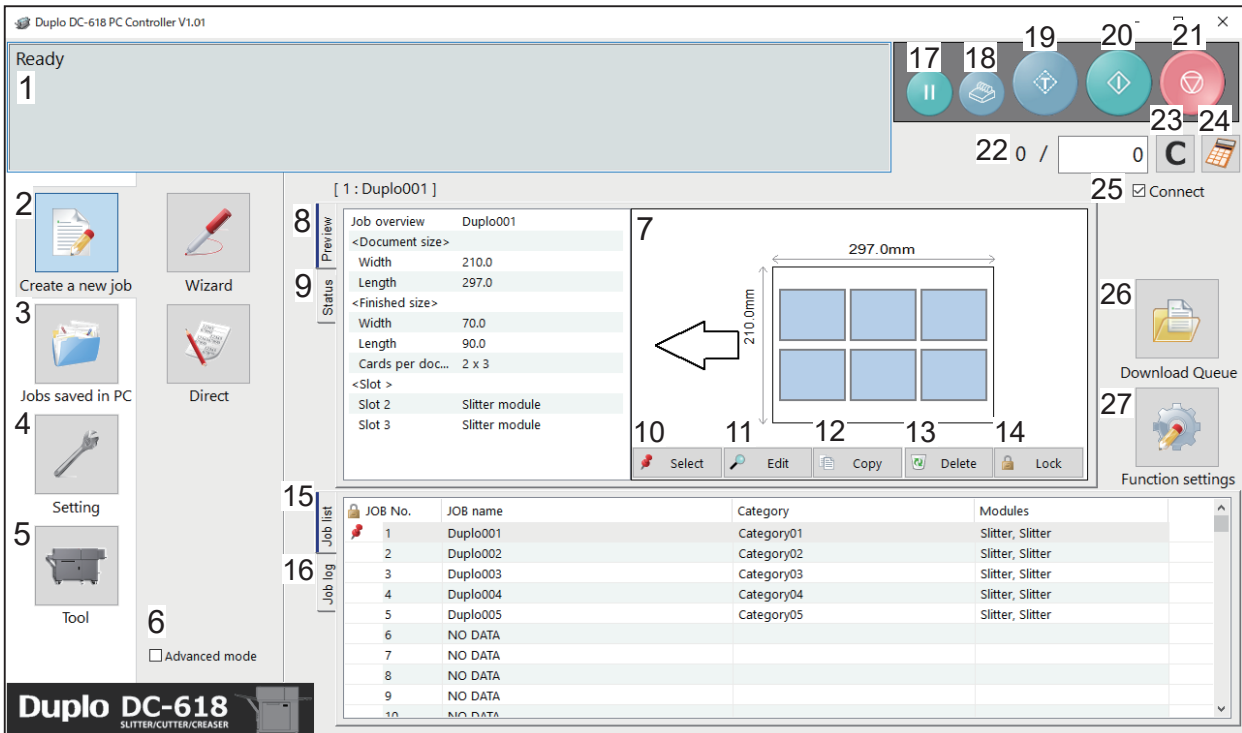
No.	Name	Function
1	System status	Displays the current machine status by letters.
2	Create a new job	Click this and select **Wizard** or **Direct** to program a JOB.
3	Jobs saved in PC	Opens a JOB saved on a computer.
4	Setting	Make default settings for the PC Controller. The other functions are for a service person use only to set the DC-618.
5	Tool	Backs up a JOB saved in the DC-618. Restores backed-up data of a JOB in the DC-618.
6	Advanced mode	Select this to program a JOB in the **advanced mode**. Clear this to program a JOB in the **simple mode**.
7	JOB preview	Displays an overview of a selected JOB. You can change settings for the selected JOB here.
8	Preview	Displays an overview of a programmed JOB.
9	Status	Displays the current machine status.
10	Select	Select a JOB on the **Job list** below and then click this to process the selected JOB.

No.	Name	Function
11	Edit	Edit a selected JOB here.
12	Copy	Makes a copy of a selected JOB to a different JOB number. Saves a copy of a JOB as a JOB file on a computer.
13	Delete	Deletes a selected JOB.
14	Lock	Locks /unlocks a selected JOB.
15	Job List	Displays a list of JOBs saved in the DC-618.
16	Job Log	Displays JOBs processed with the TEST key or the START key clicked on the PC controller and saved in the computer as logs. You can save up to 50 of lately processed JOBs. If the number of saved JOBs exceeds 50, they are deleted in chronological order.
17	PAUSE FEEDING key	Processes a JOB in the **pause feeding mode**. Click this to check how a finished product is made or to temporarily stop the DC-618 processing a JOB.
18	STACKER SETUP key	Stops the card stacker in front of the position to which a finished product is ejected.
19	TEST key	Processes only one sheet of documents for a test run.
20	START key	Processes a selected JOB. Inactive while the machine is in operation or having an error.
21	STOP key	Stops the DC-618 processing a JOB.
22	Preset Count	Presets the number of sheets to be processed for a JOB.
23	Clear	Clears the number of preset count.
24	NUMERIC key	Displays the NUMERIC keys, with which you can enter numerical values instead of using a keyboard.
25	Connect	Select this to control function limit of the control panel on the DC-618. Clear this to control function limit of the PC Controller. **REFERENCE** When the computer to which the PC Controller is connected is in the sleep mode or the hibernate mode, this is automatically cleared.
26	Download Queue	Saves a JOB that you tried to save while another JOB is being processed. You can download the JOB to the DC-618 from here.
27	Function settings	Displays the **Function settings** screen, on which you can make or change settings for a JOB.

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Programming a JOB on a Computer

REFERENCE
- **In operation** is displayed on the **system status** while a JOB is being processed.
- You can make a setting for the **blow fan** on the boxed part in the figure on the right.
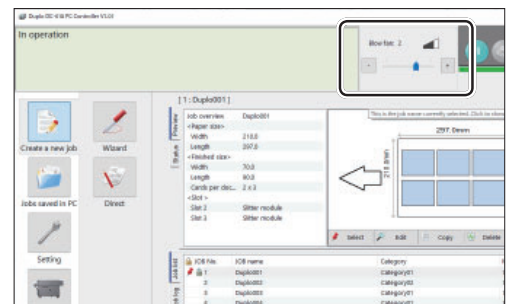
PC Controller Setting

● Settings for processing with the **RTM (Rotary Tool Module)**
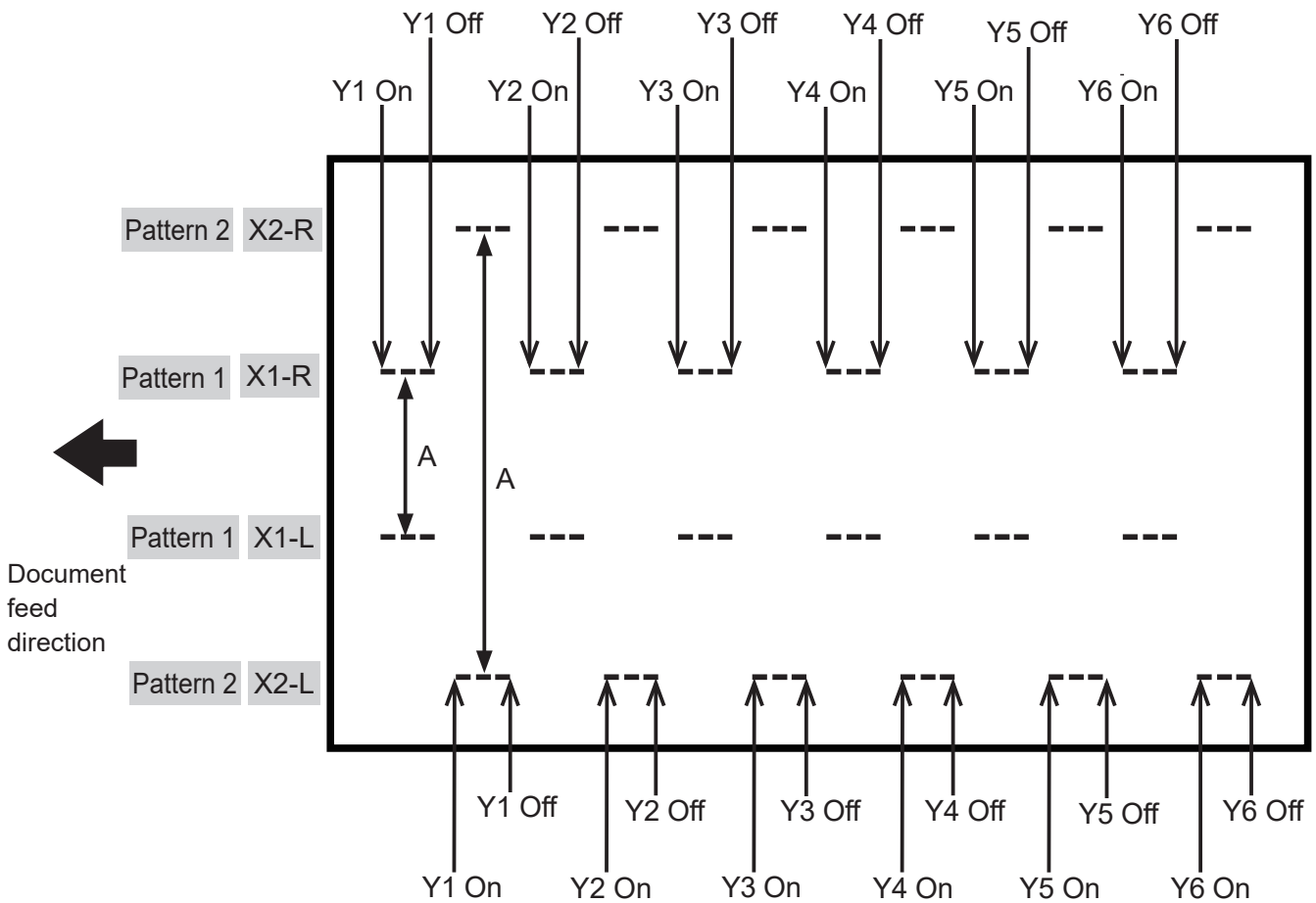
REFERENCE

You can set two patterns ([X1-R, X1-L] and [X2R, X2-L]) in the X direction from the right edge of a document.
Distance A (between Patter 1s) must be 48.0 mm or more.
You cannot set each position of Y1–Y6 of X1-R, X1-L and of X2-R, X2-L at the same positions.

● Patterns of processing with the **RTM (Rotary Tool Module)**

You can program up to six sets in the Y direction of Pattern X1.
You can program up to six sets in the Y direction of Pattern X2 as well.

4

Programming a JOB on a Computer
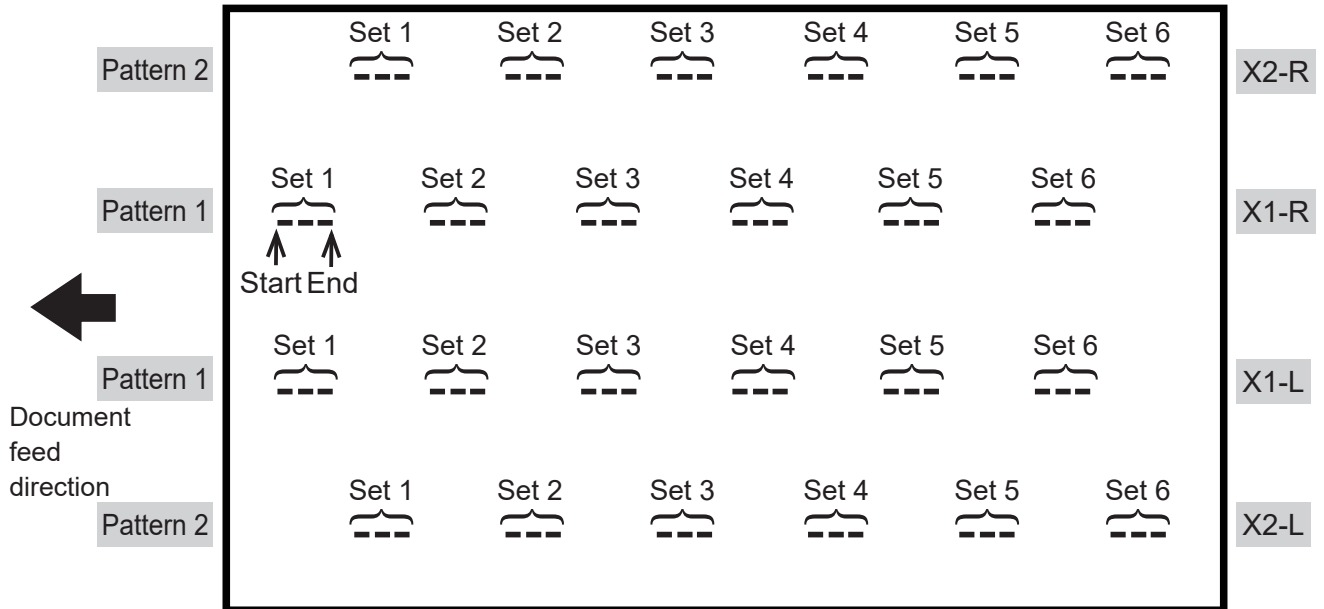
PC Controller Setting

The DC-618 can save up to 250 JOBs.
This section describes the procedure for programming a JOB in the **Wizard mode** with a preview of the JOB and in the **Direct mode** on which you directly enter each value, which is related to the **RTM (Rotary Tool Module)**.

Wizard
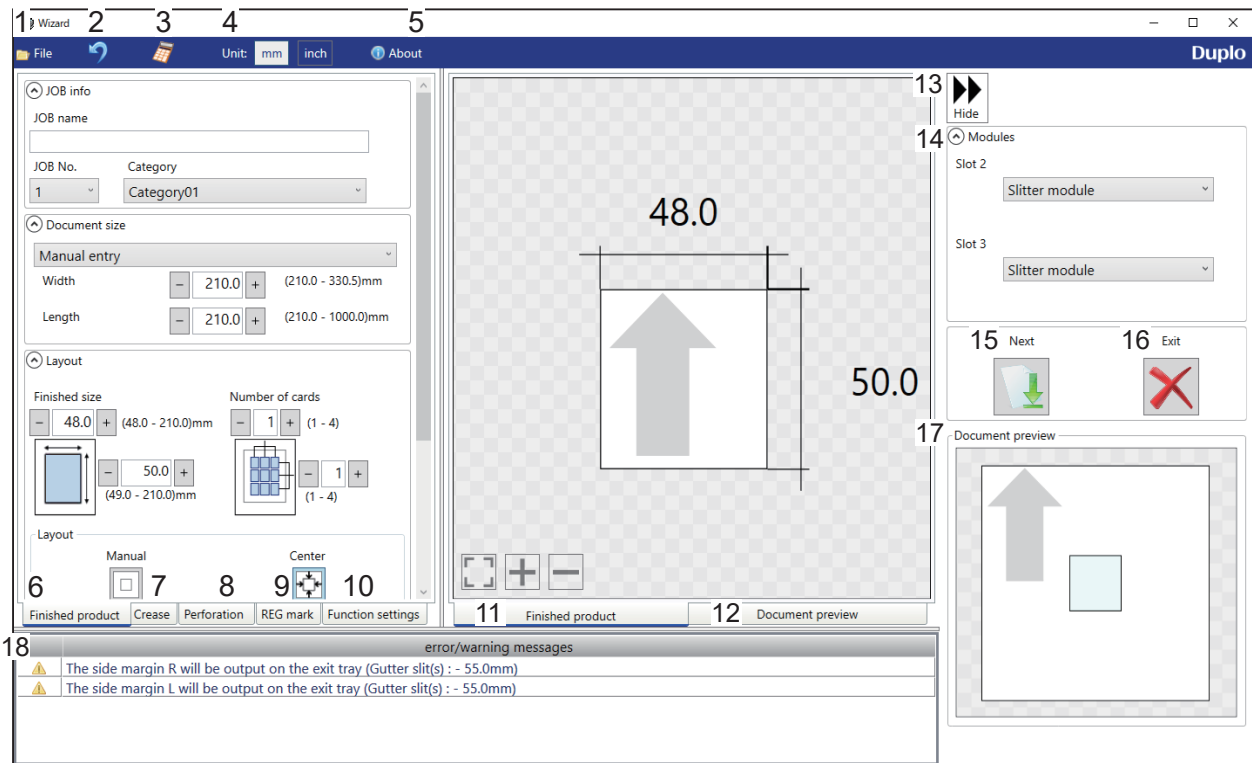
No.	Name	Function
1	File	Displays a menu. You can switch the **Wizard** screen to the **Direct** screen or exit the **Wizard** screen by clicking each item in this.
2	Undo	Returns to the previous setting.
3	NUMERIC key	Displays the NUMERIC keys, with which you can enter numerical values instead of using the keyboard.
4	Unit	Select a unit of values to enter out of mm or inch.
5	About	Displays the trademark and the open source software.
6	Finished product	Make settings for a JOB name, a JOB number, a category, a document size, a finished product size, the number of cards, margins, and gutters.
7	Crease	Specify crease positions on the document in the **Standard positions mode** or the **Non standard positions mode**.
8	Perforation	Specify perforation positions on the document in the **Standard positions mode** or the **Non standard positions mode**.
9	REG Mark	Make settings for the REG mark reading function. Appears only when CCD is activated.
10	Function settings	Make settings for each function of a JOB.
11	Finished product	Switches previews of a JOB between **Finished product** and **Document preview**.
12	Document preview	
13	Hide	Hides the right part of the **Wizard** screen and displays a JOB preview in a larger size.
14	Modules	Displays modules installed in slot 2 and slot 3.

No.	Name	Function
15	Next	Switches the **Wizard** screen to the **Direct** screen.
16	Exit	Finishes a JOB programming and returns to the main screen.
17	Document preview	Displays a preview of the whole part of a finished product.
18	error/warning messages	Displays a JOB setting that cannot be processed with an error or a warning mark. indicates that the setting is invalid for a JOB to be programmed. indicates that the JOB is processed with some irregular way.

4

Programming a JOB on a Computer

PC Controller Setting

1 Click **Create a new job** and then **Wizard** on the main screen.
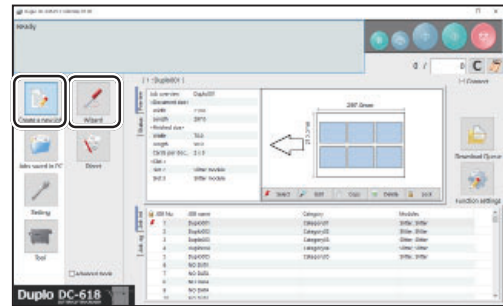
2 **Select Unit**
Select a unit of values to enter out of mm or inch.
If you select **inch**, values entered in inches are converted to ones in mm and displayed.

REFERENCE

- Values entered before a unit is selected are not converted to the other unit.
  Select either unit and then make settings for the JOB.
- You can enter values to three places of decimals in inches.
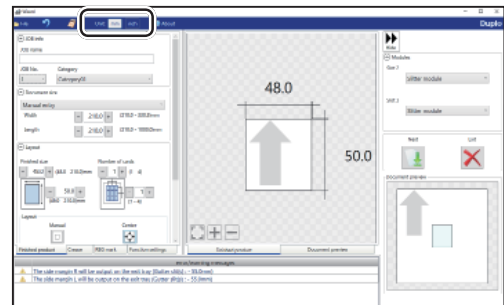
3 **Modules**
1. Select a module from the **Slot 2** box.
   Standard module
   Slitter module
   RTM (Rotary Tool Module)
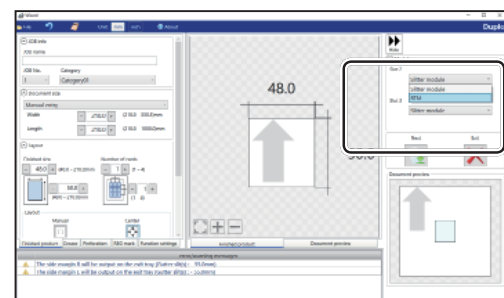
2. If you have selected **RTM (Rotary Tool Module)**, select tools for the right side and the left side.
   Perf.: Perforation tool
   Micro: Micro perforation tool
   Score: Score tool
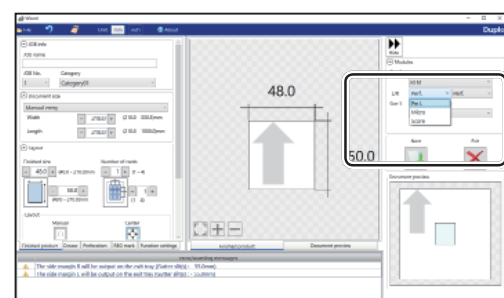
3. Select a module from the **Slot 3** box.
   Standard module
   Slitter module
   RTM (Rotary Tool Module)
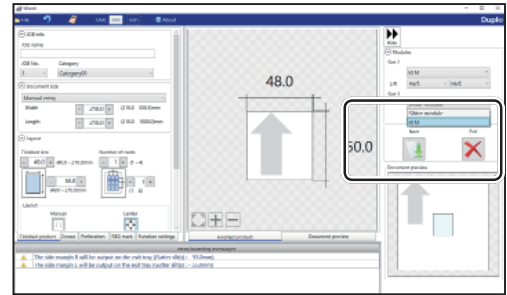
4. If you have selected **RTM (Rotary Tool Module)**,
   select tools for the right side and the left side.
   Perf.: Perforation tool
   Micro: Micro perforation tool
   Score: Score tool
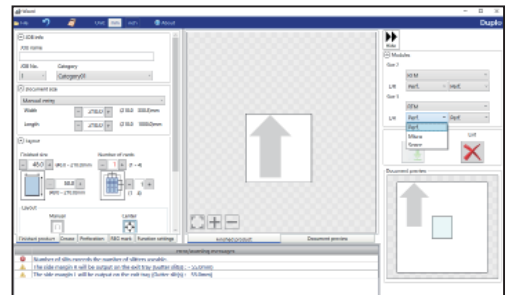
④ **JOB No.**
Select a JOB number from the **JOB No.** box.

REFERENCE

You can set a JOB number of 1 to 250.
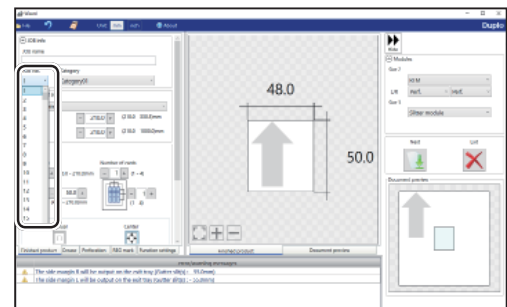
⑤ **JOB name**
Enter a JOB name.
You can enter up to 50 characters and/or letters.

REFERENCE

Usable characters and letters;
   Alphabetical letters (A to Z, a to z)
   Numerals
   Symbols
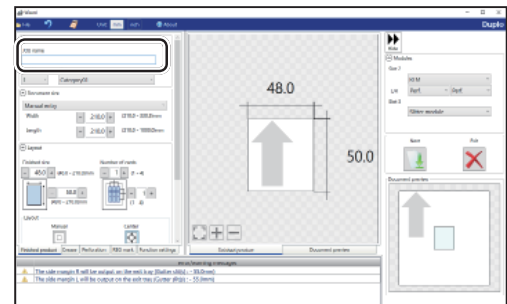
⑥ **Category**
Select a category in which to save the JOB from the
Category box.

4

Programming a JOB on a Computer

65
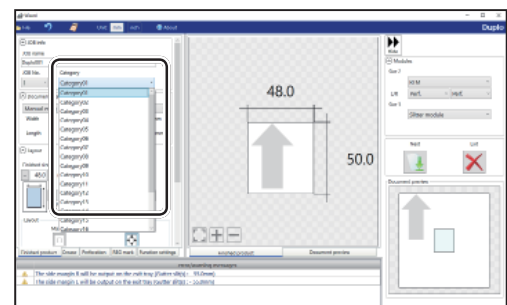
7 **Document Size**
Select the document size from the **Document size** box.

REFERENCE

Select **Manual entry** when processing custom-size documents. Enter the width and the length of the document.
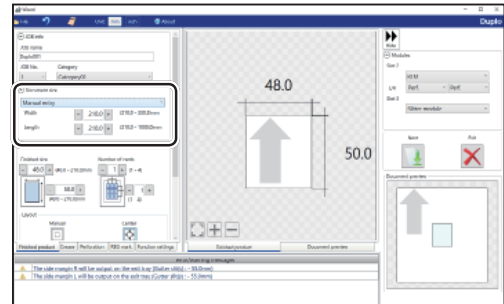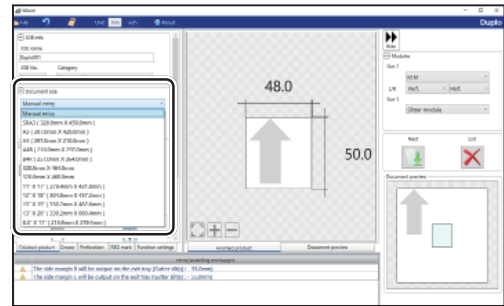
8 **Layout**
Finished size
Enter the width and the length of the finished product.
Number of cards
Enter the number of the finished products in a horizontal and a vertical direction.
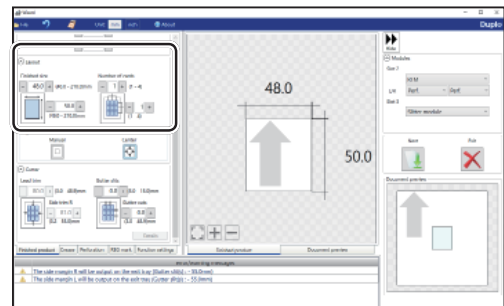
9 **Layout**
Select and touch **ON** or **OFF**.
Manual: Enables you to manually enter values to set a layout of the finished product.
Center: Automatically sets a layout of the finished product in the center of the document. Automatically makes settings for **Lead trim** (the lead margin cut) and **Side trim R** (the right margin slit).

REFERENCE

If you click **Center**, the message as shown on the right appears.
Click **OK**.
Clicking **Cancel** returns to the previous screen without selecting **Center**.
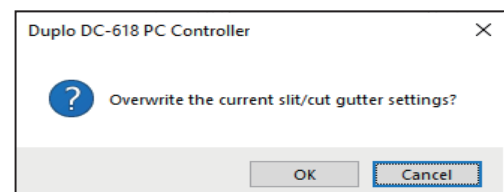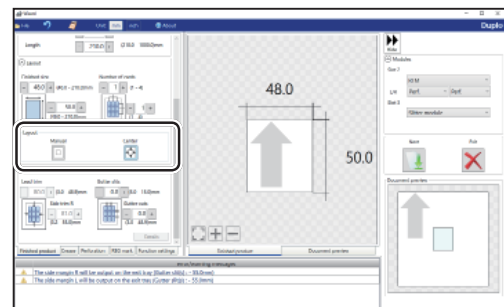
10 **Gutter**

Make settings for **Lead trim** (the lead margin cut), **Side trim R** (the right margin slit), **Gutter slits**, and **Gutter cuts**.

1. Enter values in each box.

REFERENCE

If you have selected **Center** in step 9, you cannot manually enter values for **Lead trim** (the lead margin cut) or **Side trim R** (the right margin slit).

2. Clicking **Details** displays the **Gutter setting details** screen, on which you can make settings for the width of gutter slits and gutter cuts.
   Click **OK** when the setting is completed.
   The settings are saved and the previous screen reappears.
   Clicking **Cancel** returns to the previous screen without saving the them.
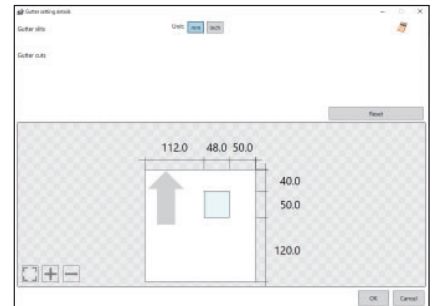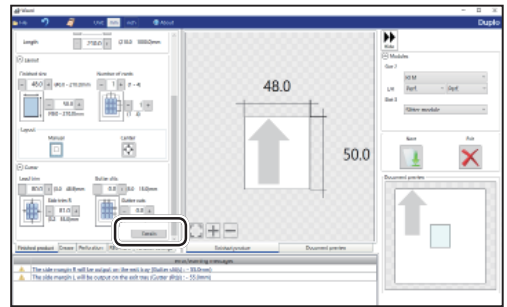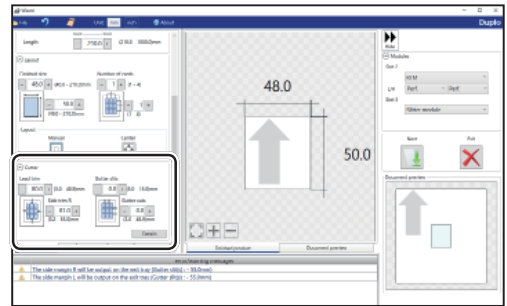
11 **Crease**

Set crease positions.
Click the **Crease** tab.
You can set up to 20 creases on one document.
Clicking the 🔒 icon switches entry mode between **Standard positions** and **Non standard positions**.

Standard positions: Automatically sets crease positions. Select a fold pattern and adjust values in the **A**, **B**, and **C** boxes. Then click **Apply**.

4

Programming a JOB on a Computer
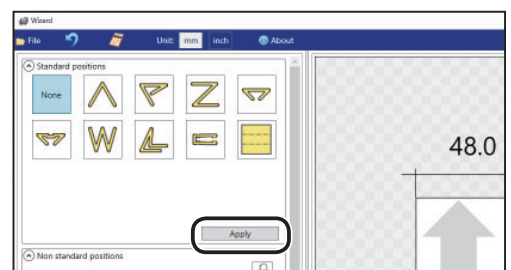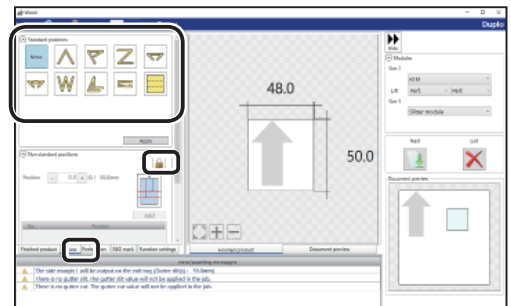
Non standard positions:
Add: Adds a crease to a designated position.
The added crease position is displayed on the list below.
* A crease position is set according to a finished product size.
Edit: Enables you to change a selected crease position on the list.
Delete: Deletes a selected crease position.
All clear: Deletes all of the crease positions on the list.
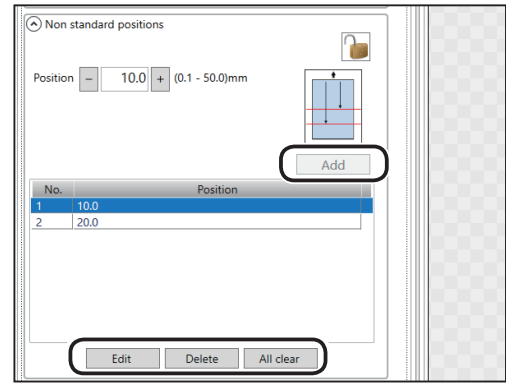
REFERENCE

If you have entered a value for a crease and click the 🔓 icon, the message as shown on the right appears.
Click **Yes** to switch the entry mode to **Standard positions**, which deletes all the entered crease positions in the **Non standard positions**.
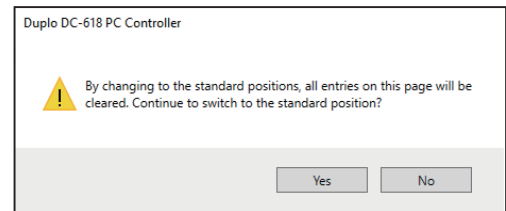
⑫ **Perforation**
Set perforation positions:
Click the **Perforation** tab.
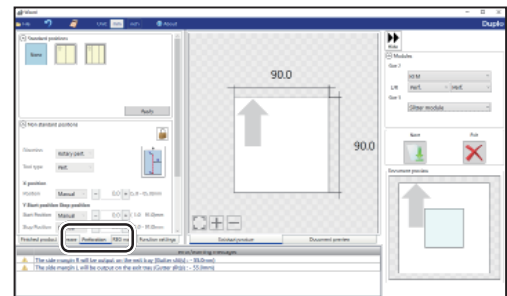
Standard positions: Select a pattern to process. Click **Apply**. Perforation positions are automatically set.
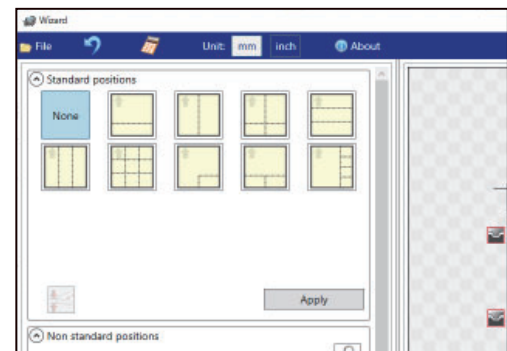
• **Lengthwise**
Perforates a document lengthwise.
1. Enter a value for at which perforation position the rotary tool processes with the NUMERIC keys or by clicking **+** or **-**.
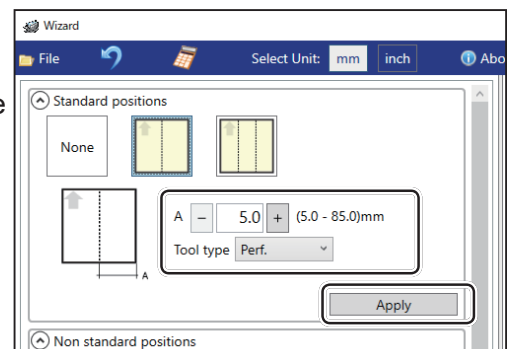
2. Click the **Tool type** box and select a rotary tool out of **Perf. (perforation tool)**, **Micro (micro perforation tool)**, and **Score**.
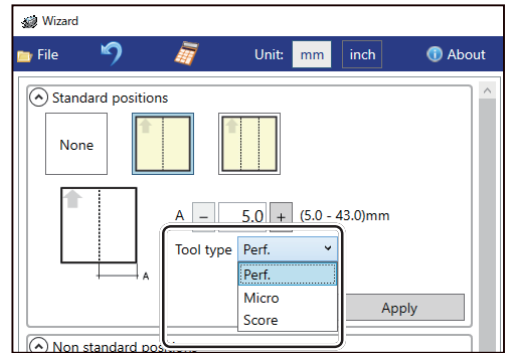
- **Lengthwise even**

  Perforates a document lengthwise evenly.

  1. Enter a value for at which perforation position the rotary tool processes with the NUMERIC keys or by clicking **+** or **-**.
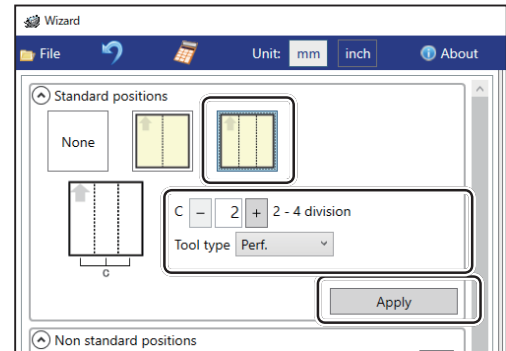
2. Click the **Tool type** box and select a rotary tool out of **Perf. (perforation tool)**, **Micro (micro perforation tool)**, and **Score**.
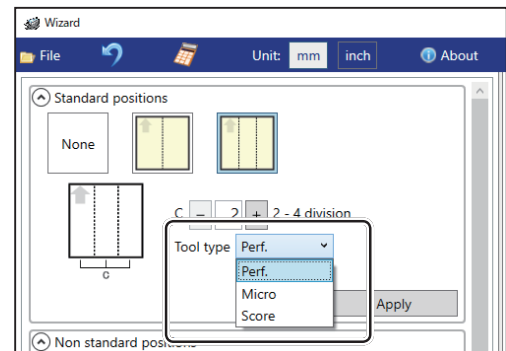
- **Widthwise**

  Perforates a document widthwise.
  This is available when **CPM (Cross Tool Module)** is available. For the details, see Chapter 4 <u>Programming a JOB on a Computer</u> - <u>Wizard</u> in the DC-618 CPM Instruction Manual.

4

Programming a JOB on a Computer
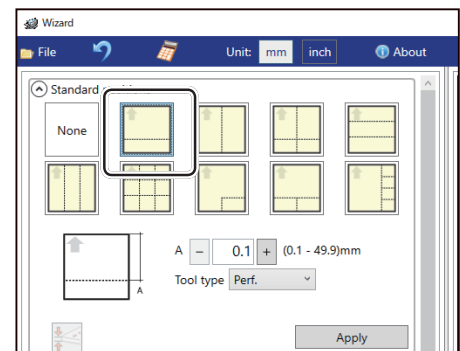
• **Crosswise**
Perforates a document crosswise.
This is available when both of **RTM (Rotary Tool Module)** and **CPM (Cross Tool Module)** are available.

1. Enter values of the distance between the lead edge of the finished product and the processing start position of the rotary tool for **A** and the distance between the right edge and the processing position of the rotary tool for **B** with the NUMERIC keys or by clicking **+** or **-**.

2. Click the **Tool type** box and select a rotary tool out of **Perf. (perforation tool)**, **Micro (micro perforation tool)**, and **Score (score tool)**. Click **Apply**.
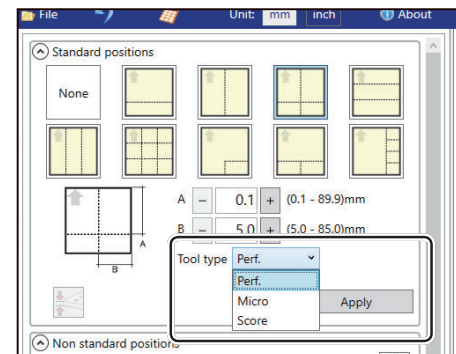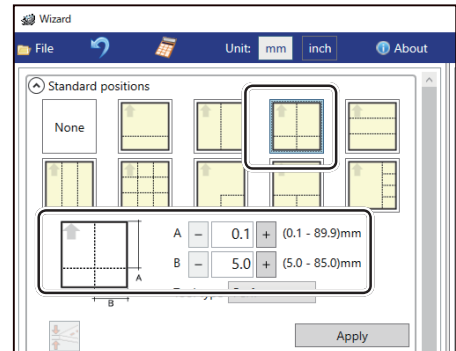
• **Widthwise even**
Perforates a document widthwise.
This is available when **CPM (Cross Tool Module)** is available. For the details, see Chapter 4 Programming a JOB on a Computer - Wizard in the DC-618 CPM Instruction Manual.
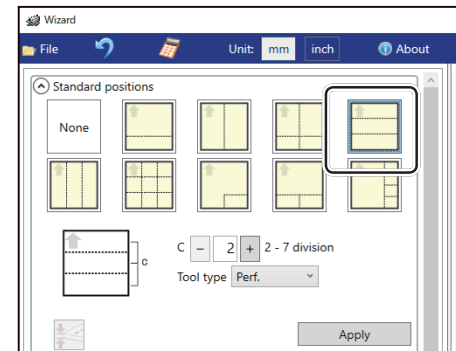
• **Crosswise even**
Perforates a document crosswise evenly.
This is available only when both of **RTM (Rotary Tool Module)** and **CPM (Cross Tool Module)** are available.

1. Enter the number of cards widthwise for **C1** and that lengthwise for **C2** with the NUMERIC keys or by clicking **+** or **-**.
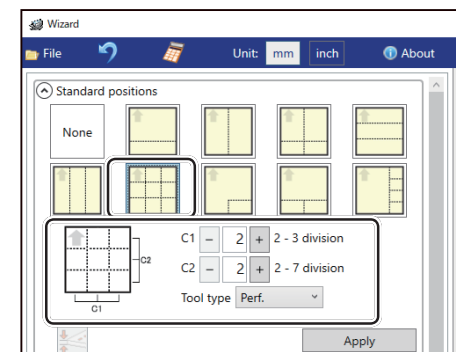
2. Click the **Tool type** box and select a rotary tool out of **Perf. (perforation tool)**, **Micro (micro perforation tool)**, and **Score (score tool)**. Click **Apply**.
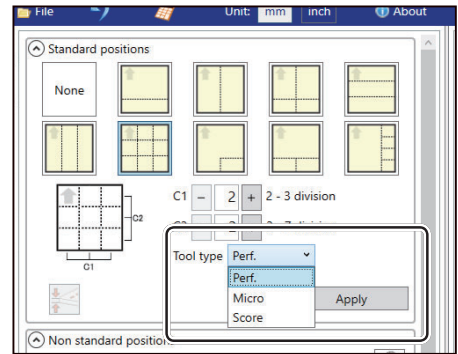
• **L angle**
  Perforates a document in a L-shape so that a card is made at a corner.
  This is available only when both of **RTM (Rotary Tool Module)** and **CPM (Cross Tool Module)** are available.

  1. Click the **Layout** box and select at which position the document is processed out of **Top Left**, **Top Right**, **Bottom Left**, and **Bottom Right**.

  2. Enter values of the length of the finished product for **A** and the width of the finished product for **B** with the NUMERIC keys or by clicking **+** or **-**.
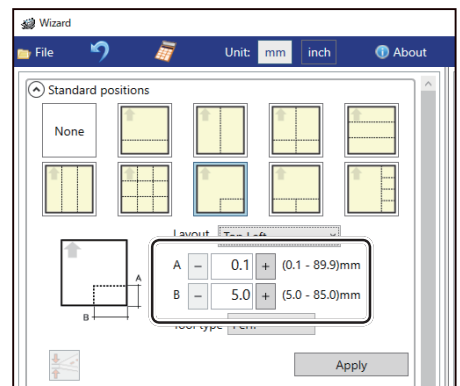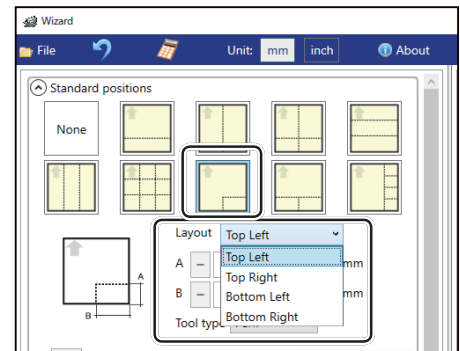
  3. Click the **Tool type** box and select a rotary tool out of **Perf. (perforation tool)**, **Micro (micro perforation tool)**, and **Score (score tool)**. Click **Apply**.

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Programming a JOB on a Computer
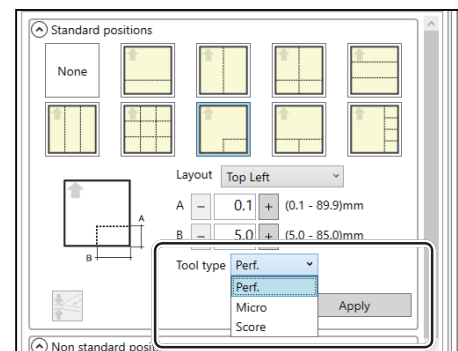
- **T shape**

Perforates a document widthwise and then lengthwise to divide it into two or three pieces. This is available only when both of **RTM (Rotary Tool Module)** and **CPM (Cross Tool Module)** are available.

1. Click the **Layout** box and select at which position the document is processed out of **Top** and **Bottom**.

2. Enter a value of the distance between the lead edge of the document and the processing start position of the rotary tool for **A** and a value of into how many pieces the document is divided for **C**.
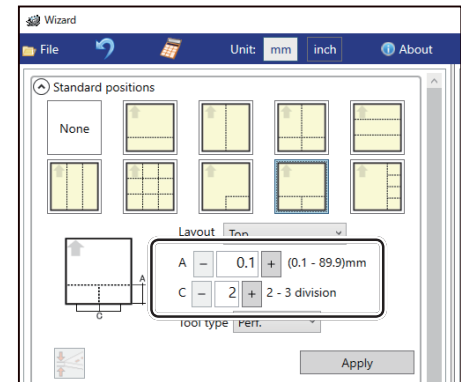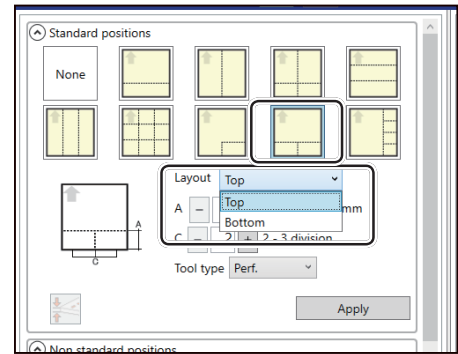
3. Click the **Tool type** box and select a rotary tool out of **Perf. (perforation tool), Micro (micro perforation tool)**, and **Score (score tool)**. Click **Apply**.
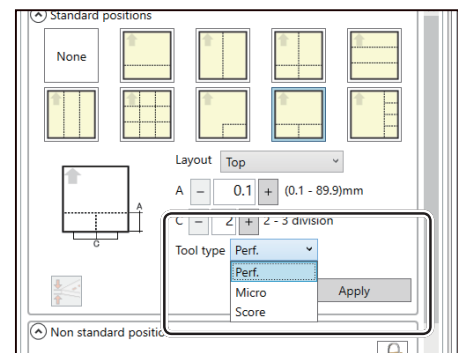
- **Tear off coupons**

Perforates a document lengthwise and then widthwise to divide it into two to seven pieces. This is available only when both of **RTM (Rotary Tool Module)** and **CPM (Cross Tool Module)** are available.

1. Click the **Layout** box and select at which position the document is processed out of **Left** and **Right**.
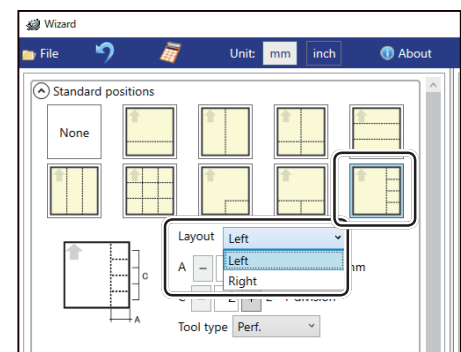
2. Enter a value of the widthwise distance between the right side edge of the document and the processing start position of the rotary tool for **A** and a value of into how many pieces the document is divided for **C**.
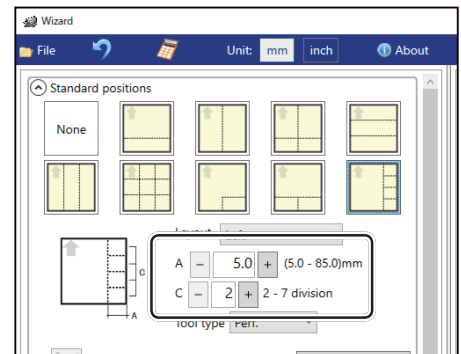
3. Click the **Tool type** box and select a rotary tool out of **Perf. (perforation tool)**, **Micro (micro perforation tool)**, and **Score (score tool)**. Click **Apply**.
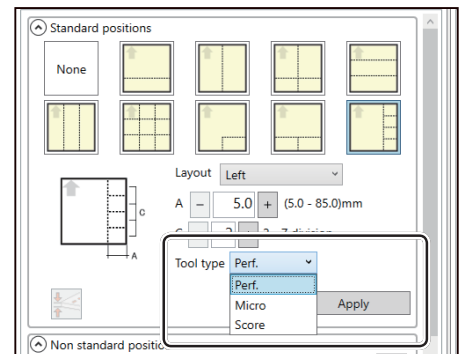
Non standard positions:
Clicking the 🔒 icon switches entry mode between **Standard positions** and **Non standard positions**.
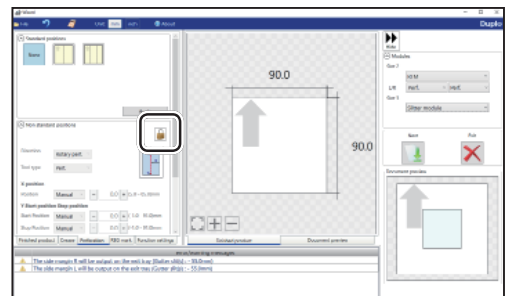
1. Click the **Tool type** box and select a **rotary tool** out of **Perf. (perforation tool)**, **Micro (micro perforation tool)**, and **Score (score tool)**.
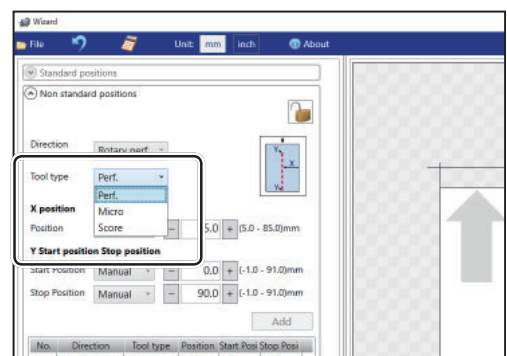
2. **X position (crosswise)**
Click the **Position** box and select a crosswise processing position of the **rotary tool** out of **Manual**, **1/2**, **1/3**, **2/3**, **1/4**, **2/4**, and **3/4**.

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Programming a JOB on a Computer
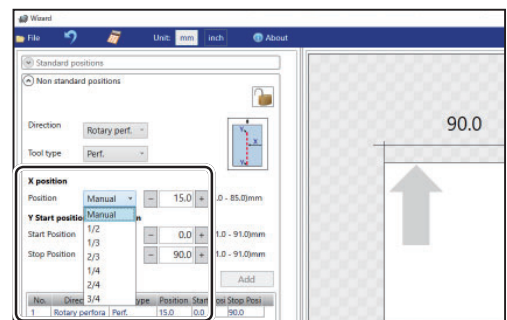
3. If you have selected **Manual** in step 2, enter a value for **Position** with the NUMERIC keys or by clicking **+** or **-**.
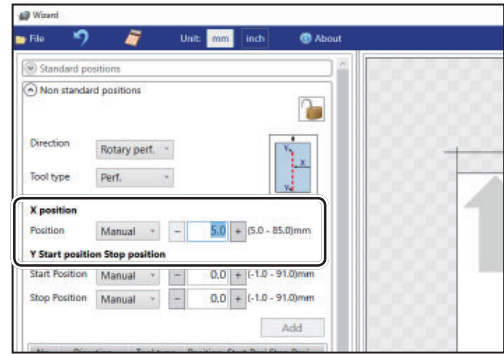
4. **Y Start position Stop position (lengthwise)** Click the **Start Position** box and select a processing start position (lengthwise) of the **rotary tool** out of **Manual**, **0**, **1/2**, **1/3**, **2/3**, **1/4**, **2/4**, **3/4**, and **4/4**.
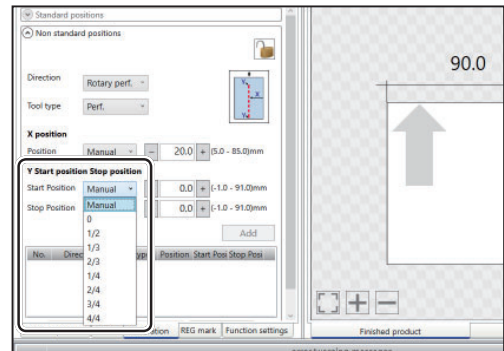
5. If you have selected **Manual** in step 4, enter a value for **Start Position** (lengthwise) of the **rotary tool** with the NUMERIC keys or by clicking **+** or **-**.
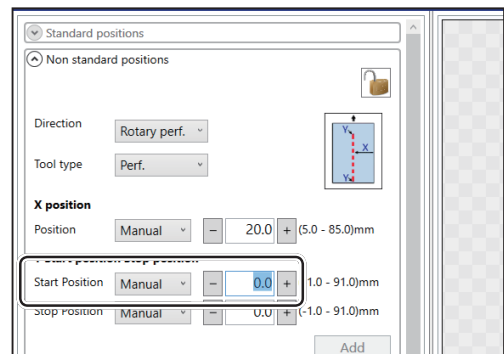
6. Click the **Stop position** box and select a processing stop position (lengthwise) of the **rotary tool** out of **Manual**, **0**, **1/2**, **1/3**, **2/3**, **1/4**, **2/4**, **3/4**, and **4/4**.
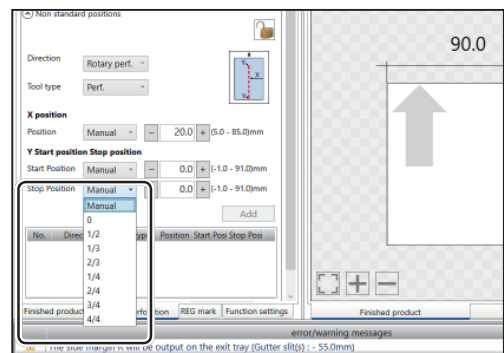
7. If you have selected **Manual** in step 6, enter a value for **Stop Position** (lengthwise) of the **rotary tool** with the NUMERIC keys or by clicking **+** or **-**. Then click **Add**.
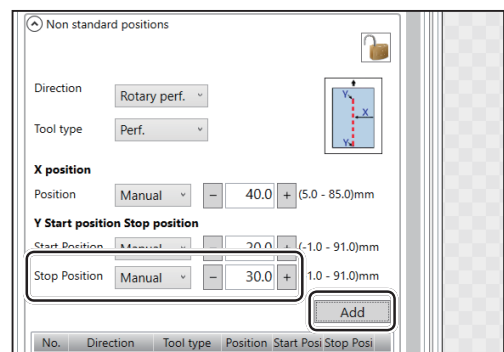
8. In similar ways to steps 5 and 7, enter values for the start position and the stop position (lengthwise) of the **rotary tool**. Then click **Add**.
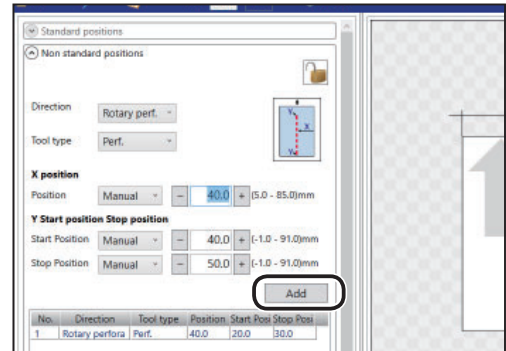
9. The added start position and the stop position are displayed on the list below. Check the contents.
   Edit: Enables you to change a selected position on the list.
   Delete: Deletes a selected position on the list.
   All clear: Deletes all of the processing positions of the **rotary tool** on the list.
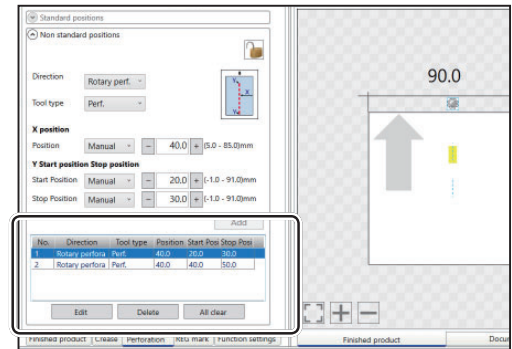
⑬ **REG mark**
This senses a REG mark and then reads the image drift and compensates it.
Click the **REG mark** tab.
When using this function, select **On** for the **REG mark** box.
Side mark: Enter the distance from the right edge of the document to the side mark in the **Side mark** box.
Lead mark: Enter the distance from the lead edge of the document to the lead mark in the **Lead mark** box.
REG mark spec: Select a REG mark type (**Standard** / **Bold mark width**).
Normally select **Standard**.

Standard   Bold mark width

 REFERENCE

Standard: Select this when processing normal documents with a REG mark of standard thickness printed on them.
Bold mark width: Select this when processing specially treated documents (glossy documents). Print a bold REG mark on them in advance and then select **Bold mark width**.

• If it fails to read a REG mark, select **Bold mark width**.
• Select **Off** if you do not use the REG mark reading function.

 IMPORTANT

If there are scratches or stains in the printing range of the REG mark, the position may not be corrected.
Also if the read side of a document is rough and glossy, the CCD may not be able to read a REG mark and/or a barcode. (The document may diffusely reflect light.)
When using specially treated documents (glossy document), print a bold REG mark on them in advance. Then, select **Bold mark width** for **REG mark spec**.

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Programming a JOB on a Computer

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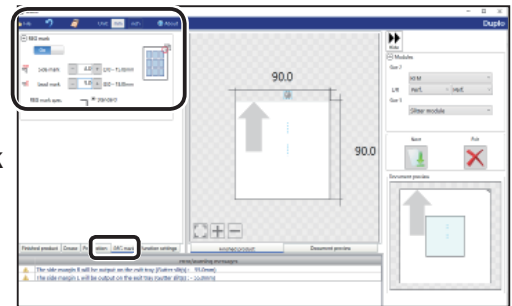
14 **Function settings**
Click the **Function settings** tab.
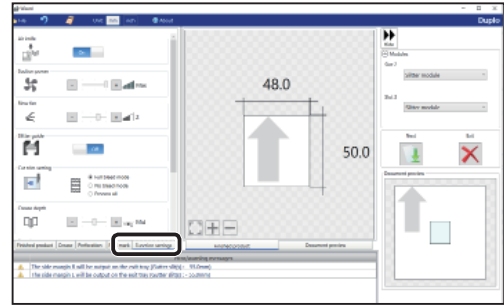
Air knife
Compressed air is blown out from the front to the corner of a document. This prevents a double feed. To use this function, select **On**. If not, select **Off**. Select **Off** when processing light weight documents.
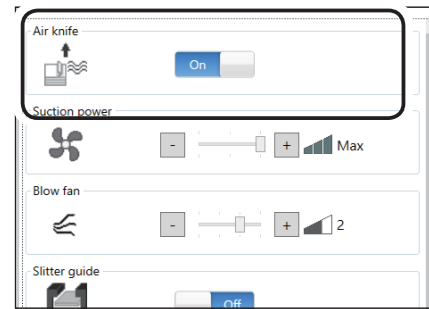
Suction power
A document is fed by being suctioned to the **conveyance belt**.
Select suction power level out of **Max**, **Mid**, or **Min** by clicking **+** or **-**.
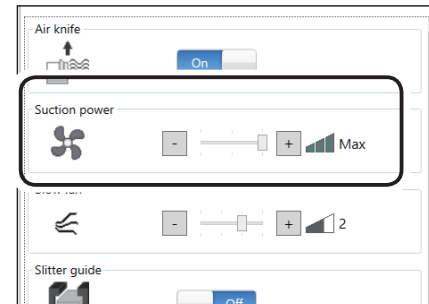
Blow fan
Air is blown out from the lead edge side of a document to loosen the documents when it is fed. Select air level from 0 to 3 by clicking **+** or **-**. Set the air level higher if the DC-618 does not feed a document. Set the air level lower if a double feed occurs.
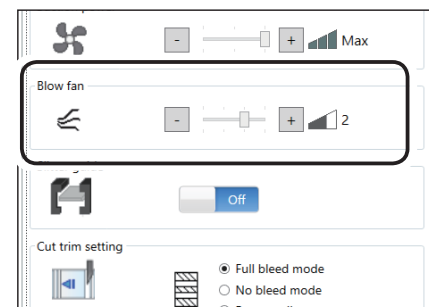
Slitter guide
This enables you to use modules as slitter guides to stabilize the document conveyance if you do not use them to process a JOB.
It is recommended that you select **On** when processing light weight documents.
Select and touch **On** or **Off**.

The **RTM (Rotary Tool Module)** and the **slitter module** can be used as slitter guides.
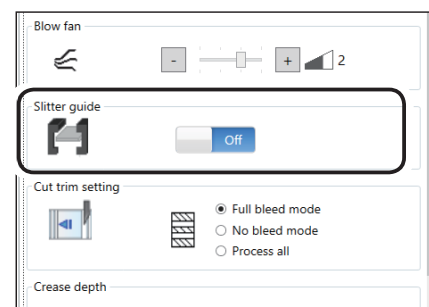
Cut trim setting
The lead margin, the trail margin, and any gutter cuts are chopped up and dropped into the waste box.
Select **Full bleed mode**, **No bleed mode**, or **Process all**.

Full bleed mode : The lead margin and the trail margin are chopped up and dropped into the waste box. Any other gutter cuts shorter than 49.0 mm in width are also chopped up and dropped into the waste box.

No bleed mode: Gutter cuts shorter than 49.0 mm in width are chopped up and dropped into the waste box.

Process all: All of the cut pieces are ejected to the exit tray. Gutter cuts shorter than 30.0 mm in width are chopped up and dropped into the waste box. The trail margin shorter than 60.0 mm are chopped up and dropped into the waste box.
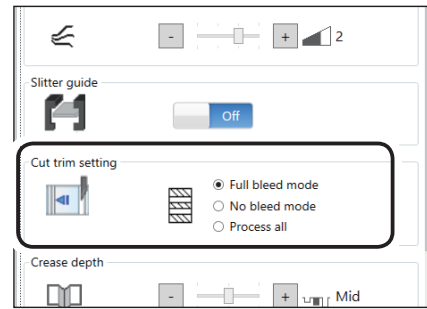
REFERENCE

If the document has no lead margin or trail margin, select **No bleed mode**.

Crease depth
This function sets the depth of a crease when a document is creased.
Select **Max**, **Mid**, or **Min** by clicking **+** or **-**.

Select **Max** when processing heavy weight documents and **Min** when processing light weight documents.
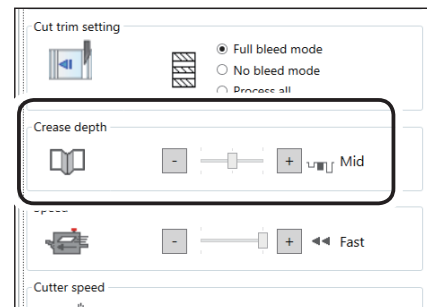
Speed
Select processing speed out of **Fast** or **Slow** by clicking **+** or **-**.

Selecting **Slow** improves finishing accuracy.
If it cannot obtain finishing accuracy because of roller slip due to slippery documents (UV coated documents and so on), select **Slow**.

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Programming a JOB on a Computer
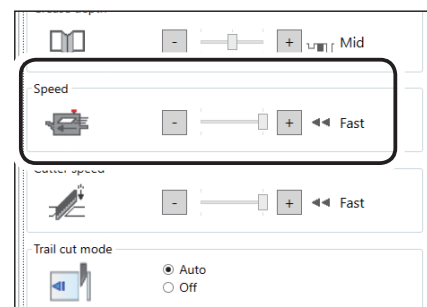
Cutter speed

Select speed of cutting a document out of **Fast** or **Slow** by clicking **+** or **-**.

REFERENCE

If it fails to cut the document with **Fast**, select **Slow**.
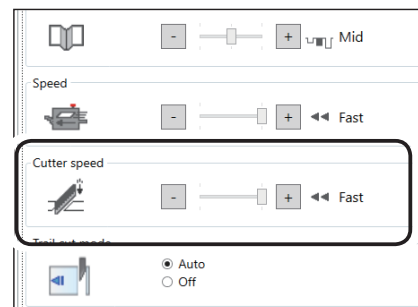
Trail cut mode

This function sets whether dummy cut for the trail margin is processed or not.

Select **Auto (automatic)** or **Off**.

    Auto: Performs dummy cut for the trail margin one time.

REFERENCE

• Dummy cut: The DC-618 performs cutting operation without a document to be cut at the position where the document is fed for the distance of the trail margin plus extra length. This is effective for dropping a document, such as when the trail margin is jammed between the roller and the lower tool in the cutter section.
• Trail margin: Means a margin of the trail edge of a document produced when the last cut is processed.
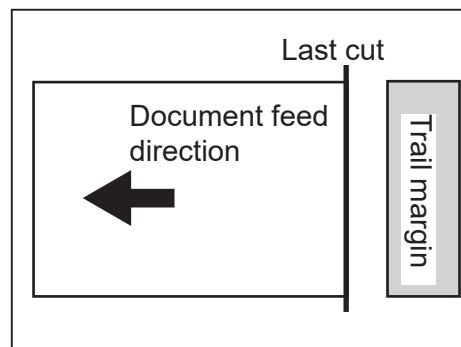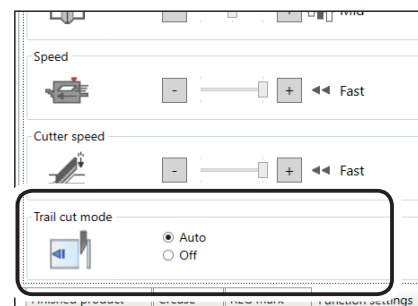
15 • **Preview**

Clicking the tabs switches JOB previews between **Finished product** and **Document preview**.

Clicking the buttons on the lower left part of the preview screen zooms up or zooms out the JOB preview.

    ⌞⌝: Adjusts a position and a size of the JOB preview according to the screen.
    +: Zooms up the JOB preview.
    −: Zooms out the JOB preview.
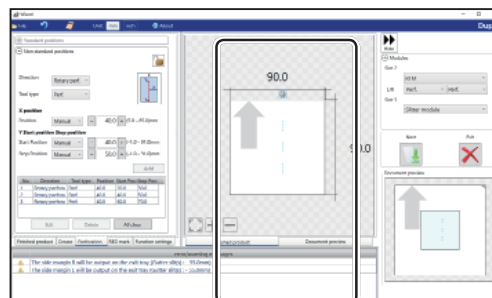
16 Set all the settings and click **Next**.
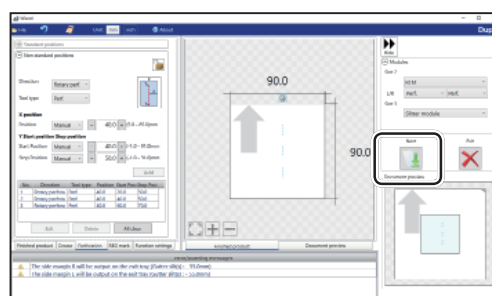
If you click **Exit**, the message as shown on the right appears.
Click **Yes** to finish the JOB setting without saving the entered values.
Clicking **No** returns to the previous screen.
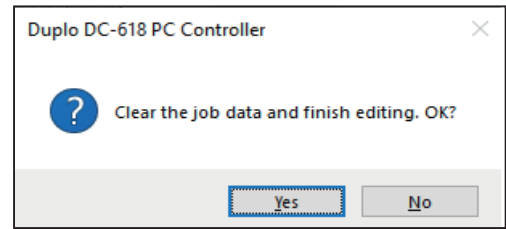
⑰ The **Direct** screen appears.
Check the details of the JOB.
To change the settings, click the text box of the item to change and re-enter a value for it.
For more details, follow step 2 and the subsequent steps in Direct (P.80) .
Clicking **Back** returns to the **Wizard** screen.
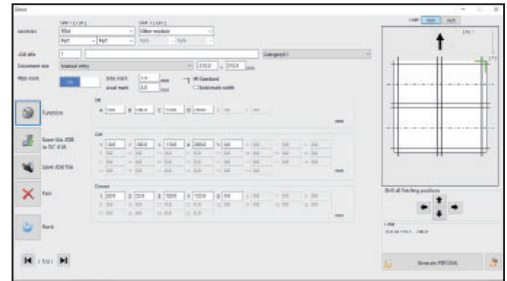
⑱ For the procedure for saving the JOB in the DC-618, see ●Saving a JOB in the DC-618 (P.88) .

For the procedure for saving the JOB on a computer, see ●Saving a JOB on a computer (P.89) .

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Programming a JOB on a Computer

Direct
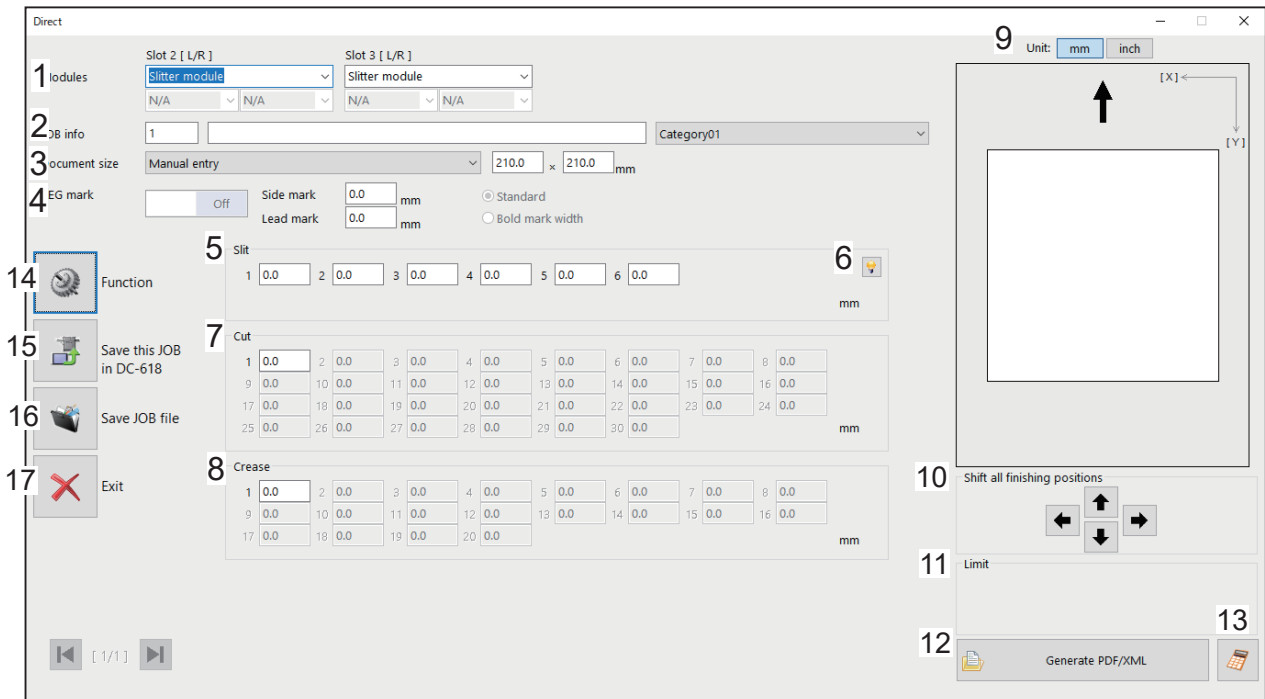
No.	Name	Function
1	Modules	Displays modules installed in slot 2 and slot 3.
2	JOB info	Enter a JOB number, a JOB name, and a category name.
3	Document size	Select a document size.
4	REG mark	Set a position and a width of a REG mark (a side mark and a lead mark). Appears only when CCD is activated.
5	Slit	Set slit positions.
6	Hint button	Displays the **Setting procedure** screen, which you can use as reference for setting slit positions. Appears only when the **Advanced mode** check box is selected.
7	Cut	Set cut positions.
8	Crease	Set crease positions.
9	Unit	Select a unit of values to enter out of mm or inch.
10	Shift all finishing positions	Fine-adjust finishing positions of the JOB by clicking the arrows if necessary.
11	Limit	Displays the limit of a value to enter.
12	Generate PDF/XML	Saves a JOB as a PDF template or an XML file.
13	NUMERIC key	Displays the NUMERIC keys, with which you can enter values instead of using the keyboard.
14	Function	Displays the **Function** screen on which to make function settings for a JOB.
15	Save this JOB in DC-618	Saves a programmed JOB or a JOB saved on a computer to the DC-618.
16	Save JOB file	Saves a programmed JOB on a computer.
17	Exit	Finishes a JOB programming and returns to the main screen.

① Click **Create a new job** and then **Direct** on the main screen.
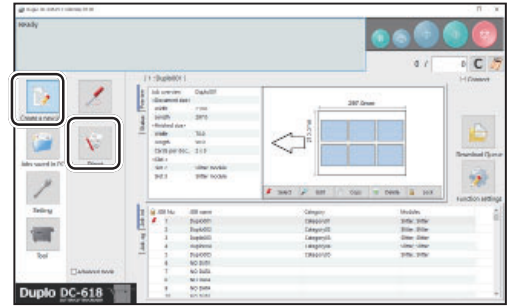
② The **Direct** screen appears.
The value limit appears on the lower right side of the screen.
Refer to it when programming a JOB.
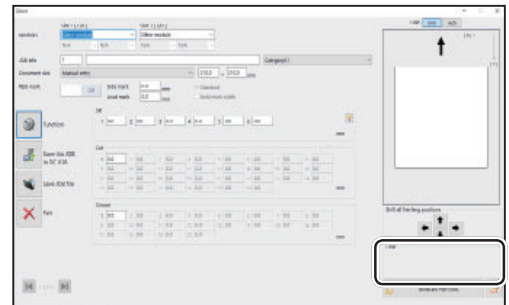
REFERENCE

Clicking the 🖩 icon displays the NUMERIC keys, with which you can enter numerical values instead of using a keyboard.
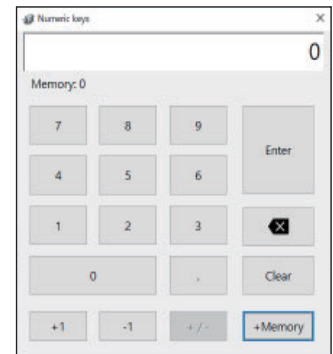
③ **Select Unit**
Select a unit of values to enter out of **mm** or **inch**.
If you select **inch**, values entered in inches are converted to ones in mm and displayed.

REFERENCE

Values that you entered before selecting the unit are not converted to the other unit.
Select either unit and then make settings for the JOB.
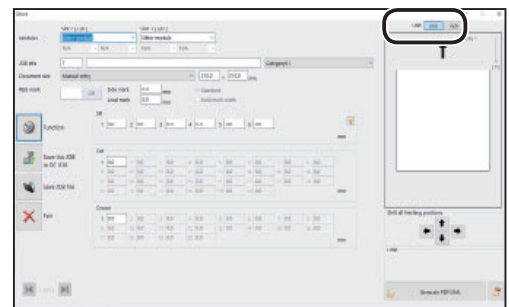
④ **Modules**
1. Select a module to install in the **slot 2** from the **Slot 2 [L/R]** box.
   Standard module
   Slitter module
   RTM (Rotary Tool Module)
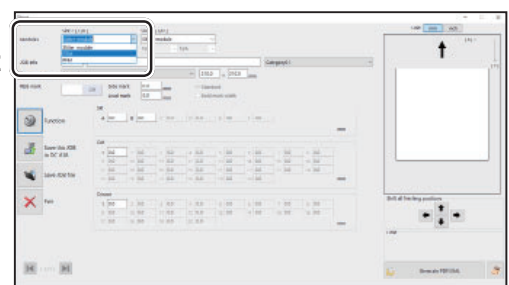
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Programming a JOB on a Computer

2. If you have selected **RTM (Rotary Tool Module)**, select a **rotary tool** on the left side from the **Tool type** box.
Perf.: Perforation tool
Micro: Micro perforation tool
Score: Score tool
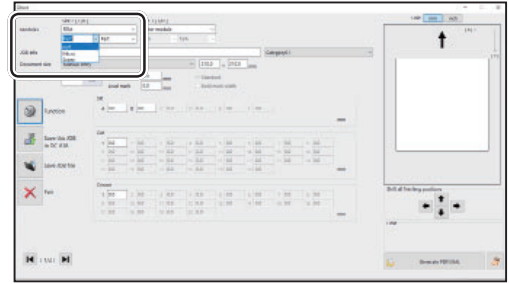
Select a **rotary tool** on the right side from the **Tool type** box as well.
Perf.: Perforation tool
Micro: Micro perforation tool
Score: Score tool
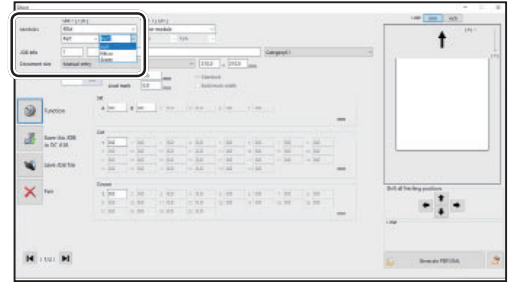
⑤ Modules
1. Select a module to install in the slot 3 from the **Slot 3 [L/R]** box.
Standard module
Slitter module
RTM (Rotary Tool Module)
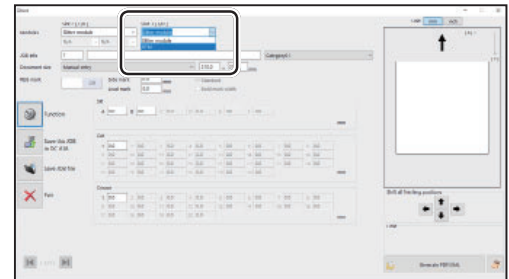
2. If you have selected **RTM (Rotary Tool Module)**, select a **rotary tool** on the left side from the **Tool type** box.
Perf.: Perforation tool
Micro: Micro perforation tool
Score: Score tool
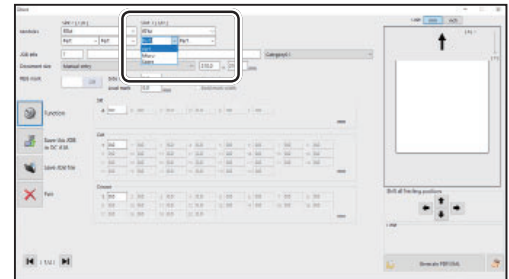
Select a **rotary tool** on the right side from the **Tool type** box as well.
Perf.: Perforation tool
Micro: Micro perforation tool
Score: Score tool
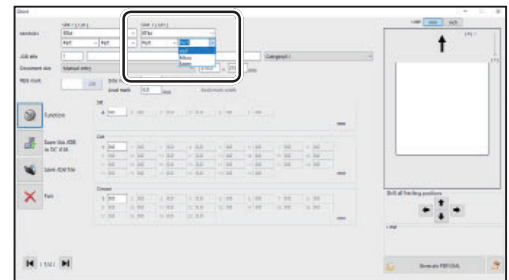
⑥ JOB No.
Enter a JOB number in the **JOB No.** box with the NUMERIC keys.

REFERENCE

You can set a JOB number of 1 to 250.
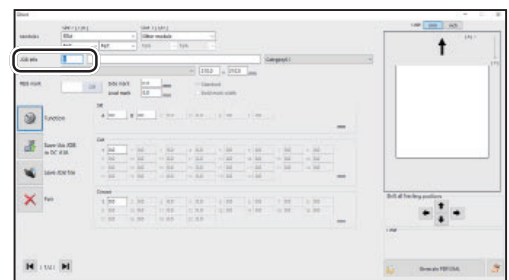
7 **JOB name**
Enter a JOB name in the **JOB name** box.
You can enter up to 50 characters and/or letters.

> **REFERENCE**
>
> Usable characters and letters;
>   Alphabetical letters (A to Z, a to z)
>   Numerals
>   Symbols
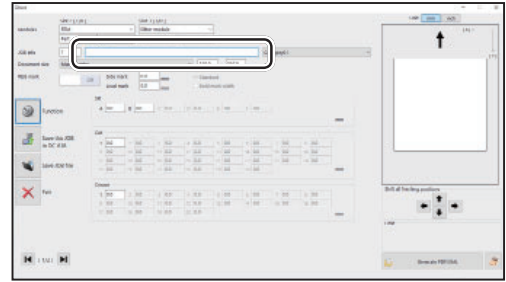
8 **Category**
Select a category in which to save the JOB from the **Category** box.

> **REFERENCE**
>
> You can set up to 20 categories.
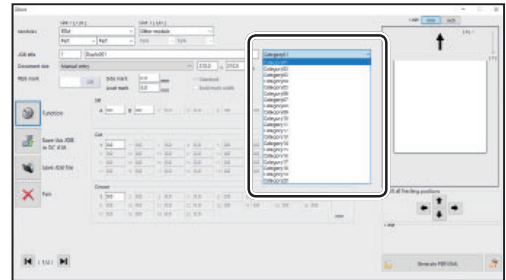
9 **Document size (Standard size)**
Select the document size from the **Document size** box.

> **REFERENCE**
>
> To process custom-size documents, select **Manual entry** and enter the length and the width of the document in the two boxes on the right.
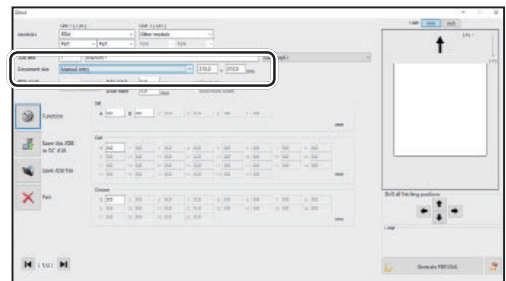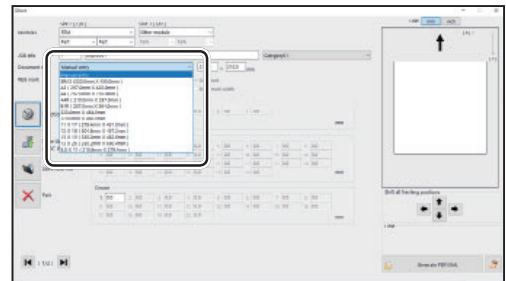
10 **Side mark**
Enter the distance from the right edge of the document to the side mark in the **Side mark** box.
Enter **0** if you do not use the REG mark reading function.
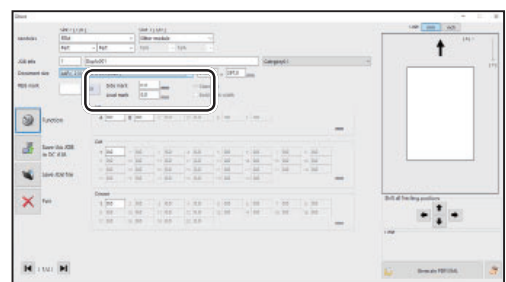
11 **Lead mark**
Enter the distance from the lead edge of the document to the lead mark in the **Lead mark** box.
Enter **0** if you do not use the REG mark reading function.

4

Programming a JOB on a Computer
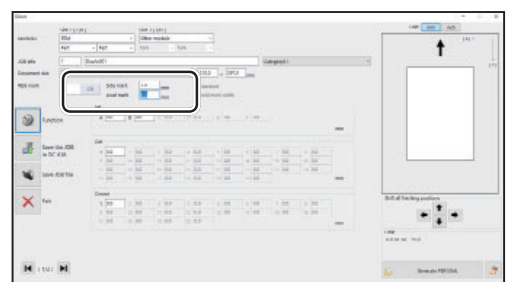
12 **REG mark type**
Select and click **Standard** or **Bold mark width**.
(This is available only when you have entered values
for **Side mark** and **Lead mark** in steps 10 and 11.)
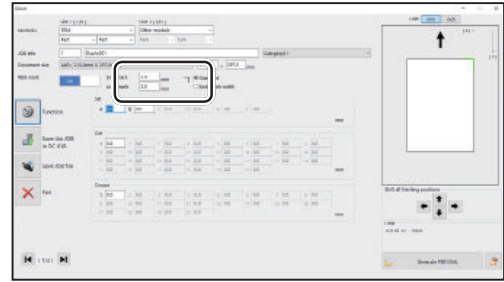
13 Select **On** if you use the REG mark reading function.
(This is available only when you have made settings
in steps 10 to 12.)
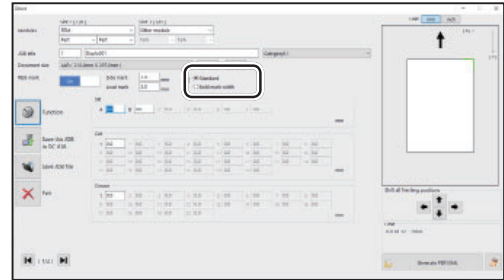
14 **Slit**
If you have selected the **advanced mode**, numerals
of 1 to 6 appear under **Slit**. If you have selected the
simple mode, alphabetical letters of **A** to **F** appear
there.
Click each **Slit** box and enter the distance from the
right edge of the document to the slit position. Press
the Enter key to set the value.
Entering **0** finishes the settings for **Slit**.
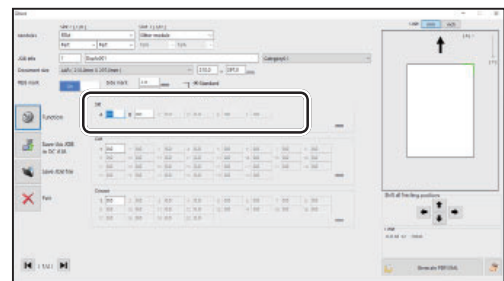
REFERENCE

• Slit position setting order
  Simple mode : Sets slits in alphabetical order of
  SlitA to **SlitF**.
  Advanced mode : Sets slits in numerical order as
  shown in the figure on the right.
  1, **2**: Margin slitter module
  5, **6**: Center slitter module
  3, **4**: Center slitter module
  e.g. If one **RTM (Rotary Tool Module)** and one
  center slitter module are installed, **A**, **B**, **C**,
  and **D** or **1**, **2**, **5**, and **6** are displayed.

• If the **RTM (Rotary Tool Module)s** are installed
  both in slot 2 and slot 3, you can enter two
  positions for **Slit**.

Document feed direction

F	E	D	C	B	A
2	6	4	3	5	1
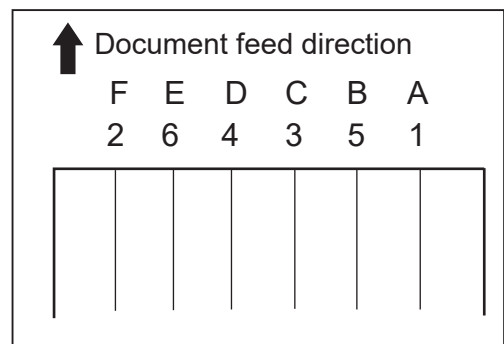
15 **Cut**
Click each **Cut** box and enter the distance from the
right edge of the document to the cut position with the
NUMERIC keys. Press the Enter key to set the value.
You can set up to 30 cuts.
Entering **0** finishes the settings for **Cut**.
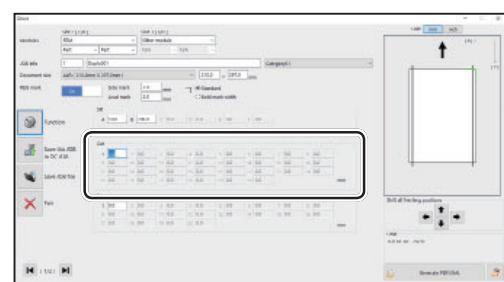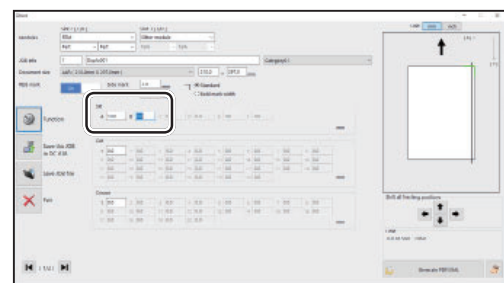
⑯ **Crease**
Click each **Crease** box and enter the distance from the right edge of the document to the crease position with the NUMERIC keys. Press the Enter key to set the value.
You can set up to 20 creases.
Entering **0** finishes the settings for **Crease**.
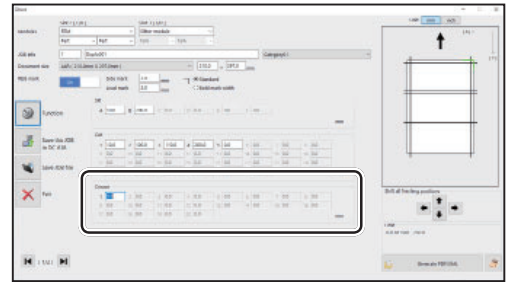
⑰ Click ▶❙ .
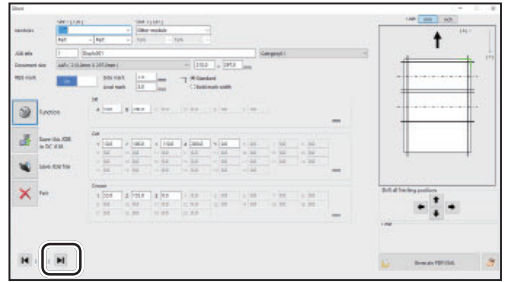
⑱ **RTM Slot 2 X1R**
Enter the distance between the right edge of the document and the position of **X1R** (Pattern 1 in the X direction, the right side tool) with the NUMERIC keys.

REFERENCE

Clicking the 💡 icon displays the **Setting procedure** screen, which you can use as reference for setting rotary tool positions.
There is a limitation on processing positions of the **RTM (Rotary Tool Module)**.
(→ P. 60 ● Settings for processing with the RTM (Rotary Tool Module))
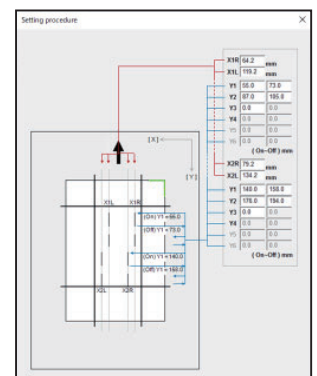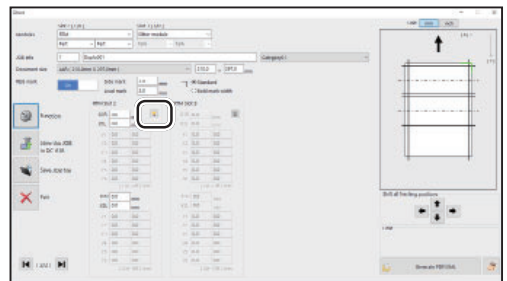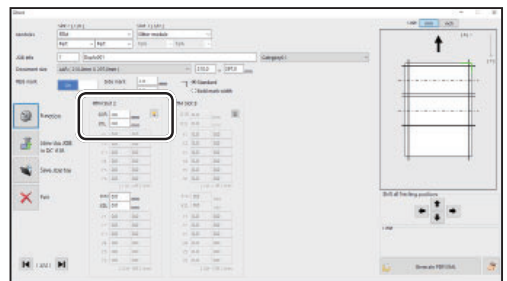
⑲ **RTM Slot 2 X1L**
Enter the distance between the right edge of the document and the position of **X1L** (Pattern 1 in the X direction, the left side tool) with the NUMERIC keys.

4

Programming a JOB on a Computer
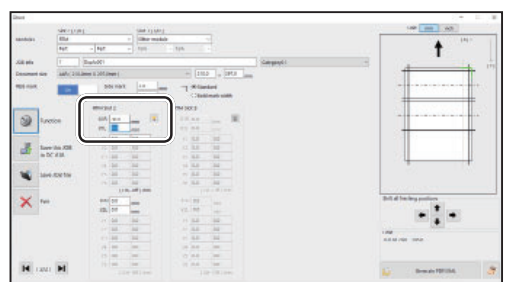
PC Controller Setting

20 **RTM Slot 2 Y1**

1. Enter the distance from the lead edge of the document to the **On** position (processing start position) of Y1 (Pattern 1 in the Y direction).

> **REFERENCE**
>
> **On** position: A position displayed as ↓ when a JOB is programmed on the control panel
> (**Y1 On** = **Y1↓**, **Y1 Off** = **Y1↑**)

2. Enter the distance from the lead edge of the document to the **Off** position (processing stop position) of **Y1** (Pattern 1 in the Y direction).

3. In similar ways to steps 20-1 and 20-2, enter values for **Y2** to **Y6**.
Entering **0** finishes the settings for Pattern 1 in the Y direction.
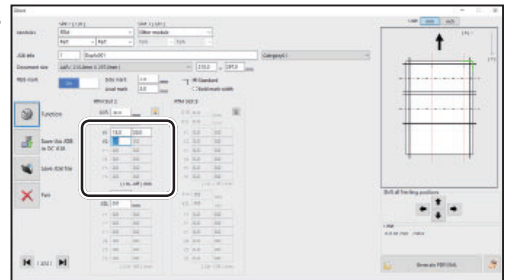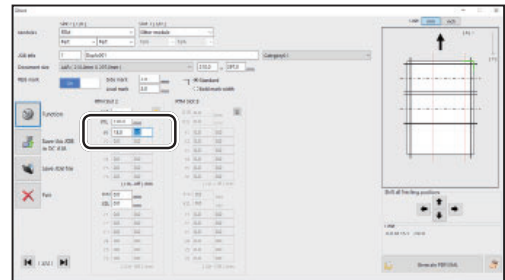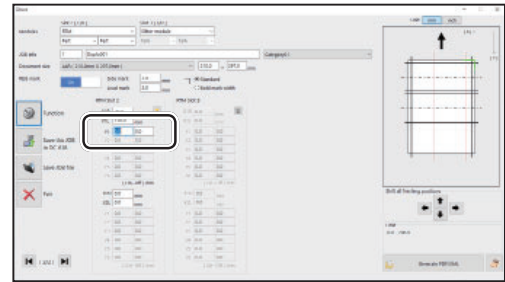
21 **RTM Slot 2 X2R**

Enter the distance from the right edge of the document to the **X2R** position (Pattern 2 in the X direction, the right side tool).
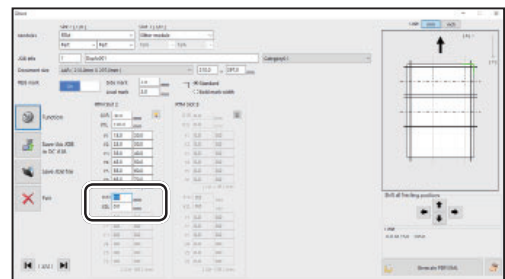
22 **RTM Slot 2 X2L**

Enter the distance from the right edge of the document to the **X2L** position (Pattern 2 in the X direction, the left side tool).
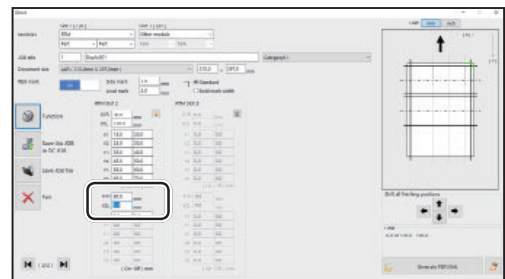
23 **RTM Slot 2 Y1**

1. Enter the distance from the lead edge of the document to the **On** position of **Y1** (Pattern 1 in the Y direction).

> **REFERENCE**
>
> You cannot set the **On** and **Off** positions at the same positions as entered in step 20.
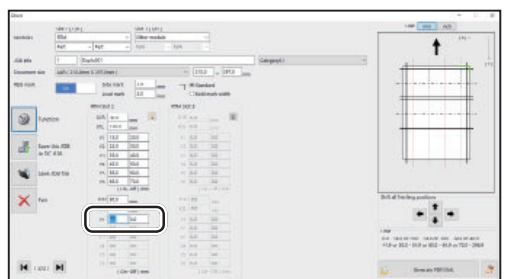
2. Enter the distance from the lead edge of the document to the **Off** position of **Y1** (Pattern 2 in the Y direction).
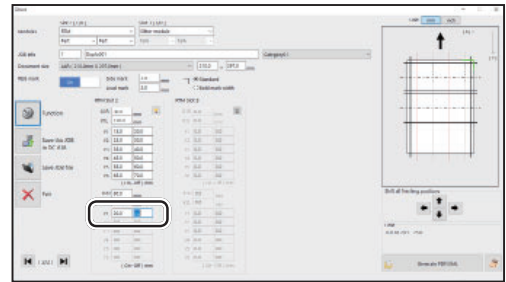
3. In similar ways to 23-1 and 23-2, enter values for **Y2** to **Y6**.
   Entering **0** finishes the settings for Pattern 2 in the Y direction.
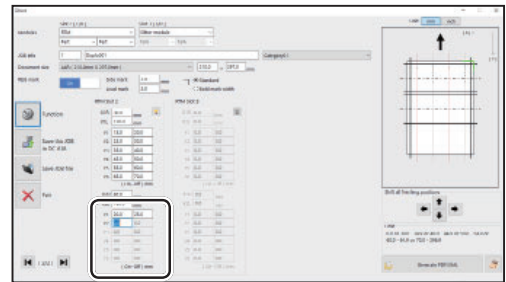
24. If you have selected the **RTM (Rotary Tool Module)** in **Slot 3**, enter a value for each position in similar ways to steps 18 to 23.
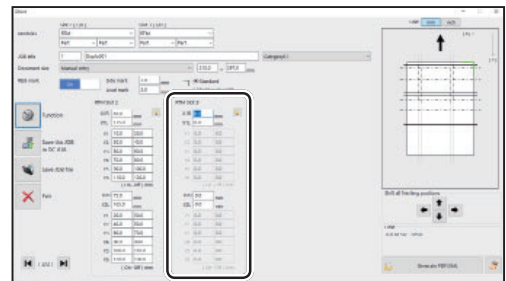
25. Check the details of the JOB.
    To change the settings, click the text box of the item to change and re-enter a value for it.
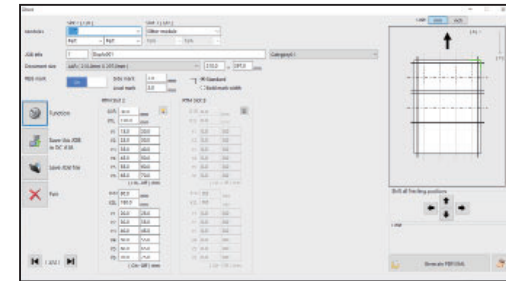
REFERENCE

Shift all finishing positions
You can fine-adjust setting positions of the JOB.

↑ : Each click on this moves the positions upward by 0.1 mm.

↓ : Each click on this moves the positions downward by 0.1 mm.

← : Each click on this moves the positions to the left by 0.1 mm.

→ : Each click on this move the positions to the right by 0.1 mm.

26. Click ⏮ .

4

Programming a JOB on a Computer
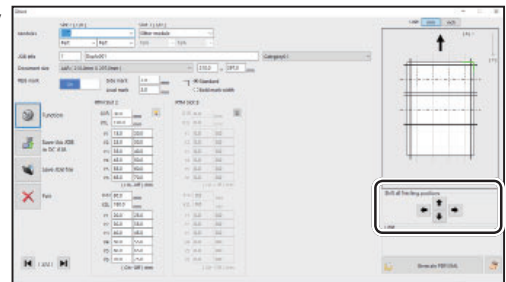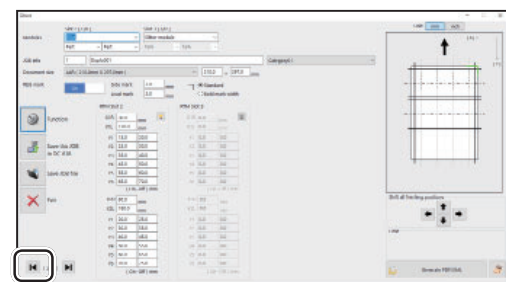
27 ● **Function**
Clicking the **Function** icon displays the function settings for the selected JOB.
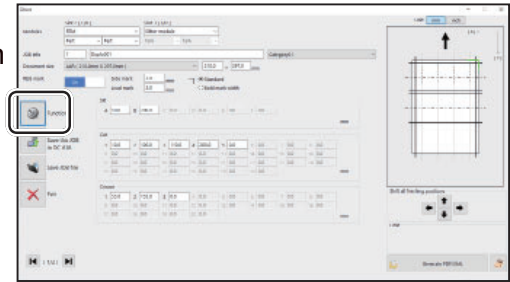
1. The function settings for the JOB are displayed.
   Check the settings and click **OK**.
   Clicking **Cancel** returns to the previous screen without changing the settings.
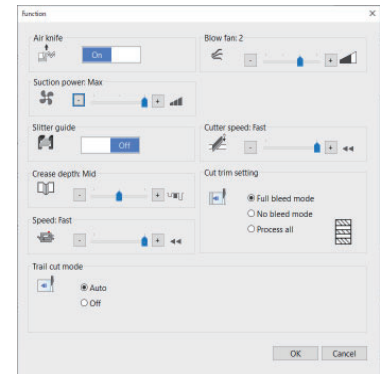
●Saving a JOB in the DC-618
   1. Click the **Save this JOB in DC-618** icon.
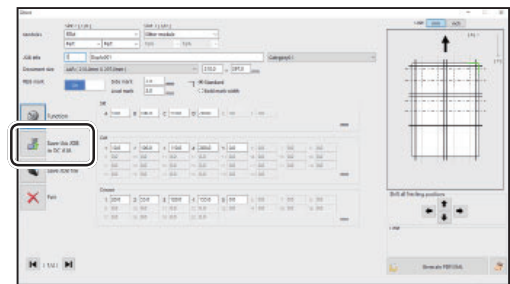
2. The message as shown on the right appears.
   Click **Yes** to save the JOB in the DC-618.
   Clicking **No** returns to the previous screen without saving it.
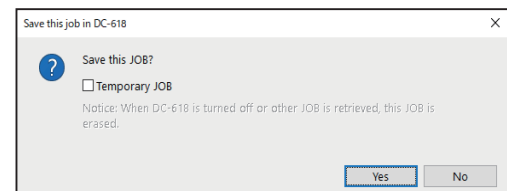
REFERENCE

To save the JOB temporarily, select the **Temporary JOB** check box.
If the DC-618 is turned **OFF** or another JOB is selected, the JOB temporarily saved is deleted.

REFERENCE

If you save a JOB while the DC-618 is operating, the message as shown on the right appears.
Clicking **OK** saves the JOB in **Download Queue**.
Clicking **Cancel** returns to the previous screen without saving it.
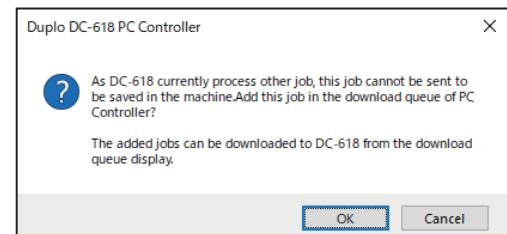
For the procedure for **Download Queue**, see Chapter 5 <u>PC Controller Setting</u> - <u>Job Detail Viewer</u> in the DC-618 PC Controller Instruction Manual.

REFERENCE

If you try to overwrite a locked JOB, the message as shown on the right appears.
Click **OK**.

●Saving a JOB on a computer
See Chapter 5 <u>PC Controller Setting</u> - <u>Programming a JOB</u> - <u>● Saving a JOB on a computer</u> in the DC-618 PC Controller Instruction Manual.

4
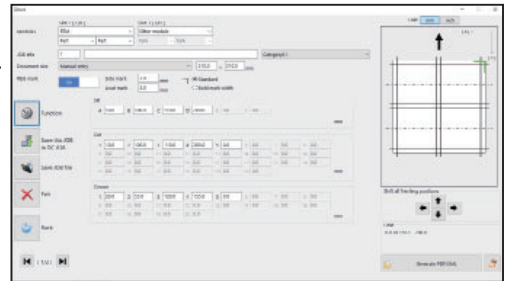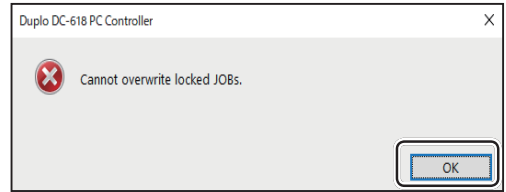
Retrieving and Processing a Saved JOB

This section describes the procedure for retrieving a JOB saved in the DC-618 or on a computer and processing it.
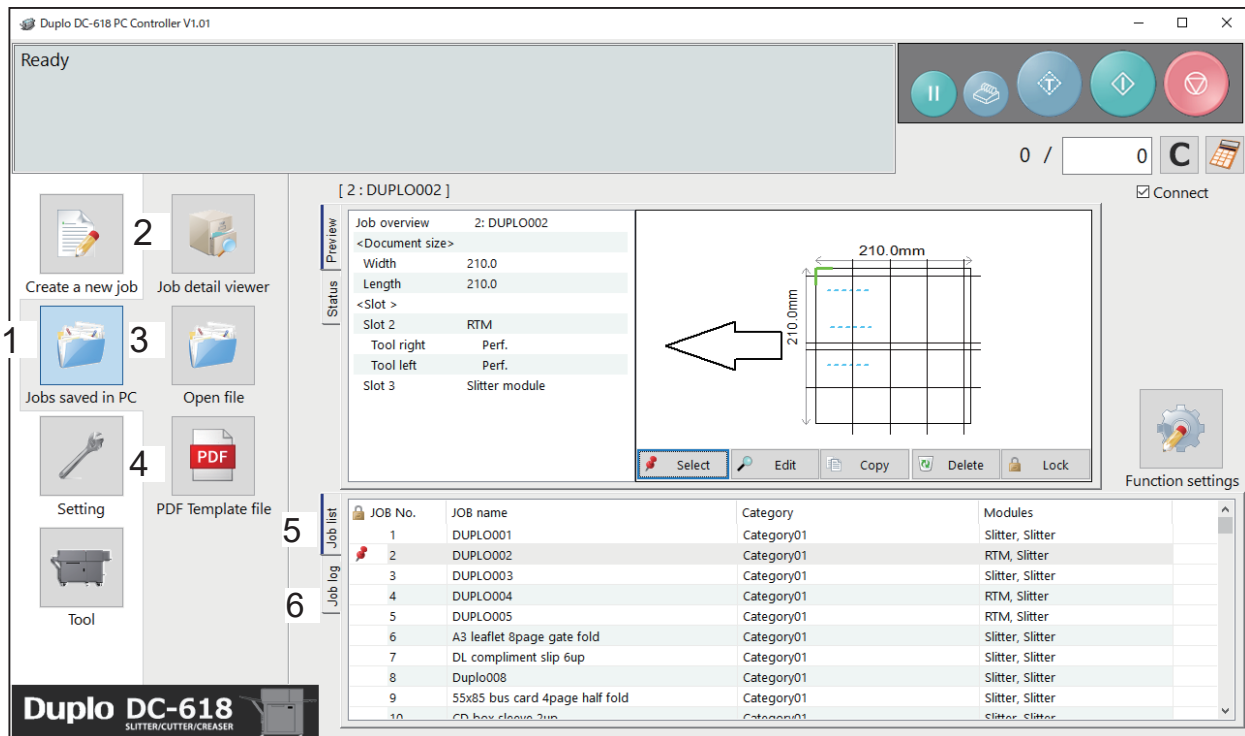
No.	Name	Function
1	Jobs saved in PC	Opens a JOB saved on a computer.
2	Job detail viewer	Displays a list of JOB files programmed with the PC Controller.
3	Open file	Opens a JOB file and displays the **Wizard** screen, the **Direct** screen, or the **All JOBs** screen on which the JOB was programmed.
4	PDF Template file	Opens a folder in which PDF templates are saved.
5	Job list	Displays a list of JOBs saved in the DC-618.
6	Job log	Displays JOBs processed with the TEST key or the START key clicked on the PC controller and saved in the computer as logs. You can save up to 50 of lately processed JOBs. If the number of saved JOBs exceeds 50, they are deleted in chronological order.

① Click **JOBs saved in PC** on the main screen.
Select a saved JOB in **Job detail viewer**, in **PDF Template file**, on **JOB list**, or on **Job log**.
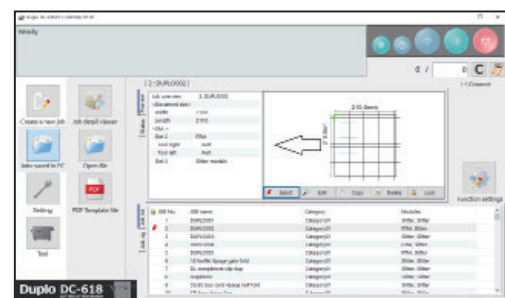
② For the subsequent procedure, see Chapter 5 <u>PC Controller Setting</u> - <u>Checking a Saved JOB</u> in the DC-618 PC Controller Instruction Manual.

Setting Default Values for a JOB

This section describes the procedure for setting default for a JOB to be programmed, which is related to the **RTM (Rotary Tool Module)**.
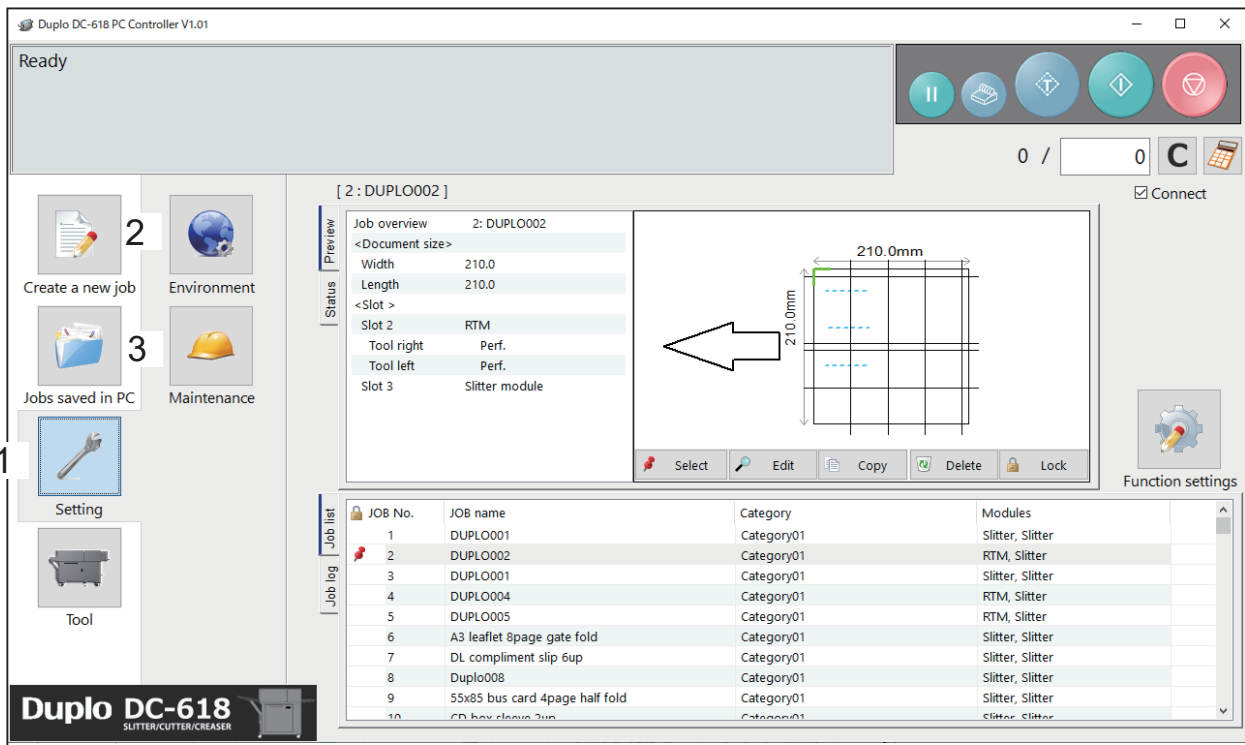

No.	Name	Function
1	Setting	Make default settings for the PC Controller. The other functions are for a service person use only.
2	Environment	Set default values for a JOB.
3	Maintenance	For a service person use only for making settings for connected units, setting a language to be displayed and so on. A password is required to access this. If any setting of those is necessary, contact our service person.

Environment

① Click **Setting** and then **Environment** on the main screen.
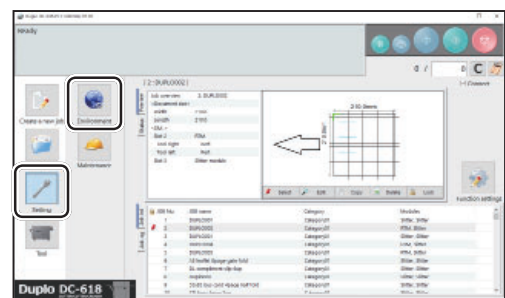
Setting Default Values for a JOB

2 Click the **Option module** tab.
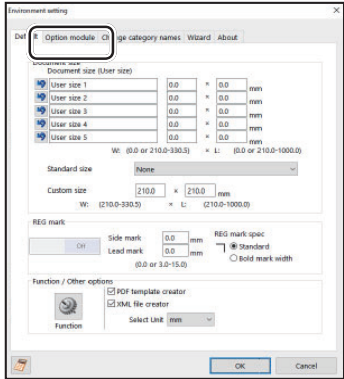
3 To set **RTM (Rotary Tool Module)**, which is used frequently, as default, select **RTM (Rotary Tool Module)** from the **Slot 2/Slot 3** box under **Default setting**.
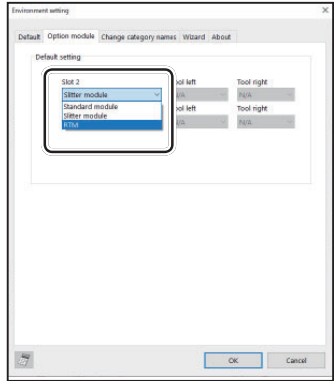
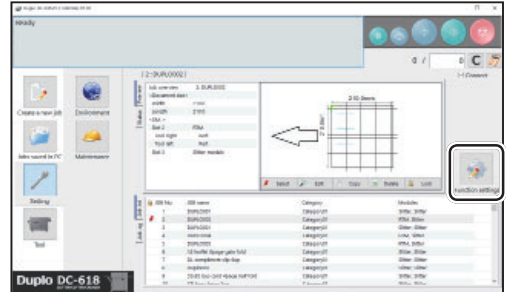**4** Select tools from the **Tool left** box and the **Tool right** box.
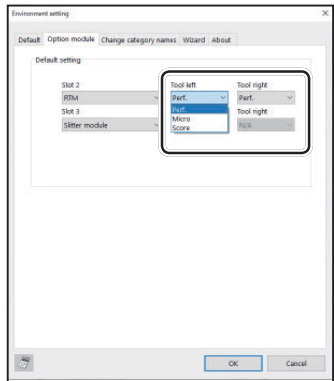
5 To set **RTM (Rotary Tool Module)** in **Slot 3** as default, follow steps 3 to 4.
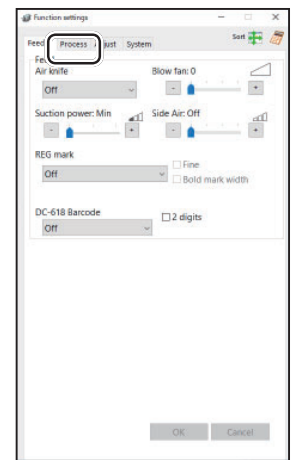Click **OK** when the setting is completed.
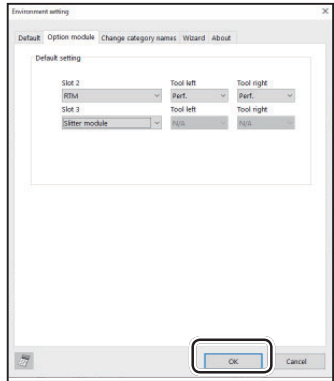
Function Settings

This section describes the procedure for displaying the **Function settings** screen on the main screen to check or change function settings for a JOB, which is related to the **RTM (Rotary Tool Module)**.

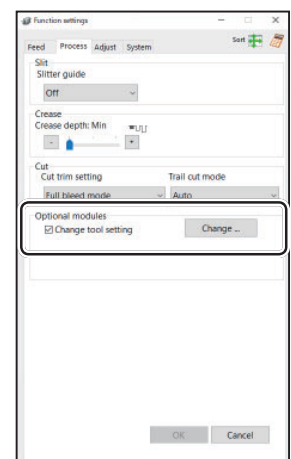**1** Click **Function settings** on the main screen.

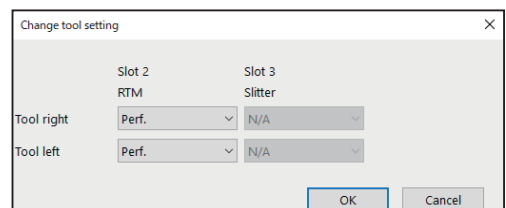**2** The **Function settings** screen appears.
Click the **Process** tab.

Process

1 ●**Optional modules**
Displays the type of the **rotary tools** of the modules that are installed in slot 2 and slot 3.
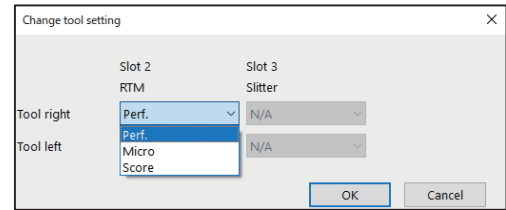1. Select the **Change tool setting** check box. Click **Change...**

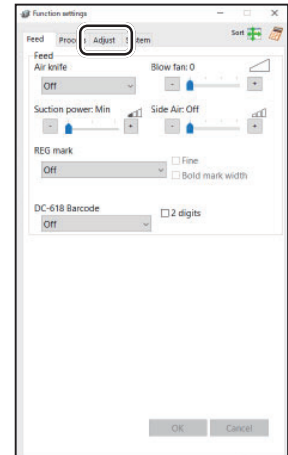2. The **Change tool setting** screen appears.

Function Settings

3. Select each tool for **Slot 2** or **Slot 3** from the
   Tool left box and the **Tool right** box.
   Click **OK** when the setting is completed.
   Clicking **Cancel** returns to the previous screen
   without changing the settings.

Adjust

1 Click the **Adjust** tab.

2 ● **RTM (Rotary Tool Module) Adjust**
You can change the settings for the **rotary tools** of the modules
that are installed in slot 2 and slot 3.

1. **RTM on pos Adj. (RTM on position Adjustment)**
   You can adjust the processing start position of the **rotary tool** in
   the range of -9.9 to +9.9 mm.
   + : Each click on this increases the value by 0.1 mm.
   The processing start position moves toward the document
   trail edge.
   - : Each click on this decreases the value by 0.1 mm.
   The processing start position moves toward the document
   lead edge.

2. **RTM off pos Adj. (RTM off position Adjustment)**
   You can adjust the processing stop position in the range of -9.9
   to +9.9 mm.
   + : Each click on this increases the value by 0.1 mm.
   The processing stop position moves toward the document
   trail edge.
   - : Each click on this decreases the value by 0.1 mm.
   The processing stop position moves toward the document
   lead edge.

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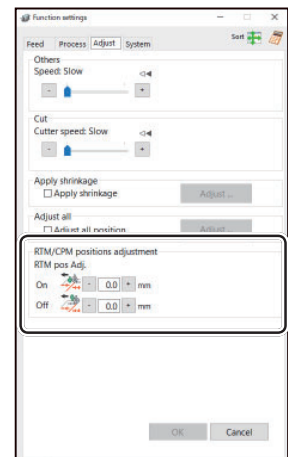
3 When the setting is completed, click **OK**.
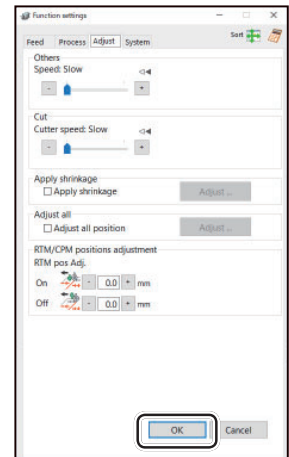
4 To save the settings for **Function settings** in the DC-618, click **Yes**.
The settings for **Function** (→P.88) set for each JOB are not overwritten.

4

Programming a JOB on a Computer

MEMO
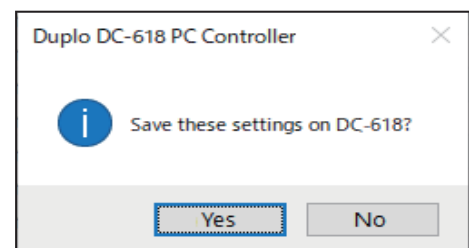
Chapter 5

Troubleshooting

This chapter describes what to do when an error has occurred and how to deal with document jams and error messages.
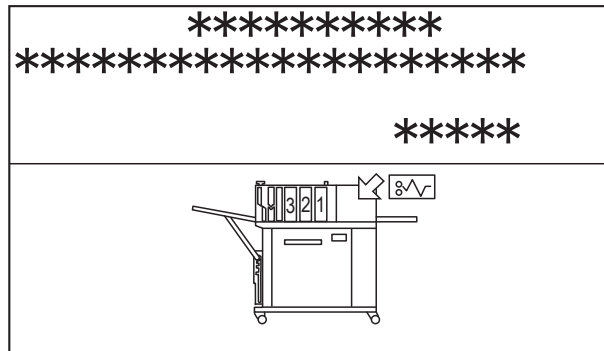
If Messages Appear

If an error has occurred, figures and messages appear on the touch panel.
Confirmation messages may also appear. In such cases, follow the procedure below to clear the error.

- **Display on the touch panel**

  An arrow points at the position where the error is occurring in the figure of the machine displayed in the lower part on the screen.
  The error status and the solution are displayed in the upper part on the screen.

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Message	Status and Solution
RTM pos. adj. in Adjust are invalid. Please correct. ⬇ to clear	Status: Processing positions of **Pattern 1** and **Patter 2** in **RTM pos. adj.** overlap when a JOB in which the **RTM (Rotary Tool Module)** is used is retrieved. Solution: Reprogram the JOB so that the processing positions do not overlap.
RTM: Check the setup of micro perf tools. to continue ⬇ to clear	Status: With a JOB in which the **RTM (Rotary Tool Module)** is used selected, this message appears when processing starts. Solution: To continue processing the JOB, press the icon key that is displayed. To clear the error, press the STOP key. If you are using the PC Controller, the message as shown below appears on the computer. Duplo DC-618 PC Controller ⓘ RTM: Check the setup of micro perf tools. Slot2 R: Raise L: Lower Slot3 R: Not in use L: Not in use Press OK to start the JOB. [OK] [Cancel]
RTM: Check the setup of micro perf tools. ⬇ to clear	Status: A **barcode** was read. With a JOB in which the **RTM (Rotary Tool Module)** is used selected, this message appears when processing starts. Solution: Press the STOP key to clear the error.

If a Document Jam Has Occurred

⚠ WARNING

- Do not touch the tool. Doing so may cause injury.
- Before removing the jammed document, make sure that the machine is fully stopped. Use the pliers that came with the machine to prevent your hands or fingers from being caught in the machine.

J05 CHECK MSM/SLOT2

J06- * CHECK CUTTER/CREASER/SLOT1/2/3

SLOT#-* LOCK

## SLOT# UPPER LOCK

DOCUMENTS IN MACHINE

A document jam has occurred in the **cutter/creaser/slot** section.
A document jam is displayed on the touch panel. Follow the procedure below to remove the jammed documents.

REFERENCE

Follow the procedure below as well if **MARGIN-*
LOCK**, **SLOT#-* LOCK**, **GUTTER* LOCK**, **CUTTER
LOCK**, **CREASE TOOL (MALE) LOCK**, or **SLOT#
UPPER LOCK** appears.

J06- * CHECK CUTTER/CREASER/SLOT
Remove documents
from Cutter/Creaser/Slot section.
▽ to clear

① Press the JOG (forward) key to eject the document.
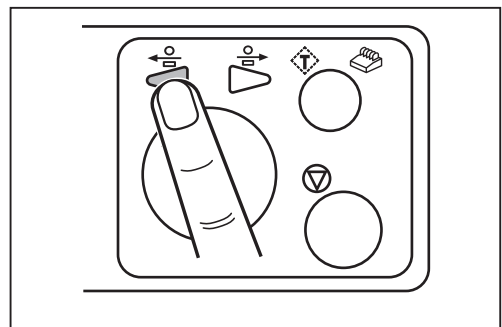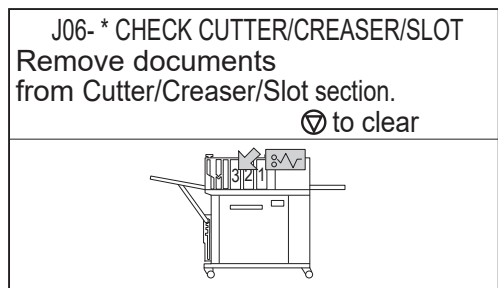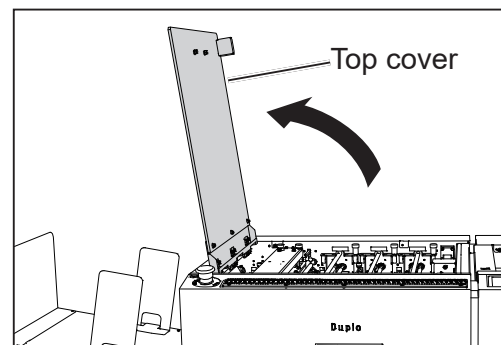
If a Document Jam Has Occurred

2 Press the STOP key to clear the error.
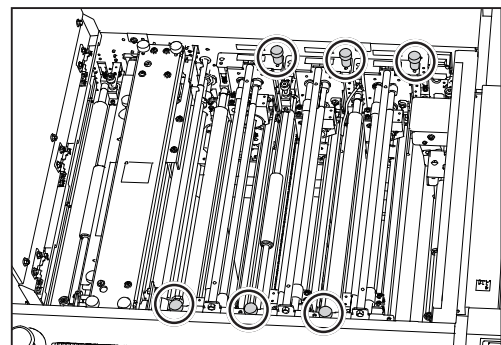The DC-618 is reset and the error message is cleared.
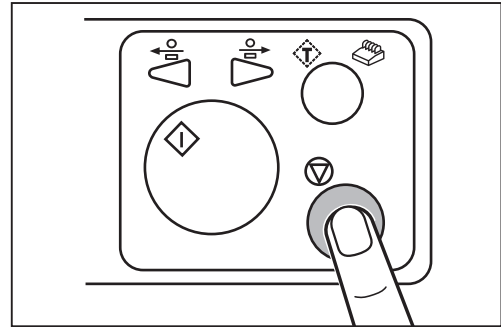
If you cannot remove the jammed documents in the procedure above, follow the procedure below.

● **When removing the document from the slot section:**
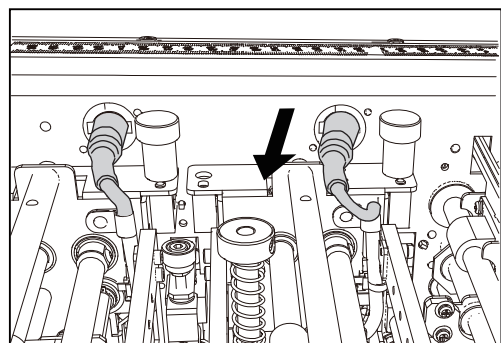
1 Open the **top cover**.

Top cover

2 Loosen the **fixing screws** (two each) on the modules in **slot 1**, **slot 2**, and **slot 3**.

REFERENCE

If the **RTM (Rotary Tool Module)** is installed in **slot 2** or **slot 3**, disconnect the connector of the module.

**3** Grasp the **handle** to take out the modules in **slot 1**, **slot 2**, and **slot 3** by lifting them up.

4 Remove the jammed document with the **pliers** and so on.

5 Install the modules removed in step 3 to their original positions in **slot 1**, **slot 2**, and **slot 3** according to the **positioning pins**.

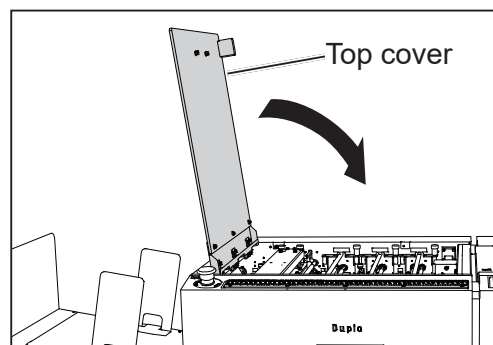**6** Tighten the **fixing screws** (two each) on the modules to secure them.

REFERENCE

If the **RTM (Rotary Tool Module)** is installed in **slot 2** or **slot 3**, connect the connector of the module.

5

Troubleshooting
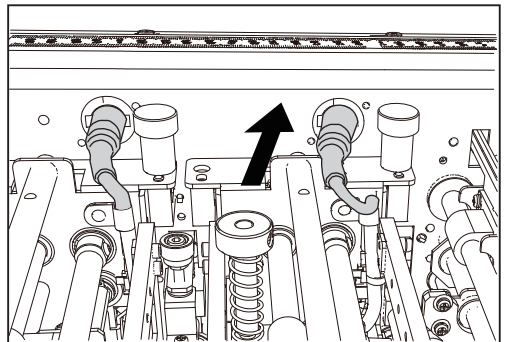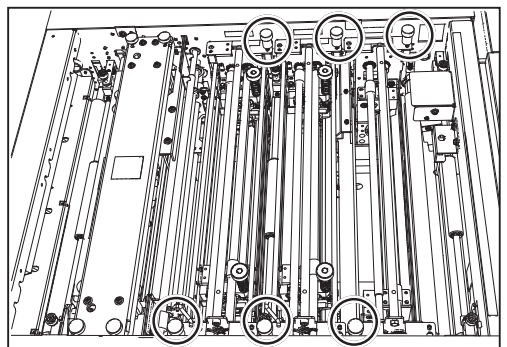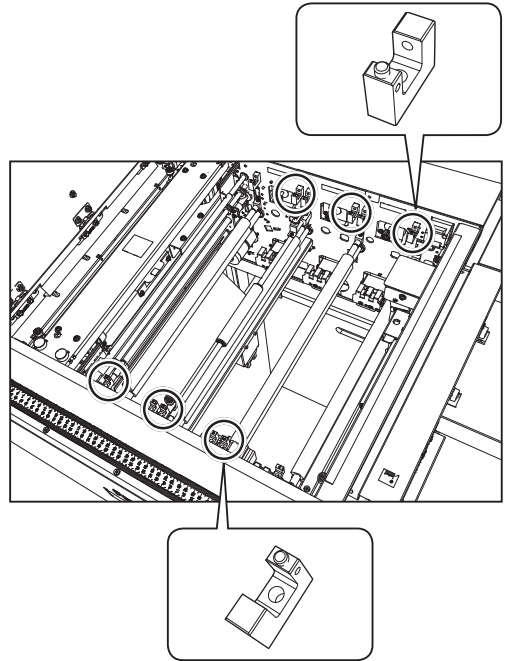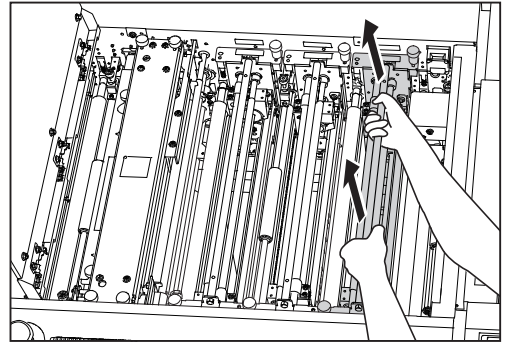
If a Document Jam Has Occurred

7 Close the **top cover**.

Top cover

Daily Maintenance

This chapter describes daily maintenance of the product.

Daily Maintenance

Clean the product periodically to maintain its performance.

⚠ WARNING

- Before cleaning, be sure to turn the power **OFF**, wait until the machine cools off and unplug the power cord. Otherwise, fire or electric shock may occur.
- Never remove covers on the machine or modify them.
- Do not spill water or any liquid inside of the machine. It may cause fire or electric shock. If it happens, contact our service person.

Clean the product in the following procedure.
1. Tightly wring a soft cloth that has been moistened with water or mild detergent.
2. Wipe off any dirt on the module.
3 .Wipe off the excess moisture on the module with a soft dry cloth.

⚠ WARNING

- Never use alcohol or solvent cleaner. It may tarnish or damage the exterior finish.
- Do not put diluted petroleum or insecticide. It may cause fire.

Dust accumulation may cause the product to malfunction. Clean it periodically. Contact our service person as for cleaning of the inside of the product.

Chapter 7

Specifications

This chapter lists the specifications.

7

Specifications

Specifications

	DC-618 Rotary Tool Module
Model name	RTM-08 DC-618 Rotary Tool Module
Module type	Customer replaceable module
Paper weight	Perforation: 110–400 gsm Micro-perforation tool: 110–180 gsm Score: 110–400 gsm * Laminated / UV coated stock within the above range including lamination/coating layer.
Paper type	Uncoated, Coated, Laminated (laminate thickness: 10 μ or less), UV coated
Module slot	Slot 2 and/or Slot 3 * When using 1×RTM-08 only, RTM-08 is used on Slot 2 (OMK-13 is required on DC-618). * When using RTM-08/PFM-04/CPM-08 on Slot2, RTM-08 can be used on Slot 3. (OMK-13 and OMK-14 are required on DC-618.)
Rotary tool in 1 module	2
Position setup	Automatic * Image shift compensation by reading REG mark is available.
Skip perforation	Yes (2 tools in 1 module skip at the same time)
Max partial perforation	6 (in 1 widthwise position by 1 tool)
Programmable widthwise position	2 per 1 tool
Tool position	Minimum distance from the side edge of documents: 5 mm Minimum distance from the slit positions: 5 mm
Minimum distances between the tools	48 mm
Depth adjustment	Manual
RTM tools spec	Perforation	Cut: 0.6 mm / Tie: 0.6 mm (21.2 TPI)
	Micro-perforation	Cut: 0.28 mm / Tie: 0.23 mm (49.8 TPI)
	Score	Male: 0.8 mm / Female: 1.2 mm
Tool replacement	Customer replaceable tools * Replaceable with Perforation, Micro-perforation, and Score tool
Dimension	In use	455 (W) × 95 (D) × 205 (H) mm
	When packed	640 (W) × 160 (D) × 330 (H) mm
Weight	Net	7.0 kg
	Gross	8.5 kg

● Other specifications comply with the specifications on DC-618.
● The specifications are subject to change without prior notice.

Duplo

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