# DocuCutter DPC-400

# Digital Die Cutter

# **Operation Manual**





Revision: 111519AP

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#### 1. User Notes

## **1>SAFETY RULES**

After receiving the machine, if end users require any further modification or change of one part or several parts of the machines, they are obligated to advise the machines back to the manufacture for this treatment.

We do not have any legal responsibilities if the breakdown of the machines or operator's injuries is caused by the importer's modifications or changes to one part or several parts of the machines performed by end users.

The machine has many safety features which make it a safe machine to operate. Regardless of your experience, safety instructions must be read carefully, completely understood, and applied to your daily work habits. If you do not understand or are confused by certain safety instructions presented in this manual, discuss them with your supervisor. Machine setup, cleanup, and maintenance operation will vary. Therefore, it is essential all employees to practice safe work habits. SAFE WORK HABITS PREVENT INJURIES. The main rule to follow is to ALWAYS make sure the main drive is STOPPED and LOCKEDOUT when performing setup, cleanup, and maintenance operations.

The safety precautions in this manual provide guidelines for the protection and for that of fellow workers.

# 1.1 Precautions

Before any maintenance is performed on the machine, switch off all sources of energy, electrical, do not operate the equipment when panels and safety guards are not in place. Failure to observe this warning could result in personal injury.

## 1.2 Avoid Accidents

Most accidents are caused by the failure of some individual to follow simple and fundamental safety rules and precautions. For this reason, most accidents can be prevented by recognizing the real cause and doing something about it before the accident occurs. With any machinery, a careful and trained operator is the best insurance against an accident.

# 1.3 Safety Issues & General Safety Rules

DO	DO NOT
<ol> <li>Read and understand this manual before attempting to operate or service the machine.</li> </ol>	<ol> <li>Do not attempt to operate or service the machine without reading and understanding this manual.</li> </ol>
2. Be familiar with the machine safety rules and practices.	2. Do not remove the safety devices. Including electrical interlocks.
<ol> <li>In case of an accident while the machine, is running press the emergency stop button to stop the machine.</li> </ol>	3. Do not start the machine unless you are sure there is no danger to you or your fellow workers.
4. Warn others of an intended action that may endanger them.	4. Do not clean or lubricate moving parts of a machine that is running.
5. Perform lubrication and oiling of the machine only when it is stopped.	5. Do not unauthorized persons to operate the machinery.
<ol> <li>Verify that all guards are installed before operating the machine.</li> </ol>	6. Do not wear jewelry, neckties, or loose clothing near moving machine.
7. When working on electrical equipment, power must be shut off to all circuits before any work is attempted. Individual switches must be opened, and the equipment circuits tested to make sure there is no power.	7. Do not place tools on a machine that is running.
8. Be sure all operators are aware of all areas and operations that require extra safety measures.	8. Do not reach into the machine to make adjust while it is running.
9. Keep the floor clean around the machine.	9. Do not use a rag on rotating rollers. Do not use any cleaning cloths or paper on rotating rollers
10. Keep aisles and walkways clear.	10. Do not have anything (coins, pens, etc.) in your pockets.
11. Return tools to their proper places after use.	11. Do not allow horseplay in the work area.

# 2.INTRODUCTION

## 2.1 What is the DocuCutter DPC-400 Does

DocuCutter DPC-400 is design for cutting and creasing to the digital printed material, such as labels, cards and packing cartons on demand.

## 2.2 Symbol Description

This manual's symbols correspond to the specific area on the machine. These safety warnings are placed to protect both the user and anyone within the machine's vicinity. These are also positioned to ensure that the machine is operated properly and safely. Each symbol and its meanings are explained below.

	Keep your hands away. Something heavy might fall from above.
	Be careful of high voltage or the risk of electric shock.
	Power Switch
CAUTION ROLLING Keep hands owey	Be careful of rollers and keep your hands away.
WARNING UV LIGHT. Do not look directly at light.	CAUTION Be careful of UV light. Do not look directly into the beam or view directly with any optical instruments.
WARNING WARNING CUT Keep hands away	Be careful of touching the blades. The blades are extremely sharp which could result in a serious injury when coming into play with hands or other parts of the body

# Duplo USA Corporation 3050.Daimler Street Santa Ana,CA 92705 USA Product: Paper Cutter Model:DocuCutter 4001 S/N:\*\*\*\*\*\*\*\*\*\*\* Rating:220v~,60HZ,20A

## 2.4 USAGE PRECAUTIONS

- 2.4.1 Before Operation
  - a. Understand emergency stop button and main power location. In addition, normal operation must be confirmed.

- b. Tools and sundries should not be put on the machine.
- c. No obstacles should surround or be placed on top of the machine.
- d. Personnel staying in risk areas are forbidden.
- e. Do not place any liquids on top of the machine
- 2.4.2 During Operation
  - a. Do not open any doors or guards.
  - b. No personnel in risk areas.
  - c. No maintenance and repair.
- 2.5.3 Maintenance
  - a. Power must be turned off before leaving the machine.
  - b. The location of each limited switch is identified.
  - c. Power must be turned off when personnel enter risk areas.
  - d. Check all buttons and switches are in the normal position.
  - e. Switches must be turned off before opening any door/guards.

#### 2.5.4 Others

- a. Damaging all external and internal panels and controls is forbidden.
- b. Do not cover each button and switch.
- c. The machine should be kept clean at all time.
- d. Warning signs and tags on the machine should not be removed or destroyed. If you have any questions, please contact your agent or dealer.

## 2. Frame and Parts

Name	Photo	Qty'	Name	Photo	Qty'
Ethernet cable		10m	Grounding cable		1
Creasing wheel	0	1	Power supply cable	700	3m
Straight screwdriver		1	Dongle		1
Picture knife		1	screw		dozens
Allen wrench	ure.	1	Pipe clamp	Je se	5

#### 2-1 List of Parts (1)

- <u>Caution</u>:
- Check items listed above before installation
- The tools and blades listed above is a standard offer, tools and blades vary based on specific offers. Please check with your supplier if you have any questions.
- The photos above are for reference only. The tools and blades listed above subject to change without notice.

## 2-2 CUTTER FRAME-



## **2-3 CUTTER FRAME**



2-4 CUTTER FRAME-



## 2-5 Sheets Pre-load Platform



# 3. Operation guide

#### 3-1 Installation

#### Key Components



- 1. Feeder
- 2. Conveyor Belt
- 3. Cutting Head
- 4. Control Panel
- 5. Stacking Tray
- 6. Electric box

a. Long arm forklift or crane at less 1 tons

b. It requires a proper area for placing the cutter, about 79CM\*230CM, the floor should be as flat as possible.

c. It requires a clean room without EMI or static interference and operates under circumstance with humidity of 50-80%Rh and 20-25 $^{\circ}$ C.

d. Compressed air supply: 4-8kg/cm^2, no less than 1.5HP.

## Placement

a. Extend feet of the cutter (to the height that higher than the wheels) with

adjustable wrench after place the cutter in position



- b. Level the system is very important
- c. Stacking Tray Install and adjust proper size for paper

Oppressed Air Installation

- 1. Incoming Air Adjuster No.1 Adjust the air pressure to 0.3-0.6Mpa,
- 2. Adjust valve No. 2 to 0.2-0.3Mpa.



## **3-2 Cutting Tools Installation**

Select the type of tool you need.

Tool Name	J201	J202	J205	J206	J208
Paper Type	Paper/Card	Paper/Card	Card	Stickers	Sticker
Paper Thickness	120-300gsm	150-400gsm	400-1kg		Sticker or less
(gsm)					than 300gsm

**1** Blade Installation Procedures

a. Unscrew the cap of the blade holder:



b. Put a blade into the holder and push it to the end:



c. Put the cap back and leave about 2mm of the tip of the blade out of the cap. Make

sure the tip can rotate freely in the holder:



d. Put the holder to the cutting head of the cutter. Make sure the holder is put in

posi4tion. Fasten the holder by a flat screwdriver

# **Creasing wheel installation**

1&2 are the Allen screws, those two screws use for fix the crease wheel .Number 3 is the screw which use for pull the wheel holder and adjust the center of wheel blade .

