

DocuCutter DPC-400

Digital Die Cutter

Operation Manual



Revision: 111519AP

CONTENTS

| | |
|---|-------|
| 1. User Notes | 3-6 |
| 2. Frame and Parts | 7 |
| 2-1 List of Parts (1) | 7 |
| 2-2 CUTTER FRAME- | 8 |
| 2-3 CUTTER FRAME- | 8 |
| 2-4 CUTTER FRAME- | 8 |
| 2-5 Sheets Pre-load Platform | 9 |
| 3. Operation guide | 9 |
| 3-1 Installation | 10 |
| 3-2 Cutting Tools Installation | 12 |
| 3-3 Turn on/off | 13 |
| 3-4 Cut Depth and Tools Selection Setting | 14 |
| 3-5 Offset for Creasing Wheel Tool | 15 |
| 3-6 Data Transmission Settings | 16 |
| 3-7 Camera Settings | 17-18 |
| 4. SOFTWARE | 19-22 |
| 4-1 Software Installation | 19 |
| 4-2 Print Setup | 20-21 |
| 4-3 Print Files | 22-24 |
| 4-4 Camera Registration | 25-26 |
| 5. Function Setup | 27-33 |
| Cutter reset interface | 27 |
| 5-1 TEST | 27 |
| 5-2 Setup | 28-32 |

| | |
|--------------------|----|
| 5-3 Suction | 33 |
| 5-4 Reset | 33 |
| 5-5 Enter | 33 |
| 5-6 Communication | 33 |
| 6. Q & A of Alarms | 34 |
| 7. Maintenance | 35 |
| 8. Specification | 36 |
| Warranty | 37 |

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 |
|---|--|
| 1. Read and understand this manual before attempting to operate or service the machine. | 1. Do not attempt to operate or service the machine without reading and understanding this manual. |
| 2. Be familiar with the machine safety rules and practices. | 2. Do not remove the safety devices. Including electrical interlocks. |
| 3. In case of an accident while the machine, is running press the emergency stop button to stop the machine. | 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. |
| 6. Verify that all guards are installed before operating the machine. | 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

2.1What 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 |
|  | Be careful of rollers and keep your hands away. |
|  | CAUTION Be careful of UV light. Do not look directly into the beam or view directly with any optical instruments. |
|  | 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 |

2.3 Name Plate

Duplo USA Corporation
3050.Daimler Street
Santa Ana,CA 92705 USA
Product: Paper Cutter
Model:DocuCutter 400I
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.

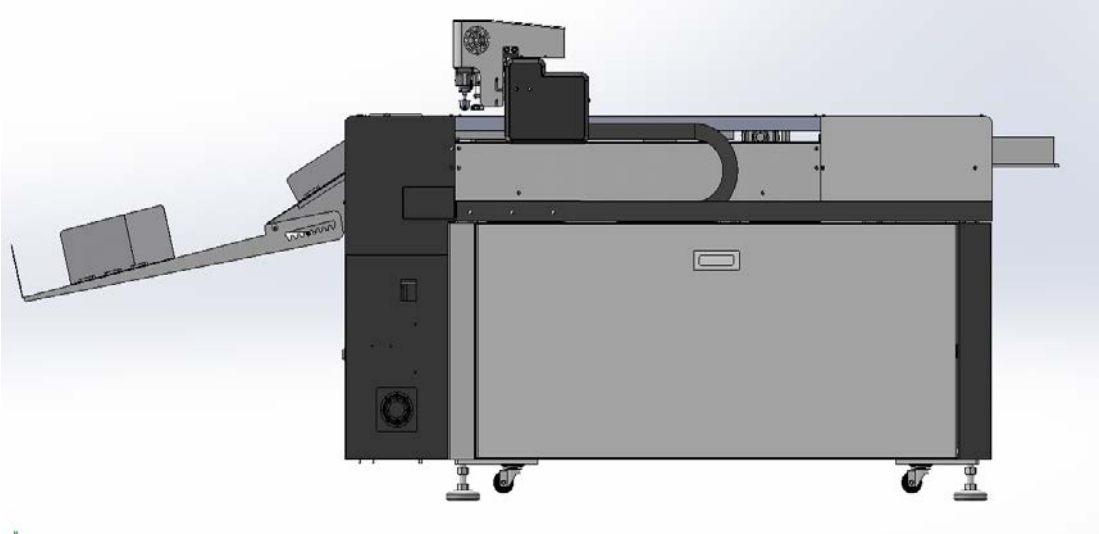
2. Frame and Parts

2-1 List of Parts (1)

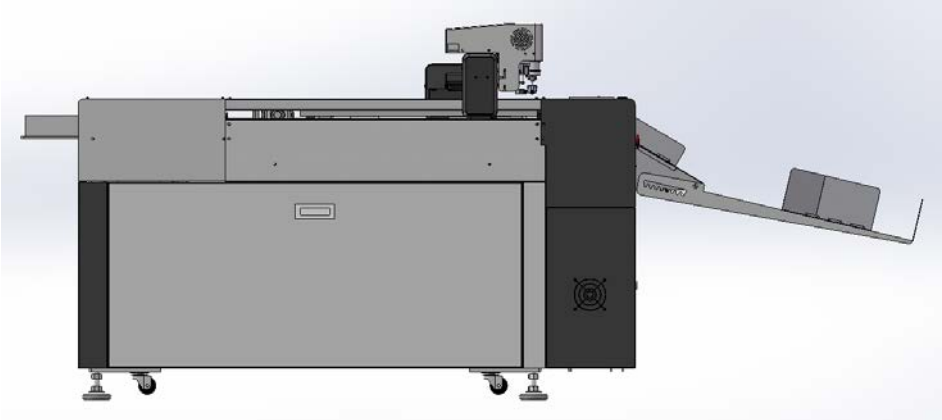
| Name | Photo | Qty' | Name | Photo | Qty' |
|----------------------|---|------|--------------------|---|--------|
| Ethernet cable |  | 10m | Grounding cable |  | 1 |
| Creasing wheel |  | 1 | Power supply cable |  | 3m |
| Straight screwdriver |  | 1 | Dongle |  | 1 |
| Picture knife |  | 1 | screw |  | dozens |
| Allen wrench |  | 1 | Pipe clamp |  | 5 |

- **Caution:**
- 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.**

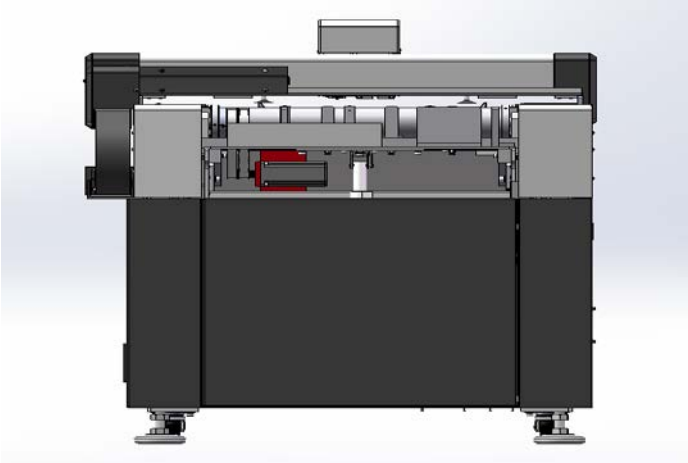
2-2 CUTTER FRAME-



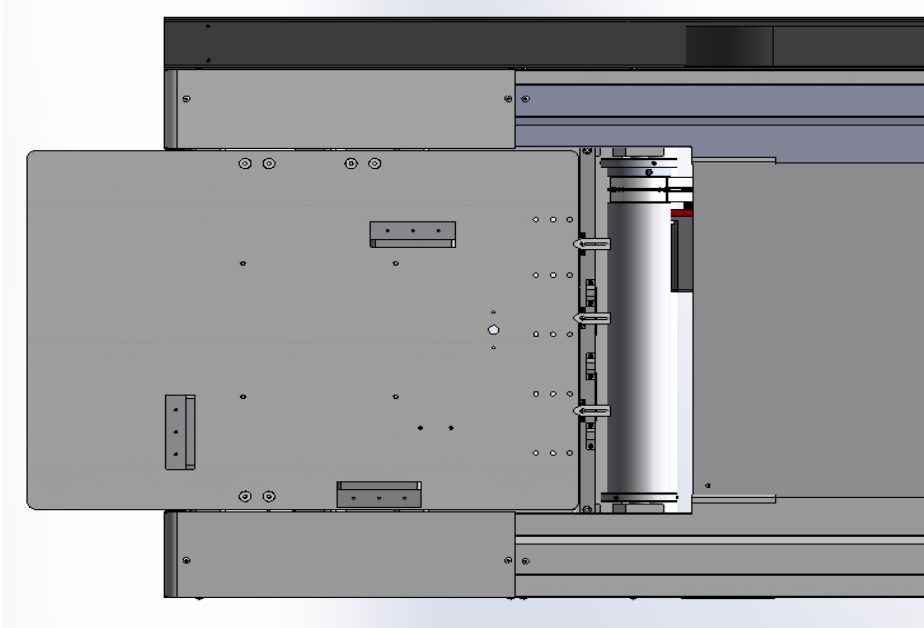
2-3 CUTTER FRAME



2-4 CUTTER FRAME-



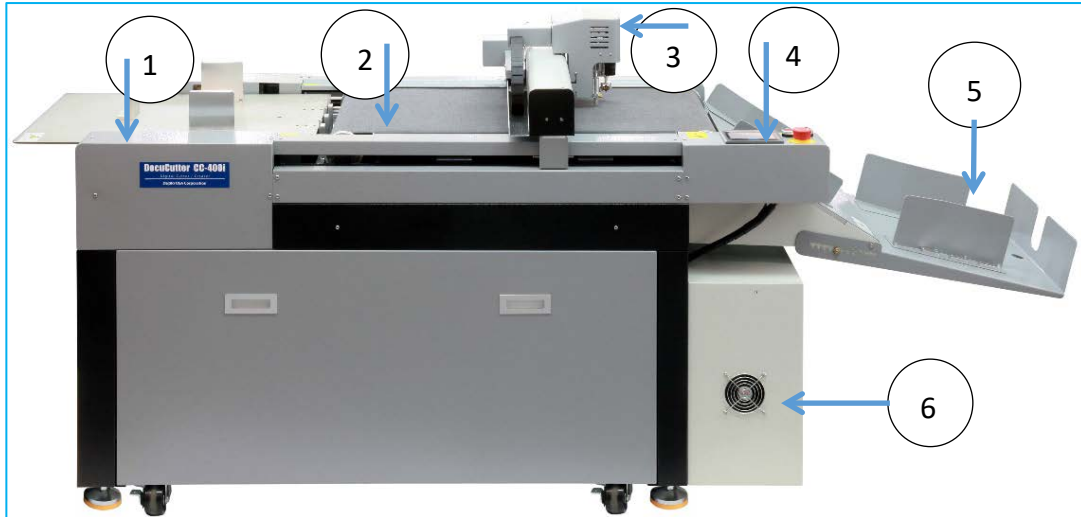
2-5 Sheets Pre-load Platform



3. Operation guide

3-1 Installation

Key Components



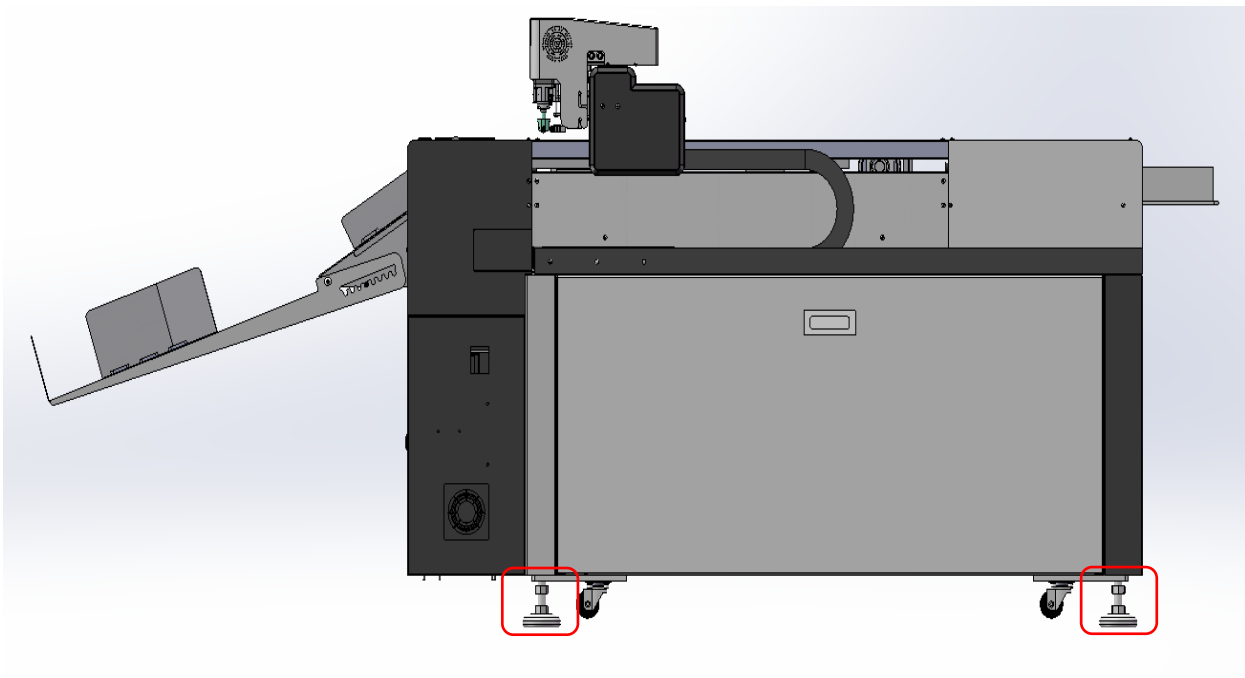
1. Feeder
2. Conveyor Belt
3. Cutting Head
4. Control Panel
5. Stacking Tray
6. Electric box

❶ Installation Requirement

- 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°C.
- d. Compressed air supply: 4-8kg/cm², no less than 1.5HP.

❷ Placement

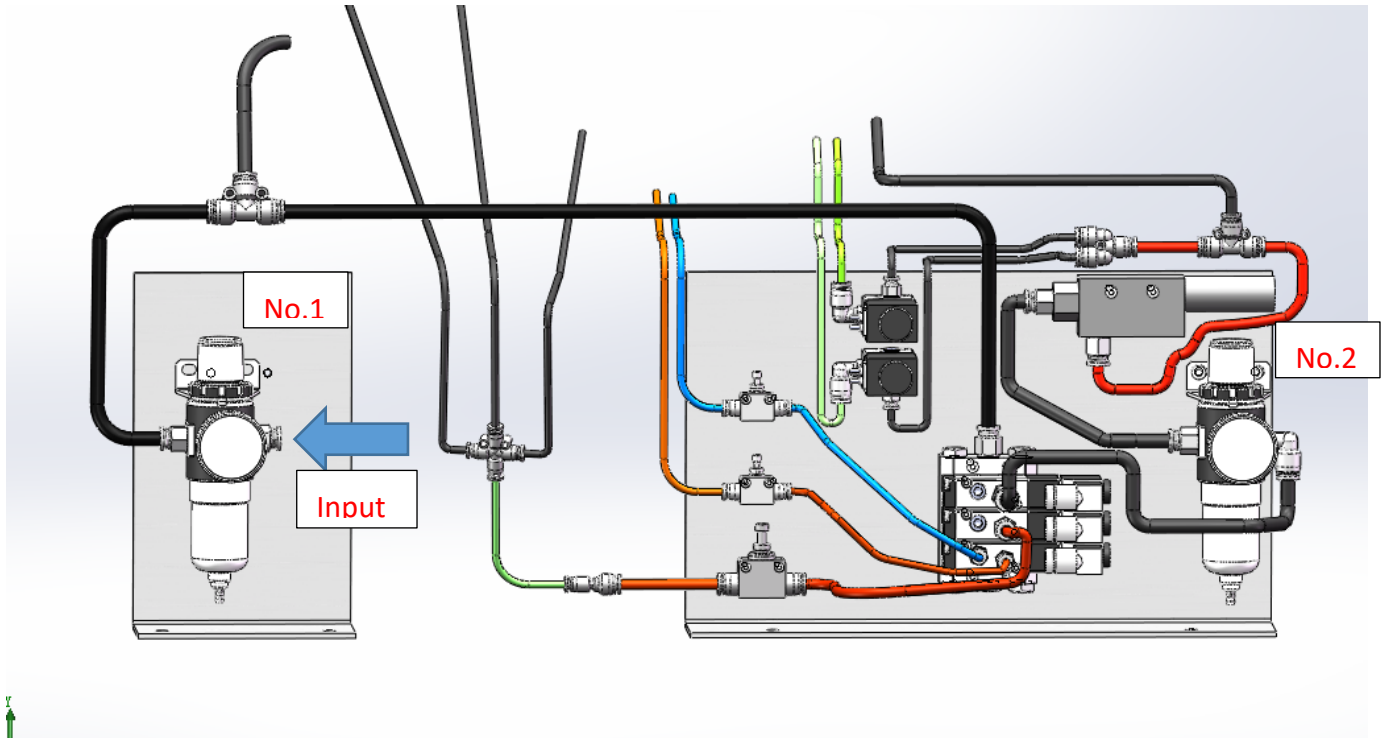
- a. Extend feet of the cutter (to the height that higher than the wheels) with adjustable wrench after place the cutter in position



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

Compressed 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.



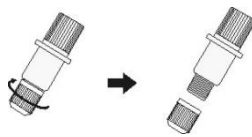
3-2 Cutting Tools Installation

Select the type of tool you need.

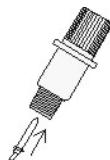
| Tool Name | J201 | J202 | J205 | J206 | J208 |
|-----------------------|------------|------------|---------|----------|-----------------------------|
| Paper Type | Paper/Card | Paper/Card | Card | Stickers | Sticker |
| Paper Thickness (gsm) | 120-300gsm | 150-400gsm | 400-1kg | | Sticker or less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

① Blade Installation Procedures

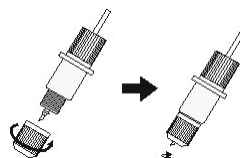
a. Unscrew the cap of the blade holder:



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:

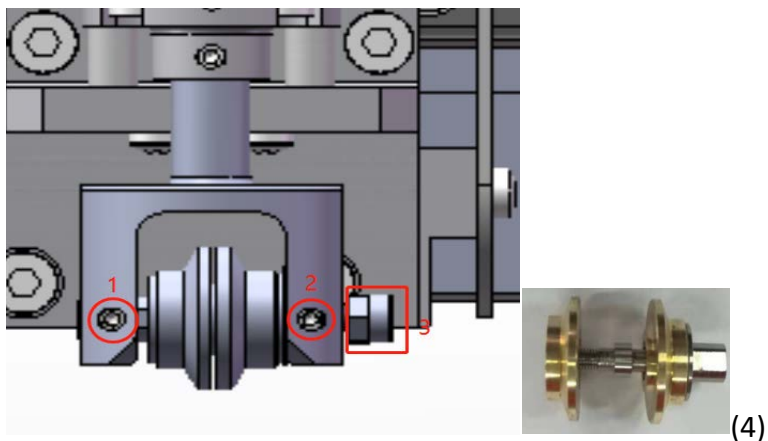


d. Put the holder to the cutting head of the cutter. Make sure the holder is put in position. Fasten the holder by a flat screwdriver

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. loosen 1&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

① 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:



③ Click [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.








④ 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



| | |
|---|---|
|  | To enter the TEST menu |
|  | To enter the Setup menu |
|  | To turn the pump ON or OFF |
|  | To reset the machine to the home position |
|  | To resume the job |

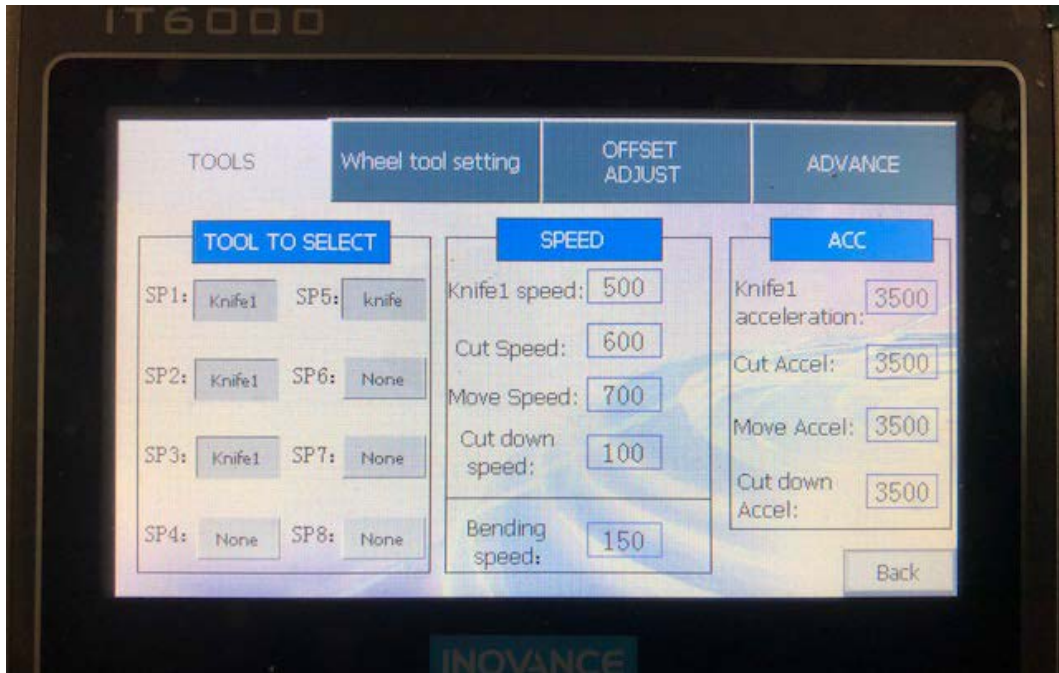
TEST SCREEN



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

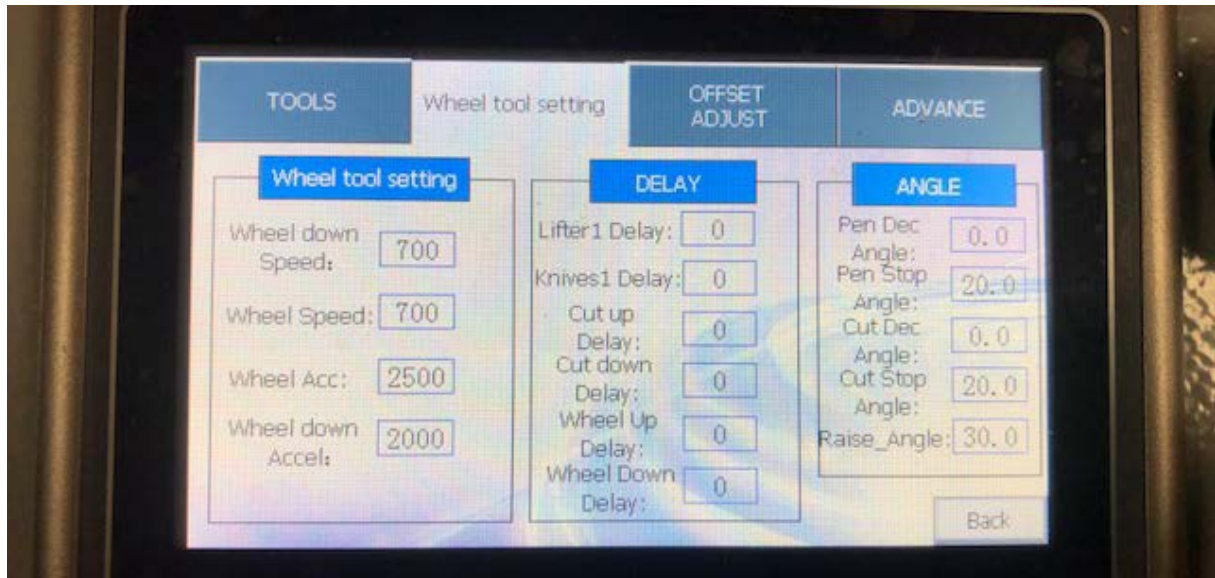
SETUP SCREEN

TOOLS TAB



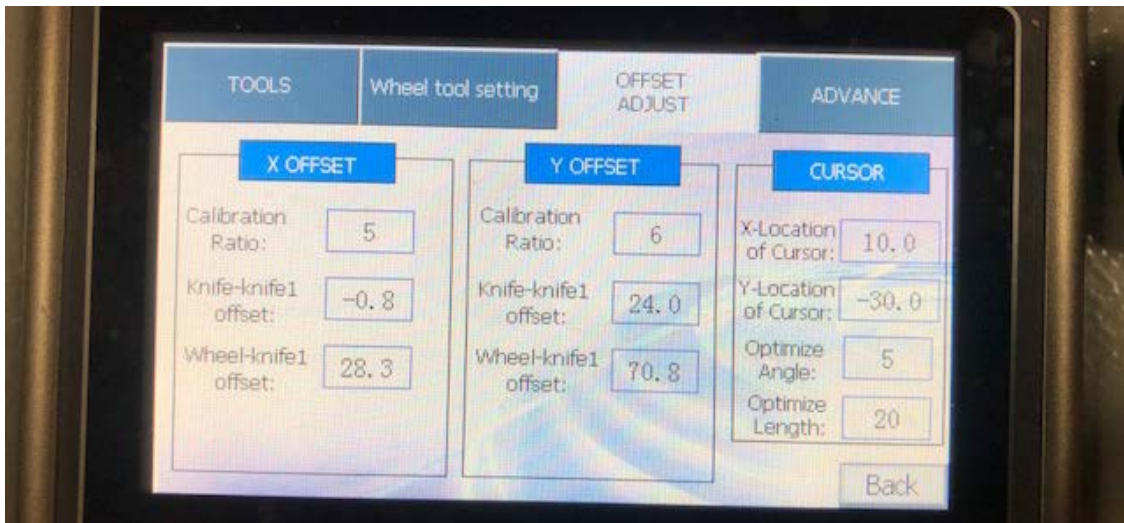
| TOOL SELECT | SPEED | ACC |
|--|--|--|
| SP1 to SP8: Define the tool used - None - Knife - Knife1 - Wheel | Knife1 Speed: Maximum speed it can reach 500 (default) | Knife1 Acc: Acceleration speed of Knife1 3500 (default) |
| | Cut Speed: Maximum speed of Knife tool 600 (default) | Cut Accel: Acceleration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

WHEEL TOOL SETTING



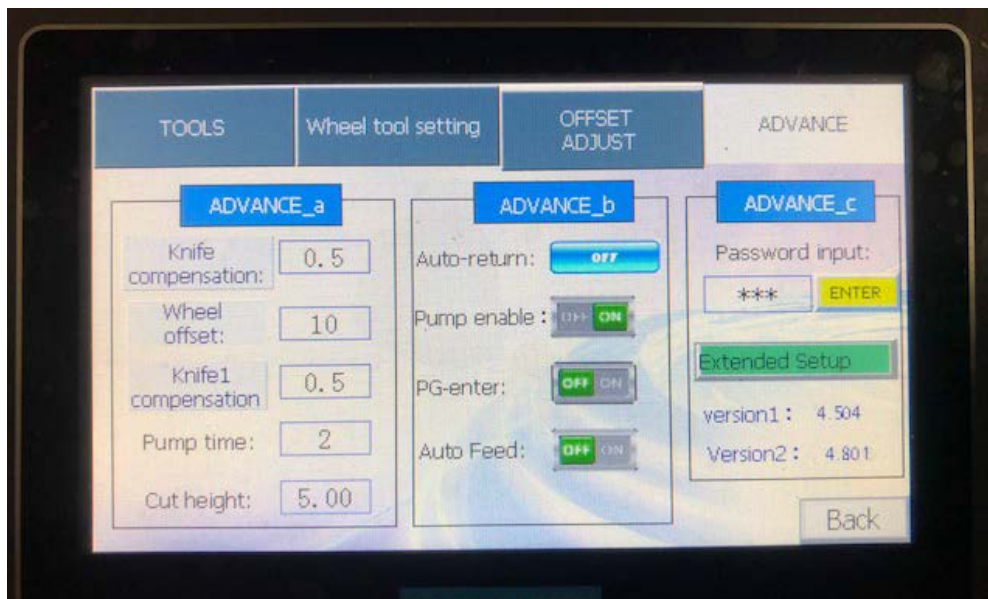
| WHEEL TOOL SETTING | DELAY (Not Used) | ANGLE |
|---|------------------|----------------------|
| Wheel Down Speed: Maximum down speed of wheel 700(default) | Lifter1 Delay: 0 | Pen Dec Angle: 0.0 |
| Wheel Speed: Maximum speed of wheel 700 (default) | Knives1 Delay: 0 | Pen Stop Angle: 20.0 |
| Wheel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

OFFSET ADJUST



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

ADVANCE



| ADVANCE_a | ADVANCE_b | ADVANCE_c |
|--|---|------------------------------|
| <p>Knife Comp: Adjusts the angle of corner cut</p> <ul style="list-style-type: none"> -If the angle is rounded, increase the value -If the angle has point, decrease the value | <p>Auto-return: Head returns to set positions</p> <ul style="list-style-type: none"> Off= stays at its current position after cuts Back= goes to starting position Max= goes to the corner of the document | <p>Password Input: 8888</p> |
| <p>Wheel offset: If wheel isn't making a straight line along the X axis. 10 units is 1°</p> <ul style="list-style-type: none"> -Positive rotates counter clockwise -Negative rotates clockwise | <p>Pump enable: Automatically turns on pump before cutting. If OFF you are required to manually turn ON pump before cutting.</p> | <p>Extended Setup button</p> |
| <p>Knife1 Comp: Adjusts the angle of corner cut</p> <ul style="list-style-type: none"> -If the angle is rounded, increase the value -If the angle has point, decrease the value | <p>PG-enter: OFF (default)</p> | |
| <p>Pump time: delays the time before the cutter starts</p> <p>2 = Default</p> | <p>Auto-Feed: Automatically feeds the next sheet</p> | |
| <p>Cut height: Adjusts the lift up height of the tool</p> <p>5mm= Default</p> | | |

Extended Setup



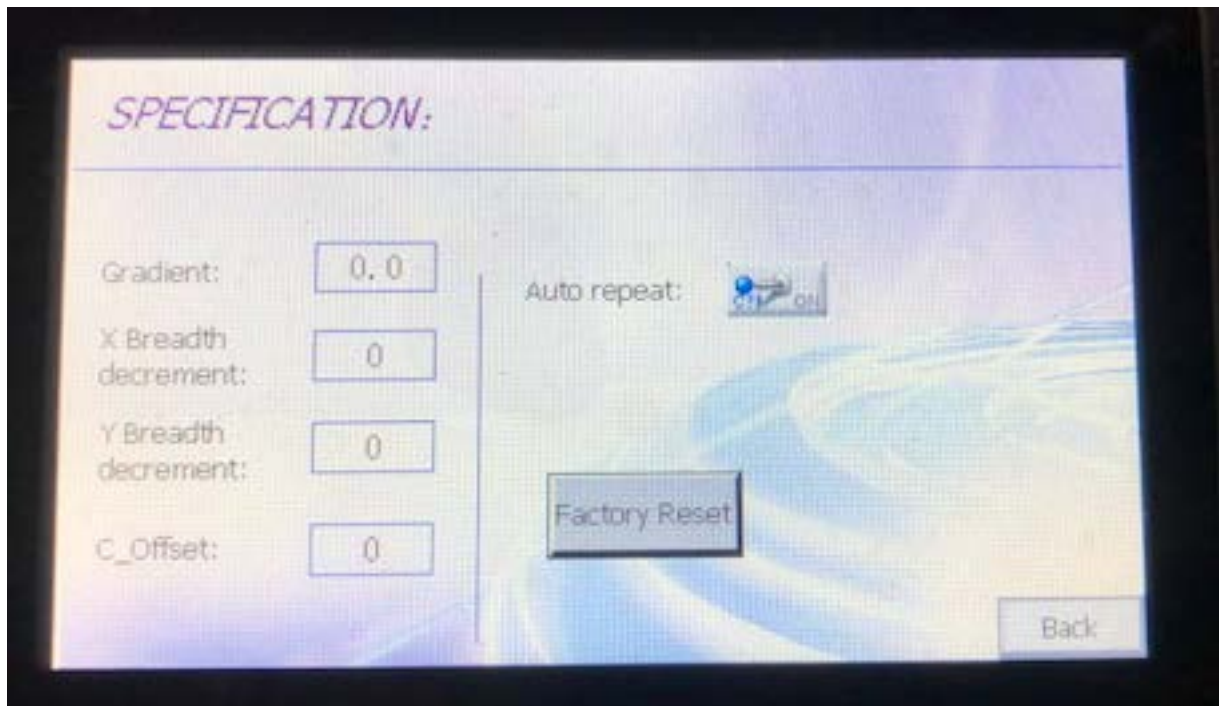
Rolling Repeat: Table repeat previous job

IP: IP address

Material Type: Board (default)

Vacuum Sucker 1&2: ON (default)

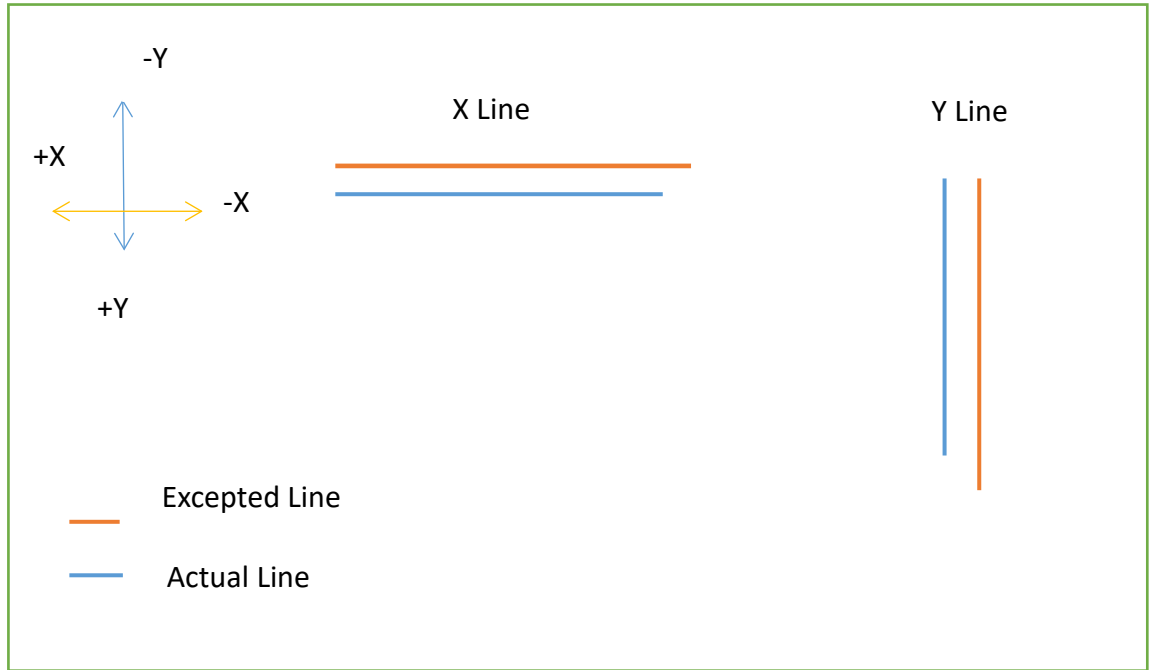
Feed Length: You can adjust the length to accommodate a longer sheet above 600mm.



Auto Repeat: Machine will run the same job continuously

Factory Reset: resets machine

CALIBRATION RATIO

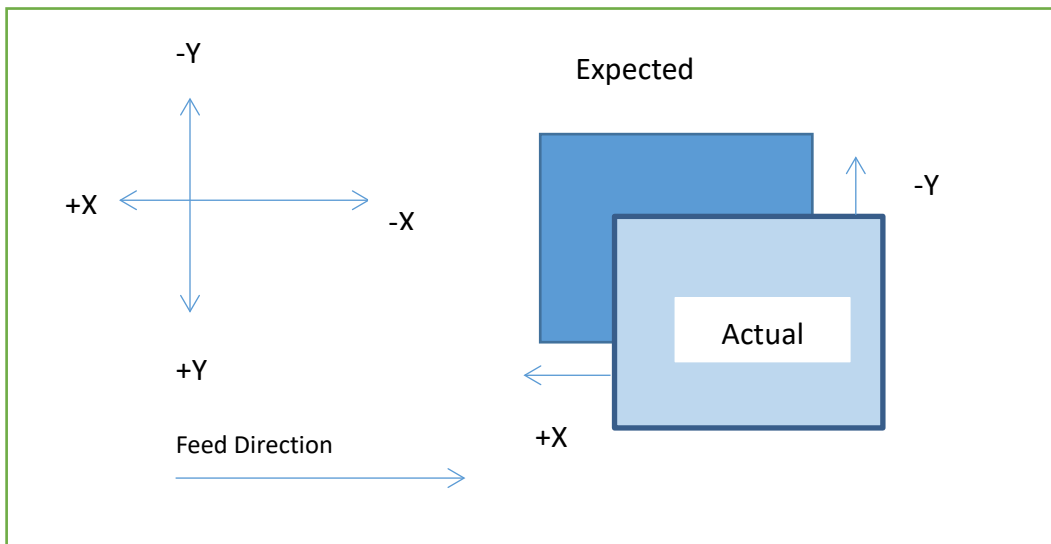


1. Draw a 200mm line on the program and send to the machine.

- 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.

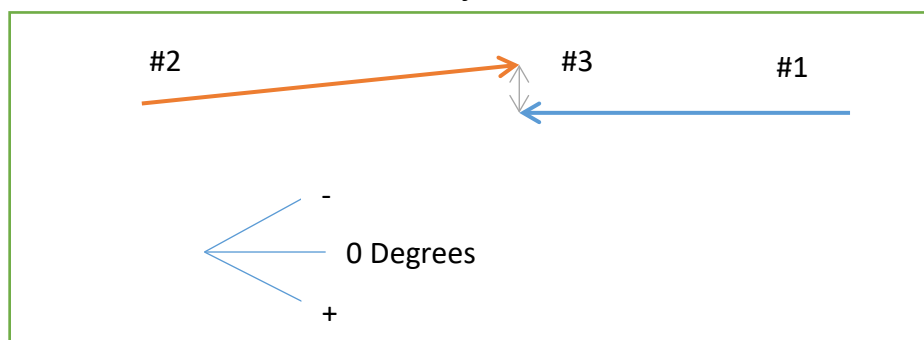
ADVANCE_a CALIBRATION

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



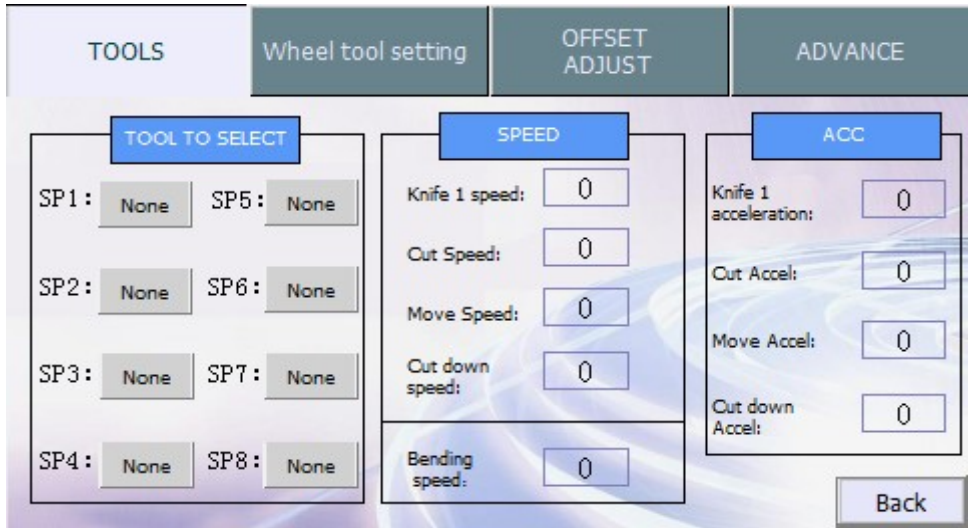
1. Press Wheel Action and make a line #1 by pressing the Left arrow.
2. Press Wheel Action to Lift the tool, press Left Arrow key to move the Head down a few inches.
3. Press Wheel Action to drop the Wheel and press Right Arrow to make Line #2 until it reaches the beginning of line #1.
4. The lines should 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 Decrease value from Wheel Offset.

Note: 10 units is 1 degree.

3-4 Cut Depth and Tools Selection Setting

① Tools Selection

Enter the main page, click “SETUP” button to enter into the menu and click “TOOLS” button, popping up window of tools selection SP1-SP8. Select tools as required.



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

② Cut Depth Setting

Set cut depth after tools are selected. Click “TEST” on main page, popping up window as below:



1. Change values of Knives depth to change cut depth of each tool.
2. Click “PUMP” On.

3. Click “Knife Action” to check knife depth. If the blade tip does not reach to table mat click “knife action” 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 “Next Page” enter into wheel depth adjust page (see picture below), click “wheel↓” button to move down the wheel until it touch mat surface, click “Wheel Origin” button to save the depth and click “Back”.

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.

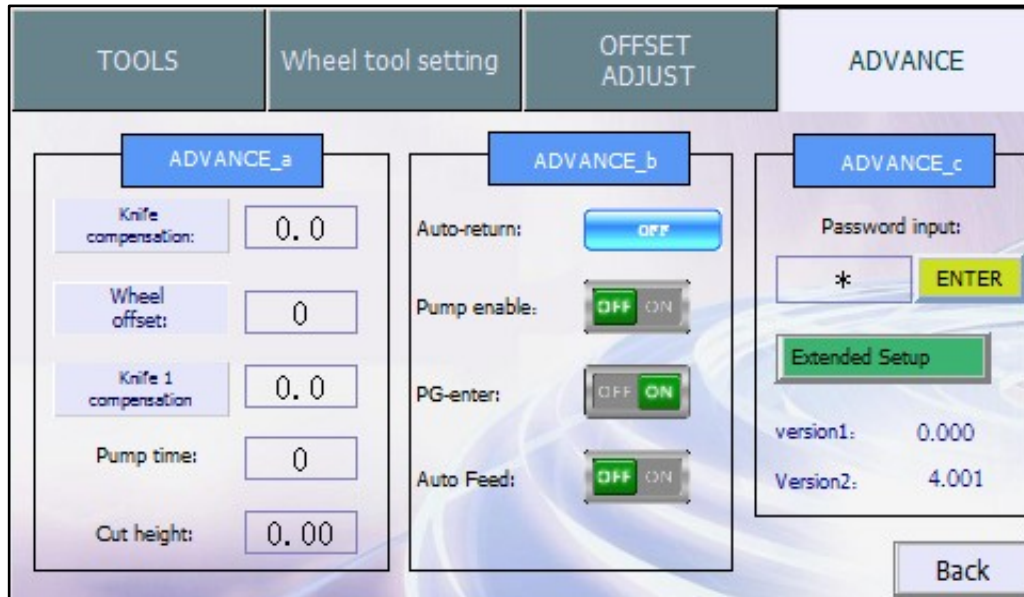
Note: First check knife depth and wheel depth before click buttons of knife action and wheel action. Larger depth settings would damage the mat and even the machine. You must click “Wheel Origin” button after finish value settings of wheel depth, otherwise the settings would become valid.



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 “SETUP” button and then click “ADVANCE” button to enter angle settings. Change deflection angle value by clicking “Wheel offset” button on column “ADVANCE 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 “Back” after setting finishes.and reset machine.

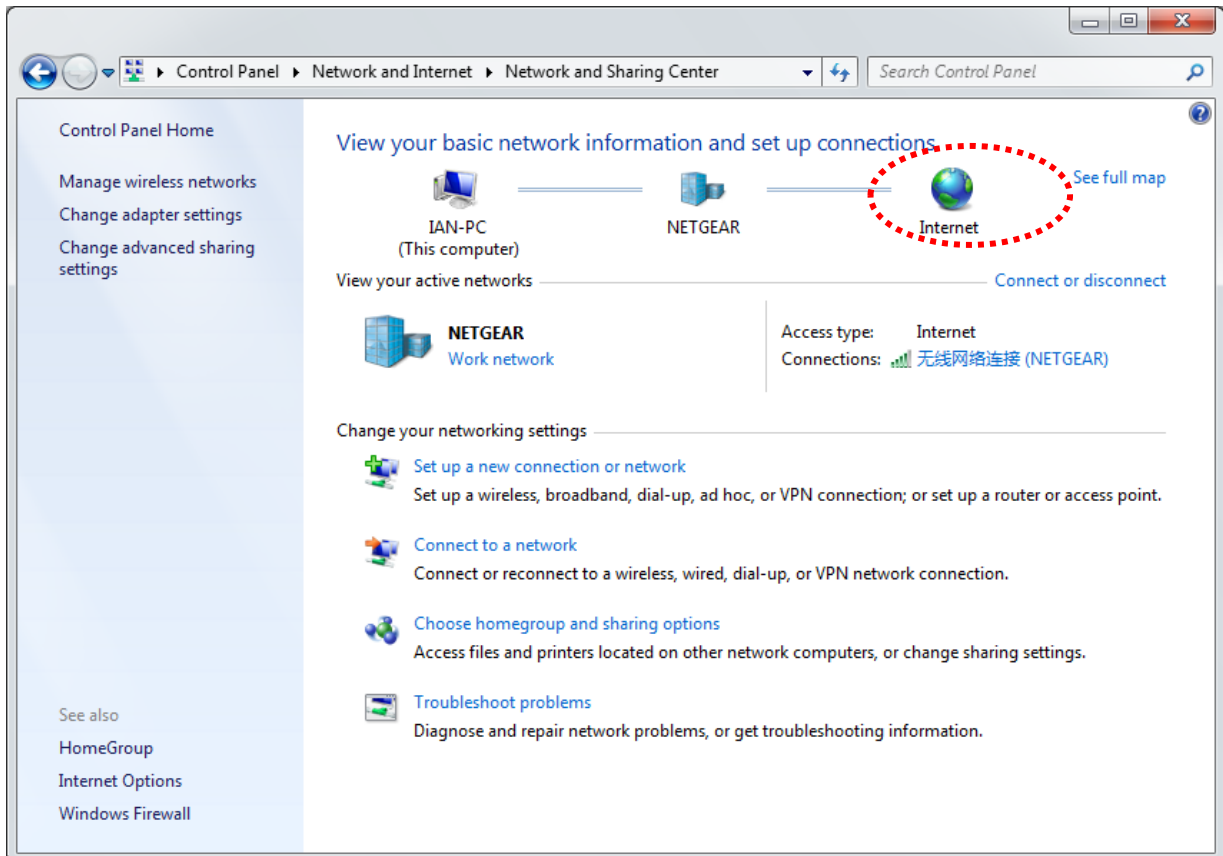


Caution:The diameters must be more than 6mm as using creasing wheel to crease/cut arcs or circles, otherwise creasing wheel or serrated knife tool would be damaged.

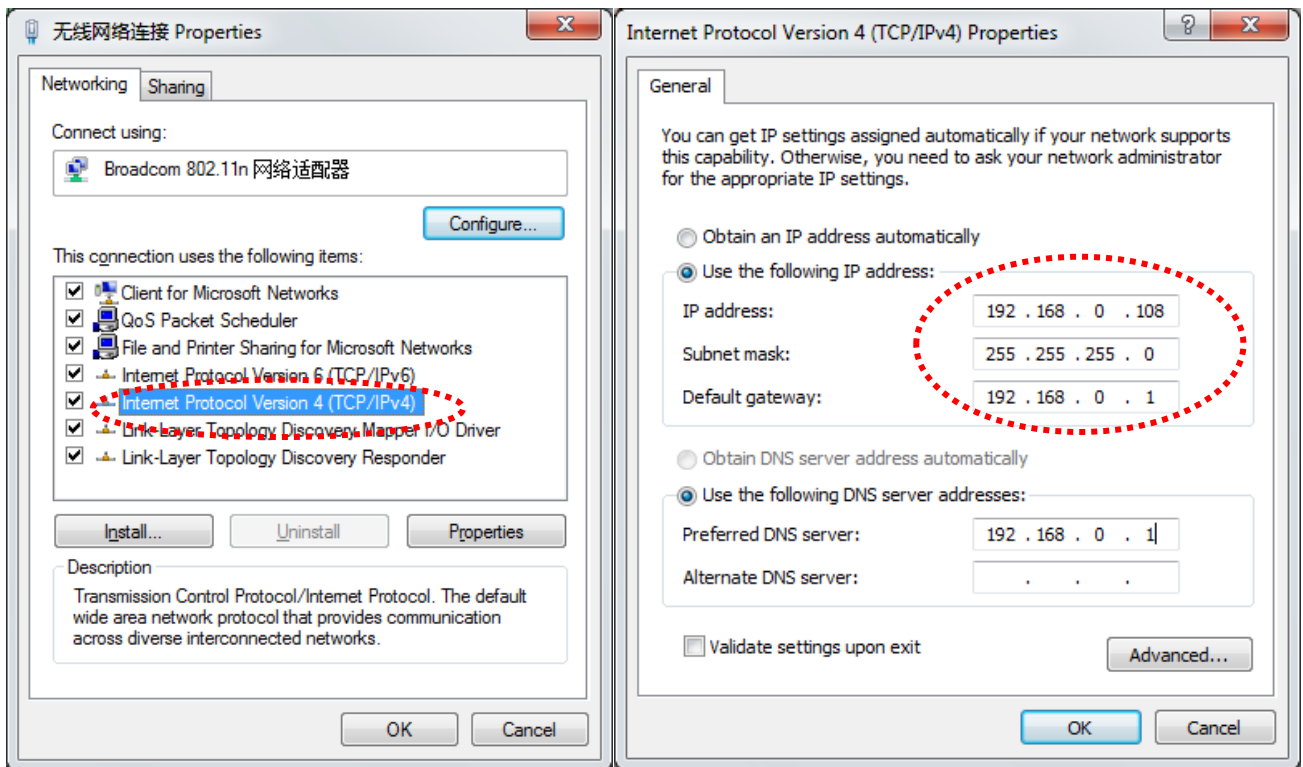
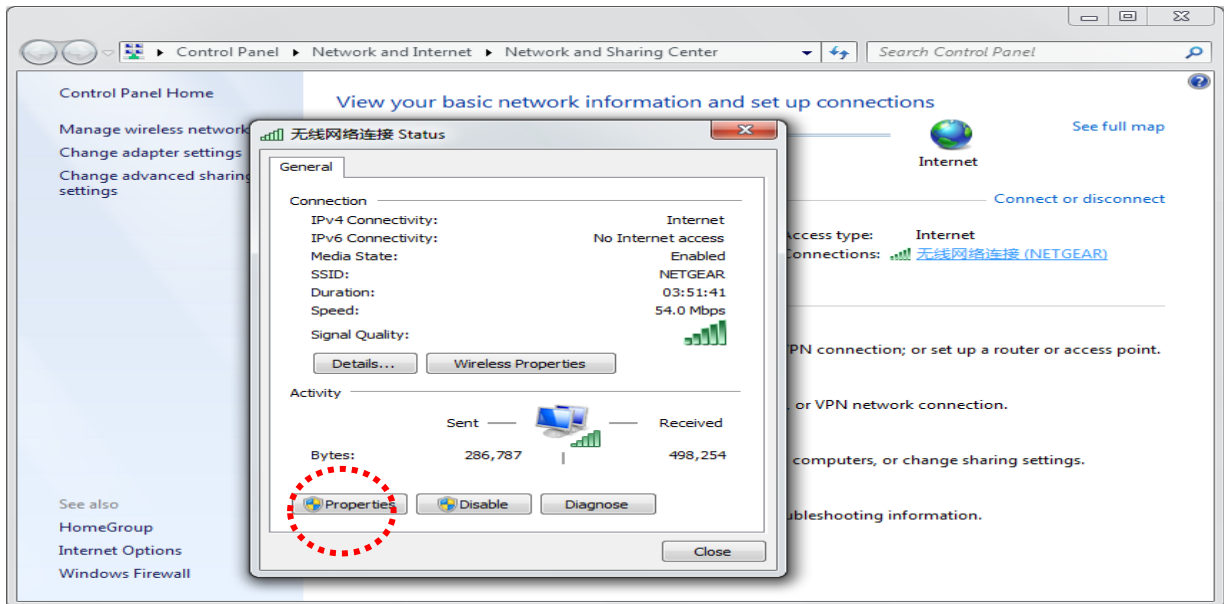
3-6 Data Transmission Settings

① PC Settings

Click “internet” on the desktop, click “Network and Sharing Center” to enter the control panel.



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




② IP SETTING

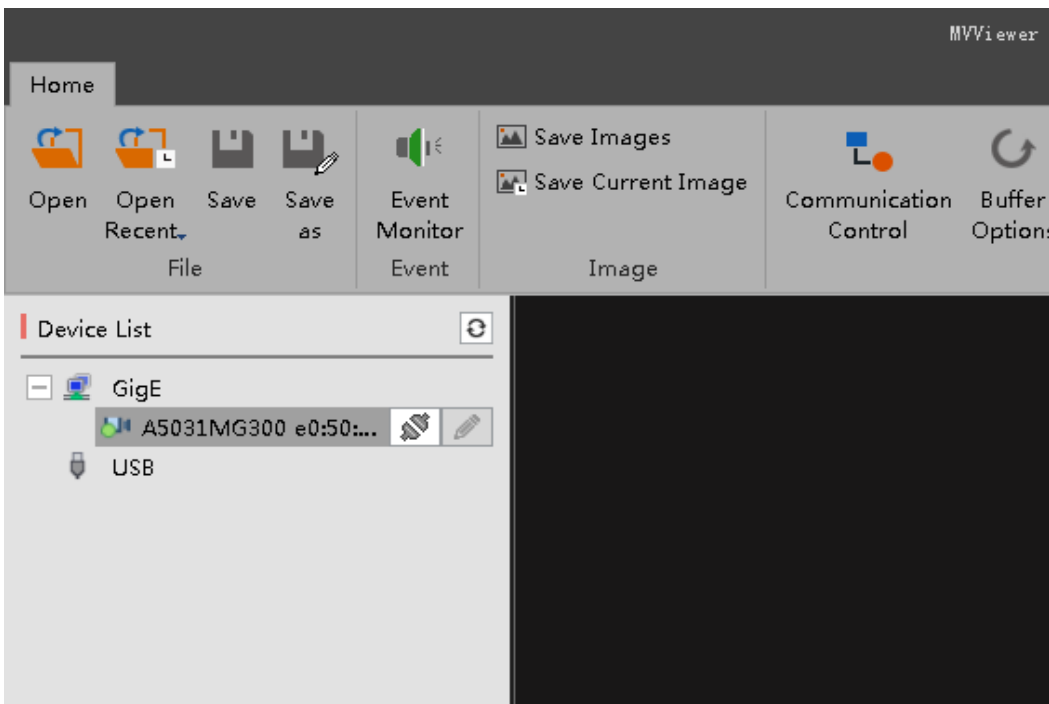
After initializing, click connection on the main menu, IP address setting pops up, IP address set as 192.168.0.250, after finish setting, IP address will be saved automatically (Note: Keep the computer and the cutter on the same segment, otherwise disconnected).

3-7 Camera Settings



Click  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 “edit”.

Setting IP address as 192.168.1.X, IP address of computer as 192.168.1.X+1, same as 3-5, select “local connection2” 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.



Interface Info

| | |
|-----------------|--|
| MAC Address | <input type="text" value="b8:97:5a:c3:1d:cc"/> |
| IP Address | <input type="text" value="192.168.3.100"/> |
| Subnet Mask | <input type="text" value="255.255.255.0"/> |
| Default Gateway | <input type="text" value="0.0.0.0"/> |

Device Info

| | |
|-----------------|--|
| MAC Address | <input type="text" value="e0:50:8b:2e:1f:a6"/> |
| IP Address | <input type="text" value="192.168.3 .100"/> |
| Subnet Mask | <input type="text" value="255.255.255.0"/> |
| Default Gateway | <input type="text" value="0 .0 .0 .0"/> |

Caution:

- IP address of the cutter must be the same segment as that of the local router and PC, otherwise data transmission may fail.
- Restart the cutting system after IP settings is done.

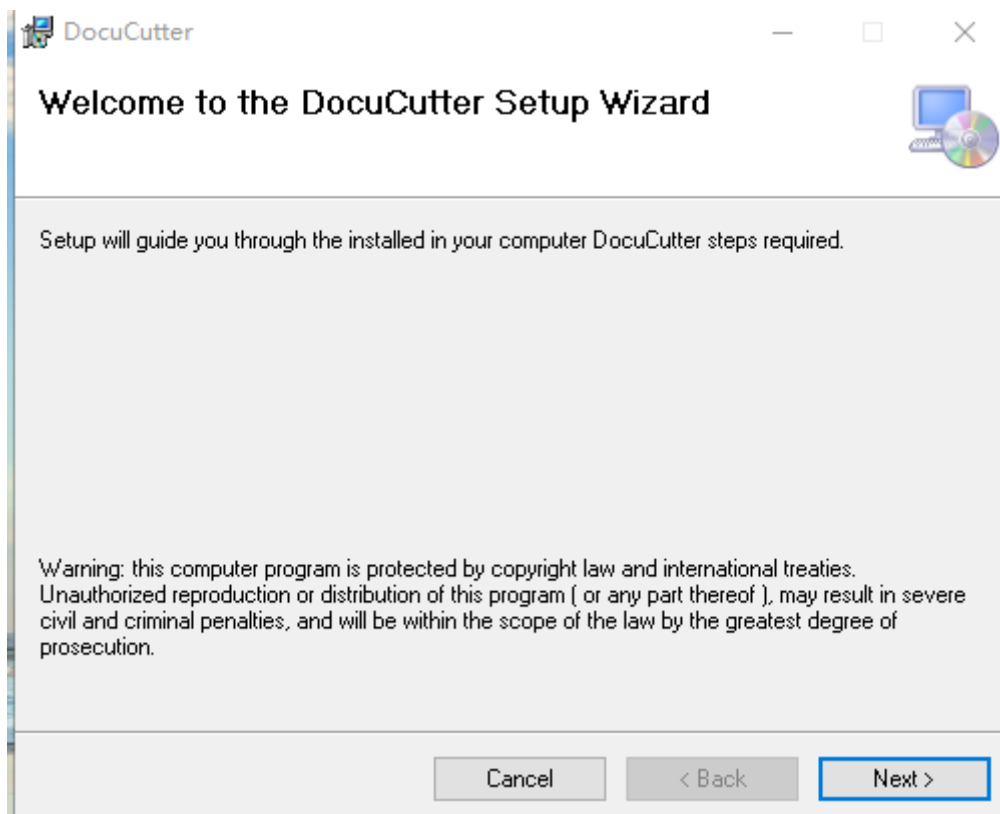
4. SOFTWARE

4-1 Software Installation


① Software Installation

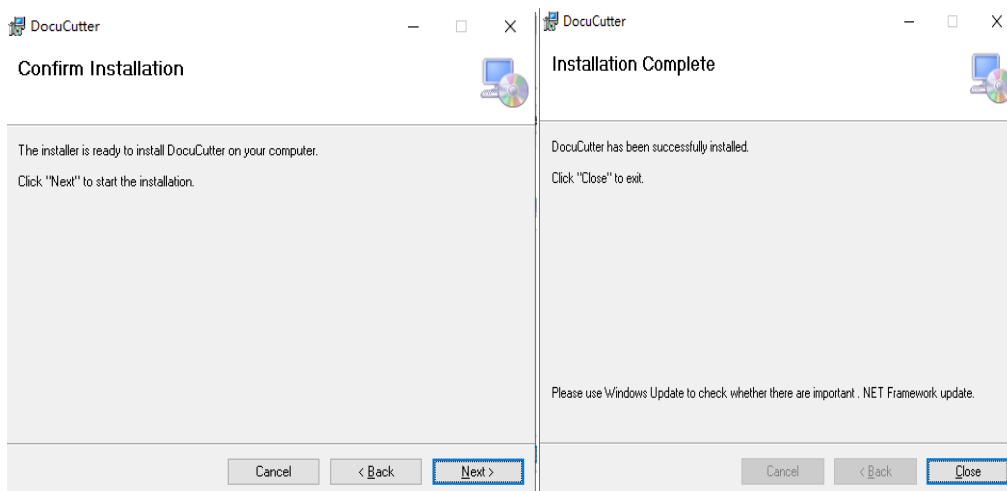
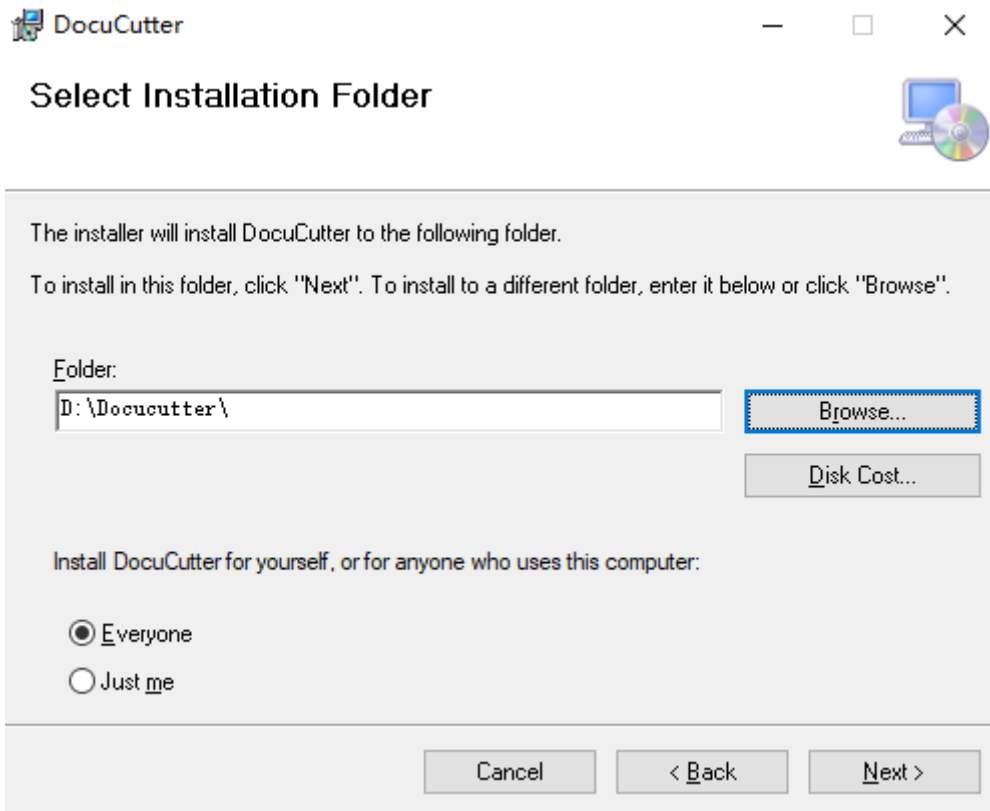
Double click **Duplo USA ******Setup.exe

| 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 |



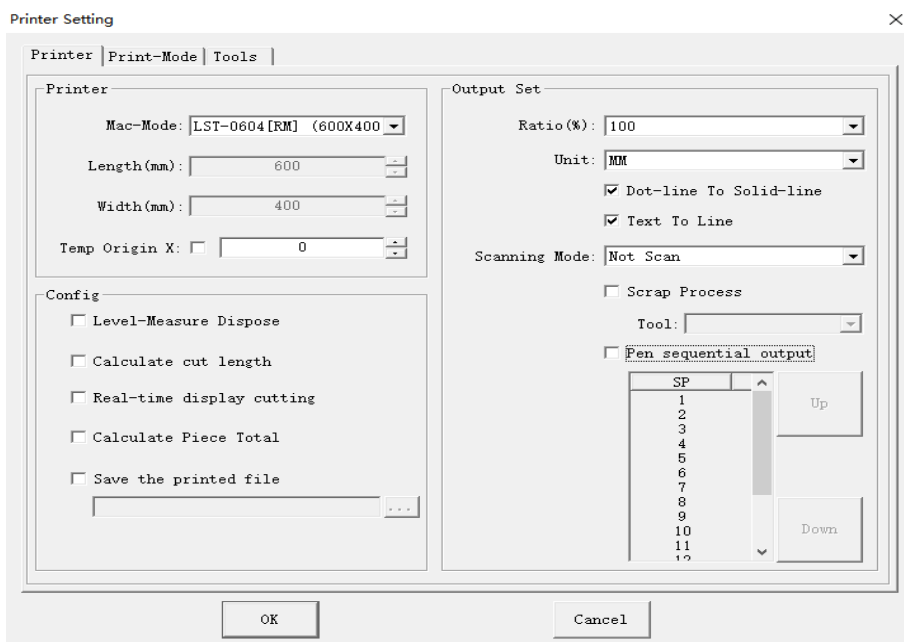
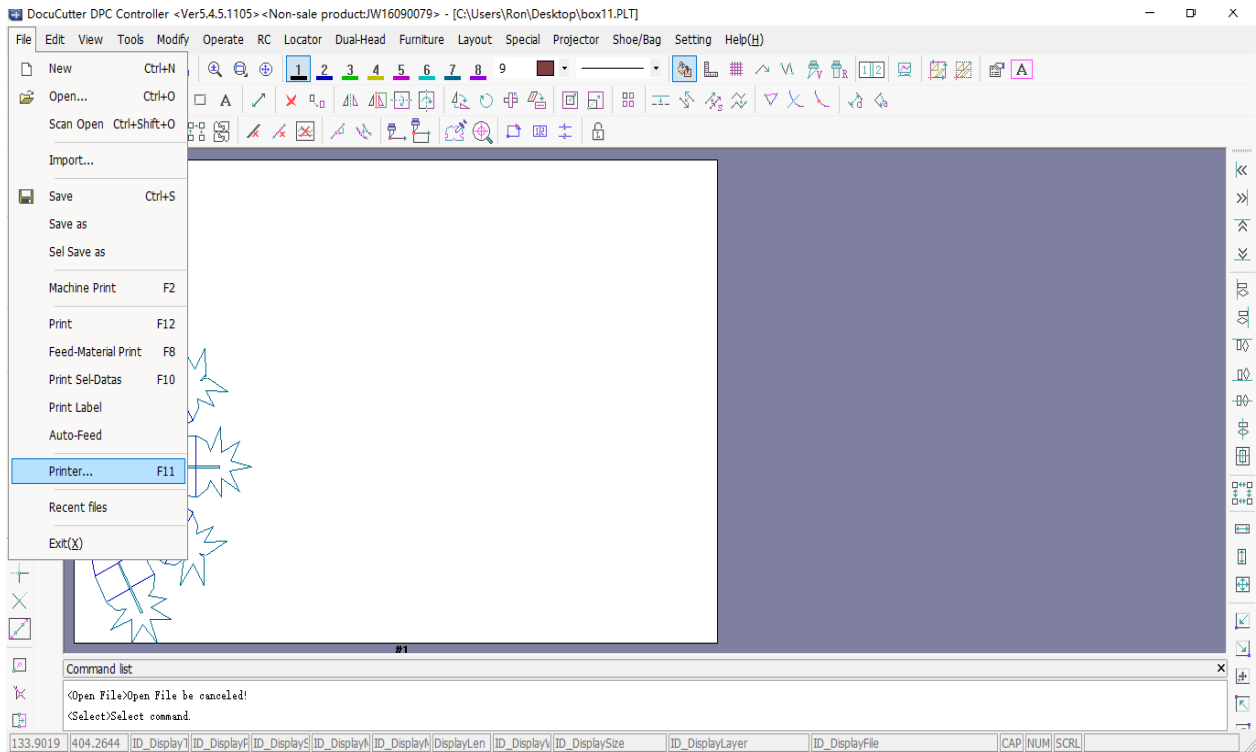
Click “Next” and install the program on non-system disk, click “Next” to continue the

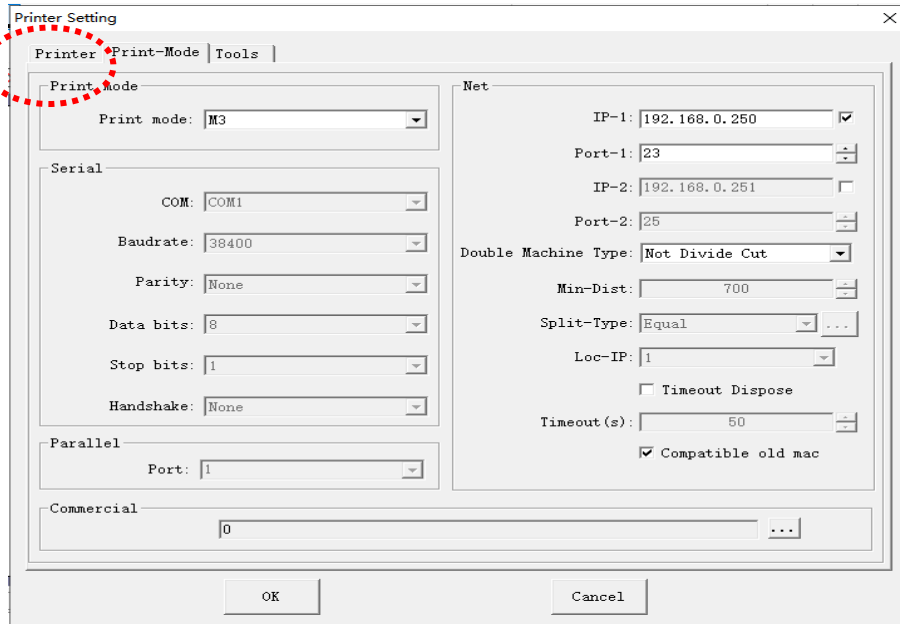
installation of  click “Close” to finish the installation.



4-2 Print Setup

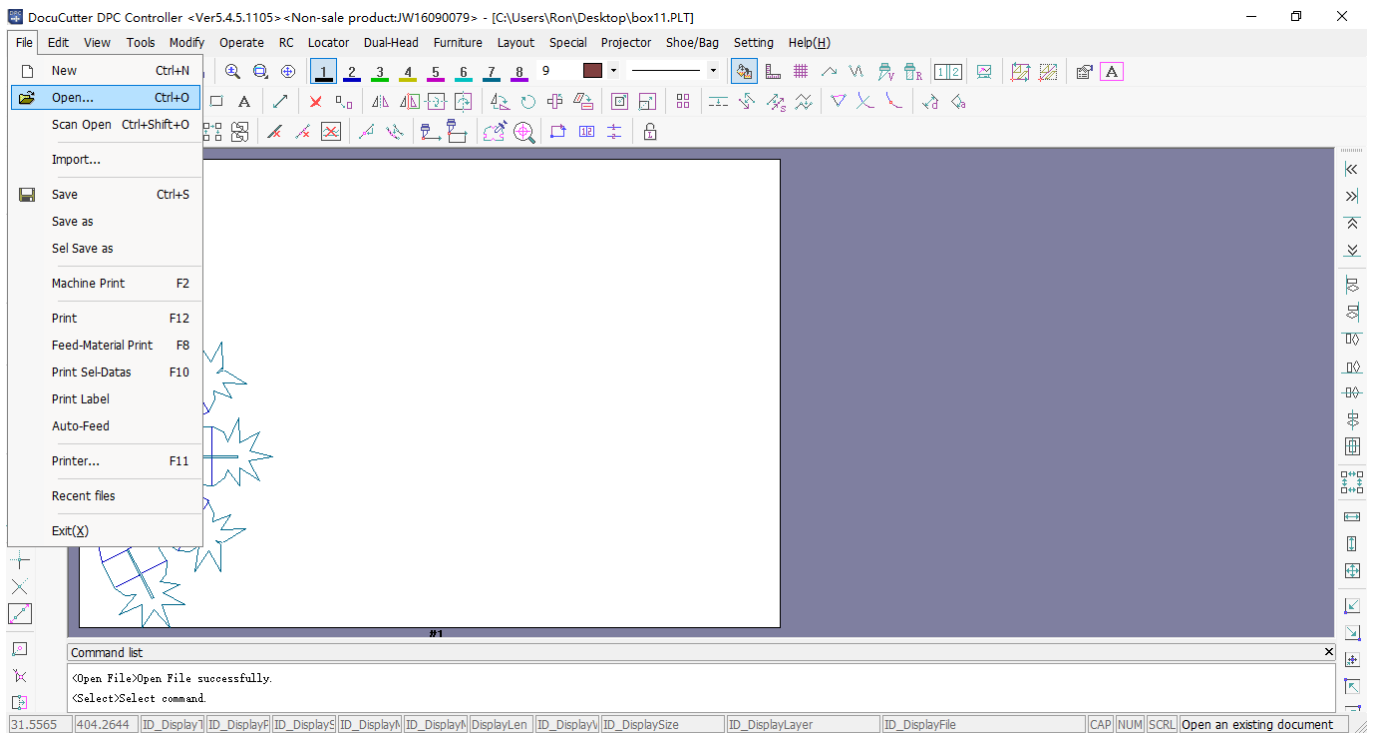
1. Open **Duplo USA**, click "File" menu > "Printer" and set cutter model. LST0604
2. Then click "Print-Mode" and set IP address from the machine.
3. Select "Compatible old mac".

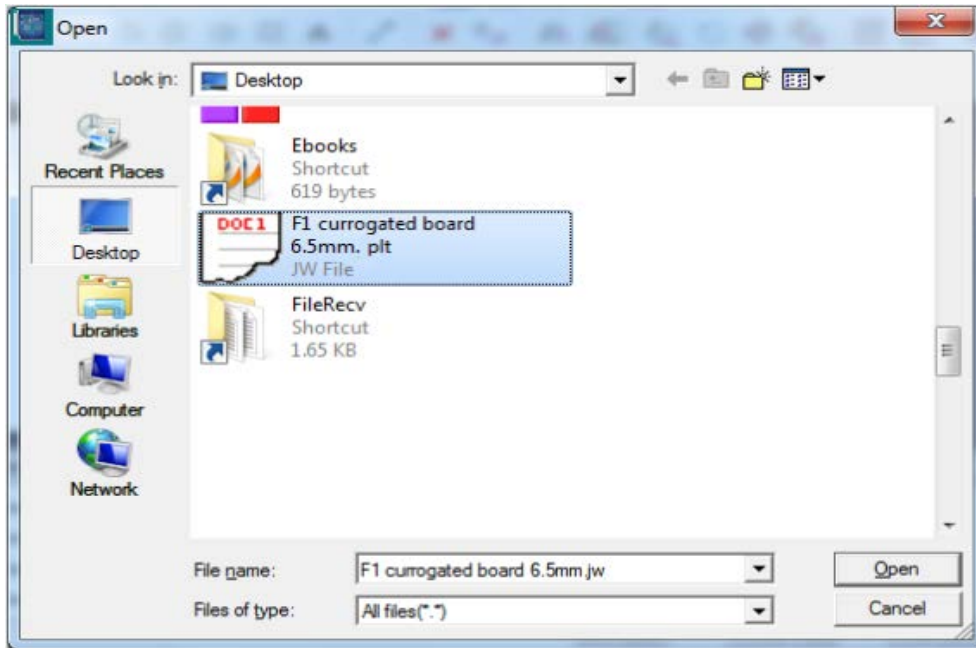




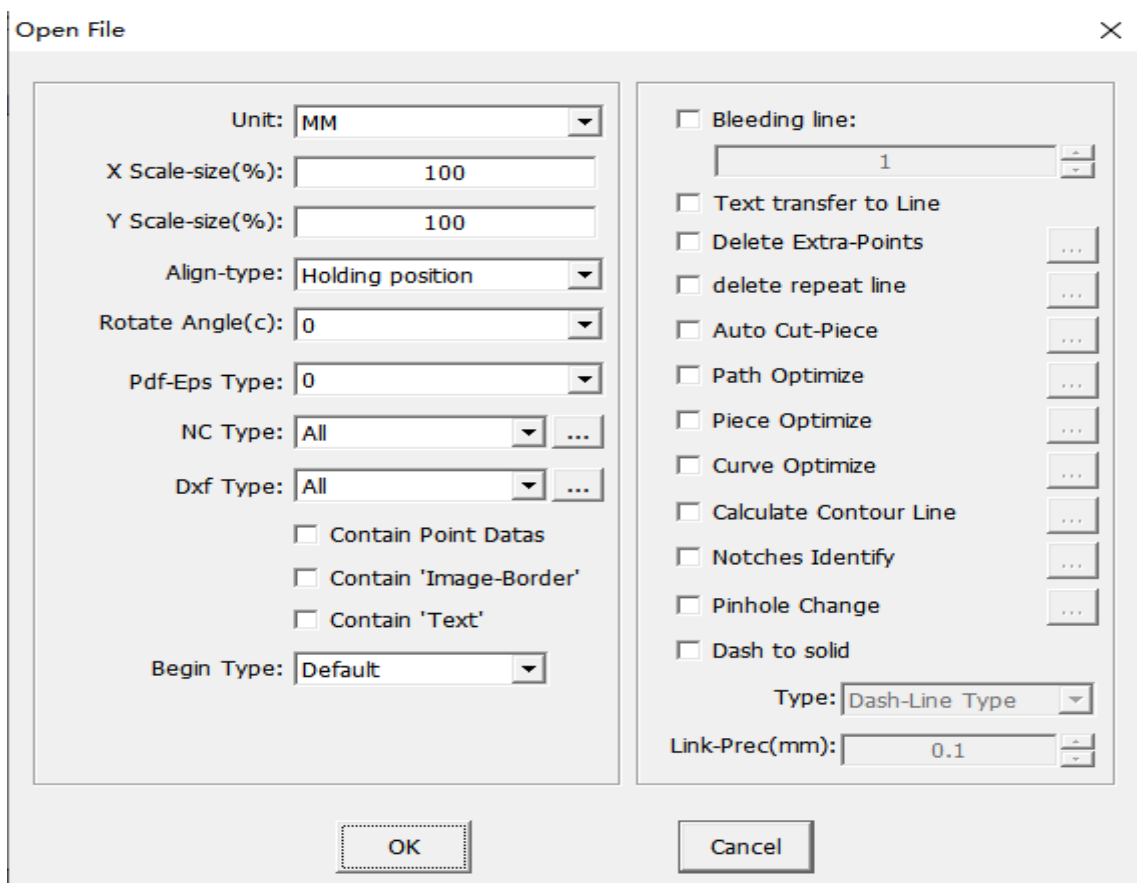
4-3 Print Files

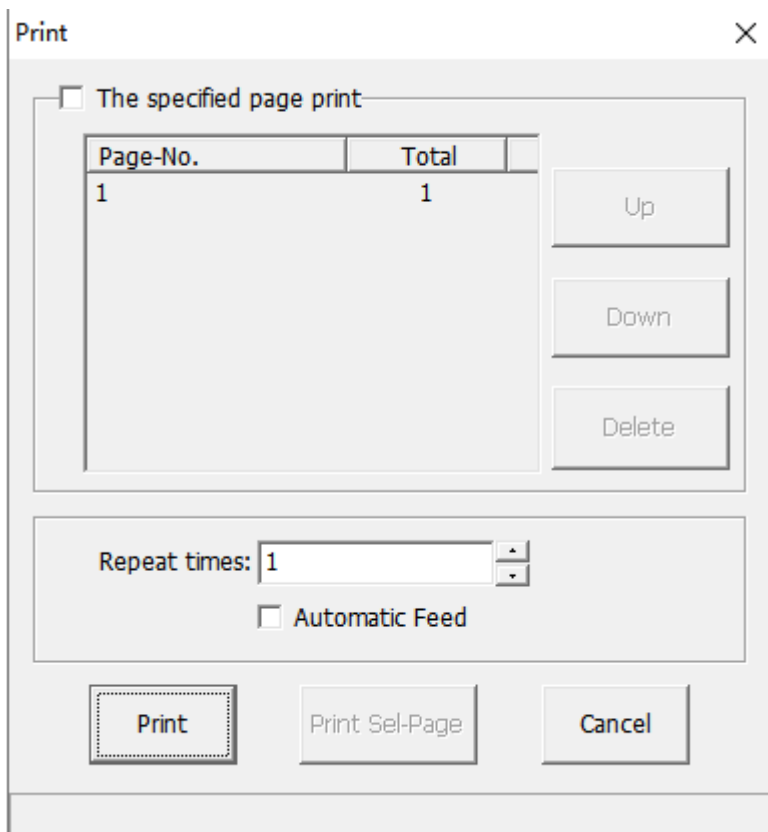
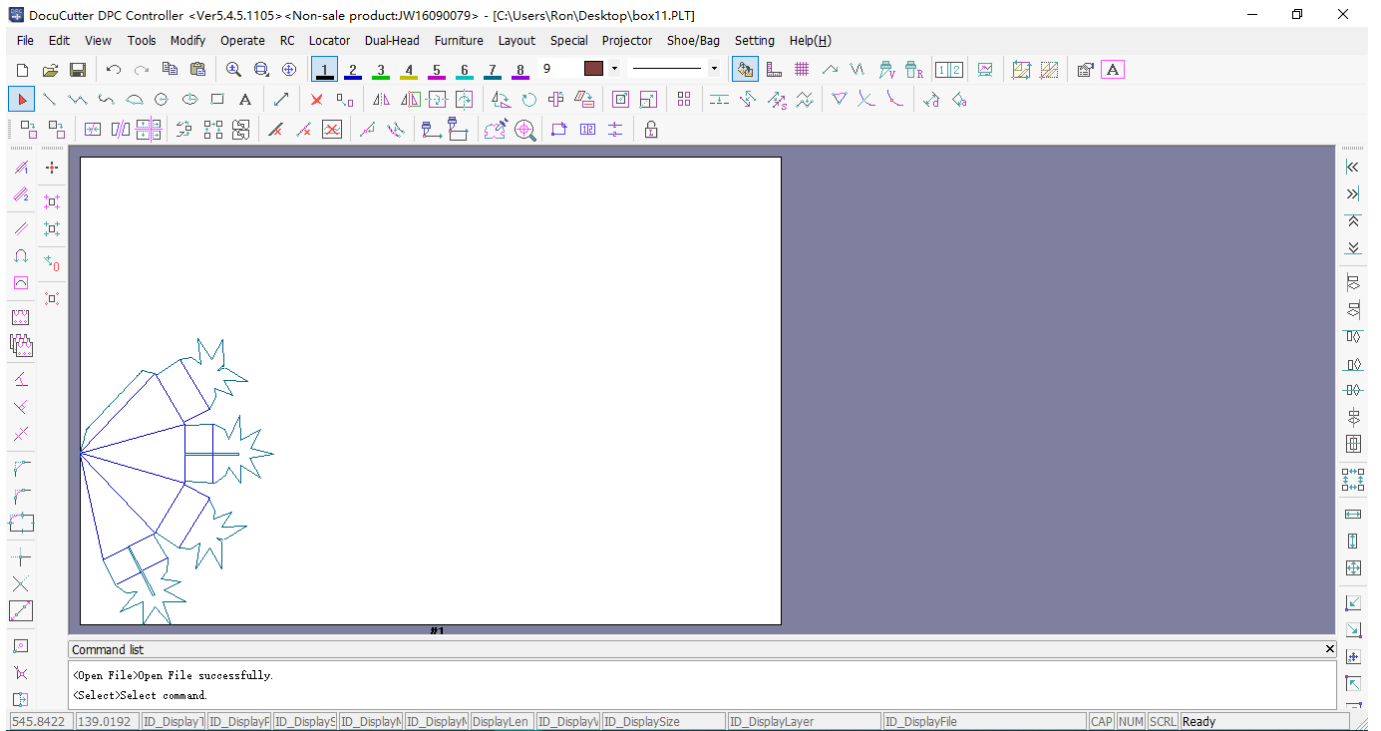
Open **Duplo USA**, click “File” menu > Open, and choose files required.





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





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

System Option Help

Watcher Dir: ...

| File Name | |
|-----------|--|
| | |
| | |
| | |
| | |

< [Progress Bar] >

Pause
Delete
Clear
Up
Down

Print Queue

| File Name | |
|-----------|--|
| | |
| | |
| | |
| | |

< [Progress Bar] >

Pause
Delete
Clear
Up
Down

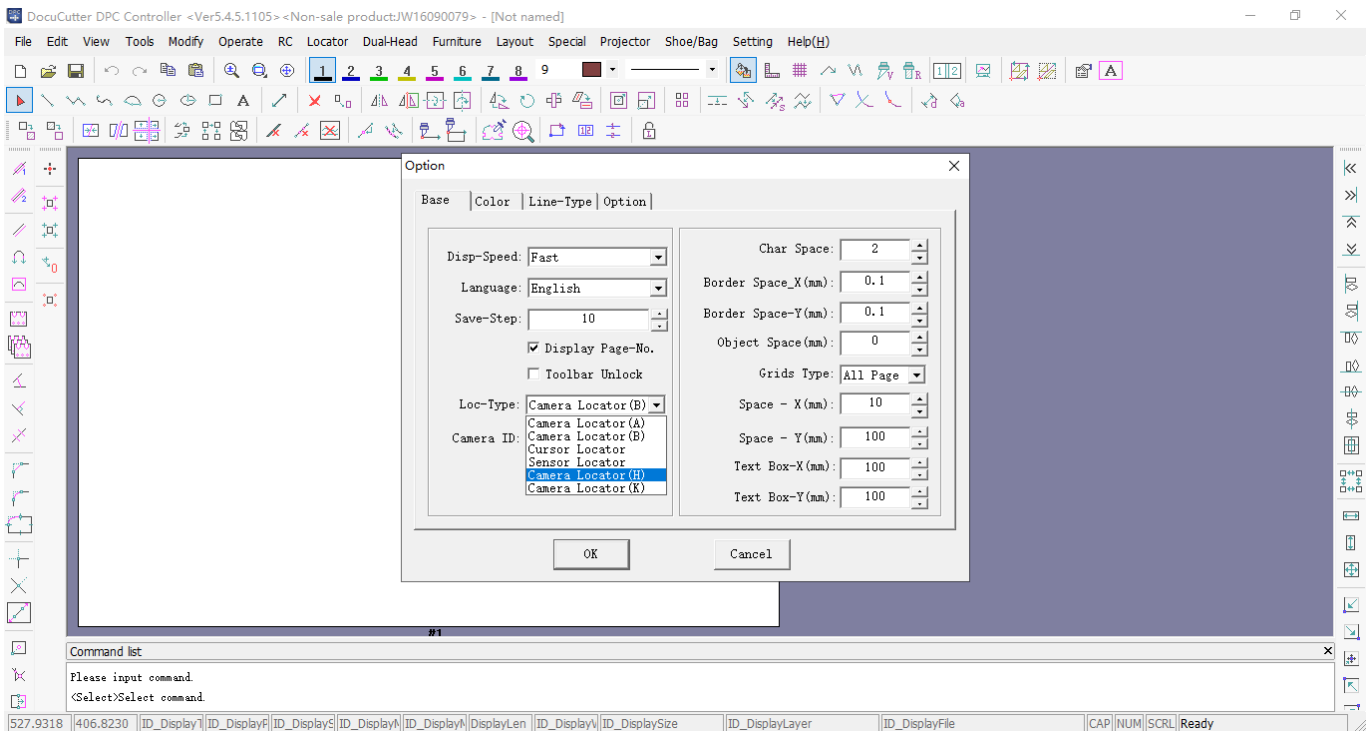
| File Name | Result | Time | Cause |
|-----------|--------|------|-------|
| | | | |
| | | | |
| | | | |
| | | | |


< [Progress Bar] >

Watcher Files: 0 Print-Queue Files: 0 Printed Files: 0 Wait need-Dispose File.

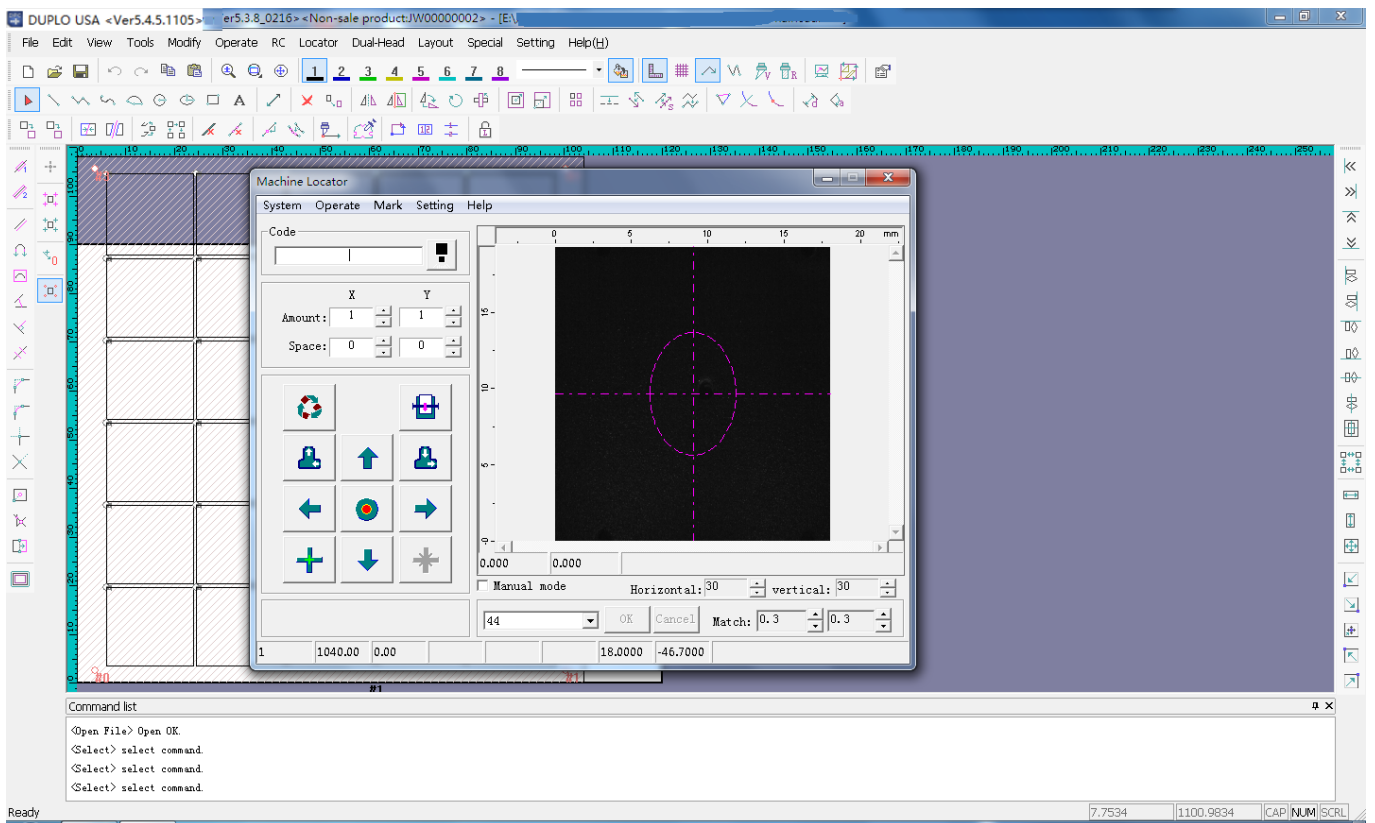
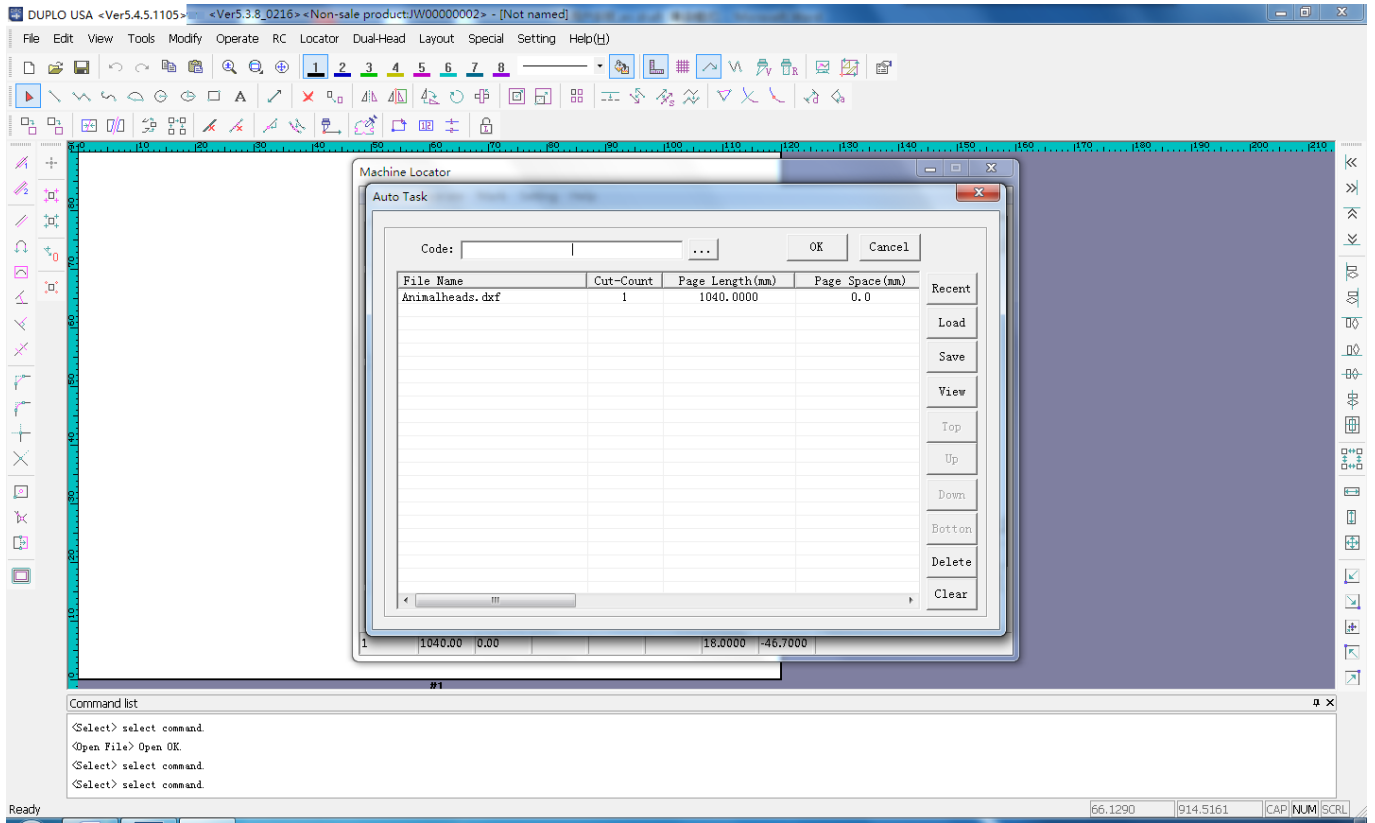
4-4 Camera Registration

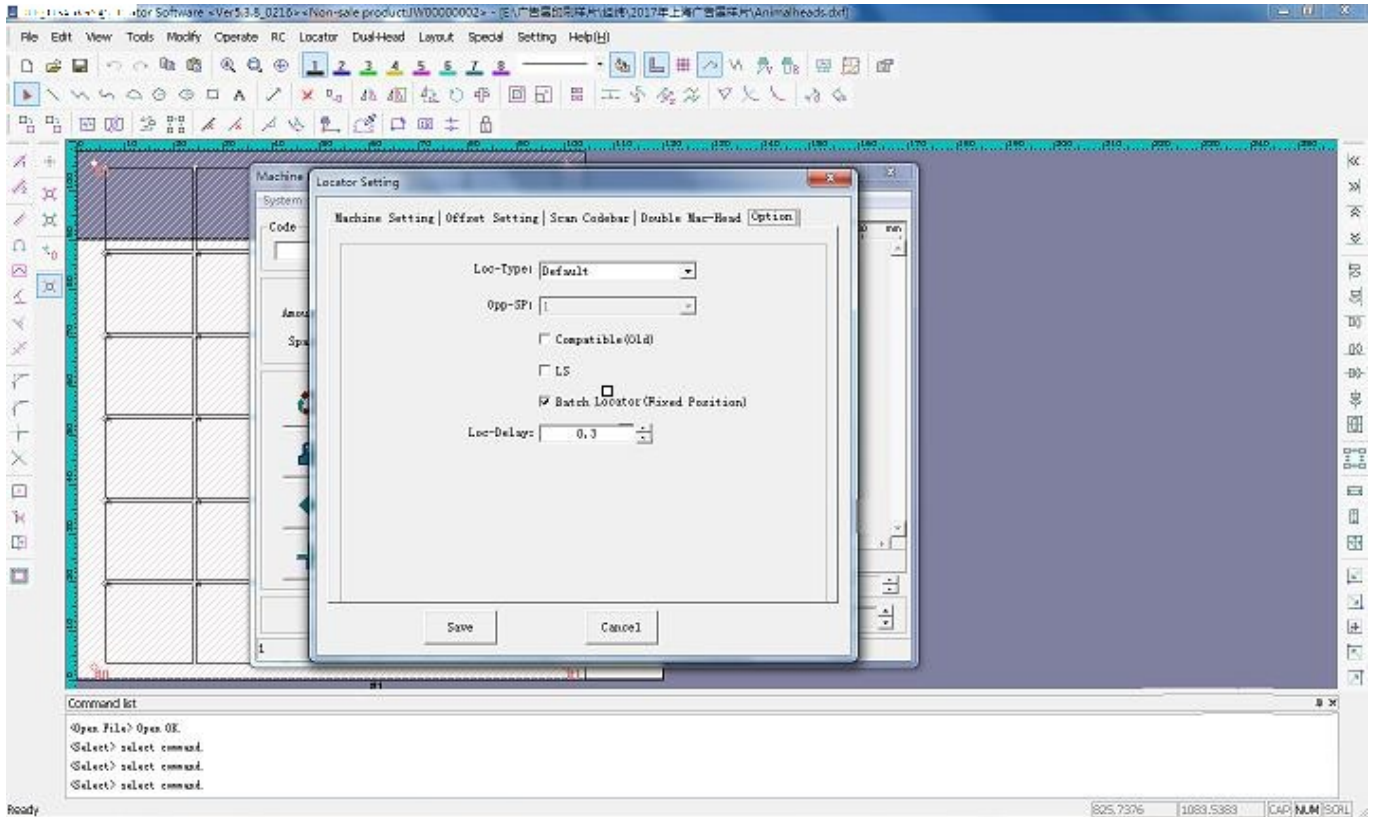
① Click “Setting”_setting_ in the menu of **Duplo USA** and select “Camera Locator (H)” in the drop-down box of “Loc-type”



② Re-Open **Duplo USA** and click “Icon” →  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 “Locator settings”, select “batch production” while set the auto feeder ON. Move the camera to the mark, click the “find the mark” button on the HMI, then the cutter would search marks automatically. The machine would start cutting operation as registration process finishes.





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!

NOTE

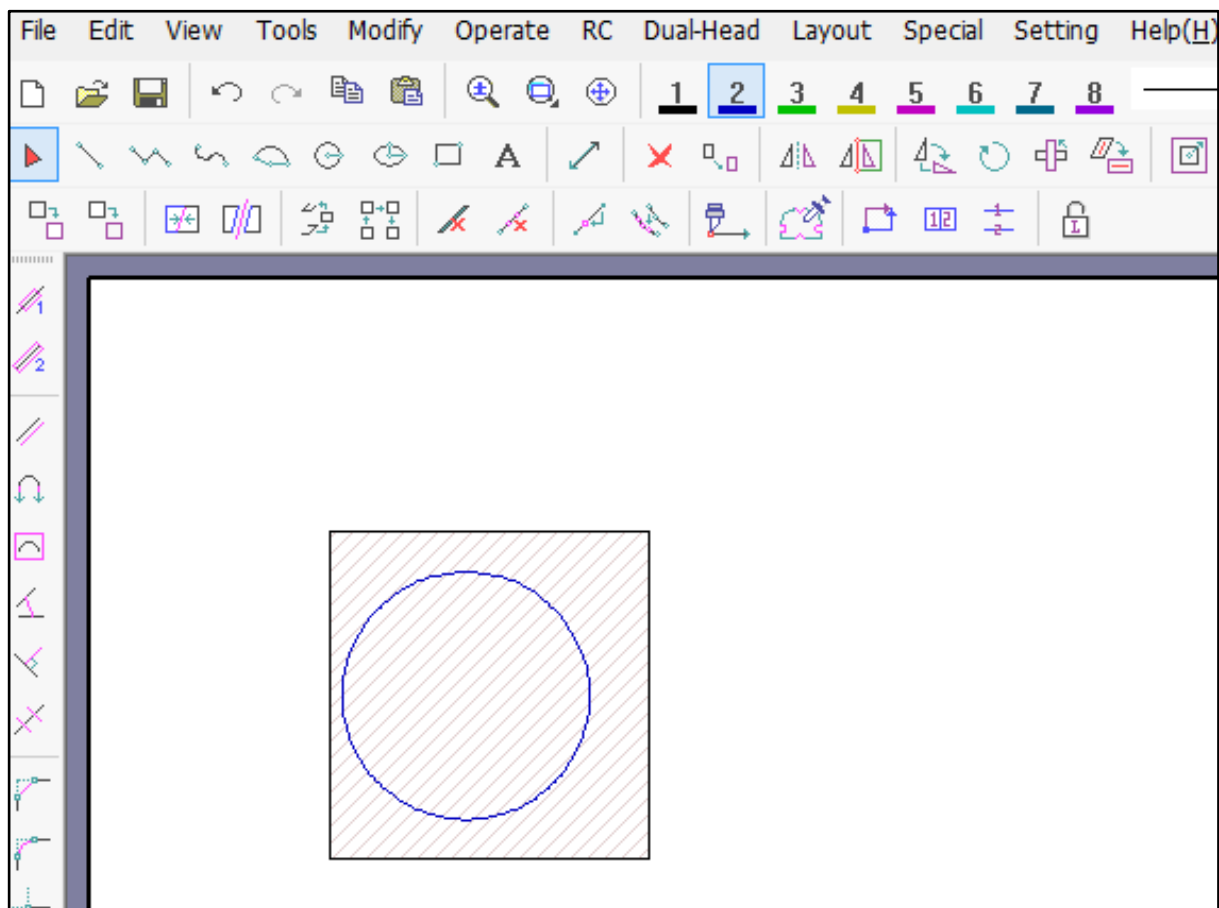
-Camera accuracy is 0.3 and cutter accuracy is 0.2

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.



offset

Example:

Example:

Designed size

X1000mm,

Y1000mm

Defaults

X Calibration Ratio: 0

Y Calibration Ratio: 0

Actual cut output

X990mm, Y1100mm

After calibrate

X Calibration Ratio:

Y Calibration Ratio:

Warning;

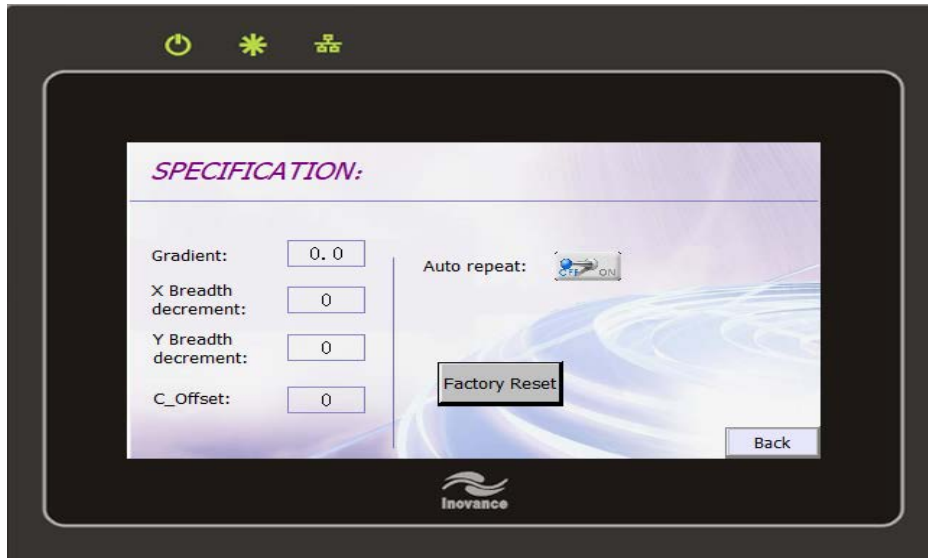
- Existed parameters of offsets are factory defaults, which is required to be followed strictly, otherwise there would occur equipment damages and unexpected risks.

Example of gradient coefficient adjustment

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




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




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 |
|---|--|
| <p>The document is outsize Pls press the Crash Reset ..</p>  | <p>1. Cut file is over the working size of the cutting table, please select correct machine model on Duplo USA</p> <p>2. Cut file is over valid work area of Duplo USA</p> |

| | |
|--|--|
| | <p>please move the file within the valid work area.</p> |
| <p>Press Enter To Continue</p>  | <p>This is of safety protection. Screen is locked as a given job finishes. Click "<u>ENTER</u>" to resume normal home screen</p> |
| <p>Note:</p> <p>Please restart the machine!</p> | <p>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.</p> |
| <p>Note:</p> <p>The password has expired,please contact the manufacturer.</p> | <p>Please contact your supplier directly as see this alarm.</p> |

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:

| Item | Description | Frequency | | | |
|------|-------------------------------|------------|--------------|----------------|-----------------------|
| | | 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:

Purchashe date: