
INSTALLATION MANUAL

SLITTER / CUTTER / CREASER

DC - 646

Service Person only

To ensure safe and correct installation of the product,
read these instructions carefully before installation.

Duplo

Safety Precautions

Warning Terminology

 The following warning terminology is used in this installation manual.

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".)

- The precautions below are vital for safety and must be taken.

 WARNING	
	<ul style="list-style-type: none">● Use only the power cord that is provided among the accessories. Insert the power cord plug firmly into the socket, so that proper electrical contact is effected. → Use of any other power cord could result in imperfect grounding. If grounding is imperfect and electrical leakage occurs, fire or electric shock could result.
	<ul style="list-style-type: none">● Do not use a source voltage other than that specified. Do not connect two or more loads to a single outlet. → Doing so may result in fire or electric shock.
	<ul style="list-style-type: none">● Do not place the machine in a humid or dusty area. → Doing so may result in fire or electric shock.

 CAUTION	
	<ul style="list-style-type: none">● Do not place the machine in an unstable position, such as on an unsteady support or sloping area. → If the machine is dropped or falls over, this could result in personal injury.
	<ul style="list-style-type: none">● Once the machine is in position, secure in place using the casters. → If the machine falls over, this could result in personal injury.

 **WARNING**



Use this machine correctly in accordance with the instructions. Great care must be taken to ensure person safety while installing, operating, checking, and maintaining this machine.



The maintenance including dangerous work, transportation or installation should be carried out by a person with sufficient knowledge and experience of this machine and system.

 **CAUTION**



Never lay the machine on its side.

 **WARNING**



This machine is heavy-weight equipment. When moving it by using the casters, two or more persons are required. Pay extra attention to slopes when transporting.

 **WARNING**



Do not place the machine outside. Rain drops, water, or dust may result in electric fire, electric shock or malfunction.

 **CAUTION**



Horizontally place the machine on a flat hard floor that bears the weight of the machine, and take actions for the machine not to fall over. Imperfect installation could result in dropping or falling, causing personal injury .

 **WARNING**



Do not touch the tools contained in each module. Injury may result.

 **WARNING**



Turn off the power before uninstalling, adjusting and installing the modules.

● To All Dealers/Distributors

Be sure to offer training in replacement of the tool, adjustment, and safety precautions to customers who are in charge of maintenance when the machine is installed.

Instruct customers that replacement of the tool must be performed only by the trained person in charge of maintenance.

Be sure to offer training in **pressing and releasing the back-up rollers** to customers who are in charge of maintenance.

Procedures for contacting back-up rollers is described in this manual. Have customers keep this manual at hand.

Duplo is not responsible for damage, injury, or any other troubles due to failure to observe the description in this manual.

● Installation environment

Operating temperature	10°C–30°C
Operating humidity	40%–70%
Storage temperature	0°C–50°C, no condensation
Storage humidity	10%–80%, no condensation

1. Unpacking Checks

1. Check the product name on the package.

Product name: DC-646

(The DC-646 includes 115V model, 230V model, ASIA model.)

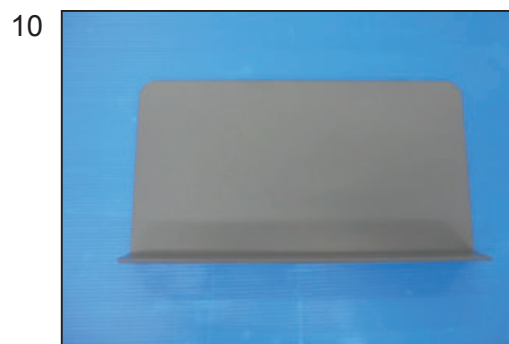
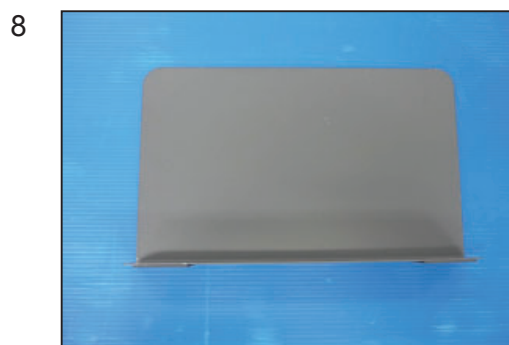
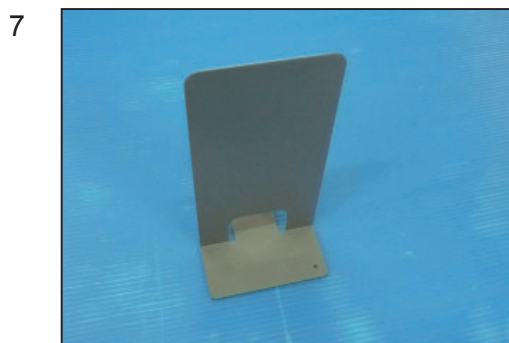
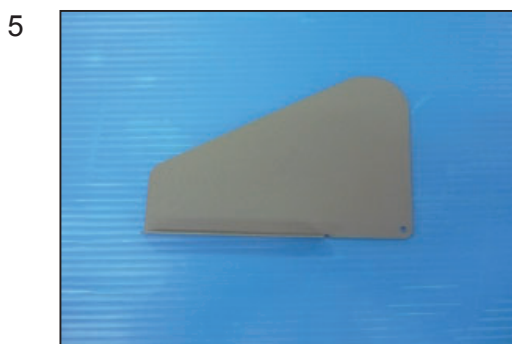
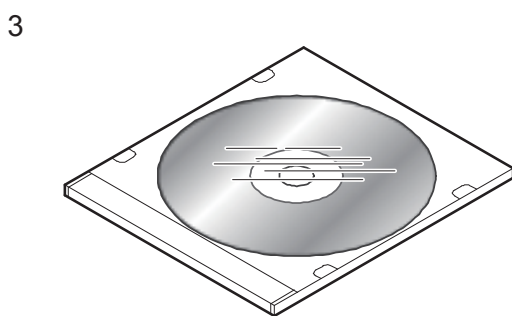
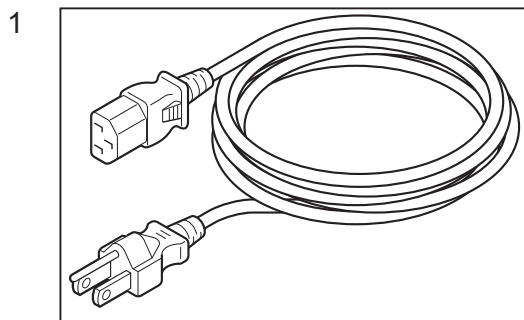
2. Unpack the package.

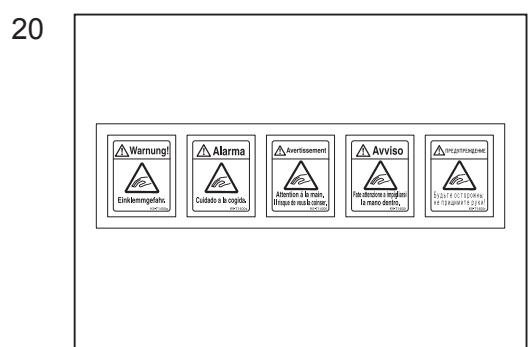
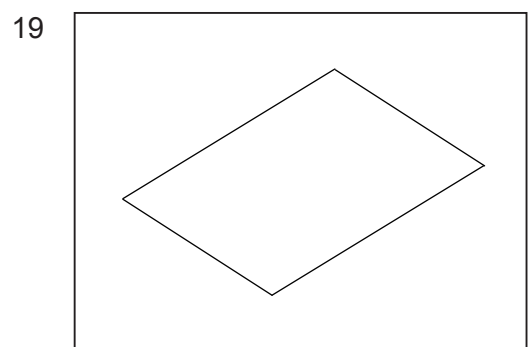
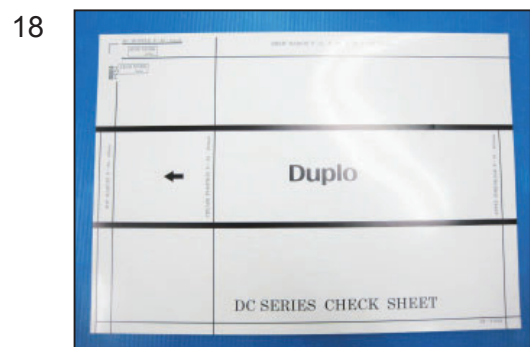
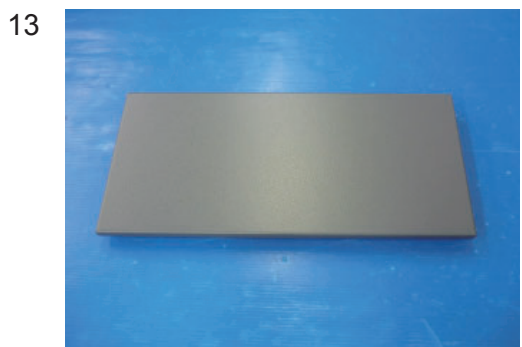
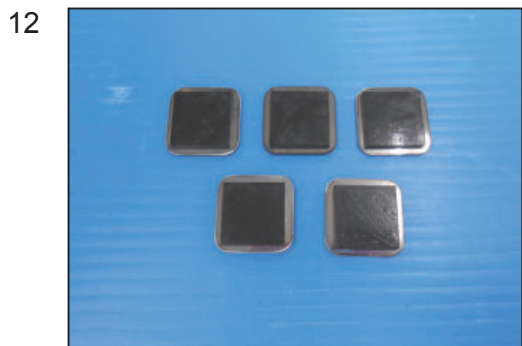
IMPORTANT

Carry out unpacking in a place that is safe for the work.

3. Check the contents.

No.	Name	Part No.	Q'ty	Remarks
1	Power cord	E1-8108*	1	115V model
2	Power cord	L1-W126*	1	230V model , ASIA model
3	PC controller CD	W5-Y198*	1	
4	Card stacker		1	
5	Support guide (for card stacker)	W5-L232*	4	
6	Guide assy (for card stacker)	Y2-L208*	1	
7	Side guide (for exit tray)		2	
8	Side guide (for feed tray)		1	
9	Upper guide		1	
10	Back guide (for exit tray)		1	
11	Back guide (for feed tray)		1	
12	Back guide weight (for feed tray)		5	
13	Plate (for PC)	U7-M722*	1	115V (USA) model, 230V model
14	PC arm mount assy		1	115V (USA) model, 230V model
15	Screw (HSKW5×12)		7	115V (USA) model, 230V model
16	Hexagon wrench	XZ057	1	
17	Shaft (tool)	W5-G138*	1	
18	Check sheet	S2-Y104*	6	
19	Coated paper 320×450 mm (230 gsm)		5	Used for pressure adjustment when the driving roller and the press roller are replaced. See the service manual for adjustment procedure.
20	Warning label	K9-T140*	3	230V model
21	Warning label	M7-T307*	2	230V model
22	Warning label sheet	L8-T112*	4	230V model
23	Warning label	W5-T135*	1	230V model
24	Warning label sheet	P9-T301*	1	230V model
25	Label sheet	U3-T114*	1	230V model
26	Label	U3-T112*	1	
27	Installation Manual	W5-Y206*	1	
28	Instruction Manual	W5-Y204*	1	

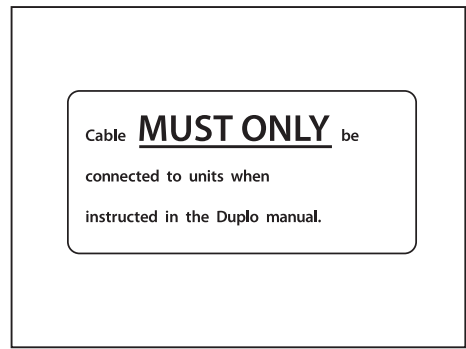




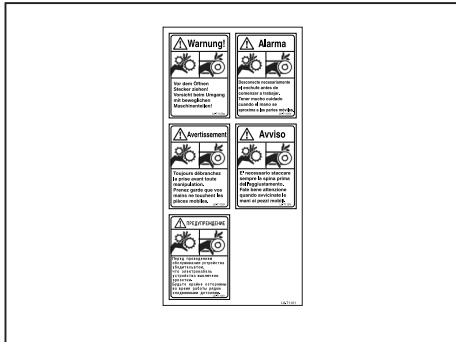
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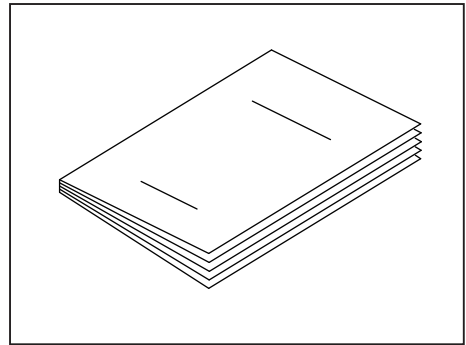
26



22



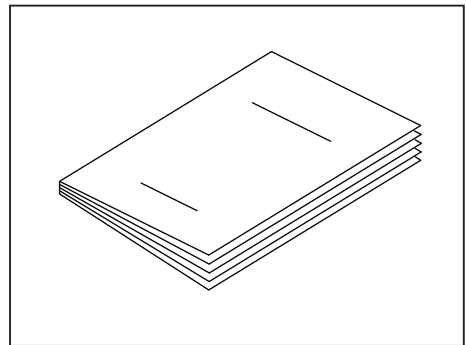
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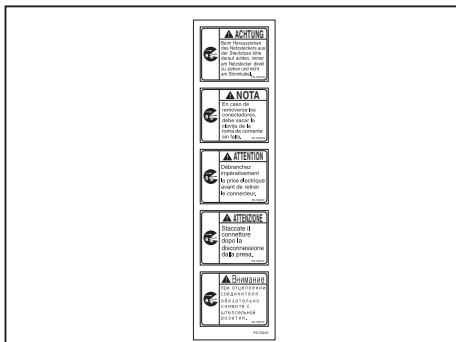
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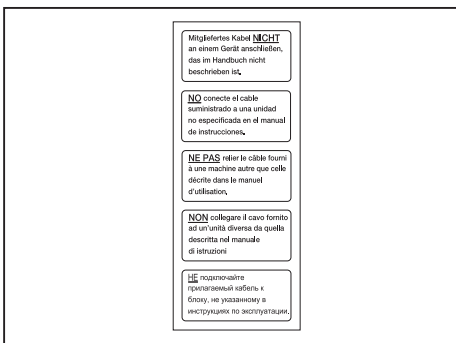
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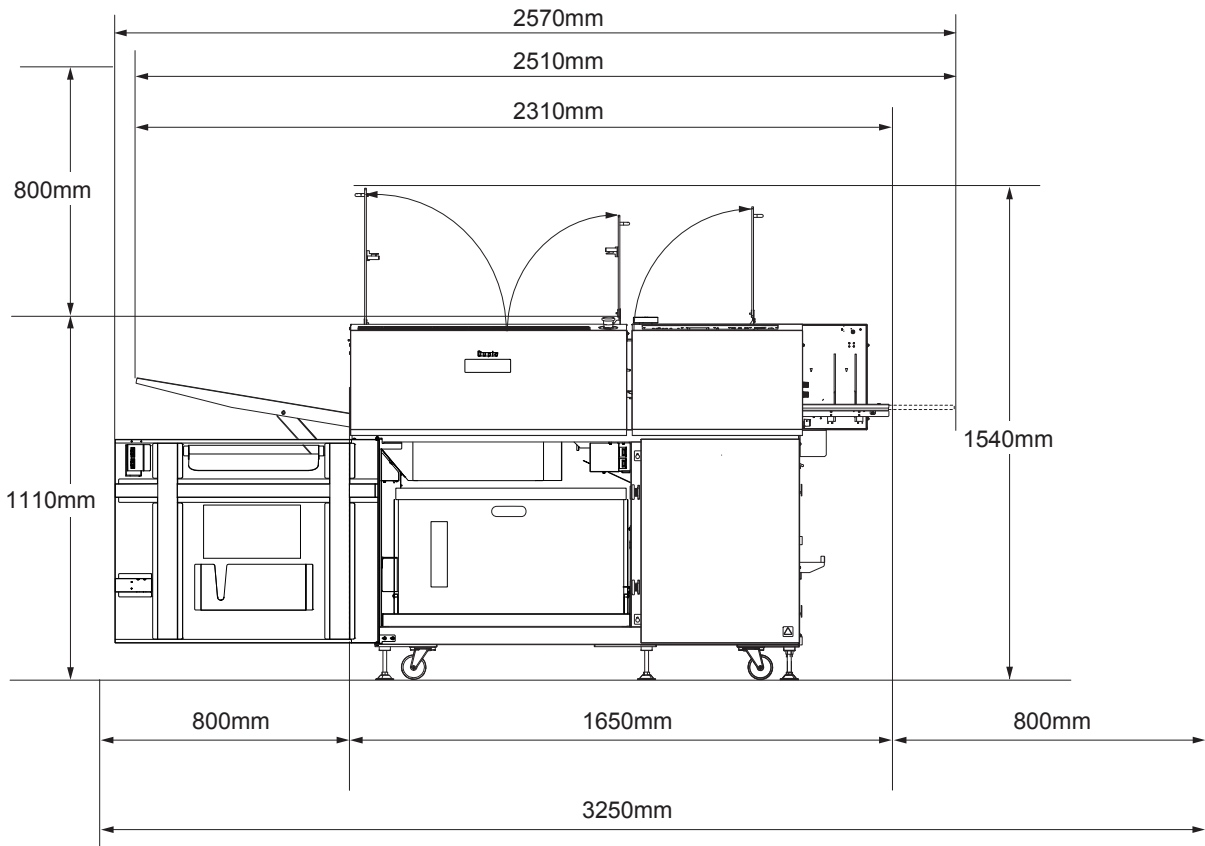
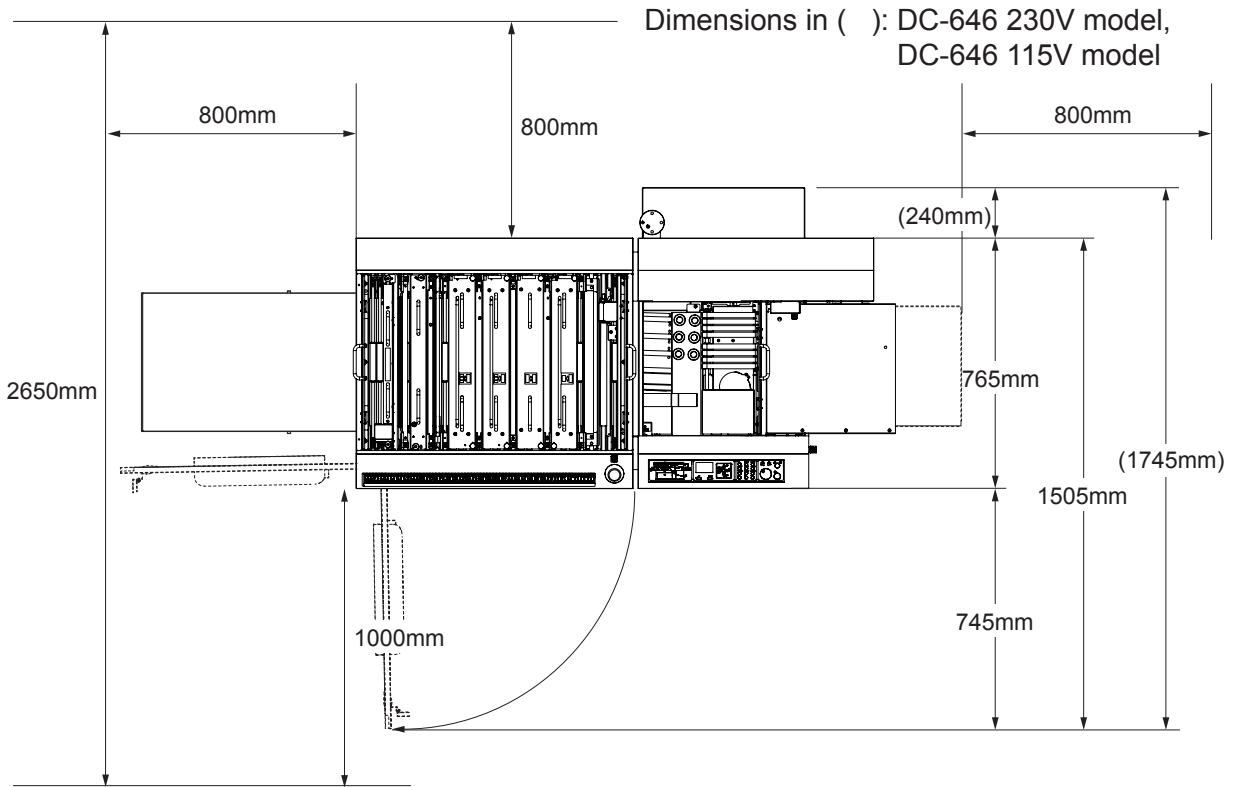
24



25



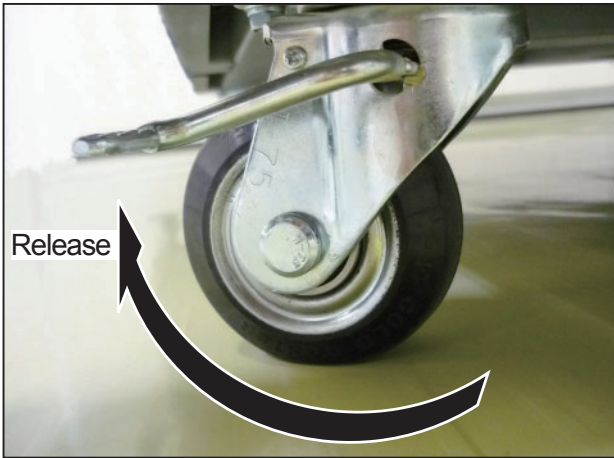
2. Machine Dimensions and Required Space for Operation



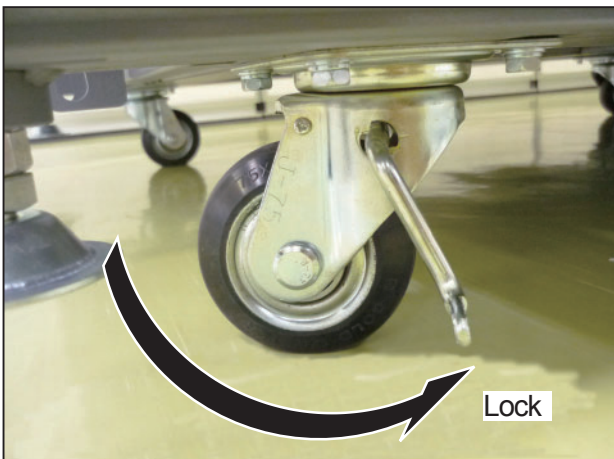
3. Installation

1. Release the four caster locks on the operator's side, and slowly move the DC-646 by pushing it to the place to be installed.

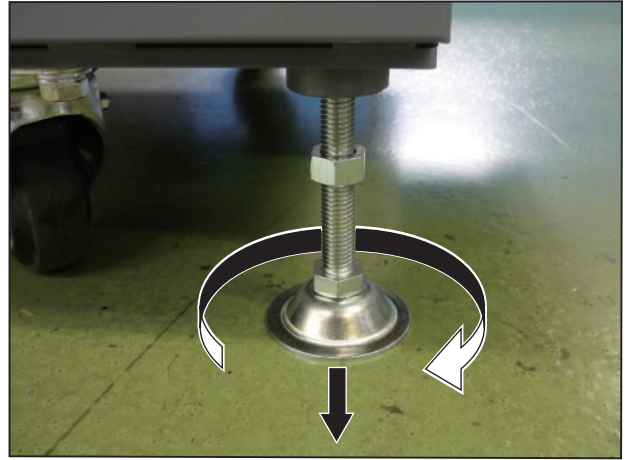
⚠ WARNING
This machine is heavy-weight equipment. When moving it by using the casters, two or more persons are required. Pay extra attention to slopes when transporting.



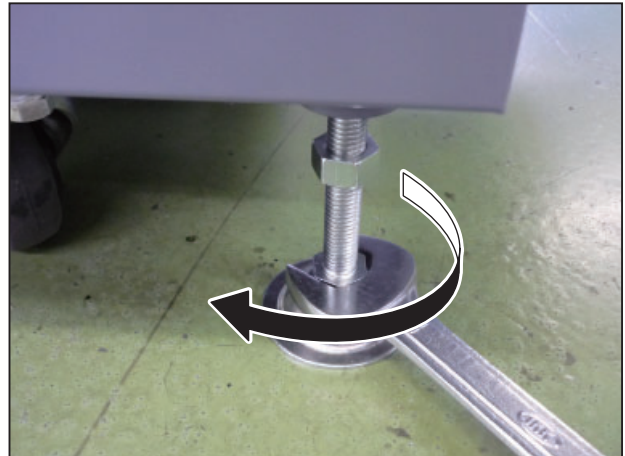
2. Lock the casters when you reach the place to install the machine.



3. Adjust the six adjuster feet on the bottom of the machine to bring into contact with the floor.

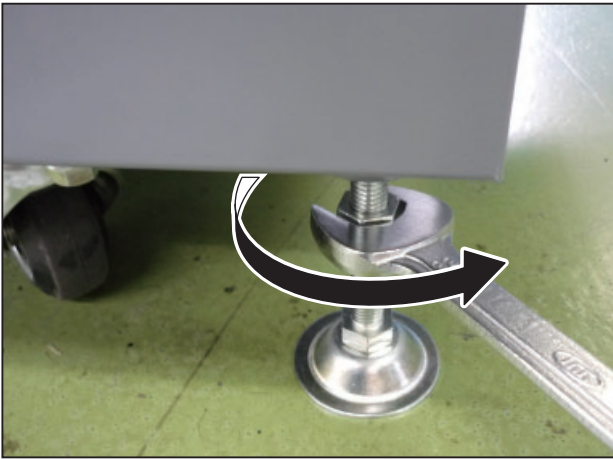


4. Adjust each adjuster foot until the casters come to the position apart from the floor.



5. Use a level gauge to make sure that the machine has been setup horizontally. If it hasn't been setup horizontally, then adjust the adjuster feet again so that it is setup horizontally.

6. Tighten the nuts to secure the adjuster feet.



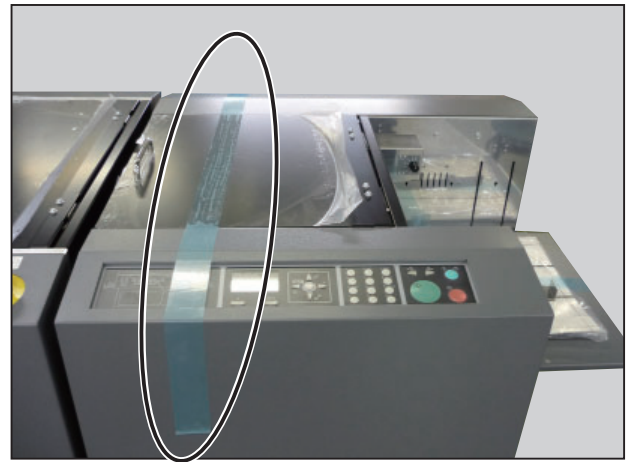
Ejection side (tapes, cushioning materials)



7. Remove the plastic cover from the DC-646.

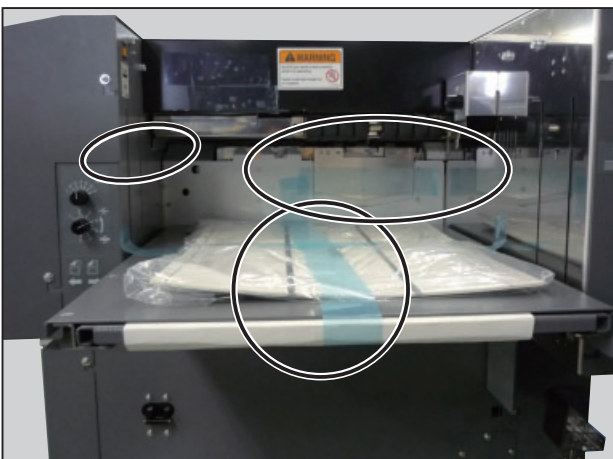


Top cover 1 (tape)



8. Remove all the tapes and cushioning materials from the machine.

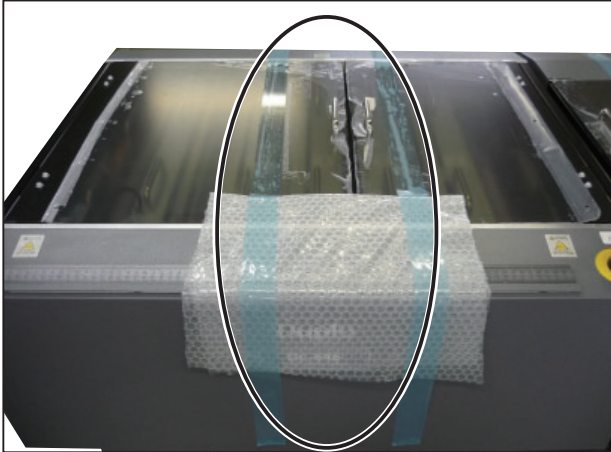
Document feed side (tapes)



Inside the top cover 1 (tapes)



Top cover 2 and top cover 3
(tapes, cushioning materials)



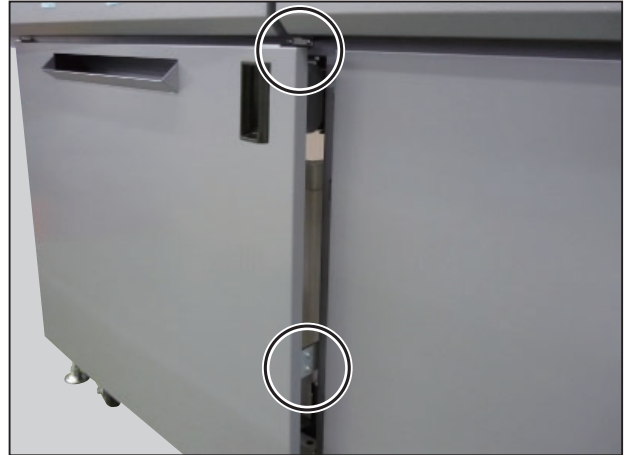
Inside the top covers 2 and 3 (tapes securing the fixing screws on each module)



9. Remove the five screws to remove the fixing angle under the feed tray.



10. Remove the screws (two each) securing the two angles for securing the front cover.



Open the front cover, and remove the two screws to remove the angle securing the front cover from the DC-646.

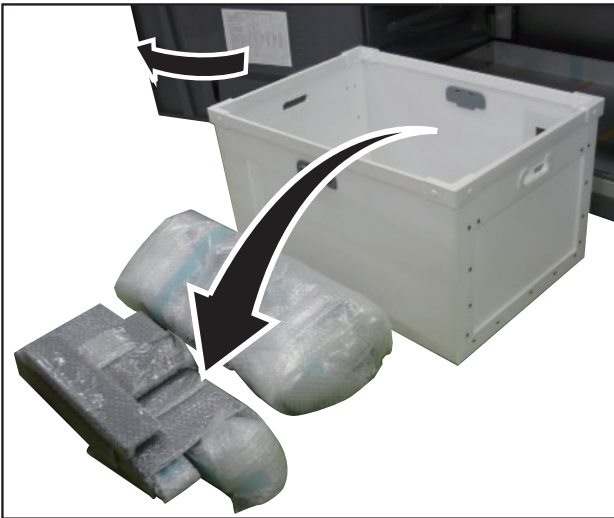


Open the front cover, and remove the screws (two each) to remove the two fixing angles securing the front cover.





11. Take out the included items in the waste box and check for any missing parts.



REFERENCE

Keep the removed fixing angles and the fixing screws for when the machine is moved.

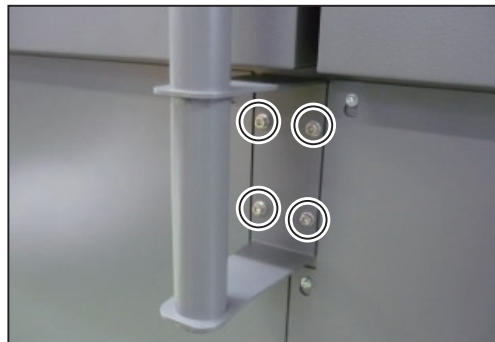
● Attaching the PC arm mount assy

(115V model, 230V model)

1. Attach the PC arm mount assy to the indicated place below.



2. While holding the PC arm mount assy with both hands, secure it with the four included screws (M5×12) from the upper ones.



REFERENCE

Lastly retighten the screws (M5×12) with a wrench.

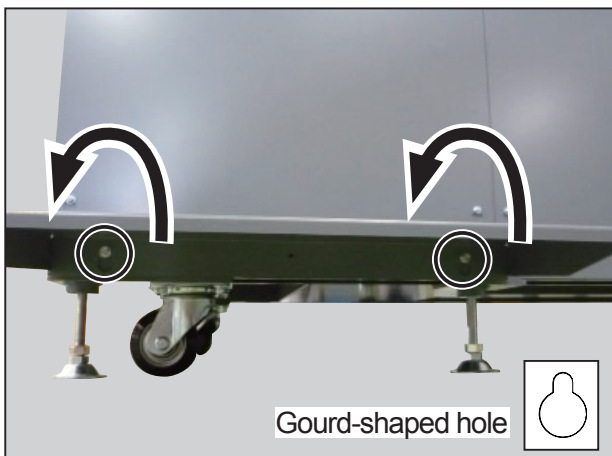
● Attaching the PC tray

(115V model, 230V model)

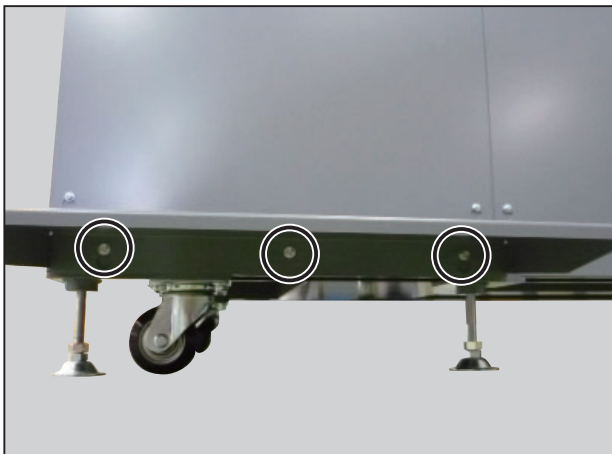
1. Temporarily attach the included two screws (M5×12) to the places (indicated in the following figure) on the non-operator's side.



2. Attach the **PC tray** by inserting the temporarily attached two screws in the gourd-shaped holes of the PC tray.

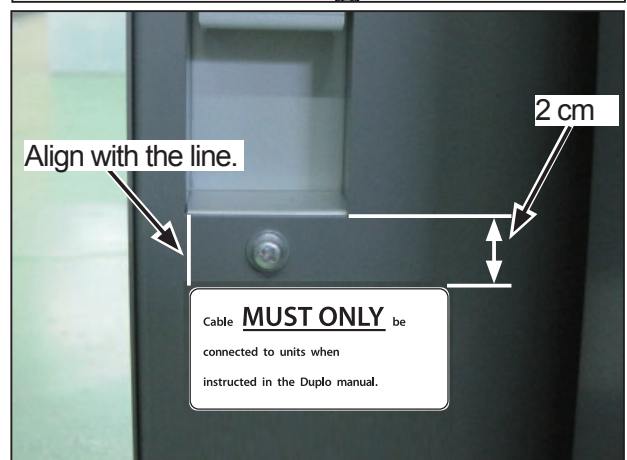
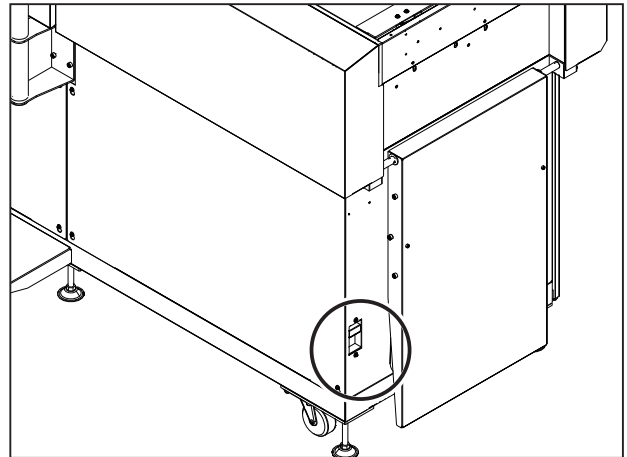


3. Use the included screw (M5×12) to secure the screw hole in the middle of the PC tray. Tighten the two temporarily attached screws.



● Affixing the warning label

1. Affix the **warning label** (U3-T112*) to the indicated place.

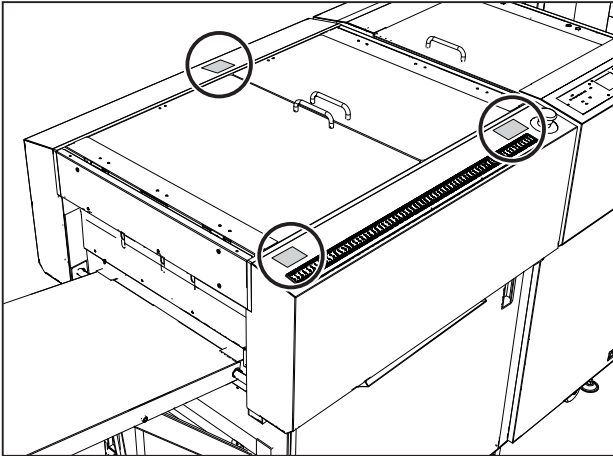


REFERENCE

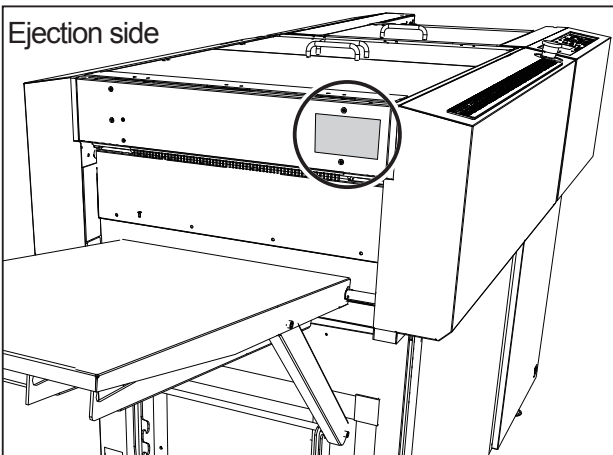
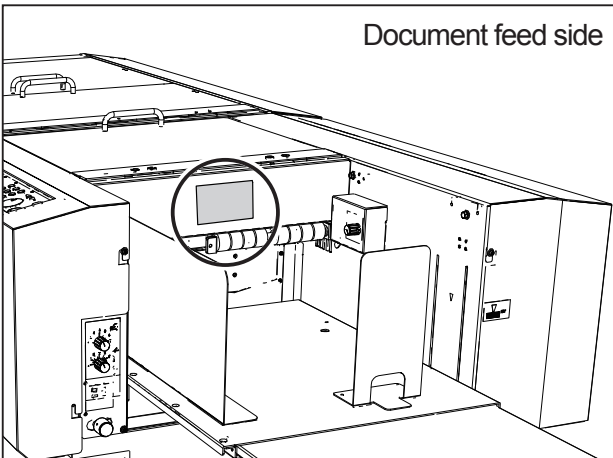
When the display language of the machine is other than English, affix the **warning label** (U3-T114*) corresponding to each destination.

- **Affixing the warning label on the existing label (Only when the display language is other than English)**

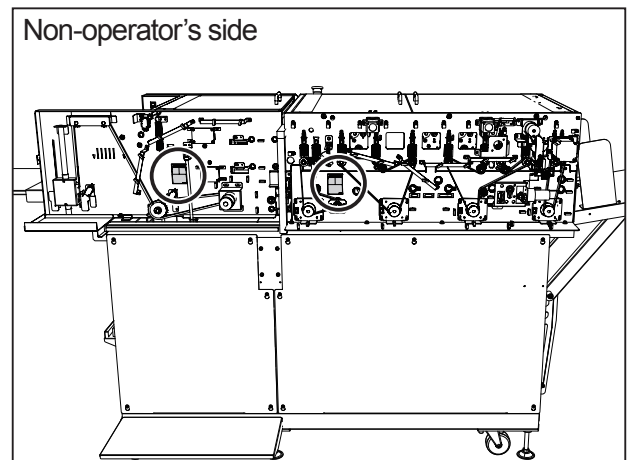
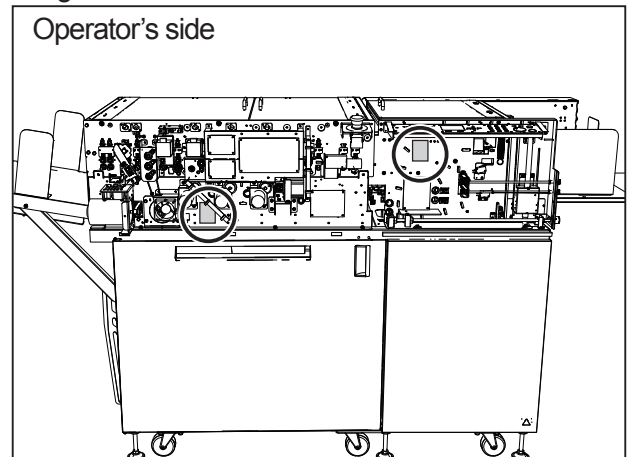
1. Affix the **warning labels (K9-T140*)** corresponding to destination on the existing labels at the three places in the following figure.



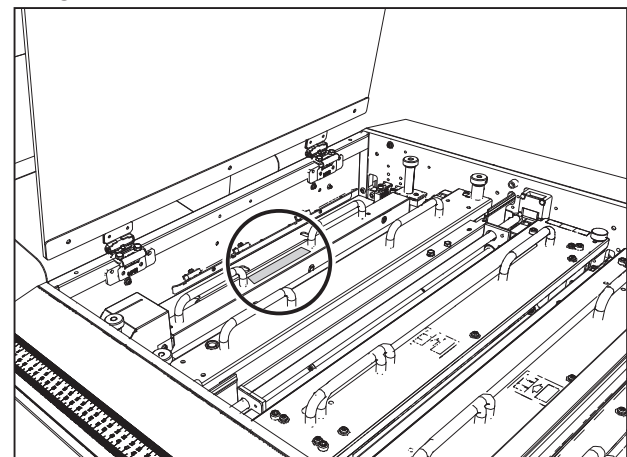
2. Affix the **warning labels (M7-T307*)** corresponding to destination on the existing labels at the two places in the following figure.



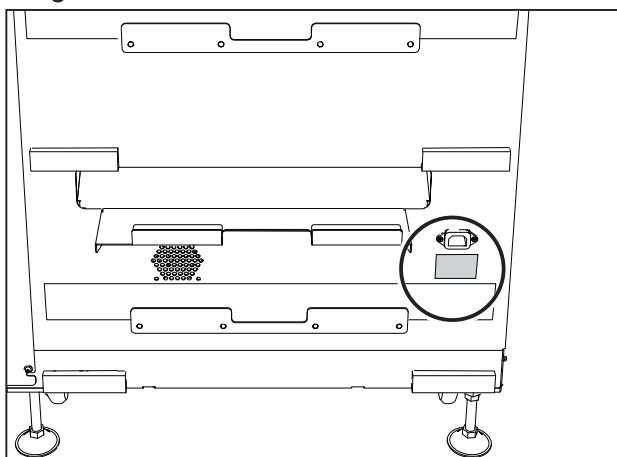
3. Affix the **warning labels (L8-T112*)** corresponding to destination on the existing labels at the four places in the following figure.



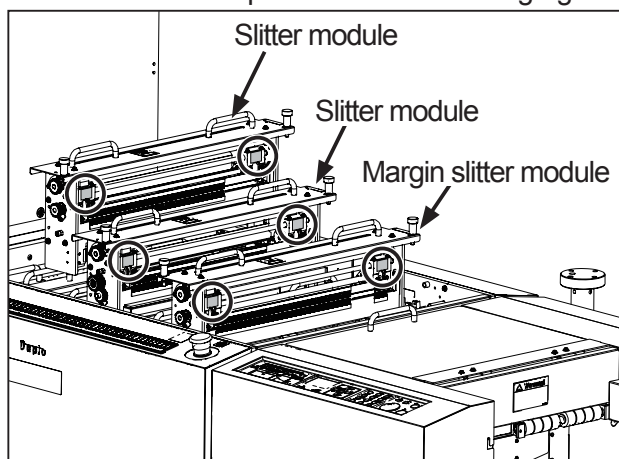
4. Affix the **warning label (W5-T135*)** corresponding to destination on the existing label at the indicated place in the following figure.



5. Affix the **warning label** (P9-T301*) corresponding to destination on the existing label at the indicated place in the following figure.

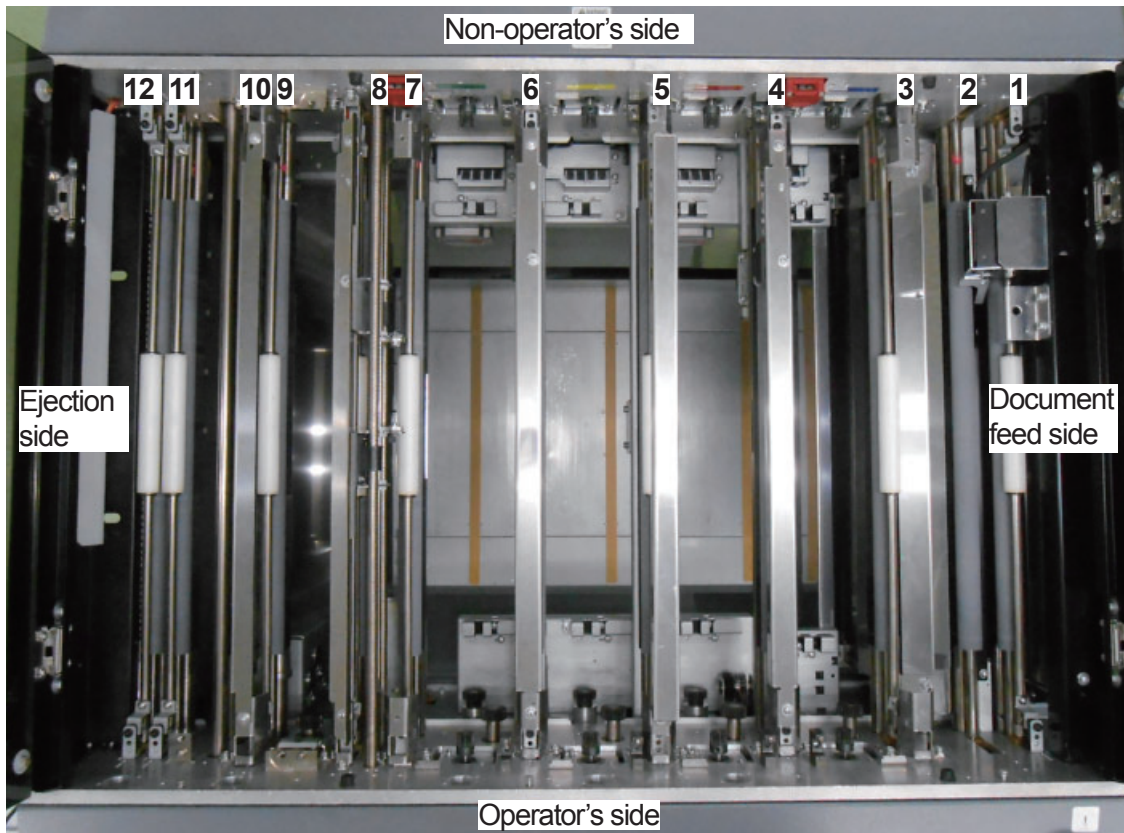


6. Affix the **warning labels** (S5-T109*) corresponding to destination on the existing labels at the six places in the following figure.

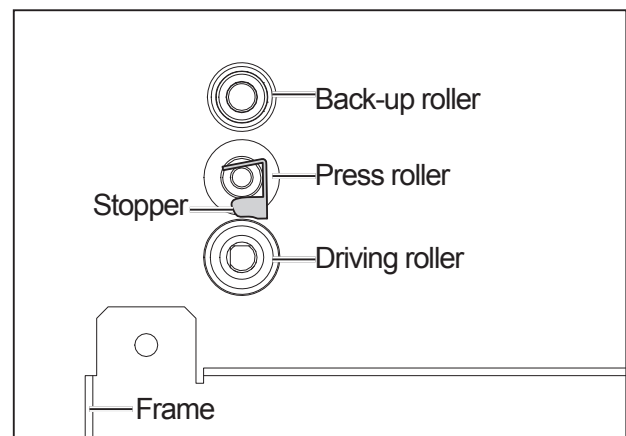
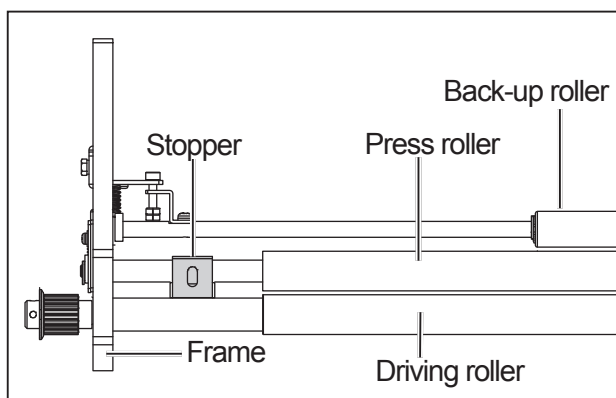


4. Removing the Stopper of the Press Roller

Remove all of the modules before removing the stoppers.



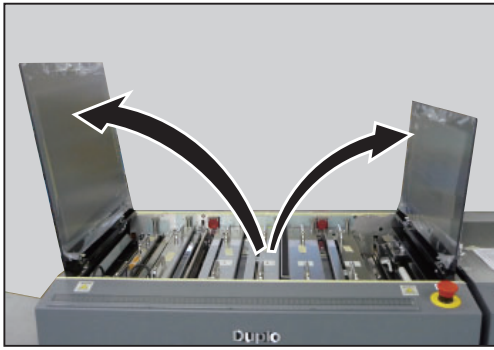
- At shipment, the **press rollers** are not in contact with the **driving rollers**. Remove the stopper by removing the blue tape with hand to bring the **press roller** and the **driving roller** into contact with each other at the time of unpacking. The stoppers releasing the contact of the press rollers and the drive rollers are located at 12 places on the non-operator's side in the above picture.



REFERENCE

Store the stoppers that have been removed for when the machine is not used for a long period.

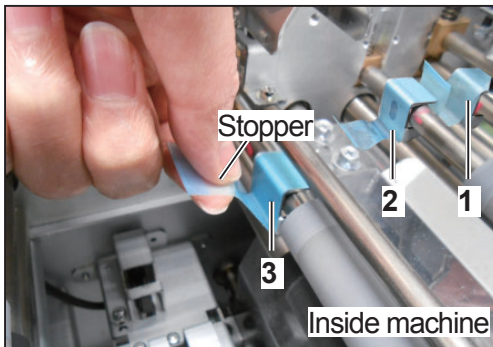
1. Open the **top cover 2** and the **top cover 3**.



2. Remove all of the modules.

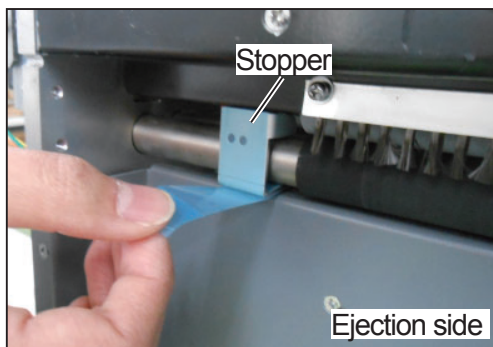
1. Removing the stoppers of 1–11

1. Remove the blue tape with hand to remove the stoppers of 1–11 inside the machine (non-operator's side). (The following picture shows 1–3.)



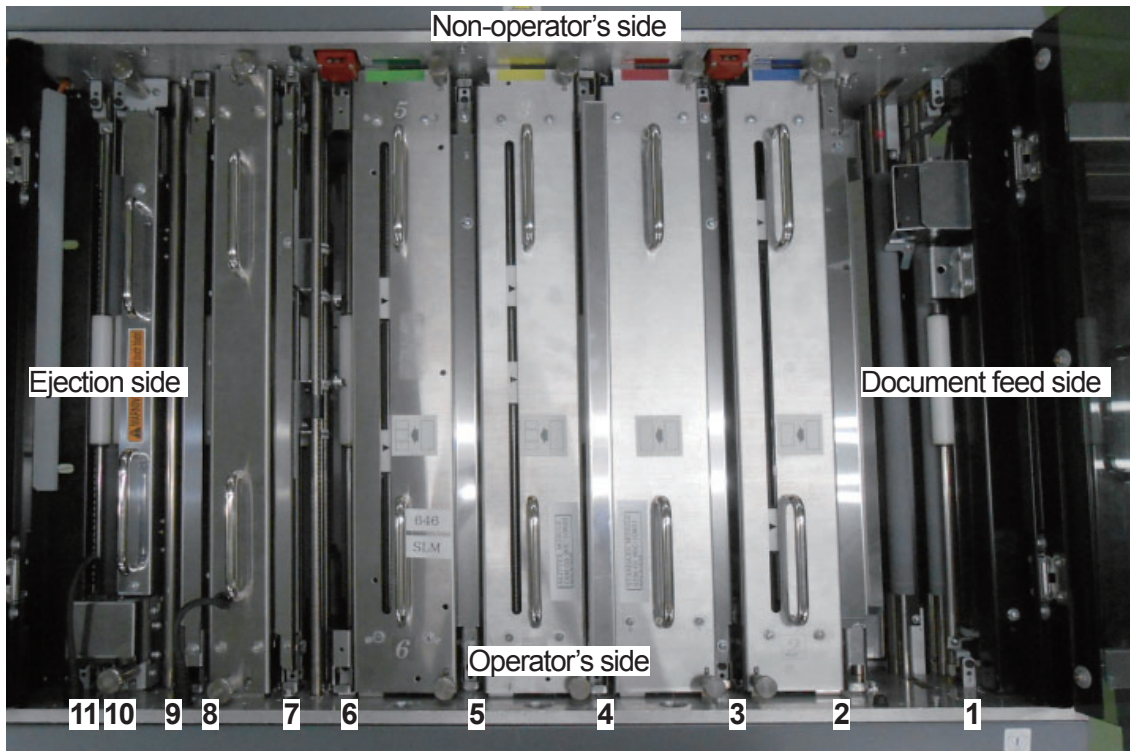
2. Removing the stopper of 12

1. Remove the blue tape by hand to remove the stopper of 12 from the ejection side (non-operator's side).



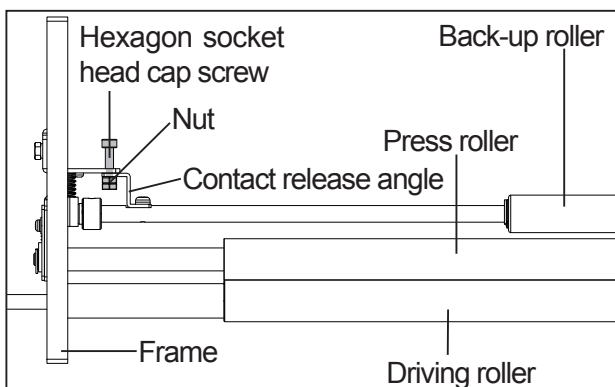
2. Install all of the modules.

5. Pressing the Back-Up Roller

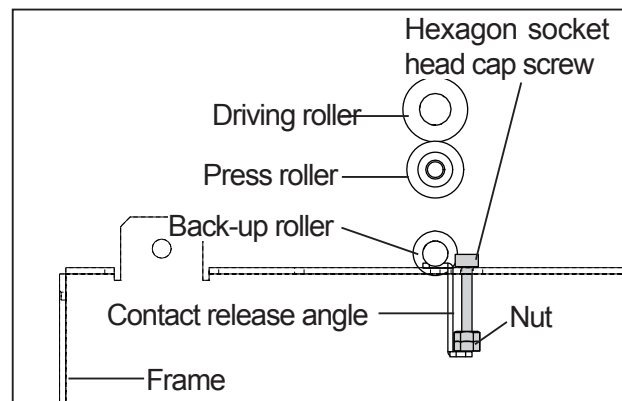


- At shipment, the **press rollers** are not in contact with the **back-up rollers**. Turn the hexagon socket head cap screws to bring the **press rollers** and the **back-rollers** into contact with each other at the time of unpacking. The hexagon socket head cap screws bringing the back-up rollers into contact with the press rollers are located at the 11 places (both on operator's side and non-operator's side) in the above picture.

At the time of shipment, the 20 hexagon socket head cap screws (one each on the operator's side and non-operator's side) of **1–8** and **10–11** are loosened. Turn them clockwise to bring the back-up rollers into contact with the press rollers when installing the machine.



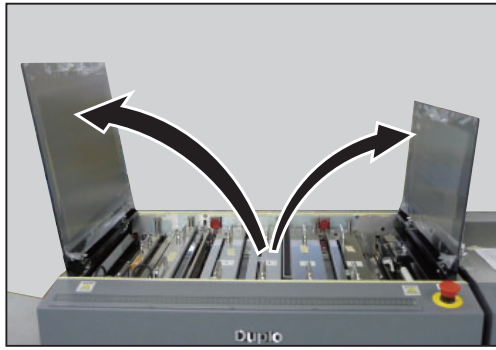
The hexagon socket head cap screws (one each on the operator's side and non-operator's side) of **9** are tightened. Turn them counterclockwise to bring the back-up roller into contact with the press roller when installing the machine.



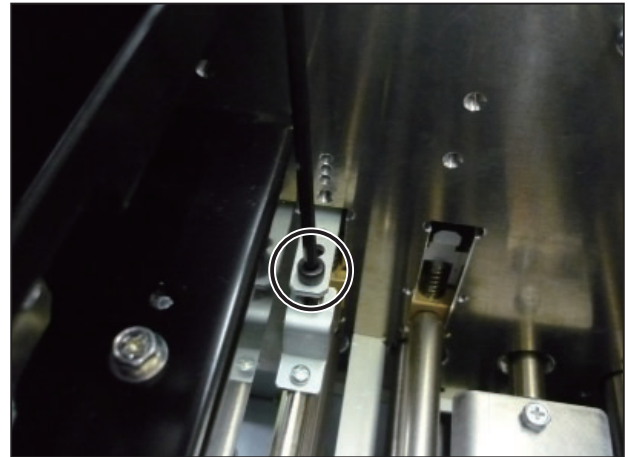
IMPORTANT

If the **press rollers** and the **back-up rollers** are in contact with each other for a long period, the **press rollers** will get dented. When the machine is not used for a long period, release the roller pressure. When using the machine after a long unused period, be sure to bring the rollers into contact with each other.

1. Open the **top cover 2** and the **top cover 3**.



(The following picture shows the operator's side of 1.)

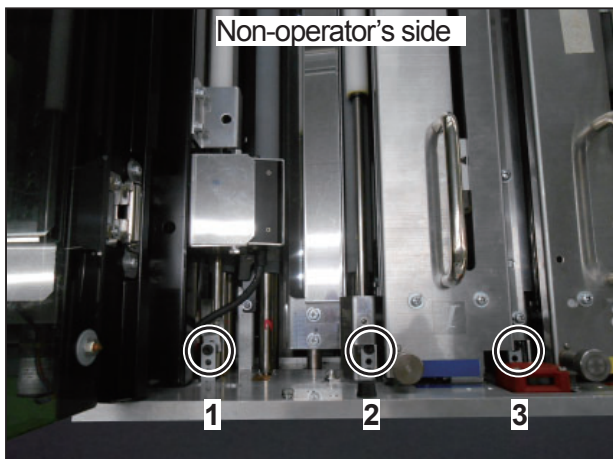


1. **Pressing the back-up rollers of 1–8 and 10–11**

1. Turn the hexagon socket head cap screws (of **1–8** and **10–11**) clockwise using the hexagon wrench to press the back-up rollers so that they come into contact with the press rollers. (The following pictures show **1–3**.)

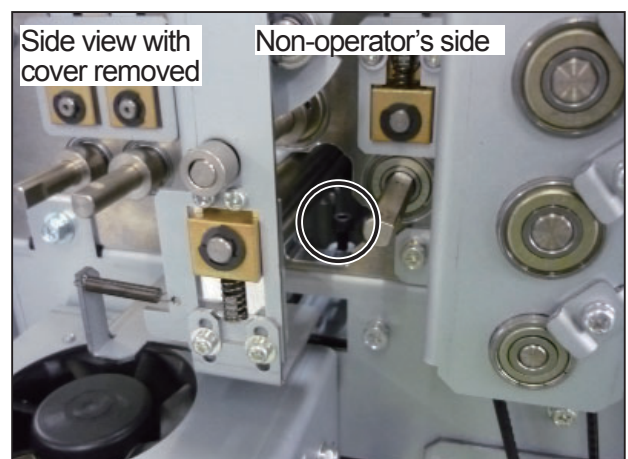
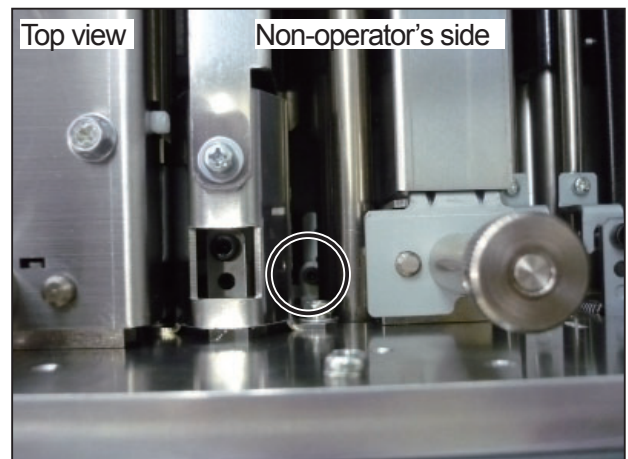
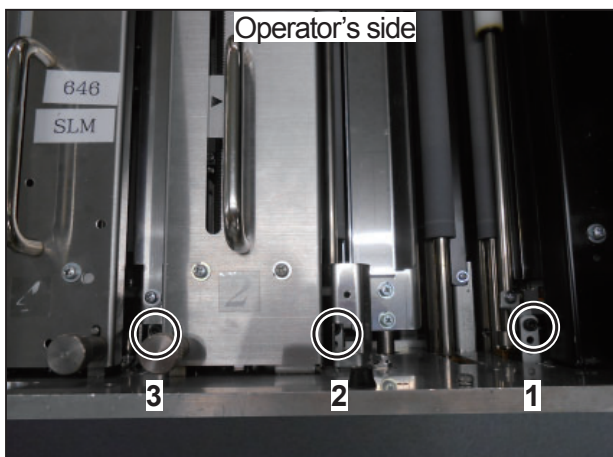
REFERENCE

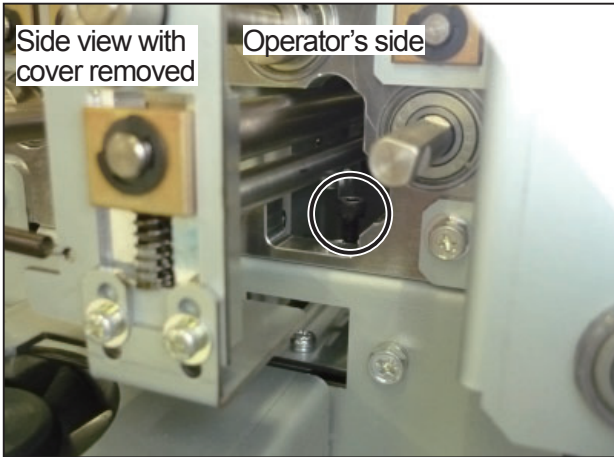
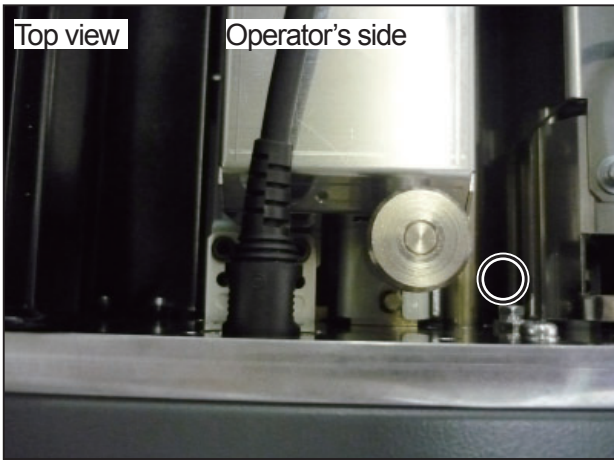
Turn the hexagon socket head cap screws clockwise until they stop. (until they come into contact with the frame and cannot be turned any more)



2. **Pressing the Back-Up Rollers of 9**

1. Turn the hexagon socket head cap screws (of **9**) counterclockwise using the hexagon wrench to press the back-up roller so that it comes into contact with the press roller. (The following pictures show **9**.)



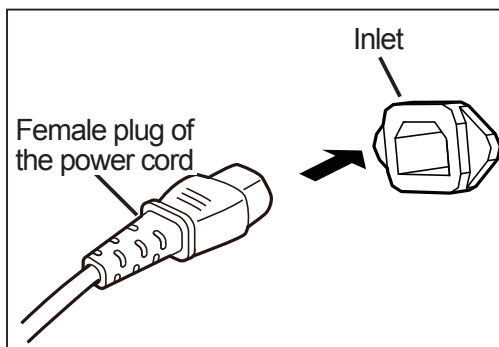


REFERENCE

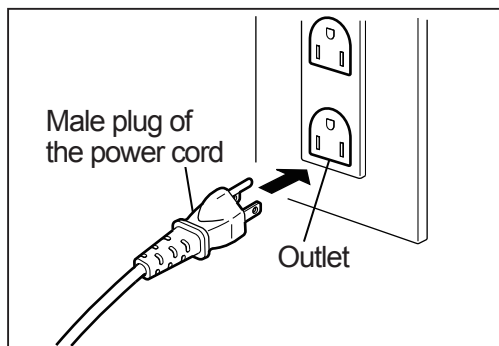
- Actually, you can turn the hexagon socket head cap screws without removing the covers.
- Turn the hexagon socket head cap screws counterclockwise until they stop. (until the nuts come into contact with the frame and the screws cannot be turned any more)

6. Selecting Language

1. Make sure that the power is off.
Connect the female plug of the supplied power cord to the inlet of the DC-646.



2. Insert the male plug of the power cord into the outlet.



! WARNING

Insert the power cord plug securely so that proper electrical contact is made. If grounding is imperfect, and electrical leakage occurs, fire or electrical shock could result.

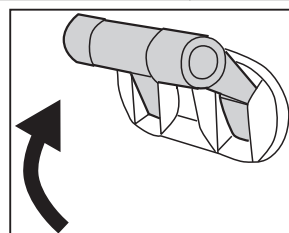
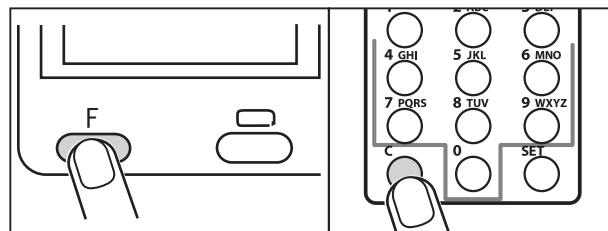
! WARNING

Unplug the power cord when emergency situation.

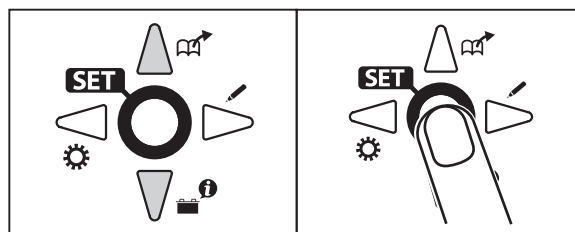
! CAUTION

Use a access-friendly outlet so that an operator easily plugs and unplugs the power cord after installation.

3. Turn on the power while simultaneously pressing the F key and C key.



4. Press the CURSOR (Up/Down) key to select language, and press the SET key.

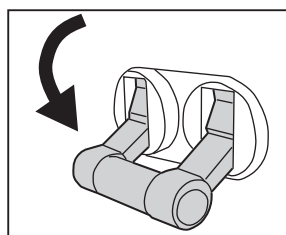


Select one from the following eight languages.

REFERENCE

English, French, Italian, German, Spanish, Japanese, Polish, and Russian

5. Turn off the power.



6. Turn on the power.
The LCD display appears in the language set in step 4.

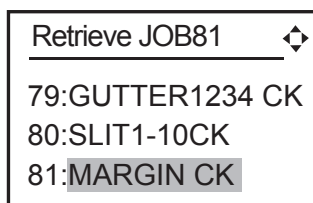
7. Operation Check

IMPORTANT

When measuring finished product size, prepare a digital vernier caliper that can measure length of 150 mm or more. (Measuring accuracy: ± 0.01 mm)

• Checking skew correction of document feed section

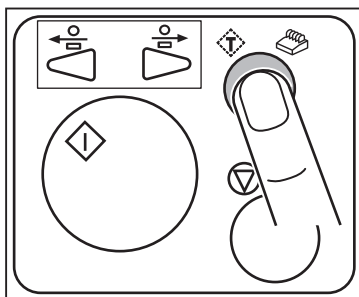
1. Turn on the power while simultaneously pressing the CURSOR (Up) key and the CLEAR key.
2. Access the **Service person JOB81**, and press the SET key.



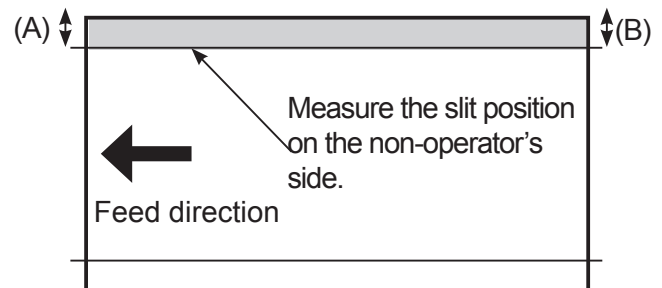
REFERENCE

Pressing the CURSOR (Right) key displays the details of **JOB81** in order.

3. Load A3 document (230 gsm, coated) on the feed tray, and press the TEST key. It is processed following the settings of **Service person JOB81**. (For details → See the table **JOB81** on page 23.)



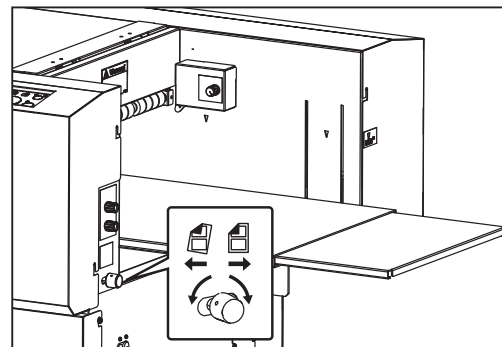
4. Measure the widths (A) (lead edge) and (B) (trail edge) of the right margin dropped in the waste box with a vernier caliper. Check if the widths are ± 0.2 mm or less. When the values are as set, go to step 7. When they are not as set, go to step 5.



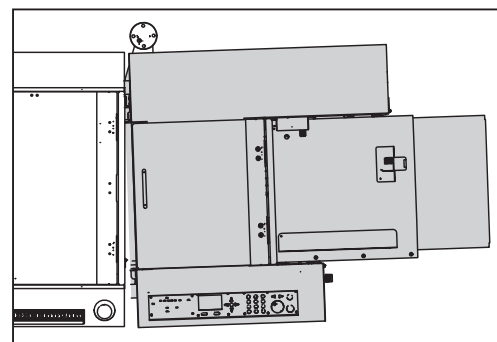
REFERENCE

25 mm of the right margin is slit. If you make a mark on the slit position, you can adjust skew smoothly.

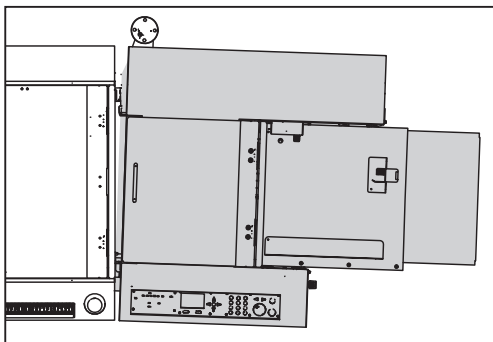
5. If the margin widths (A) and (B) are not the same, adjust the skew using the **skew adjustment knob**.



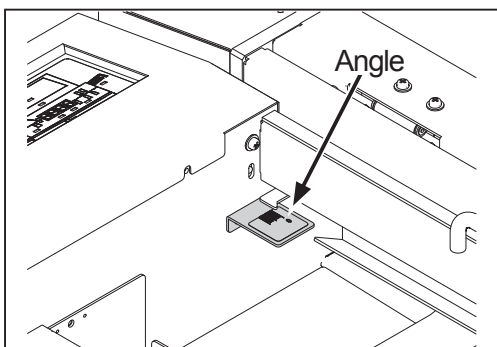
Clockwise: Turning the knob slightly shifts the lead edge of the document toward the operator's side. (When B is narrower.)



Counterclockwise: Turning the knob slightly shifts the lead edge of the document toward the non-operator's side. (When B is wider.)



6. Repeat steps 3 to 5 until the finished product is processed as set.
7. Turn off the power.
8. Loosen the screw of the angle of the **skew indicator** to set the angle at **0**.

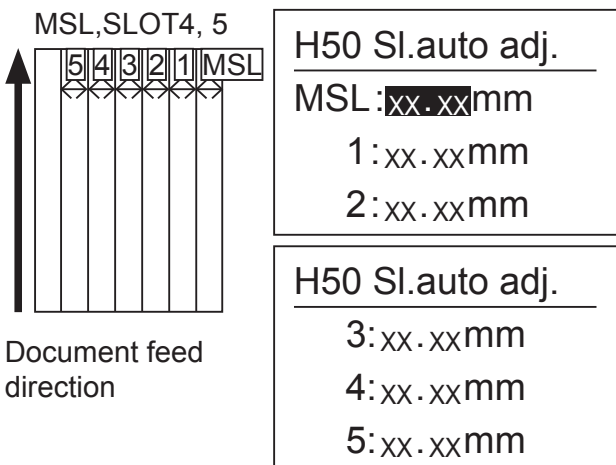


JOB81	MARGIN CK
JOB name	MARGIN CK
Width	297
Length	420
SLOT2	Not specified *1
SLOT3	Not specified *1
SLOT4	Not specified *1
Side mark	0
Lead mark	0
Slit 1	25
Slit 2	285
Slit 3	0
Slit 4	0
Slit 5	0
Slit 6	0
Cut 1	0
Crease 1	0
SLOT2 X1-1(R)	0
SLOT2 X1-2(L)	0
Air knife	OFF
Side blow fan	MID
Fan reg.	MAX
REG mark	OFF
Slitter guide	ON
Cut trim mode	Full bleed mode
Crease depth	MID
Speed	FAST
Auto trail cut	OFF

*1 JOB is processed with any module installed. However, **Standard** is always displayed for JOB property.

● Checking the slit position

1. Turn on the power while simultaneously pressing the both JOG keys to enter the HELP mode.
2. Access the **HELP-50**, and press the START key.
3. Load document (230 gsm, A3, coated) on the feed tray, and press the TEST key.
It is processed following the settings of **Service person JOB84**. (For details → See the table **JOB84** on page 24.)
4. Measure the widths of the right margin and the finished product with a vernier caliper.
Check the followings:
The right margin width is within 25 ± 0.2 mm.
The finished product width is within 50 ± 0.2 mm.
When the values are as set, go to step 8.
When they are not as set, go to step 5.



5. Press the CURSOR (Up/Down) key to move the cursor to the slit position to adjust.
Enter the value of each finished product width using the NUMERIC key.

REFERENCE

Pressing and holding the CLEAR key resets the value to the default. (This is not the factory setting.)

6. Press the SET key to save the value.

REFERENCE

Automatically calculated value is reflected in **H49**.

7. Repeat steps 2 to 6 until the finished product is processed as set.

8. Press the STOP key.

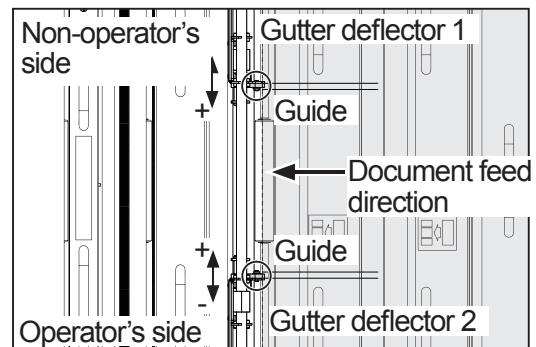
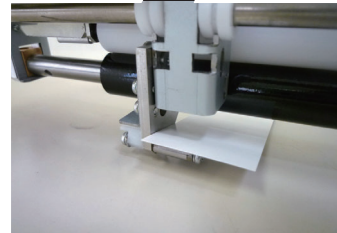
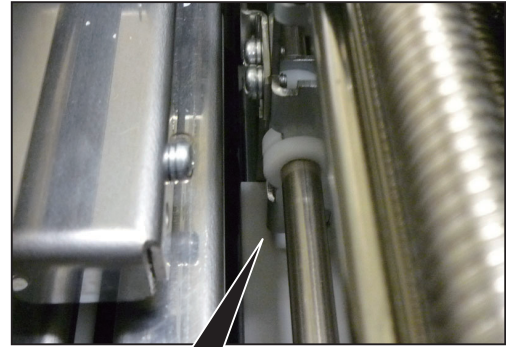
The HELP mode selection display will reappear.

JOB84	Slit check
JOB name	SLIT CK
Paper width	297
Total length	420
SLOT2	Not specified *1
SLOT3	SLITTER
SLOT4	SLITTER
Side mark	0
Lead mark	0
Slit 1	25
Slit 2	275
Slit 3	75
Slit 4	225
Slit 5	125
Slit 6	175
Cut 1	0
Crease 1	0
SLOT2 X1-1(R)	0
SLOT2 X1-2(L)	0
Air knife	OFF
Side blow fan	MID
Fan reg.	MAX
REG mark	OFF
Slitter guide	ON
Cut trim mode	Full bleed mode
Crease depth	MID
Speed	FAST
Auto trail cut	OFF

*1 JOB is processed with any module installed.
However, **Standard** is always displayed for JOB property.

● **Checking the gutter guide assy position**

1. Turn on the power while simultaneously pressing the both JOG keys to enter the HELP mode.
2. Access the HELP-54, and press the START key.
3. Load document (230 gsm, A3, coated) on the feed tray, and press the TEST key. It is processed following the settings of **Service person JOB85**. (For details → See the table **JOB85** on page 26.)
4. The gutter deflectors move and the document is conveyed close to the gutter guide assy.
5. Press the JOG key to convey the document little by little to the position where the gutter deflectors and the document can be adjusted.
6. Check the positions of the two gutter guide assys.
When the positions are correct, go to step 12.
When adjustment is necessary, go to step 7.
7. Use the CURSOR (Right/Left) key to select a gutter guide assy (1, 2).
1: gutter guide assy (non-operator's side)
2: gutter guide assy (operator's side)
8. Press the CURSOR (Up/Down) key to adjust the gutter guide assy selected in step 7 to the document edge.



Adjust the guide so that the slit gutter (edge of the finished product) fits to the guide surface.

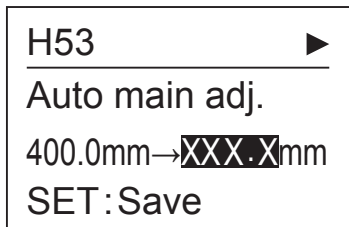
9. If you adjust the other gutter deflector continuously, use the CURSOR (Right/Left) key to select a gutter deflector (1, 2). Then carry out the adjustment in a similar way to step 8.
10. Press the F key to save the adjustment value.
11. Press the JOG key to convey the document to the exit tray. Go to step 14.
12. Press the JOG key to convey the document to the exit tray.
13. Press the STOP key to cancel adjustment mode.
14. Press the STOP key.
The HELP mode selection display will reappear.

JOB85	Slit position check
JOB name	SLIT CK
Paper width	297
Total length	420
SLOT2	Not specified *1
SLOT3	SLITTER
SLOT4	SLITTER
Side mark	0
Lead mark	0
Slit 1	5
Slit 2	285
Slit 3	95
Slit 4	195
Slit 5	100
Slit 6	100
Cut 1	0
Crease 1	0
SLOT2 X1-1(R)	0
SLOT2 X1-2(L)	0
Air knife	OFF
Side blow fan	MID
Fan reg.	MAX
REG mark	OFF
Slitter guide	ON
Cut trim mode	Full bleed mode
Crease depth	MID
Speed	FAST
Auto trail cut	OFF

*1 JOB is processed with any module installed.
However, **Standard** is always displayed for
JOB property.

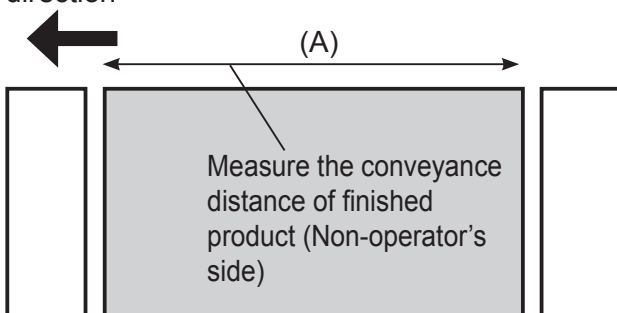
● Checking the sheet conveying distance

1. Turn on the power while simultaneously pressing the both JOG keys to enter the HELP mode.
2. Access the **HELP-53**, and press the START key.



3. Load A3 document (230 gsm, coated) on the feed tray, and press the TEST key. It is processed following the settings of **Service person JOB91**. (For details → See the table **JOB91** on page 27.)
4. Measure the finished product (A) with a vernier caliper or ruler. Check if the length is specified value ± 0.2 mm. Check if the length of the finished product is 400 mm. When the length is as set, go to step 8. When it is not as set, go to step 5.

Document feed direction



5. Enter the measured value into $\times\times.\times$ by pressing the NUMERIC key.

REFERENCE

- Pressing and holding the CLEAR key resets the value to the default value (400.0 mm \rightarrow 0.0 mm). (This is not the factory setting.)
- Pressing the JOG key conveys the document backward and forward.

6. Press the SET key to save the value.

REFERENCE

Automatically calculated value is reflected in **H52**.

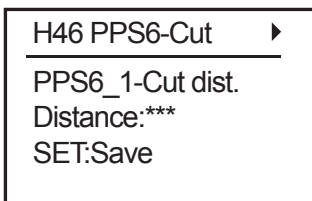
7. Repeat steps 2 to 6 until the finished product is processed as set.
8. Press the STOP key. The HELP mode selection display will reappear.

JOB91	Adjustment of vertical enlargement
JOB name	H-52 CK2
Paper width	297
Total length	420
SLOT2	Not specified *1
SLOT3	Not specified *1
SLOT4	Not specified *1
Side mark	0
Lead mark	0
Slit 1	0
Slit 2	0
Slit 3	0
Slit 4	0
Slit 5	0
Slit 6	0
Slit 7	0
Slit 8	0
Cut 1	5
Cut 2	405
Cut 3	0
Crease 1	0
SLOT2 X1-1(R)	0
SLOT2 X1-2(L)	0
Air knife	OFF
Side blow fan	MID
Fan reg.	MAX
REG mark	OFF
Slitter guide	ON
Cut trim mode	Full bleed mode
Crease depth	MID
Speed	FAST
Auto trail cut	OFF

*1 JOB is processed with any module installed. However, **Standard** is always displayed for JOB property.

● **Checking the alignment and the distance of the cut/crease positions**

1. Turn on the power while simultaneously pressing the both JOG keys to enter the HELP mode.
2. Access the HELP-46, and press the START key.
3. Load A3 document (230 gsm, coated) on the feed tray, and press the TEST key.
The document is processed following the settings of **Service person JOB83**.
(For details → See the table **JOB83** on page 29.)
4. Measure the finished product with a vernier caliper to check if it is processed as set.
When the lead margin (the first cut) is 10 mm (within ±0.1 mm), go to step 7.
When it is different, go to step 5.
5. Adjust the cut position (PPS6-1):
Set the lead margin (the first cut) position using the NUMERIC keys.
Decreasing the value moves the cut position toward the document lead edge.
Increasing the value moves the cut position toward the document trail edge.
Press the SET key to save the settings.

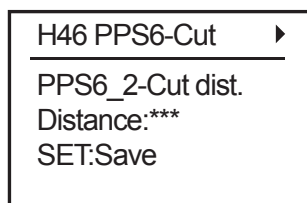


REFERENCE

Pressing and holding the CLEAR key resets the value to the default. (This is not factory setting.)

6. Repeat steps 2 to 5 until the finished product is processed as set.
7. Press the CURSOR (Right) key to display the **PPS6_2-Cut dist.** screen.
8. Load A3 document (230 gsm, coated) on the feed tray, and press the TEST key to process one sheet.
The document is processed following the settings of **Service person JOB83**.
(For details → See the table **JOB83** on page 29.)

9. Measure the finished product with a vernier caliper to check if it is processed as set.
When the lead margin (the first cut) is 10 mm, go to step 12.
When it is different, go to step 10.
10. Adjust the cut position (PPS6-2):
Set the lead margin (the first cut) position using the NUMERIC keys.
Decreasing the value moves the cut position toward the document lead edge.
Increasing the value moves the cut position toward the document trail edge.
Press the SET key to save the settings.



REFERENCE

Pressing and holding the CLEAR key resets the value to the default. (This is not factory setting.)

11. Access the HELP-46, and press the START key.
Repeat steps 7 to 11 until the finished product is processed as set.
12. Press the STOP key.
13. Access the HELP-47, and press the START key.
14. Press the TEST key.
15. Measure the finished product with a vernier caliper to check if it is processed as set.
When the crease position is 100 mm (within ±0.1 mm), go to step 18.
When it is different, go to step 16.

16. Adjust the crease position:

Enter the first crease position using the NUMERIC keys.

Decreasing the value moves the crease position toward the document lead edge.

Increasing the value moves the crease position toward the document trail edge.

Press the SET key to save the settings.

H47
Cut-Crease dist.
Distance:***
SET:Save

IMPORTANT

When the set cut distance is changed, the crease distance is also changed. Therefore re-adjust the **HELP-47 Crease Distance** every time you change the cut position.

REFERENCE

Pressing and holding the CLEAR key resets the value to the default. (This is not factory setting.)

17. Repeat steps 13 to 16 until the finished product is processed as set.

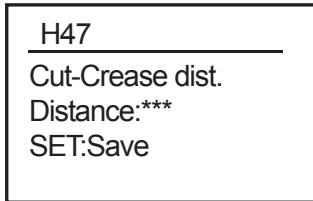
18. Turn off the power.

JOB83	Cut&Crease check
JOB name	CUT&CRE CK
Paper width	297
Total length	420
SLOT2	Not specified *1
SLOT3	Not specified *1
SLOT4	Not specified *1
Side mark	0
Lead mark	0
Slit 1	25
Slit 2	285
Slit 3	0
Slit 4	0
Slit 5	0
Slit 6	0
Cut 1	10
Cut 2	0
Crease 1	110
Crease 2	0
SLOT2 X1-1(R)	0
SLOT2 X1-2(L)	0
Air knife	OFF
Side blow fan	MID
Fan reg.	MAX
REG mark	OFF
Slitter guide	ON
Cut trim mode	Full bleed mode
Crease depth	High
Speed	FAST
Auto trail cut	OFF

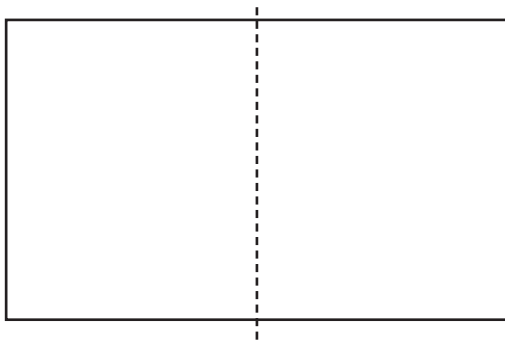
*1 JOB is processed with any module installed. However, **Standard** is always displayed for JOB property.

● **Checking the alignment and the distance of the crease position**

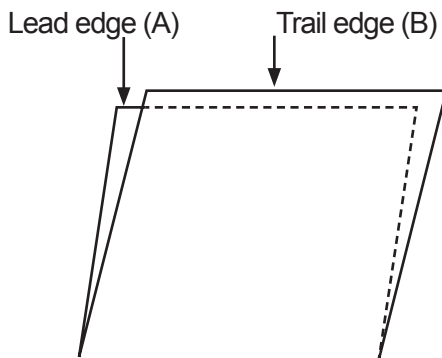
1. Turn on the power while simultaneously pressing the both JOG keys to enter the HELP mode.
2. Access the HELP-47, and press the START key.



3. Load A3 document (230 gsm, coated) on the feed tray, and press the START key. It is processed following the settings of **Service person JOB54**. (For details → See the table **JOB54** on page 30.)
4. The center of the document is creased.



5. Fold the center of the document (ceased position) to check if the lead edge (A) overlaps with the trail edge (B) perfectly.



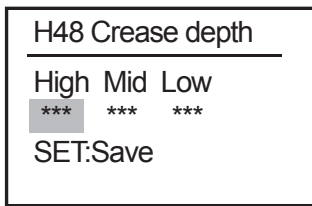
6. When the lead edge (A) overlaps with the trail edge (B) perfectly, turn off the power and go to ● Checking the crease depth on page 31. When these edges do not overlap perfectly, press the STOP key and go to ● Checking the alignment and the distance of the cut/crease positions on page 28.

JOB54	Adjustment of crease alignment
JOB name	CRE CK
Width	297
Length	420
SLOT2	Not specified *1
SLOT3	Not specified *1
SLOT4	Not specified *1
Side mark	0
Lead mark	0
Slit 1	10
Slit 2	290
Slit 3	0
Slit 4	0
Slit 5	0
Slit 6	0
Cut 1	10
Cut 2	410
Cut 3	0
Crease 1	210
SLOT2 X1-1(R)	0
SLOT2 X1-2(L)	0
Air knife	OFF
Side blow fan	MID
Fan reg.	MID
REG mark	OFF
Slitter guide	ON
Cut trim mode	Full bleed mode
Crease depth	High
Speed	FAST
Auto trail cut	OFF

*1 JOB is processed with any module installed. However, **Standard** is always displayed for JOB property.

● **Checking the crease depth**

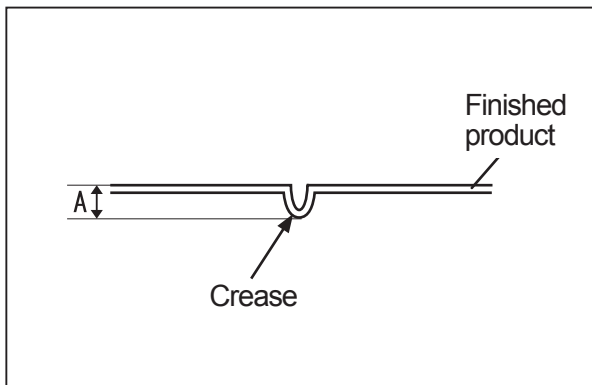
1. Turn on the power while simultaneously pressing the both JOG keys to enter the HELP mode.
2. Access the HELP-48, and press the START key.
3. Load A3 document (230 gsm, coated) on the feed tray. Make sure that the value of **High** is highlighted, and press the TEST key.
The document is processed following the settings of **Service person JOB83**.
(For details → See the table **JOB83** on page 29.)



4. Measure the crease depth of the finished product with a vernier caliper.
When the crease depth is within 0.37 to 0.42 mm, go to step 7.
When it is not, go to step 5.
5. Adjust the crease depth:
The setting of **Crease depth** of **Service person JOB83** is set to **High**.
If the depth is larger than 0.37 to 0.42 mm, decrease the value of **High**.
(The crease becomes shallower.)
If the depth is smaller than 0.37 to 0.42 mm, increase the value of **High**.
(The crease becomes deeper.)

REFERENCE

Crease depth **High** and **Low** mean the dimension of A in the figure below after the finished product is creased.



6. Press the SET key to save the adjustment value. Repeat steps 2 to 6 until the finished product is processed as set.
7. Turn off the power.