- a. loosen1&2 then loosen 3
- b. Push down that wheel blade holder
- c. Change new wheel blade (4)



**Note:** The wheel can be installed off of center. Please test the Wheel Offset Calibration on a blank sheet see if the wheel is installed correctly.

# 3-3 Turn on/off

#### Turn On the cutter

• Connect power supply and turn on the main switch ,clockwise rotate to release emergency stop button.

**2**Press Green Starting Button ..

The cutter starts initializing....

The cut system starts in 10 seconds and displays welcome page:



OClick Duplo USA and the cutter starts to reset.

Verify no people within electric appliances area before turns on main power supply.

Verify all emergency stops are closed before close the breaker.



## • Turn off the cutter

Press emergency stop down if you want to turn off the cutter. Switch off the main power supply Breaker.

## Main Screen



L	To enter the TEST menu
Ser.	To enter the Setup menu
5	To turn the pump ON or OFF
	To reset the machine to the home position
┛	To resume the job

## **TEST SCREEN**



Test Motions	Head Motion	Depth	Origin
		Knife Depth: Adjusts the knife depth.	Back Origin: Head
Knife Action	UP Arrow	The higher the number the lower the	Unit goes Feeder
		unit goes.	postion
		Knife1 Depth: Adjusts the Knife1	Front Origin: Head
Knife1 Action	DOWN Arrow	depth. The higher the number the	unit goes to Home
		lower the unit goes.	postion.
		Wheel Depth: Adjusts the Wheel	Temp Origin: Sets
Wheel Action	LEFT Arrow	depth. The higher the number the	temporary home
		lower the unit goes.	postion.
Suckar Action		Tact Speed: Speed of the Head Unit	Manual Feed: feeds
SUCKET ACTION		Test speed. Speed of the nead offic	one sheet
Pump ON/OFF	Origin		

## SETUP SCREEN

**TOOLS TAB** 

TOOLS Whe	el tool setting	OFFSET ADJUST	ADVA	NCE
TOOL TO SELECT		SPEED	ACC	
SP1: Knife1 SP5: kni	fe Knife1 spe	eed: 500	Knife1	3500
SP2: Knifet SP6: No	Cut Spee	d: 600	Cut Accel:	3500
	Move Spe	ed: 700	Move Accel:	3500
SP3: Knife1 SP7: No	speed:	100	Cut down	3500
SP4: None SP8: No	ne Bending	150	Cut down Accel:	350

TOOL SELECT	SPEED	ACC
SP1 to SP8: Define the	Knife1 Speed: Maximum speed it can	Knife1 Acc: Acceleration speed of
tool used	reach	Knife1
- None	500 (default)	3500 (default)
- Knife	Cut Speed: Maximum speed of Knife	Cut Accel: Acceleration speed of Knife
- Knite1	tool	3500 (default)
- Wheel	600 (default)	
	Move Speed: Speed of the Head Unit	Move Accel: Acceleration speed of
	in up position	Head Unit
	700 (default)	3500 (default)
	Cut Down Spood: Knife and Knife1 up	Cut Down Accel: Acceleration speed
	and down speed. Kille and Killer up	Up and down motion for Knife and
	100 (default)	Knife1 tool
		3500(default)
	Bending Speed: Control the speed	
	when making curves	
	150 (default)	

#### WHEEL TOOL SETTING

	TOOLS	Wheel tool setting	OFFSET ADJUST	ADVANCE	
	Wheel tool sett	ting	DELAY	ANGLE	
	Wheel down Speed: 70	0 Lifter 1 De Knives 1 E	elay: 0	Pen Dec 0.0 Angle: Pen Stop 70.0	
	Wheel Speed: 70	0 · Cut up Delay	. 0	Angle: Cut Dec 0.0	
1.54	Wheel Acc: 250	)0 Cut dov Delay	wn 0	Cut Stop 20.0	
	Wheel down 200 Accel:	0 Wheel Delay Wheel D	Up 0 y: 0	Raise_Angle: 30.0	

WHEEL TOOL SETTING	DELAY (Not Used)	ANGLE
Wheel Down Speed: Maximum		
down speed of wheel	Lifter1 Delay: 0	Pen Dec Angle: 0.0
700(default)		
Wheel Speed: Maximum speed		
of wheel	Knives1 Delay: 0	Pen Stop Angle: 20.0
700 (default)		
Wheel Acc: Acceleration Speed		
of Wheel	Cut Up: 0	Cut Dec Angle: 0.0
2500 (default)		
Wheel down Accel: Acceleration		
speed of wheel	Cut Down: 0	Cut Stop Angle: 20.0
2000 (default)		
	Wheel Up: 0	Raise Angle: 30.0
	Wheel Down: 0	

## **OFFSET ADJUST**

TOOLS	Wheel to	ool setting	ADJUST	AD	VANCE	
X OFFSE	T	) - Y	OFFSET		RSOR	
Calibration Ratio: Knife-knife1	5	Calibration Ratio: Knife-knife offset:	6 e1 24.0	X-Location of Cursor: Y-Location of Cursor:	10.0 -30.0	
Wheel-knife1	28.3	Wheel-knit offset:	fe1 70.8	Optimize Angle: Optimize Length:	5	

X OFFSET	Y OFFSET	CURSOR
Calibration Ratio: Adjusts the pulses of the X	Calibration Ratio: Adjusts the pulses of the	
motor.	X motor.	
-If the motor stops short of the stop positon	-If the motor stops short of the stop	X-Location: 10.0
adjust number to positive (+)	positon adjust number to positive (+)	(default)
-If the motor goes beyond the stop position	-If the motor goes beyond the stop position	
adjust number to negative (-)	adjust number to negative (-)	
Knife-Knife1 offset: Aligns the knife position	Knife-Knife1 offset: Aligns the knife	
to match Knife1, 0.1=1mm in value	position to match Knife1, 0.1=1mm in value	Y-Location: -30.0
-Positive moves tool to the Left	-Positive moves tool to the Down	(default)
-Negative moves tool to the Right	-Negative moves tool to the UP	
Wheel-Knife1 offset: Aligns the Wheel	Wheel-Knife1 offset: Aligns the Wheel	
position to match Knife1, 0.1=1mm in value	position to match Knife1, 0.1=1mm in value	Optimize Angle: 5
-Positive moves tool to the Left	-Positive moves tool to the Down	(default)
-Negative moves tool to the Right	-Negative moves tool to the Up	
		Optimize Length: 20 (default)

## ADVANCE

TOOLS	Wheel tool :	setting	OFFSET ADJUST	ADV/	ANCE
ADVANO	E_a	AD	ANCE_b	ADVA	VCE_c
Knife compensation:	0.5	Auto-return:	077	Password	d input:
Wheel [	10	Pump enable	: 0++ ON	***	LIVER
Knife1 [	0.5	PG-enter:		Extended S	4 504
Pump time:	2	Auto Feed:		Version2:	4.801
Cut height:	5.00				

ADVANCE_a	ADVANCE_b	ADVANCE_c
Knife Comp: Adjusts the angle of corner cut -If the angle is rounded, increase the value -If the angle has point, decrease the value	Auto-return: Head returns to set positions Off= stays at its current position after cuts Back= goes to starting position Max= goes to the corner of the document	Password Input: 8888
Wheel offset: If wheel isn't making a straight line along the X axis. 10 units is 1° -Positive rotates counter clockwise -Negative rotates clockwise	Pump enable: Automatically turns on pump before cutting. If OFF you are required to manually turn ON pump before cutting.	Extended Setup button
Knife1 Comp: Adjusts the angle of corner cut -If the angle is rounded, increase the value -If the angle has point, decrease the value	PG-enter: OFF (default)	
Pump time: delays the time before the cutter starts 2 = Default	Auto-Feed: Automatically feeds the next sheet	
Cut height: Adjusts the lift up height of the tool 5mm= Default		

# **Extended Setup**

Extended Setup	2	
IP: 192 -	168 • 0 • 250	
Material Type : boa	rd Rolling Repeat:	87 ON
Vacuum sucker1:	Weak Suction :	SFP on
Vacuum sucker2:	Feed Length :	

Rolling Repeat: Table repeat previous job

IP: IP address

Material Type: Board (default)

Vacuum Sucker 1&2: ON (default)

Feed Length: You can adjust the length to accommodate a longer sheet above 600mm.

Gradient: X Breadth decrement:	0.0	Auto repeat:	
Y Breadth decrement: C_Offset:	0	Factory Reset	

Auto Repeat: Machine will run the same job continuously

Factory Reset: resets machine



- 1. Draw a 200mm line on the program and send to the machine.
  - If the Actual line is short of your Expected line, increase the Calibration ratio.
  - If the Actual line is longer than Expected line, decrease the Calibration ratio.



**X and Y TOOL OFFSET CALIBRATION** 

1. Make a 100mm X 100mm square box in the program using Knife1 or Wheel and send it to the machine.

- 2. Place blank sheet and set the TEMP ORIGIN and press Enter
- 3. If the tool (Knife1 or Wheel) doesn't match Knife position then adjust the X and Y axis.

#### ADVANACE\_a CALIBRATION

#### Knife and Knife1 Compensation



- 1. Make a 100mm X 100mm square and test on blank sheet.
- 2. Check the corners of the document.
  - a. If the angle is rounded, Increase the value.
  - b. If the angle is flared, Decrease the value.



#### Wheel Offset Adjustment

- 1. Press Wheel Action and make a line #1 by pressing the Left arrow.
- 2. Press Wheel Action to Lift the tool, press Left Arrow key to move the Head down a few inches.
- 3. Press Wheel Action to drop the Wheel and press Right Arrow to make Line #2 until it reaches the beginning of line #1.
- 4. The lines should match perfectly, if not adjust the angle by moving the Wheel Offset value.

-If Line #2 is going over Line #1, Increase value to Wheel Offset

-If Line #2 is lower than Line #1 Degrease value from Wheel Offset.

Note: 10 units is 1 degree.

#### 3-4 Cut Depth and Tools Selection Setting

#### **O**Tools Selection

Enter the main page, click "<u>SETUP</u>" button to enter into the menu and click "<u>TOOLS</u>" button, popping up window of tools selection SP1-SP8. Select tools as required.

TOOLS	Wheel too	l setting	OFFSE ADJUS	T T	AD\	ANCE
SP1: None S	SELECT	Knife 1 sp	SPEED	Kr	A	
SP2: None S	SP6: None	Cut Speed		ac Ou	ut Accel:	0
SP3: None S	SP7: None	Cut down speed:		MI OL	ove Accel: ut down	0
SP4: None S	SP8: None	Bending speed:	0		:cel:	Back

Click SP1-SP8 and set the tool name to each number which you used often.

For example: SP1 to knife .Sp2 to knife1, Sp3 to wheel

#### Ocut Depth Setting

Set cut depth after tools are selected. Click "<u>TEST</u>" on main page, popping up window as below:



- 1. Change values of Knifes depth to change cut depth of each tool.
- 2. Click "PUMP" On.

3. Click "<u>Knife Action</u>" to check knife depth. If the blade tip does not reach to table mat click "<u>knife action</u>" to lift up tool, then adjust depth value again. Repeat Step until the blade touches the mat.

4. Once the blade touches mat you're done. Continue these steps for "knife1" depth setup.

A. For wheel depth setup, Click "<u>Next Page</u>" enter into wheel depth adjust page (see picture below), click "wheel $\downarrow$ " button to move down the wheel until it touch mat surface, click "<u>Wheel</u> <u>Origin</u>" button to save the depth and click "<u>Back</u>".

B. Then enter into test page and click wheel action to crease on paper and check that line.

\*If depth is not enough and you can change that wheel depth value little by little.

Note: First check knife depth and wheel depth before click buttons of knife action and wheel action. Larger depth settings would damage the mat and even the machine. You must click "<u>Wheel</u> <u>Origin</u>" button after finish value settings of wheel depth, otherwise the settings would become valid.



#### 3-5 Offset for Creasing Wheel Tool

If creasing wheel is not parallel with Y axis, return to the main page after cut depth is set,

click "<u>SETUP</u>" button and then click "<u>ADVANCE</u>" button to enter angle settings. Change deflection angle value by clicking "<u>Wheel offset</u>" button on column "<u>ADVANCE</u> a" Offset the cutter every time as deflection angle changes, otherwise any changes would come to effect. Repeat above settings till creasing wheel is parallel with Y axis. Click "<u>Back</u>" after setting finishes.and reset machine.

TOOLS	Wheel tool setting	OFFSET ADJUST	ADVANCE
ADVANC Knife compensation:	0.0 Auto-return	ADVANCE_b	ADVANCE_c Password input:
Wheel offset:	0 Pump enab	le: DFF ON	* ENTER
Knife 1 compensation	0.0 PG-enter: 0 Auto Feed:		version1: 0.000
Out height:	0.00		Back

Caution: The diameters must be more than 6mm as using creasing wheel to crease/cut arcs or circles, otherwise creasing wheel or serrated knife tool would be damaged.

#### • PC Settings

Click "internet" on the desktop, click "Network and Sharing Center" to enter the control

panel.



Click "<u>Local Connection</u>" to enter the panel, click "<u>Property</u>" and select "<u>Internet protocol 4</u>" to enter IP setting. Select "<u>using following IP address</u>", input: 192.168.0.XX, or router IP. Click "<u>Enter</u>" after finishes.

Control Panel Home	View your basic n	etwork information and	set up connections	
	view your basic i	letwork information and	See full	lmar
Manage wireless network	addl 无线网络连接 Status			map
Change adapter settings	General		Internet	
Change advanced sharin				
settings	Connection		Connect or discor	nnect
	IPv4 Connectivity:	Internet		
	IPv6 Connectivity:	No Internet access	Access type: Internet	
	Media State:	Enabled	onnections: <u>机</u> <u>无线网络连接 (NETGEAR)</u>	
	SSID:	NETGEAR		
	Duration:	03:51:41		
	Speed:	54.0 Mbps		
	Signal Quality:		PN connections or set up a router or access p	oint
	Details Wireless	s Properties	Procession, or set up a router or access p	onne.
	Acuvity		or VPN network connection.	
	Sent —	– <b>Neceived</b>		
	Dutan 200 7	127 CON		
	Bytes: 200,70	57   56,254	computers, or change sharing settings.	
See also	😯 Properties 🛛 😌 Disable	Diagnose	ubleshooting information	
			abieshooting information.	

♀ 无线网络连接 Properties	Internet Protocol Version 4 (TCP/IPv4) Properties
Networking Sharing	General
Connect using: view Broadcom 802.11n 网络适配器	You can get IP settings assigned automatically if your network supports this capability. Otherwise, you need to ask your network administrator for the appropriate IP settings.
Configure This connection uses the following items: Client for Microsoft Networks Client for Microsoft Networks File and Printer Sharing for Microsoft Networks File and Printer Sharing for Microsoft Networks File and Printer Sharing 6 (TCP/IPv6) File Henry Protocol Version 6 (TCP/IPv6) File Link-Layer Topology Discovery Responder File Link-Layer Topology Discovery Responder	<ul> <li>Obtain an IP address automatically</li> <li>Use the following IP address:         <ul> <li>IP address:</li> <li>IP2.168.0.108</li> <li>Subnet mask:</li> <li>255.255.255.0</li> <li>Default gateway:</li> <li>IP2.168.0.1</li> </ul> </li> </ul>
Install         Properties           Description         Transmission Control Protocol/Internet Protocol. The default wide area network protocol that provides communication across diverse interconnected networks.	Use the following DNS server addresses:      Preferred DNS server:      Alternate DNS server:      Validate settings upon exit      Advanced
OK Cancel	OK Cancel

### ❷ IP SETTING

After initializing, click connection on the main menu, IP address setting pops up, IP address set as 192.168.0.250, after finish setting, IP address will be saved automatically (Note: Keep the computer and the cutter on the same segment, otherwise disconnected).

#### 3-7 Camera Settings



 $^{\circ\circ}$  on the desktop, software starts tracking the cutter. The cutter will show on the list, IP

settings are required before connection. Place the mouse over the device which needs to be edited, Click "<u>edit</u>".

Setting IP address as192.168.1.X, IP address of computer as 192.168.1.X+1,same as 3-5, select "<u>local connection2</u>" before IP setting of the computer (note: X range 0-255, IP setting of the camera cannot be at the same segment with the machine. Avoid conflicts independent network card and network card driven CD included in the whole package with the machine). For example: setting the IP in the red zone 1 as 192.168.1.25, subnet mask as 255.255.255.0, Default gateway as 192.168.1.1, in red zone 2:IP as 192.168.1.26, subnet mask and default gateway remains, the setting of the camera configuration are shown in the manual of the camera.



# M√ Set IP Address

Interface Info	
MAC Address	b8:97:5a:c3:1d:cc
IP Address	192.168.3.100
Subnet Mask	255.255.255.0
Default Gateway	0.0.0
Device Info	
MAC Address	e0:50:8b:2e:1f:a6
IP Address	192.168.3 .100
Subnet Mask	255.255.255.0
Default Gateway	0. 0. 0
	<u>O</u> k <u>C</u> ancel

### Caution:

• IP address of the cutter must be the same segment as that of the local router and PC, otherwise data transmission may fail.

х

• Restart the cutting system after IP settings is done.

#### 4. SOFTWARE

#### 4-1 Software Installation

Software Installation

#### Double click Duplo USA \*\*\*\*Setup.exe

名称 ^	修改日期	类型	大小
🛃 DUPLO Ver5.4.5.1018 English.msi	2019/11/5 16:32	Windows Install	55,259 KB
🔂 setup.exe	2019/11/5 16:31	应用程序	387 KB



Click <u>"Next</u>" and install the program on non-system disk, click <u>"Next"</u> to continue the



🛃 DocuCutter				_		$\times$
Select Installation Folde	r					
The installer will install DocuCutter to the f To install in this folder, click "Next". To in:	iollowing fol stall to a diff	der. ferent folde	r, enter it belo	w or cl	ick ''Brov	vse".
Eolder: D:\Docucutter\					B <u>r</u> owse Jisk Cost.	
Install DocuCutter for yourself, or for any	yone who u	ses this co	mputer:			
DocuCutter – Confirm Installation	- ×	el # DocuCutter Installation	< <u>B</u> ack		Next	> ×
The installer is ready to install DocuCutter on your computer. Click "Next" to start the installation.		) DocuCutter has be Click: "Close" to ex	en successfully installed. it.			
Cancel < Back	<u>N</u> ext >	Please use Windo	ws Update to check whethe	r there are imp Cancel	oortant . NET Frame < <u>B</u> ack	work update.

### 4-2 Print Setup

- 1. Open Duplo USA, click "File" menu > "Printer" and set cutter model. LST0604
- 2. Then click "<u>Print-Mode</u>" and set IP address from the machine.
- 3. Select "<u>Compatible old mac</u>".

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#### 4-3 Print Files

Open **Duplo USA**, click "<u>File</u>" menu > Open, and choose files required.

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Click "<u>Open</u>" then come to the page as below. Choose proper "<u>Unit</u>", "<u>Scale-size</u>" and click "<u>OK</u>" button to open the given file. Press "<u>F12</u>" on the keyboard to print the file.

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After Click that "Print" button and Driver will send file to machine automatically.

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Oclick "Setting"\_setting\_ in the menu of Duplo USA and select "Camera Locator (H)" in the

#### drop-down box of "Loc-type"

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**Q**Re-Open **Duplo USA** and click "Icon"  $\rightarrow$   $\stackrel{\bullet}{\rightarrow}$  button to pop up camera registration

window.

Click "Open file" and select required file, then open "Auto Task", select the same file, set cut

quantity. Click "<u>Locator settings</u>", select "<u>batch production</u>" while set the auto feeder ON. Move the camera to the mark, click the "<u>find the mark</u>" button on the HMI, then the cutter would search marks automatically. The machine would start cutting operation as registration process finishes.

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#### Cautions:

- IP address of the cutter must be the same segment as that of the local router and PC, otherwise data transmission may fail.
- The introduction of this part is a just basic information for operation. Please refer to details of JWCS Help offered separately.

### Warning:

• Please choose the right machine mode as what you purchased, otherwise may occur unexpected equipment damages and personal injuries!

#### <u>NOTE</u>

-Camera accuracy is 0.3 and cutter accuracy is 0.2

#### 5. Function Setup

#### **Tool Selection:**

The expected shape comes out, After Duplo USA defined the color of the sample of SP1, SP2,

e.g. SP1 as the knife to output the rectangular. SP2 as the knife1 to output the circle.

File	Edi	t V	iew	Tool	5 N	Iodify	Ор	erate	RC	Dua	l-Head	Lay	out	Spec	ial	Sett	ing	Help( <u>H</u> )
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offset

Example:



Warning;

• Existed parameters of offsets are factory defaults, which is required to be followed strictly, otherwise there would occur equipment damages and unexpected risks.

Example of gradient coefficient adjustment

If the actual cut output is like what shows below as process a square:



Select "<u>SETUP</u>" on the main page and enter "<u>ADVANCE</u>", then optimize the cut output by adjust gradient coefficient.

• *	<b>2</b> 2	
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Y Breadth decrement:	0 Factory Reset	
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Warnings:

- Existed parameters of offsets are factory defaults, which is required to be followed strictly, otherwise there would occur equipment damages and unexpected risks.
- All parameters existed on the page after Enter the password are factory defaults.
   Please do not alter them except under the guide of suppliers. Otherwise, may occur unexpected equipment damages or personal injuries!
- Gradient coefficient is up to +/- 2.5 degrees, uncontrolled shrinking of breadth may occur if the coefficient is too large.

#### 6. Q & A of Alarms

Alarm	Solution
The document is outsize Pls press the Crash Reset	<ol> <li>Cut file is over the working size of the cutting table, please select correct machine model on Duplo USA</li> </ol>
	2. Cut file is over valid work area of <b>Duplo USA</b>

	please move the file within the valid work area.
Press Enter To Continue	This is of safety protection. Screen is locked as a given job finishes. Click " <u>ENTER</u> " to resume normal home screen
Note: Please restart the machine!	This is self-detection of the cutter. Solution: cut off the power supply and verify cutting head is ok, restart the system in 20 seconds.
Note: The password has expired,please contact the manufacturer.	Please contact your supplier directly as see this alarm.

#### 7. Maintenance

This cutter is a precise electromechanical product. Good maintenance is required for both machinery part and electrical part. Please follow below for maintenance:

ltem	Description		Frequ	lency	
nom		1 time/day	1 time/month	1 time/quarter	1 time/year
1	Media underlay/felt	Clean	Clean	Clean	replace
2	Circuit Box	/	Clean	Dedusting	Overhaul
3	Air compressor	Draining	Clean	/	/
4	Compressed air pressure meter	Draining	Clean	/	/
5	Rails	/	Dedusting	/	/
6	Transmission parts	/	/	Fastening	Overhaul
7	Cutter as a whole	Clean	/	Overhaul	Professional overhaul
8	PC	Clean	Kill virus	/	/

#### 8. Specification

Model	DocuCutter DPC-400
HMI	EN touch screen
Max. Speed	800mm/s

Max. cutting thickness	≤400gsm {0.42mm varies from different media )
Media	Folding carton, Sticker, art paper, plastic film
Repeat Precision	≤0.1mm
Catch	4G & 512MB
File Forma	HP-GL compliant
Data Interface	Ethernet
Transmission	Linear rail
Vacum Pump Power	1.5KW/50HZ
Power Supply	220V±10%/50/60HZ

# Warranty

1. One year warranty except consumables , full-life time maintenance for hardware of the equipment.

Consumables list :Synchronous Belt、 tools、 Blades、 conveyor mat、 Paper Sucker.

- 2. As warranty expires, charges of on-site service and parts would be required. Annually service is available.
- 3. Please contact our service team for on-line remote service, if necessary.
- 4. JINGWEI SYSTECHINIK LTD reserves the right of final explanation.

Reference Jwei warranty policy

**Product Name:** 

**Product model:** 

Series Number:

Purcahse date: