

Duplo

from print to documents

INSTRUCTION MANUAL

SLITTER / CUTTER / CREASER

DC - 646

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

Introduction

Thank you for your purchase of the DC-646.

To ensure safe and efficient prolonged use of this machine, read and thoroughly understand this manual before using the machine.

After using this manual, be sure to keep it in a handy place to reference.

Pictorial Symbols and Other Notations Used in This Manual

IMPORTANT : Introduces instructions for correct operation of the machine.
If these instructions are ignored, the machine may not be able to operate at optimum performance or may break down.

REFERENCE : Introduces information that is useful for operation and maintenance of the machine, or information about the machine's performance, etc.

(→ P.00 xxxx) : Indicates the page number and item containing related information.

The English version of DC-646 Instruction Manual is original instructions.

Trademarks

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All other trademarks are the property of their respective owners.

PLEASE NOTE

In the interests of upgrading our product, specifications and other data given in this manual are subject to change without notice.

If the manual contains anything that you do not understand, contact the dealer for clarification.



For EU

DECLARATION OF CONFORMITY

Duplo Seiko Corporation, located at 353, Koudai, Kinokawa-shi, Wakayama 649-6551, Japan, declares that the product (or products) complies with the provisions defined in the regulations. The reference table is mentioned below.

Low Voltage Directive 2014/35/EU
Machinery Directive 2006/42/EC
Electromagnetic Compatibility Directive 2014/30/EU
Restriction of Hazardous Substances Directive 2011/65/EU

Keeper of the technical file in the European Community:

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En

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Die Duplo Seiko Corporation mit Sitz in 353, Koudai, Kinokawa-shi, Wakayama 649-6551 Japan, erklärt hiermit, dass das Produkt (oder die Produkte) die in den Vorschriften definierten Bestimmungen erfüllt. Die Bezugstabelle ist unten aufgeführt.

Niederspannungsrichtlinie 2014/35/EU
Maschinenrichtlinie 2006/42 EG
Richtlinie 2014/30/EU zur elektromagnetischen Verträglichkeit
Richtlinie 2011/65/EU zur Beschränkung der Verwendung bestimmter gefährlicher Stoffe

Inhaber der technischen Datei in der Europäischen Gemeinschaft:

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Directive 2014/35/UE relative au matériel électrique destiné à être employé dans certaines limites de tension
Directive 2006/42/CE relative aux machines
Directive 2014/30/UE concernant la compatibilité électromagnétique
Directive 2011/65/UE relative à la limitation de l'utilisation de certaines substances dangereuses

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Direttiva 2014/35/UE relativa alle apparecchiature a bassa tensione
Direttiva 2006/42/CE sui macchinari
Direttiva 2014/30/UE di compatibilità elettromagnetica
Direttiva 2011/65/UE sulla restrizione dell'uso di sostanze pericolose

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Directiva 2014/35/UE sobre baja tensión
Directiva 2006/42/CE sobre máquinas
Directiva 2014/30/UE sobre compatibilidad electromagnética
Directiva 2011/65/UE de restricción de sustancias peligrosas

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Sp



Disposal of Old Electrical & Electronic Equipment

This symbol (the symbol of the crossed out wheeled bin) indicates that in European countries this product should not be disposed of as household waste.

Please recycle where facilities exist by checking with your local authority or supplier for recycling advice.

By ensuring this product is disposed of correctly through proper treatment, recovery and recycling, you will help prevent potential negative effects on the environment and human health.

En



Entsorgung von alten elektrischen und elektronischen Ausrüstungsteilen

Dieses Symbol (das Symbol mit dem durchgekreuzten fahrbaren Müllbehälter) zeigt an, dass dieses Produkt in europäischen Ländern nicht als Haushaltsmüll entsorgt werden darf. Bitte informieren Sie sich bei Ihren örtlichen Behörden oder bei Ihrem Händler hinsichtlich einer Empfehlung für die Entsorgung und führen Sie die betreffenden Teile dort, wo solche Einrichtungen vorhanden sind, einem Recycling-Prozess zu.

Indem sie sicherstellen, dass das betreffende Produkt durch richtige Behandlung, Rückführung und Recycling entsorgt wird, tragen Sie dazu bei, möglichen negativen Auswirkungen auf die Umwelt und die menschliche Gesundheit vorzubeugen.

Ge



Élimination du matériel électronique et électrique usagé

Ce symbole (une poubelle marquée d'une croix) indique que dans les pays européens, ce produit ne doit pas être éliminé comme des ordures ménagères.

Recyclez-le dans les sites adaptés qui vous seront indiqués par les autorités locales ou renseignez-vous auprès de votre fournisseur.

En veillant à ce que ce produit soit éliminé correctement avec un traitement, une collecte et un recyclage adaptés, vous contribuez à éviter son action nocive potentielle sur l'environnement et la santé humaine.

Fr



Smaltimento di attrezzature elettriche ed elettroniche consumate

Questo simbolo (il simbolo della pattumiera con rotelle barrata) indica che nei paesi europei questo prodotto non deve essere buttato nei rifiuti domestici.

Per favore smaltire in luogo addetto al riciclo, dove esistente, chiedendo informazioni alle autorità locali o a chi fornisce consulenza a proposito.

Garantendo uno smaltimento adeguato di questo prodotto (trattamento, recupero e riciclo corretto), aiuterete a prevenire effetti negativi sull'ambiente e sulla salute dell'uomo.

It



Eliminación de residuos de aparatos eléctricos y electrónicos

Este símbolo (un cubo de basura tachado) indica que en los países europeos este producto no deberá eliminarse como si se tratara de un residuo doméstico. Solicite asesoramiento sobre reciclaje a las autoridades locales o a su distribuidor, y siga la normativa en materia de gestión medioambiental y reciclaje de este tipo de residuos.

Si toma las medidas pertinentes para que este producto se elimine mediante un tratamiento, recuperación y reciclaje adecuados, contribuirá a evitar posibles efectos negativos en el medio ambiente y la salud humana.

Sp

Notes on Safety (Please Read and Observe)

Safety Precautions

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

The meanings of these symbols and pictures are explained below.

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

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

<Examples of Pictorial Symbols>



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



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

• Precautions for Use

WARNING



- If the machine is used after foreign matter (metal fragments, water, or liquid) has entered the machine, this may result in fire or electric shock.
→ Turn the main unit's power switch OFF, and then remove the power plug from the outlet. Contact the sales distributor.



- If the machine is used after heat, smoke, a strange smell, or other abnormality has been detected, this may result in fire or electric shock.
→ Turn the power switch OFF, and then remove the power plug from the outlet. Contact the sales distributor.



- Do not insert or drop metal, flammable material, or any other materials through the ventilation holes into the interior of the machine.
→ Doing so may result in fire or electric shock.



- Keep the machine away from a pin, wire, or other metallic or foreign objects. Do not allow liquid to enter the machine through its openings or gaps.
→ Malfunctions and a fire or electric shock may result.



- Do not place flower vases, flowerpots, cups, or water containers (including metal containers) on top of the machine.
→ Fire or electric shock may result if liquid spills inside the machine.

● **Caution for Grounding**

 **WARNING**



- 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.

● **Caution for Power Supply and Power Cord**

 **WARNING**



- Use only the power cord that is provided among the accessories. The power cord is only for this product. Never use it for another product.
- 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.



- Be sure to remove dust from the power plug and/or the outlet. Using these without removing dust may have minute electric current flow to the surface due to the humidity and cause a fire due to the heat.
- It may cause a fire or electric shock.



- Do not remove or insert the power plug with wet hands.
- Doing so may result in electric shock.



- Do not damage, break, or modify the power cord. Do not place heavy objects on, tug or bend it unnecessarily.
- Doing so may result in fire or electric shock.



- Remove the power plug itself, not the cord.
- Tugging the cord may damage it (expose conductors, or cause disconnections, etc.), resulting in fire or electric shock.

Notes on Safety (Please Read and Observe)

● Prohibition of Disassembly or Modification

WARNING



- Do not modify the machine.
→ Doing so may result in fire or electric shock.



- Do not remove the rear lid, cabinet, or covers from the machine.
→ The inside of the machine contains high-voltage parts, which may cause electric shock.

● Caution for Location

WARNING



- Do not place the machine in a humid or dusty area.
→ Doing so may result in fire or electric shock.



- The machine is not suitable for use in locations where children are likely to be present.

CAUTION



- Before moving the machine, remove the power plug from the outlet.
→ If the power cord is damaged, this may result in fire or electric shock.



- Do not place the machine in an unstable position such as on an unsteady floor or a sloping area.
→ If the machine drops or falls over, it may result in injury.



- Avoid placing the machine in a place subject to direct sunlight or heating equipment such as a stove.
- Avoid placing the machine in a place subject to high or low temperature or high humidity.
→ The document absorbs moisture and it may cause document jam or wrinkles.



- Leave the power cord unplugged when the machine is not used for a long period.
→ The insulation may deteriorate and cause an electrical fire.

• **Caution for Cleaning**

 **CAUTION**



- Before cleaning the machine, turn off the power switch and unplug the power cord.
→ If the machine is activated accidentally, it may cause injury.



- Do not use flammable sprays or solvents inside or near the machine.
→ Gas may accumulate inside the machine causing a fire or explosion.

• **Preventing Injury to Hands or Fingers**

 **WARNING**



- The optional modules contain uncovered tools. Keep your hands or fingers off inside those.



- Use pliers or a similar tool to remove jammed document.
Be sure to unplug the power cord before removing jammed document in order to prevent an electric shock.

• **Caution for Installation**

 **WARNING**



- The machine must be installed by service person only.
→ If you want to change installation location, contact our service person.
(Changing location requires precise adjustment.)

 **WARNING**

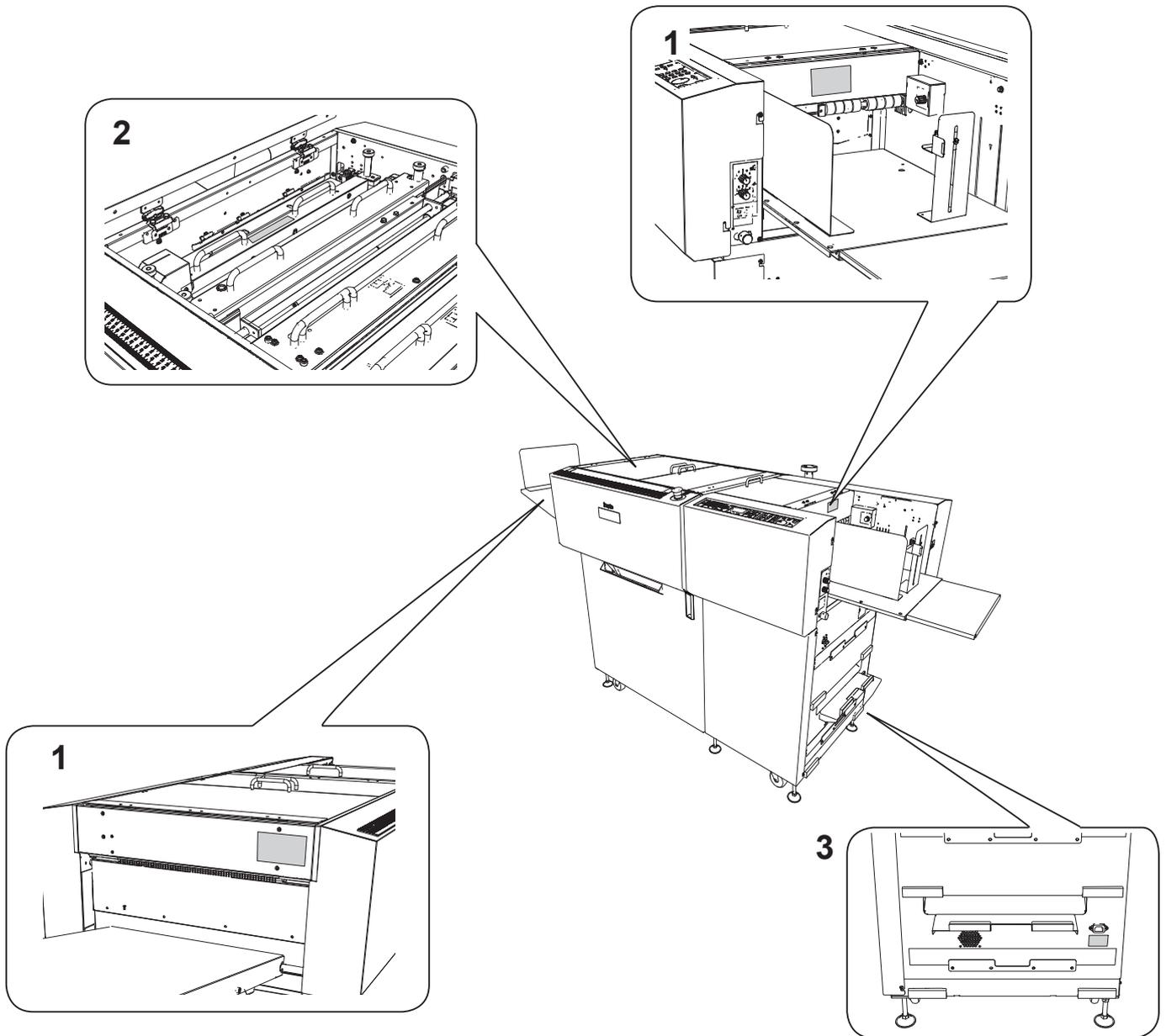


- Once the machine is in position, secure in place using the casters.
→ If the machine falls over, this could result in personal injury.

Notes on Safety (Please Read and Observe)

Locations of Warning Labels

Keep the WARNING and CAUTION labels clean at all times.
If labels become damaged or come off, contact our service person.



1

! WARNING

DO NOT put hands inside machine while it is operating.

Hands could get caught up or crushed.

M7-T3030

2

! WARNING Do not touch blade!

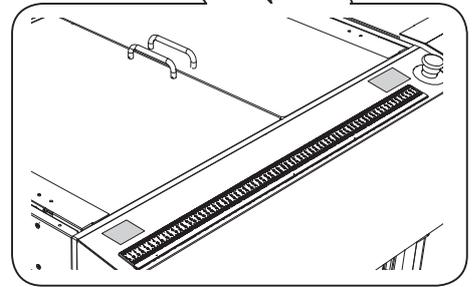
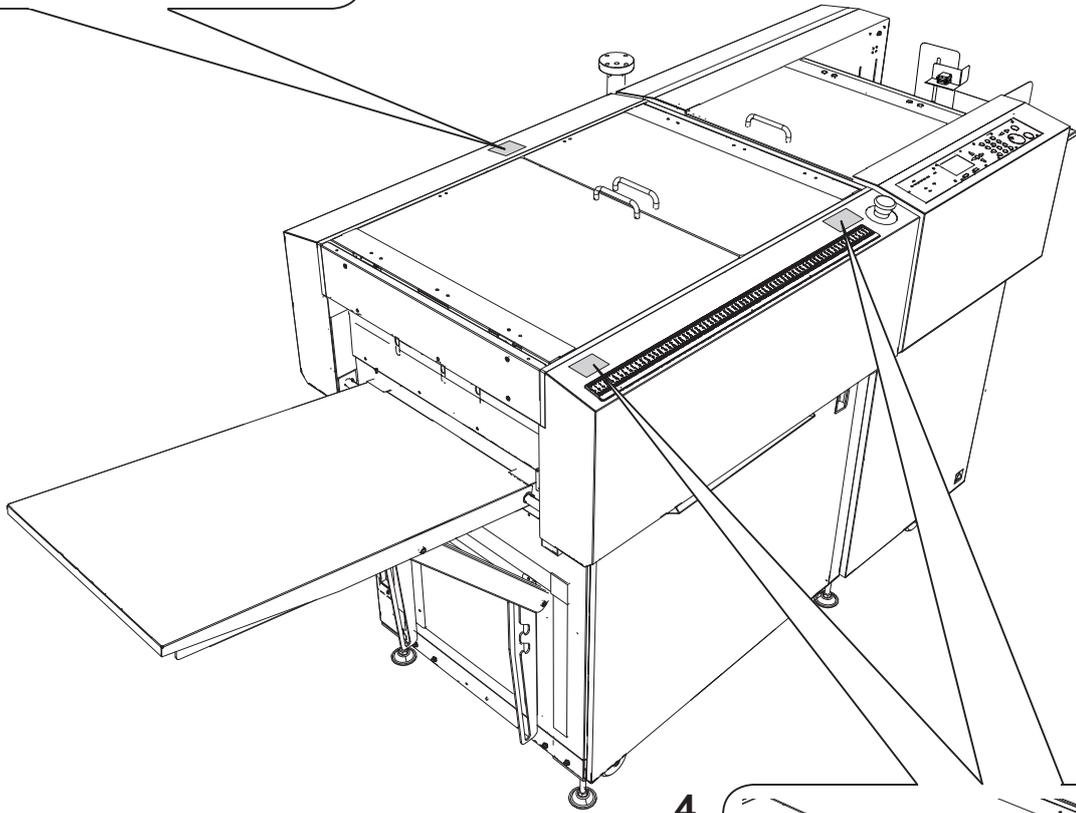
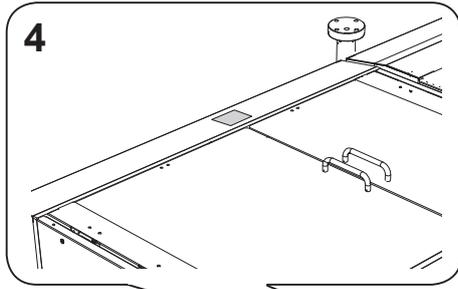
3

! CAUTION

Before removing the connector, be sure to shut off the machine by unplugging. P9-T3100

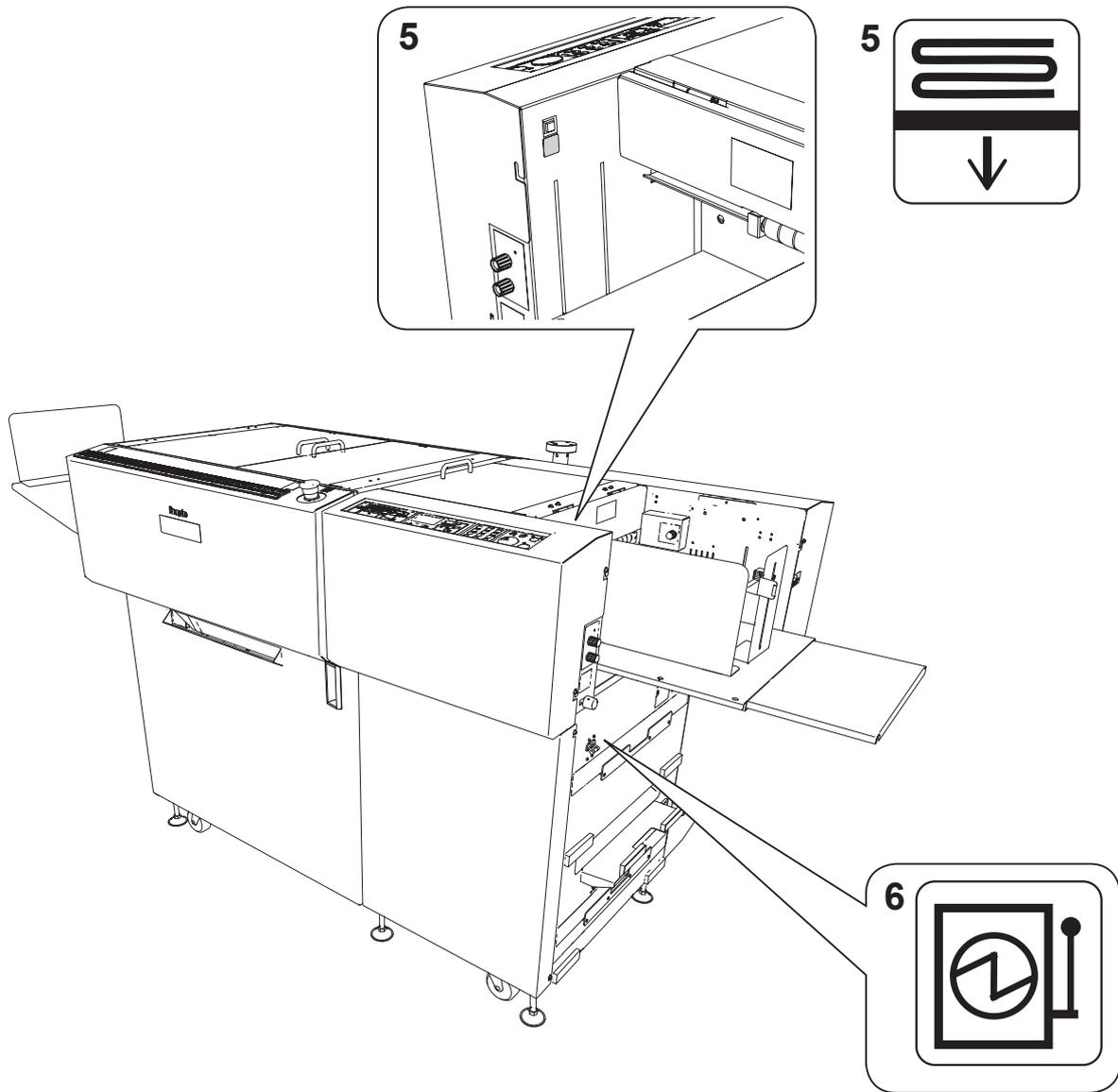
No.	Part No.	Name	Q'ty
1	M7-T303*	WARNING LABEL	2
2	L8-T107*	WARNING LABEL	1
3	P9-T310*	CAUTION LABEL	1

Notes on Safety (Please Read and Observe)



No.	Part No.	Name	Q'ty
4	K9-T139*	WARNING LABEL	3

Notes on Safety (Please Read and Observe)



No.	Part No.	Name	Q'ty
5	U7-T109*	LABEL	1

- The symbol in the LABEL indicates the elevator down switch.

230 V model only

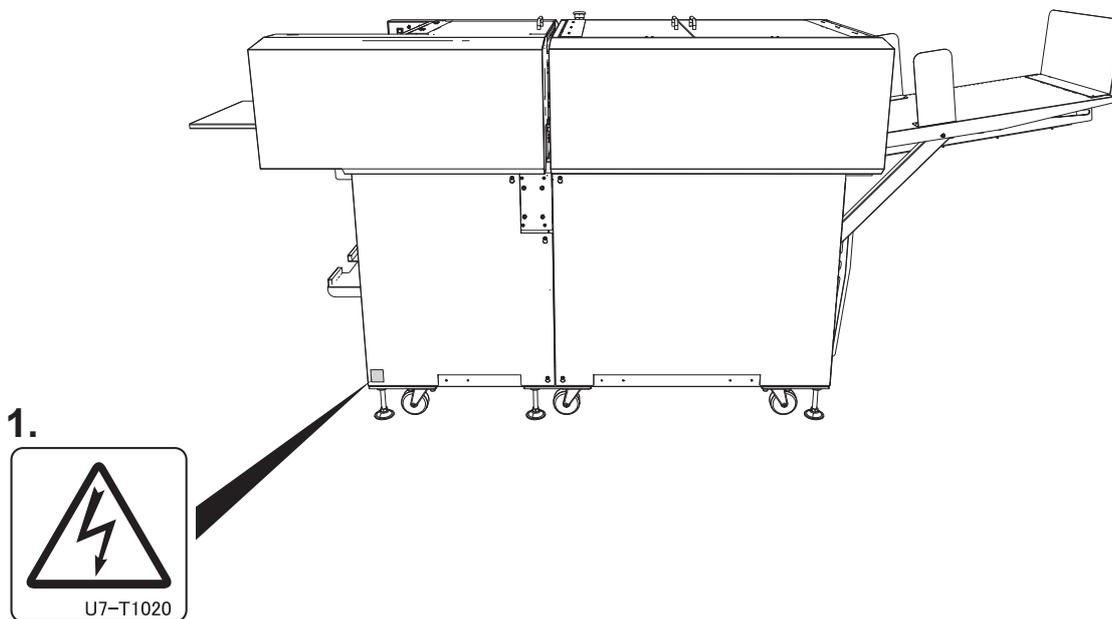
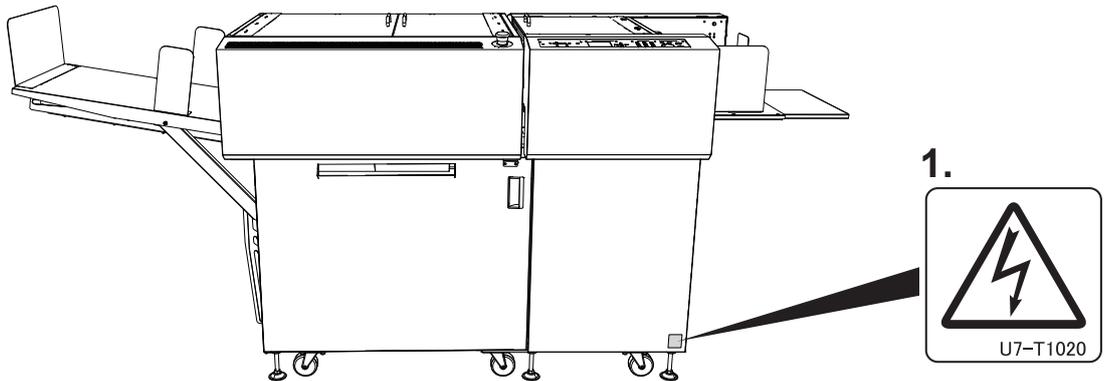
No.	Part No.	Name	Q'ty
6	U7-T108*	LABEL	1

- The symbol in the LABEL indicates the power switch.

Labels of High-Voltage Warning

There are several high-voltage area inside the machine.

230 V model only

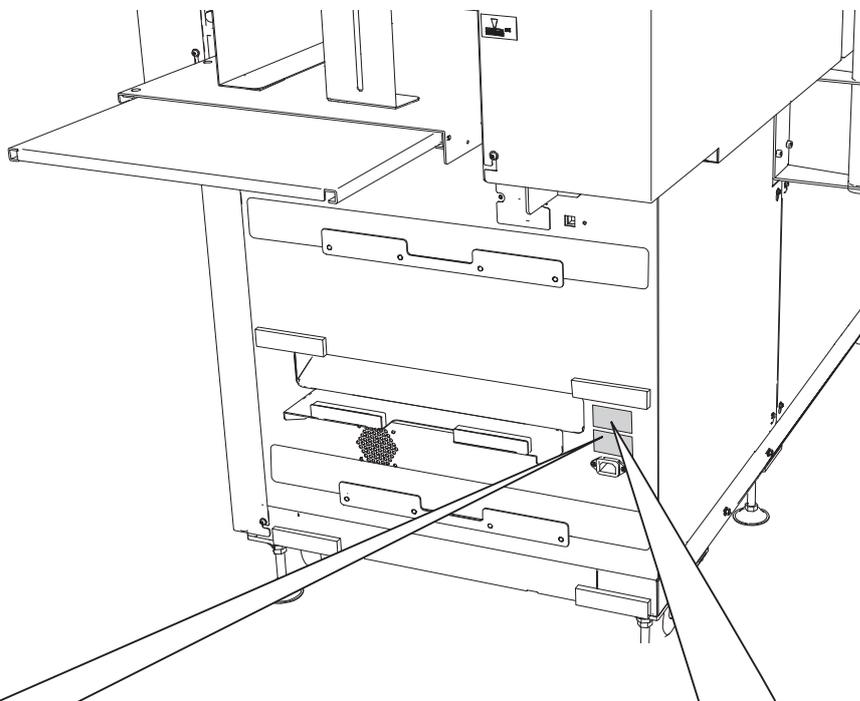


No.	Part No.	Name	Q'ty
1	U7-T102*	WARNING LABEL	2

- The safety symbol in the WARNING LABEL indicates risk of electric shock inside the machine.

Location of Rating Labels

Rating labels are located on the lower part of the ejection side.



1

Duplo		DC-646	
115V	60Hz		
4.0A			
SER. NO. *****		MADE IN JAPAN	
DUPLO SEIKO CORPORATION			

3

Weight:280Kg
 Short-circuit rating:15A ac
 Electrical diagram:W5-V700*
 Date of mfg:*.****
 Address of the manufacturer
 :353 koudai Kinokawa-shi Wakayama 649-6551
 Japan

2

Duplo		DC-646	
SLITTER/CUTTER/CREASER			
230V~ 50/60Hz single-phase			
1.9A			
SER. NO. *****		製造日期:****. **. **	
DUPLO SEIKO CORPORATION MADE IN JAPAN			

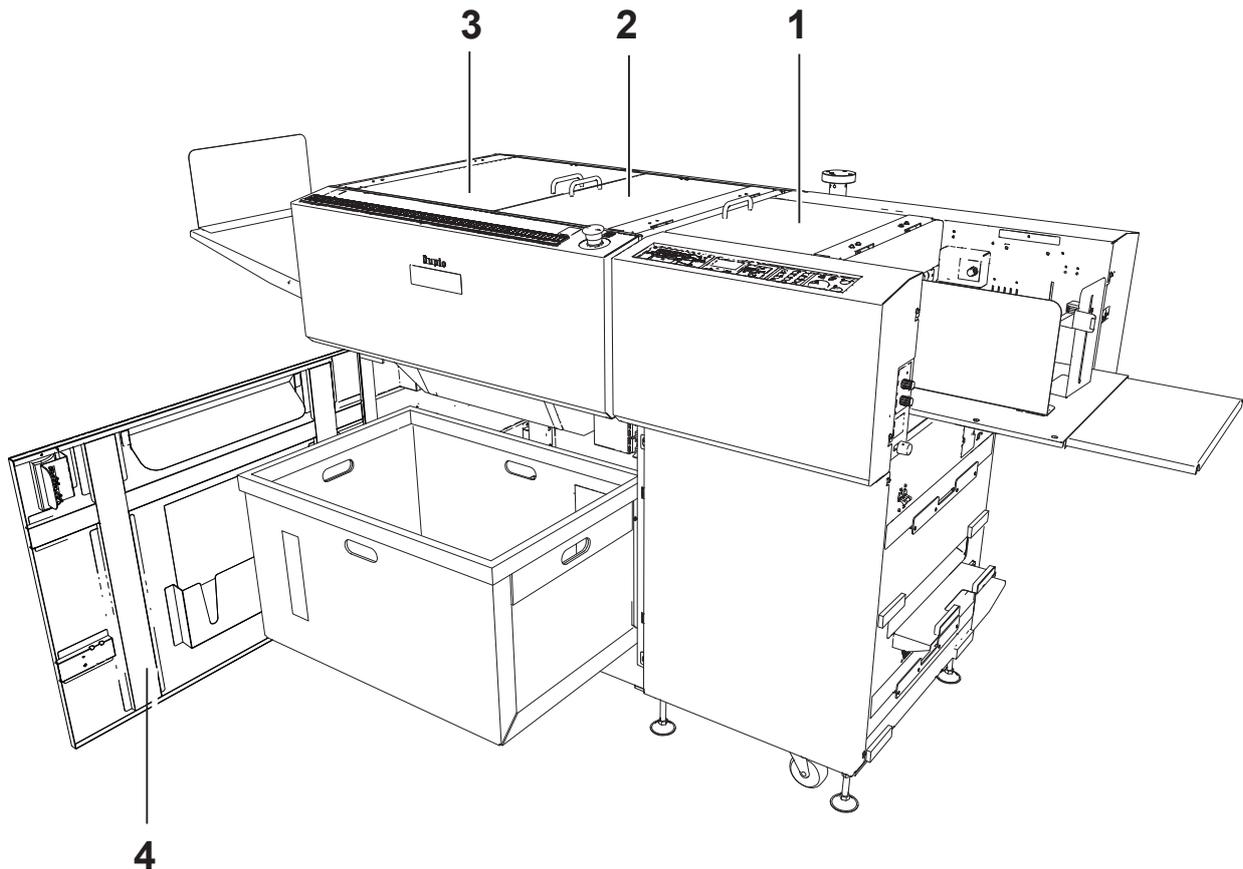
Model	Rating label
DC-646 115V	1
DC-646 230V	2, 3

Interlock System for Safety

- What is the interlock system for safety?

It is the function for keeping you safe and for avoiding any dangerous operations or situations by the limitation of operation which may cause a damage to the machine or other surrounding facilities.

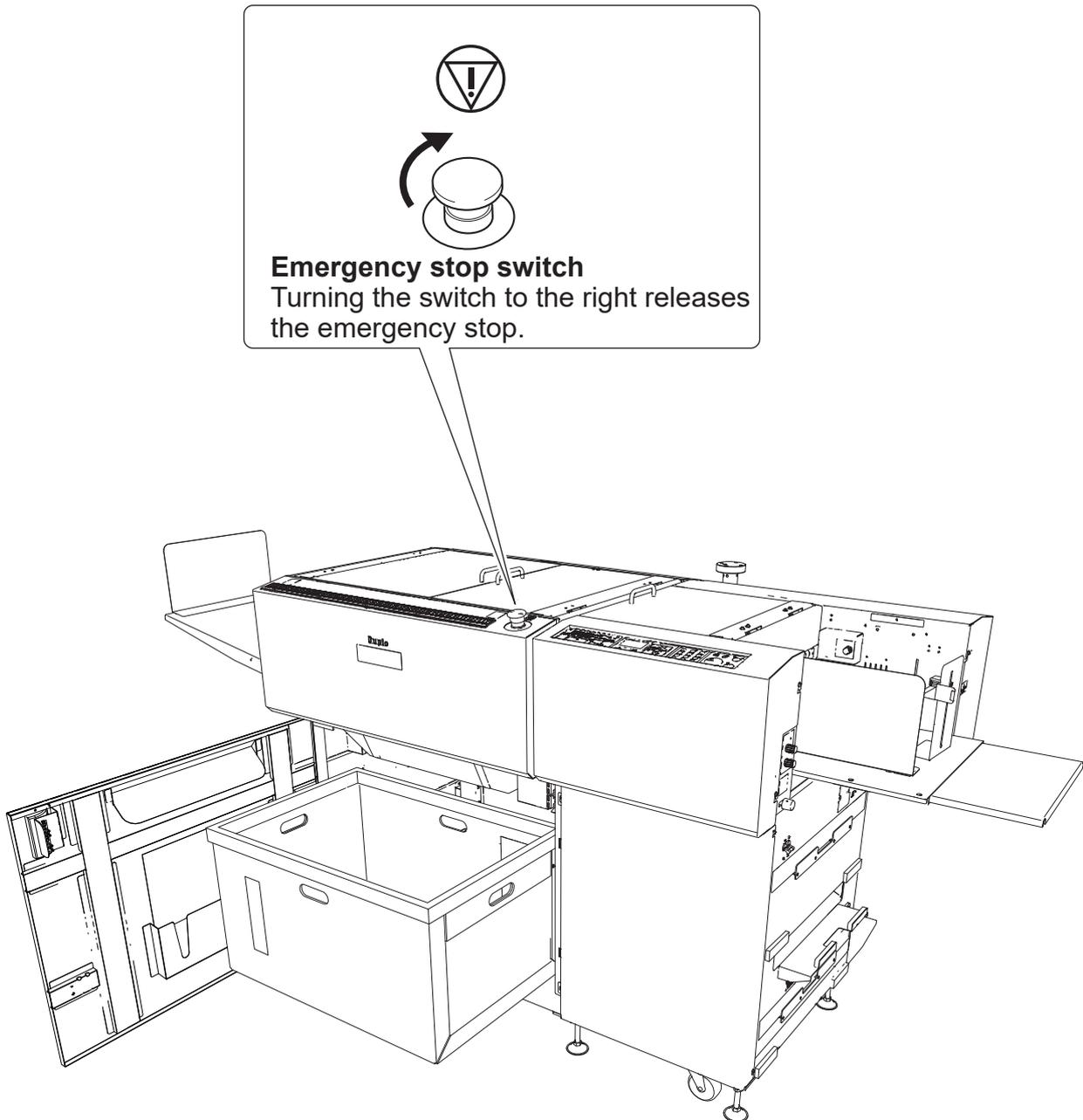
The DC-646 is equipped with various safety functions for the case of causing any dangerous operations or situations, and it stops running the operation in those cases.



No.	Name	Equipment for safety
1	Top cover 1	The DC-646 stops running when the interlock switch detects the cover opened.
2	Top cover 2	The DC-646 stops running when the interlock switch detects the cover opened.
3	Top cover 3	The DC-646 stops running when the interlock switch detects the cover opened.
4	Front cover	The DC-646 stops running when the interlock switch detects the cover opened.

Emergency Stop Function

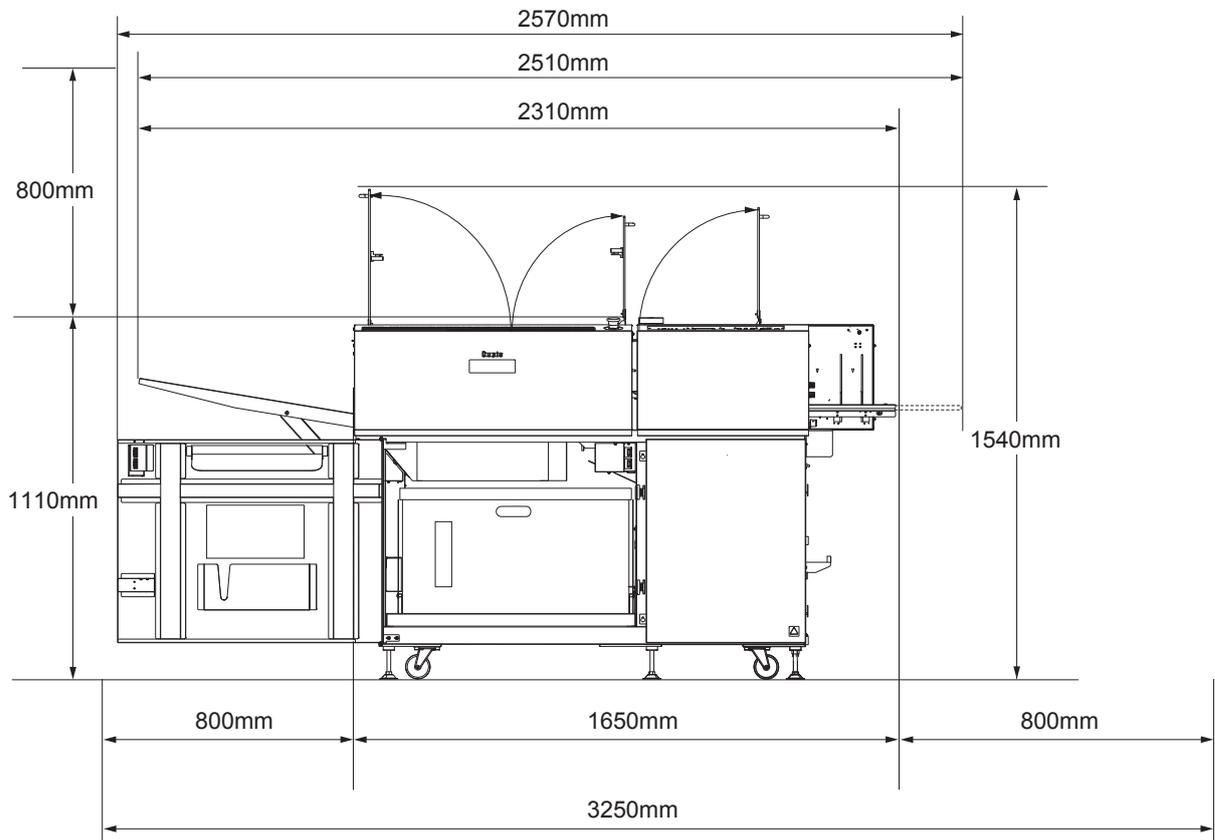
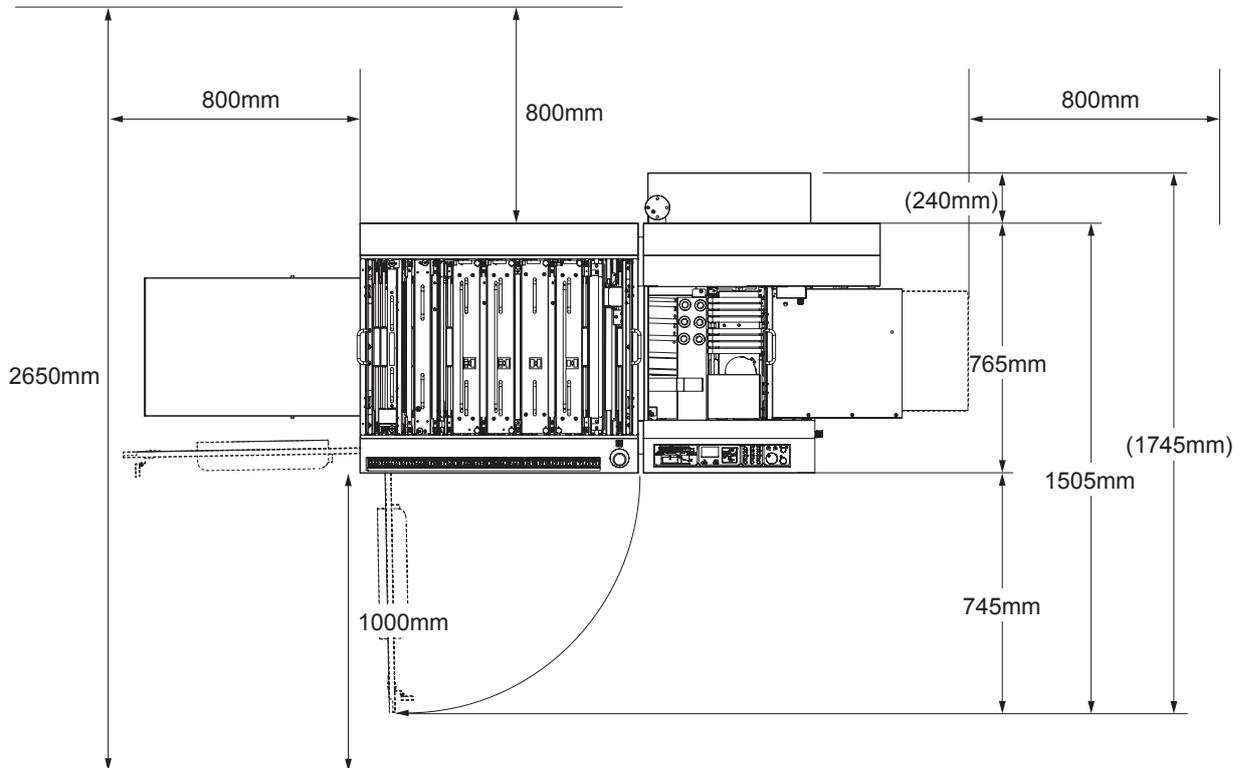
The machine is equipped with the emergency stop functions for the safety of an operator. When you need to stop the machine for emergency, press the emergency stop switch. Turning the switch to the right releases the emergency stop. To stop the machine normally, press the STOP key of this machine.



Machine Dimensions and Required Space for Operation

* With the PC arm amount attached

Dimensions in (): DC-646 115V(USA), DC-646 230V(UK)



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Chapter 1

Before Using This Machine

This chapter contains essential information you should understand such as how to set up the system, the names of the machine parts and so on.

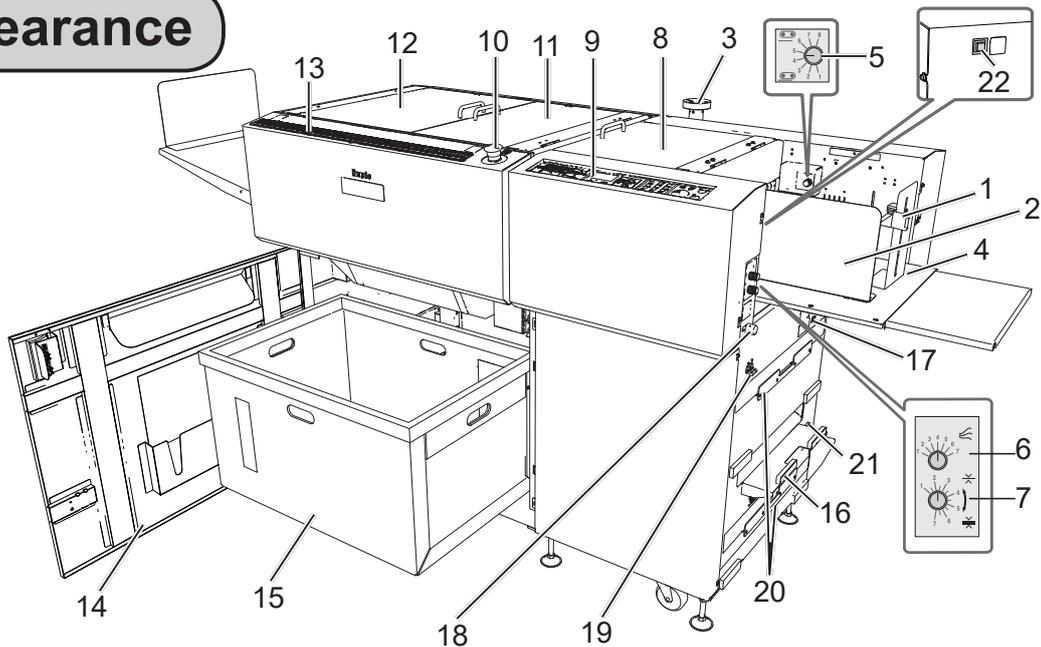
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Part Names and Their Functions

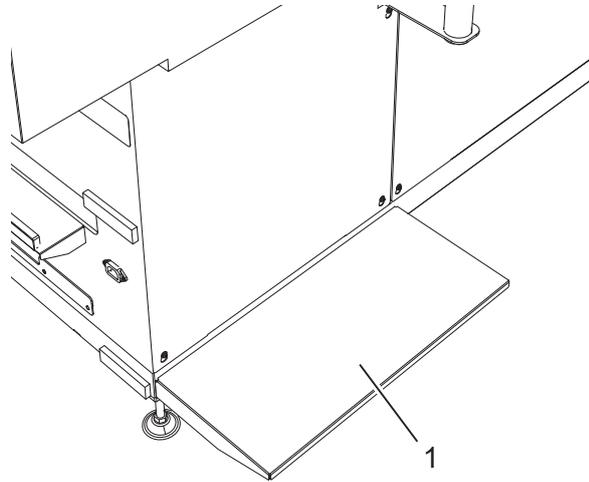
Appearance



No.	Name	Function
1	Back guide (for feed tray)	Set this according to the document size.
2	Side guide (for feed tray)	Set this according to the document size.
3	PC arm mount	Install a commercial monitor arm for putting the laptop computer. (Model: 115V (USA), 230V (UK))
4	Feed tray	Original document is placed here.
5	Level adjustment knob	Adjusts the elevator height.
6	Airflow adjustment knob	Adjusts the airflow level.
7	Separator adjustment knob	Adjusts the distance between the separator and the conveyance belt.
8	Top cover 1	Open this to move the upper guide or to remove a document jam from the document feed area. When the cover is open, the machine stops running with the interlock switch.
9	Control panel	Displays operations and status.
10	Emergency stop switch	Press this to stop the machine in an emergency. Turning the switch to the right releases the emergency stop.
11	Top cover 2	Open this to remove a document jam from the slitter/optional module area or to replace the optional module. When the cover is open, the machine stops running with the interlock switch.
12	Top cover 3	Open this to remove a document jam from the cutter/crease/optional module or to replace the optional module. When the cover is open, the machine stops running with the interlock switch.
13	Scale	Measures the cut and slit position, and the finished product.
14	Front cover	Open this to remove the waste box. When the cover is open, the machine stops running with the interlock switch.
15	Waste box	Receives pieces of waste paper.
16	Reject tray	This is where the document comes if it is rejected due to a double feed, a barcode error, or a REG mark error.
17	USB terminal	Used for the connection to your computer on the PC Controller that you are using.
18	Skew adjustment knob	Adjusts the document skew.
19	Power switch	Move this up/down to turn the power ON/OFF.

Part Names and Their Functions

No.	Name	Function
20	Module hanger	Unused modules can be hung on this.
21	AC inlet	Connect the power cord here.
22	Elevator down switch	Press this to lower the feed tray to the bottommost position.

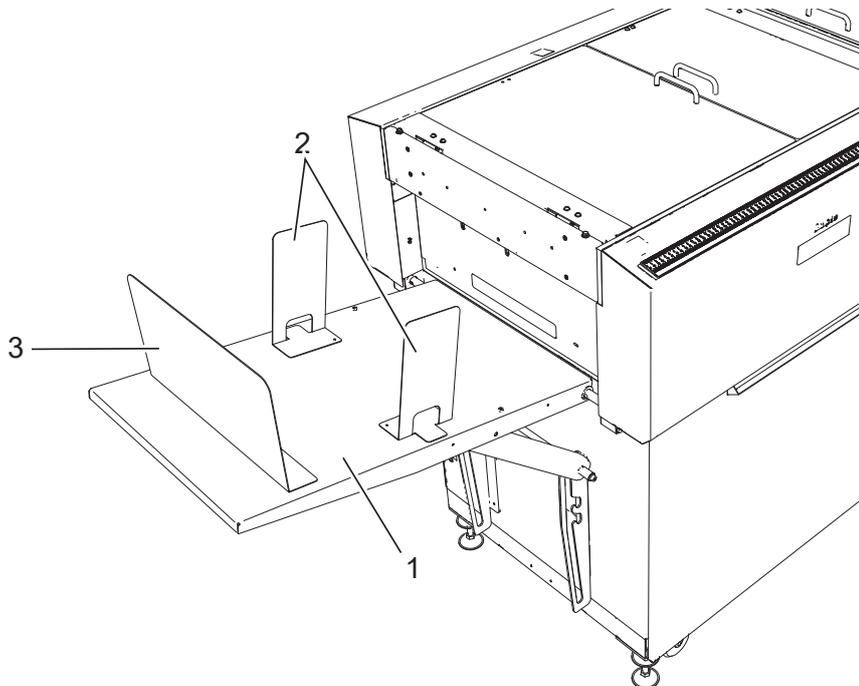


1

Before Using This Machine

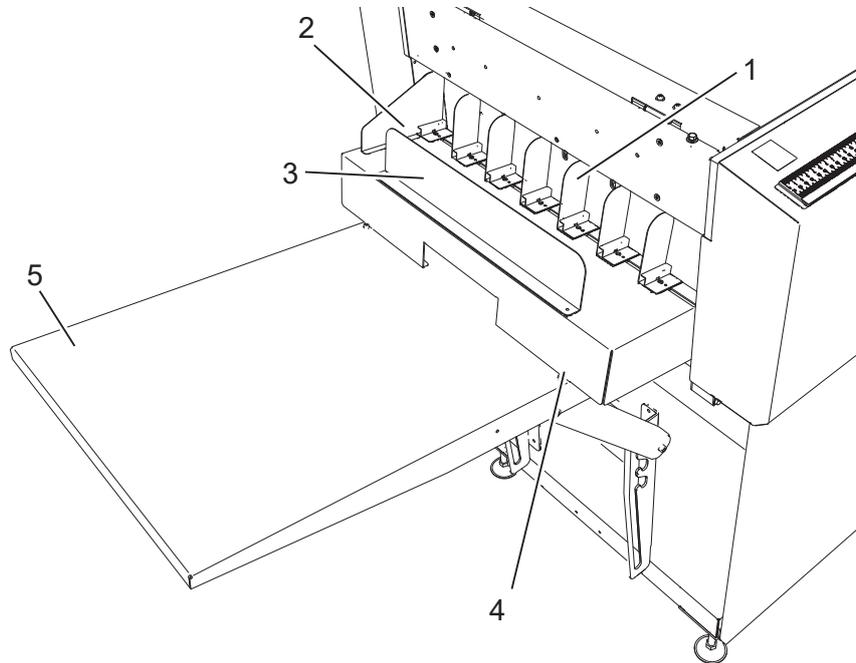
No.	Name	Function
1	PC tray	Place a desktop computer on this tray. (Model: 115V (USA), 230V (UK))

Ejection Side



No.	Name	Function
1	Exit tray	Receives finished products.
2	Side guide (for exit tray)	Set this according to the document size.
3	Back guide (for exit tray)	Set this according to the document size.

Ejection Side (with card stacker attached)

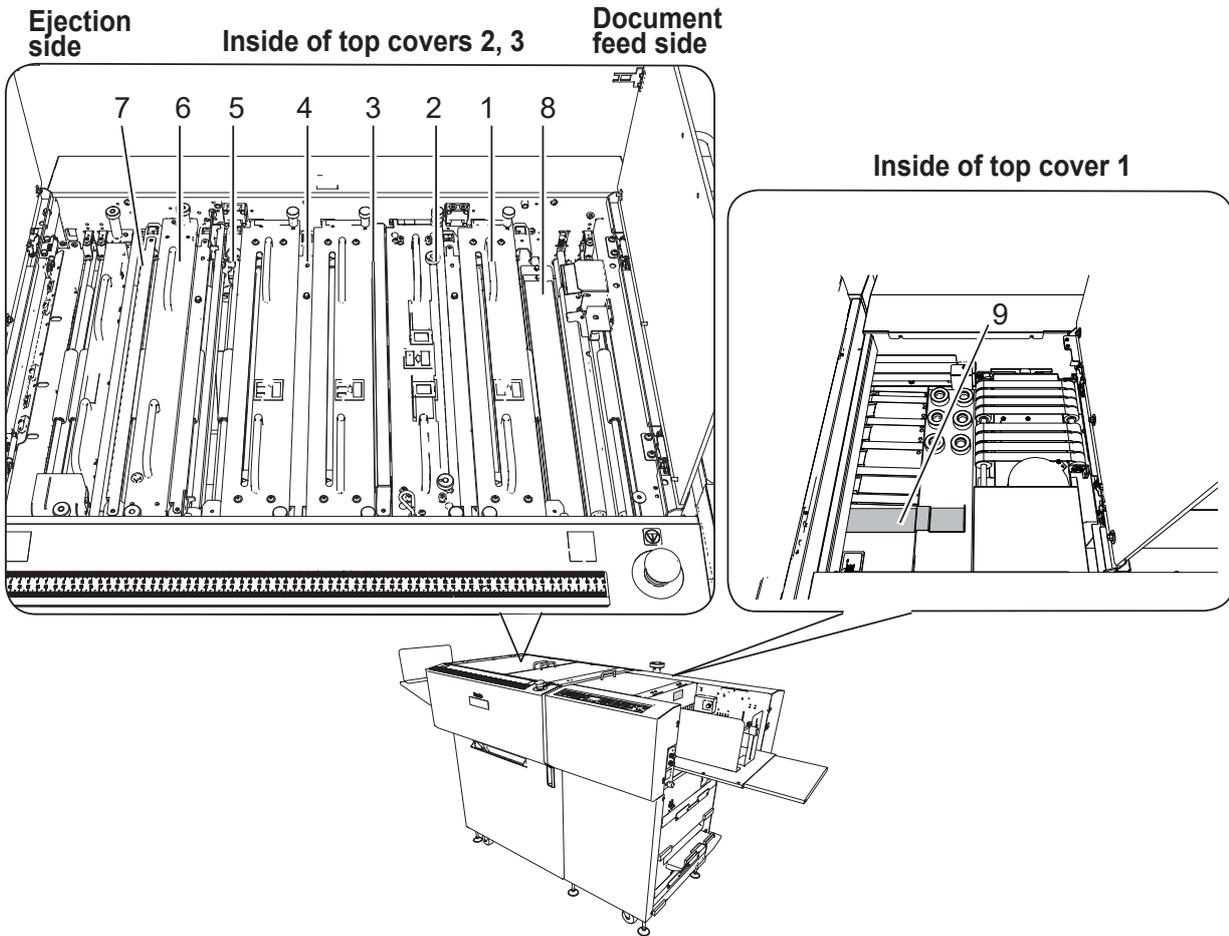


No.	Name	Function
1	Guide	Set this according to the card width.
2	Support guide (for card stacker)	Set this when document alignment is poor.
3	Guide assy (for card stacker)	Set this according to the card length.
4	Card stacker	Receives card-sized finished products.
5	Exit tray	Receives finished products.

Inside

1

Before Using This Machine

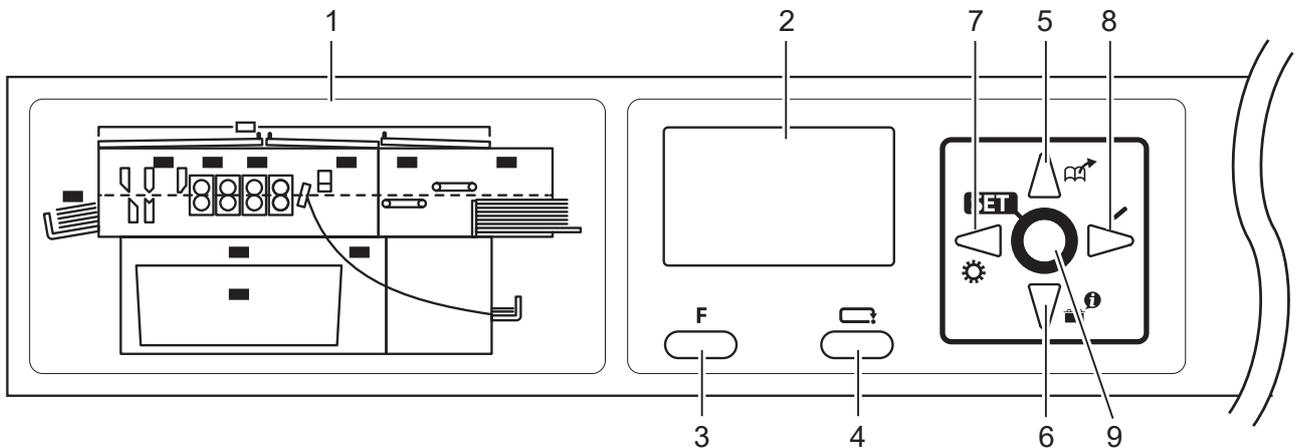


No.	Name	Function
1	Margin slitter module	Cuts off the both margins of the operator's side and the non-operator's side.
2	Standard module	You can also install the slitter module (option), the CPM (cross tool module (option)), or the RTM (rotary tool module (option)) here.
3	Center slitter module 1	Cuts a document parallel to the document feed direction. You can also install the standard module or the RTM (rotary tool module (option)) here.
4	Center slitter module 2	Cuts a document parallel to the document feed direction. You can also install the standard module or the RTM (rotary tool module (option)) here.
5	Gutter deflector	Drops waste cut off with the slitters into the waste box.
6	Creaser module	Creases a document perpendicularly to the document feed direction.
7	Cutter module	Cuts a document perpendicularly to the document feed direction.
8	Reject	This is where the document comes when it is rejected due to a double feed, a barcode error, or a REG mark error.
9	Upper guide	Used to set light weight documents.

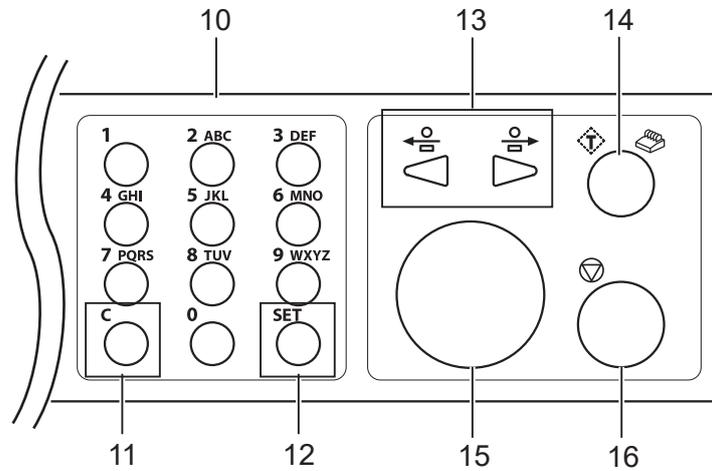
IMPORTANT

- Install each module properly as shown in the above figure. It is especially important that the slitter modules are installed in correct positions (slot 2, 3, and 4) with correct orientation.
- Slitter modules for the DC-645 cannot be used in the DC-646.

Control Panel



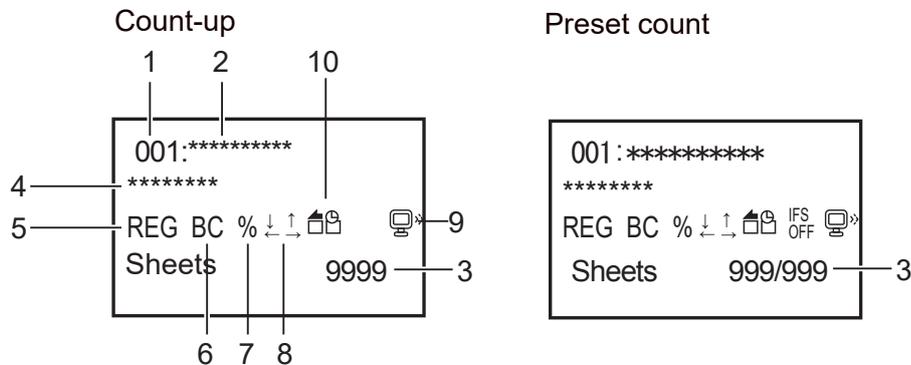
No.	Name	Function
1	OK Monitor	The LED of the error area flashes if an error is detected.
2	LCD panel	Displays the status of the machine. Displays messages if an error or a document jam has occurred.
3	F key	Press this to switch from the current screen to the function selecting screen.
4	RETURN key	Press this to switch from the current screen to the previous screen.
5	CURSOR (Up) key	Press this to move the cursor in an upper direction. Press this to retrieve a saved JOB.
6	CURSOR (Down) key	Press this to move the cursor in a lower direction. Press this to confirm module setup and tool setup for the CPM (cross tool module (option)) and the RTM (rotary tool module (option)).
7	CURSOR (Left) key	Press this to move the cursor to the left. Press this to retrieve a function setting.
8	CURSOR (Right) key	Press this to move the cursor to the right. Press this to save or overwrite a JOB.
9	SET key	Press this to set selection/entry.



No.	Name	Function
10	NUMERIC key	Press this to program a JOB and to enter preset count.
11	CLEAR key	Press this to clear the entered value when programming a JOB. Press this to clear the count of sheets processed in the count-up mode. Press this to clear the count of sheets processed in the preset count mode, which switches to the count-up mode.
12	SET key	Press this to set selection/entry.
13	JOG key	Press this to eject the document from the machine when a document jam has occurred.
14	TEST key	Press this to process one sheet of documents for a test run. Press this to check if a finished product is made as it is programmed. When the card stacker is attached, pressing and holding the TEST key stops finished products at the ejected area for about one minute for guide adjustment.
15	START key	Press this to start processing documents. The START key light turns green when the machine is ready to process the document in this machine. This key is inactive when the light is red. In this case, the machine may be running or having an error. When you press and hold the START key when the machine is ready for operation, the machine enters the pause feeding mode. When you press the START key in the pause feeding mode, the machine starts operation. When you press and hold the START key during operation, the machine enters the pause feeding mode.
16	STOP key	Press this to switch the current screen to the main screen or to stop processing.

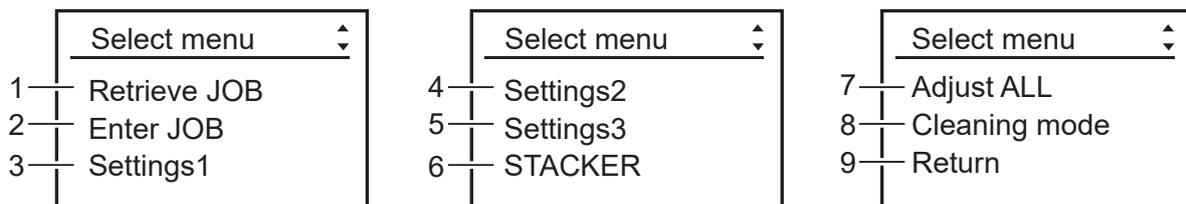
LCD Panel

• Standby screen



No.	Name	Function
1	JOB No.	Displays the JOB number currently selected.
2	JOB Name	Displays the JOB name currently selected.
3	Counter	Displays the number of document sheets processed with the JOB currently set.
4	Status	Displays the machine status.
5	REG	Displayed when Read REG mark (REG mark reading) is ON .
6	BC	Displayed when Read Barcode (barcode reading) is ON .
7	%	Displayed when Apply Shrinkage is set in Settings3 .
8	↓↑	Displayed when Adjust All is set.
9	☒	Displayed when the DC-646 is connected to the PC Controller.
10	☒	Displayed when Batch separation is set. (Displayed only when IFS off is activated).

• Select menu screen

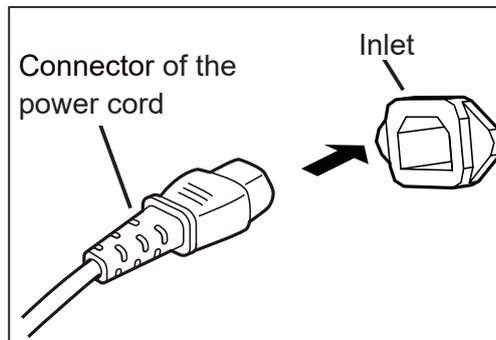


No.	Name	Function
1	Retrieve JOB	Retrieves a saved JOB.
2	Enter JOB	Enters and changes a JOB.
3	Settings1	Changes functions of the machine.
4	Settings2	Changes functions of the machine.
5	Settings3	Changes functions of the machine.
6	STACKER	Changes setting for STACKER . (Displayed only when IFS off is activated).
7	Adjust All	Corrects the document position in a vertical and a horizontal direction against the JOB set.
8	Cleaning mode	Retrieves Cleaning mode to clean the conveyance belt / conveyance roller.
9	Return	Returns to the standby screen.

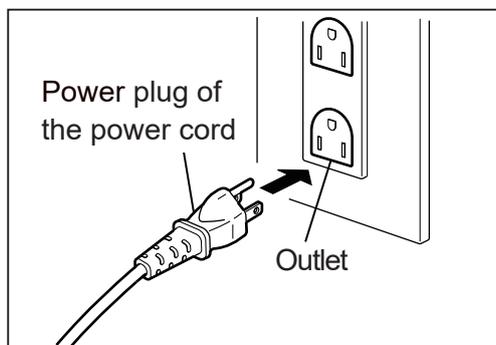
Turning Power ON/OFF

Turning Power ON

- 1 Connect the connector of the power cord to the **Inlet**.



- 2 Connect the power plug of the power cord to the **outlet**.



WARNING

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

CAUTION

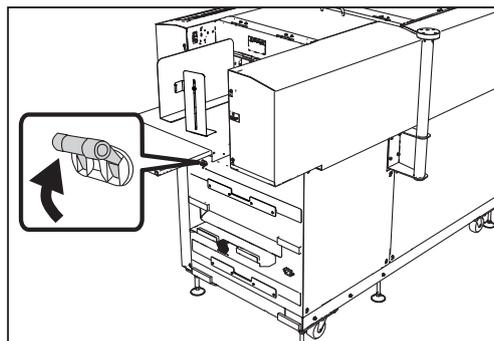
- Use an access-friendly outlet so that an operator easily plugs and unplugs the power cord after installation.

WARNING

- Unplug the power cord in an emergency situation.

- 3 Move the power switch lever upward to turn **ON** the power.

The model name of this machine appears on the LCD panel and a warm-up starts.



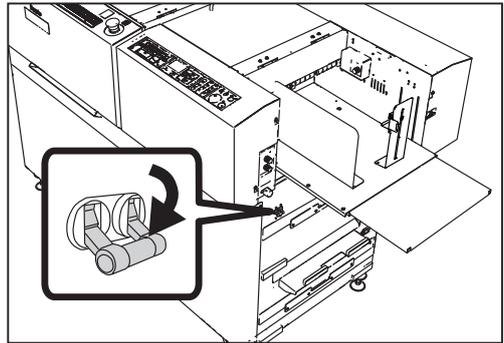
1

Before Using This Machine

Turning Power OFF

- 1 Press down the power switch lever to turn **OFF** the power.

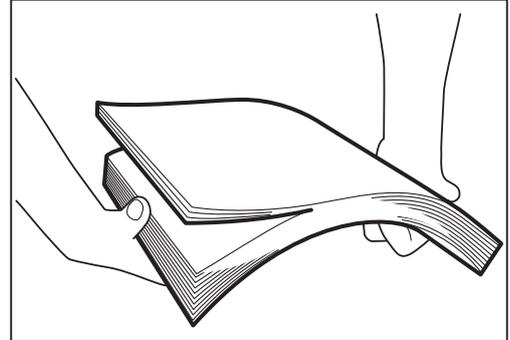
The power turns **OFF** and the display on the LCD panel disappears.



Preparation Before Use

Loading Documents

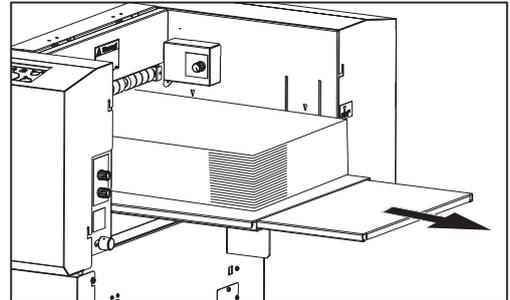
- 1 Prepare appropriate documents for the JOB selected.
Loosen the stack of the documents by flipping through the sheets and align them.



- 2 Load the documents on the **feed tray** and gently push them toward the inside of the machine.

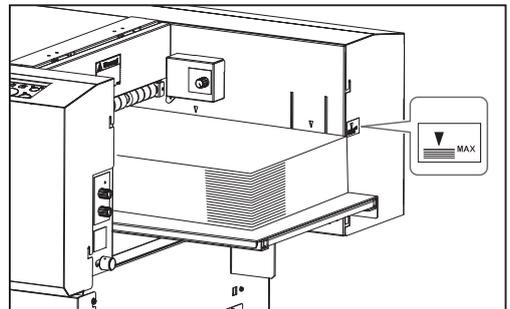
REFERENCE

Fully extend the feed tray for the vertically long document.



IMPORTANT

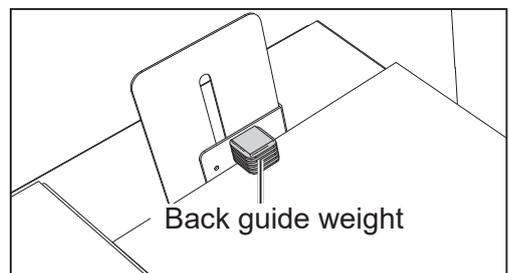
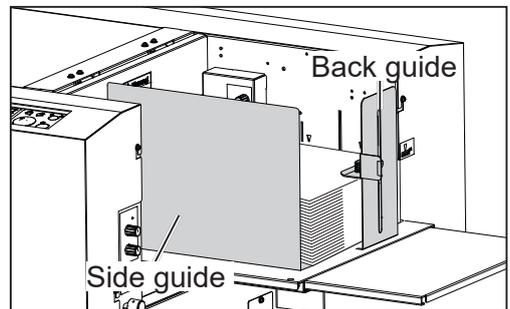
The height of the document stack should not exceed the **MAX** level.



- 3 Attach the **side guide** (for the **feed tray**) and the **back guide** (for the **feed tray**) according to the document size.

REFERENCE

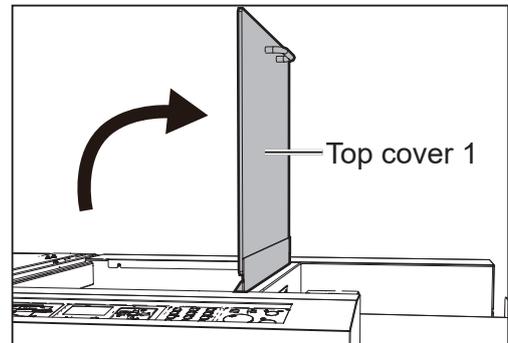
Use the **back guide weight** according to the document weight and the number of sheets.



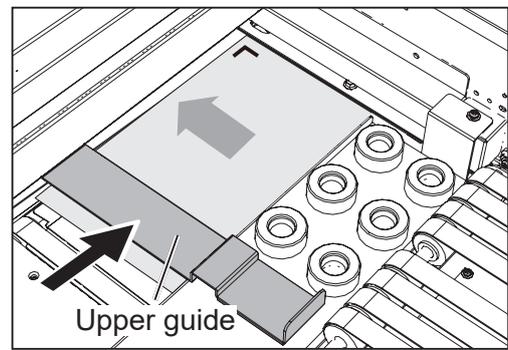
Attaching the Upper Guide

Attach the **upper guide** to keep the document feed stable when using light weight documents.

- 1 Open the **top cover 1**.

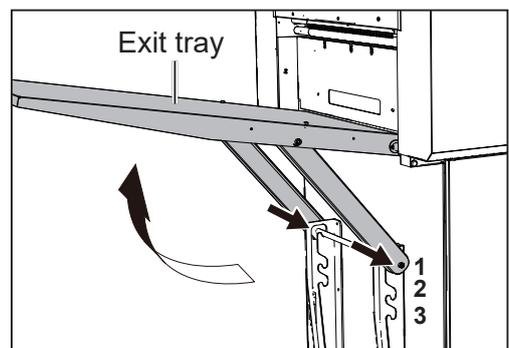


- 2 Attach the **upper guide** to the position where the left edge of the document passes.



Setting the Exit Tray

- 1 As shown in the right figure, lift the **exit tray**. The **exit tray** can be adjusted to three positions.

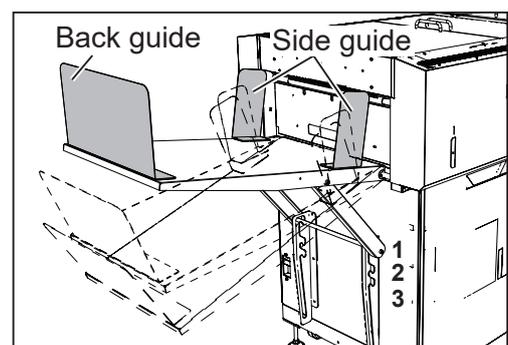


- 2 Attach the **back guide** (for the **exit tray**) and the two **side guides** (for the **exit tray**).

REFERENCE

Attaching orientation of the **back guide** differs depending on the setting angle of the **exit tray**. (See the figure on the right.)

- 1: **Exit tray** - upper position
→ Attach the **back guide** with L orientation.
- 2: **Exit tray** - middle position
→ Attach the **back guide** with J orientation.
- 3: **Exit tray** - lower position
→ Attach the **back guide** with J orientation.



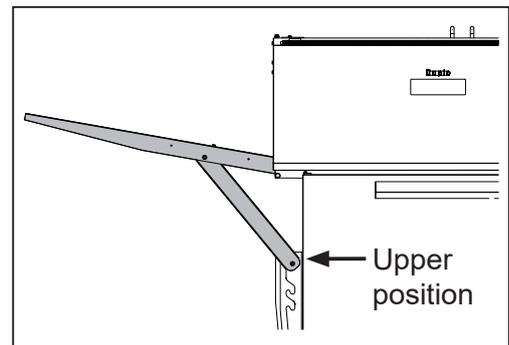
Attaching the Card Stacker

Attach the **card stacker** when making card-sized products.

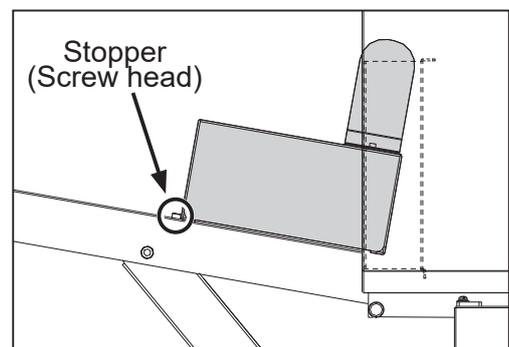
REFERENCE

- Use the **card stacker** when the length of a finished product is 150 mm or shorter.
- In the case that the finished products are not aligned on the **exit tray** even the finished product size is 150 mm or longer, use the **card stacker** with the **stopper**. Adjust the **stopper** according to the finished product length.

- 1 Remove the **side guide** and the **back guide**, and set the **exit tray** to upper position.



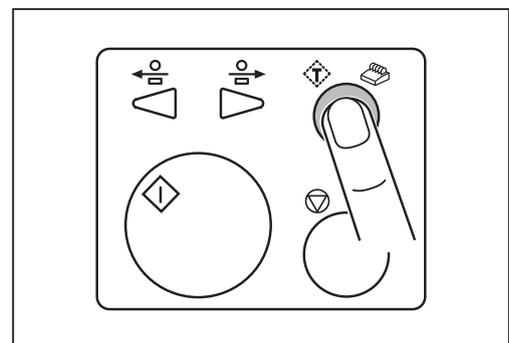
- 2 Locate the **card stacker** on the **exit tray** with it in contact with the **stopper** as shown in the right figure.



- 3 Press and hold the TEST key to perform a test run for one sheet.

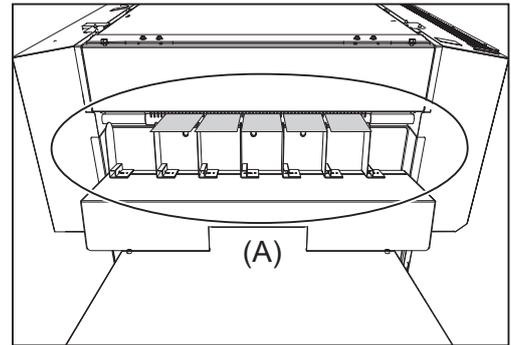
REFERENCE

Pressing and holding the TEST key enters the **stacker setup mode**.



Preparation Before Use

- 4 The finished products temporarily stop for about one minute when they reach the document-exit point.
Slide the **guide** to the point at which the finished product is ejected during the time.



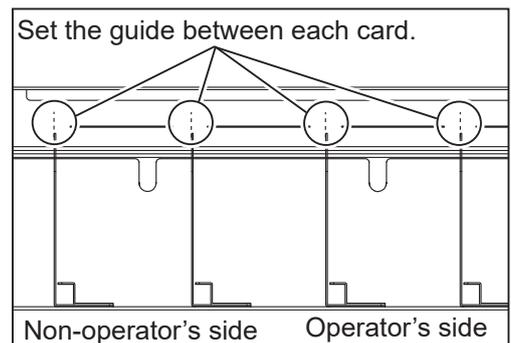
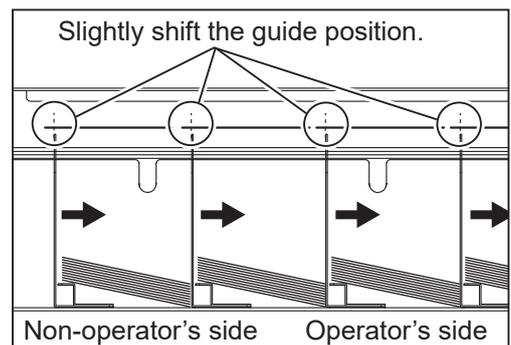
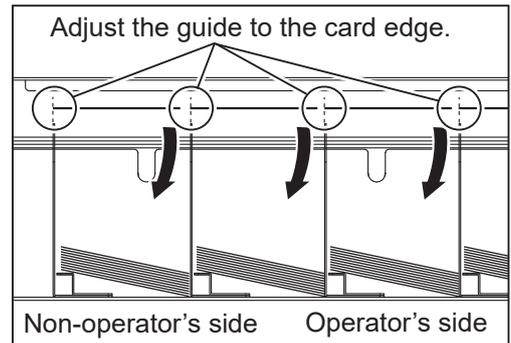
- 5 Adjust each **guide** to appropriate position so that the card edge on the non-operator's side comes into contact with the **guide**.
The cards tidily drop off with leaning.

REFERENCE

The figure on the right shows front view of (A) in step 4.

REFERENCE

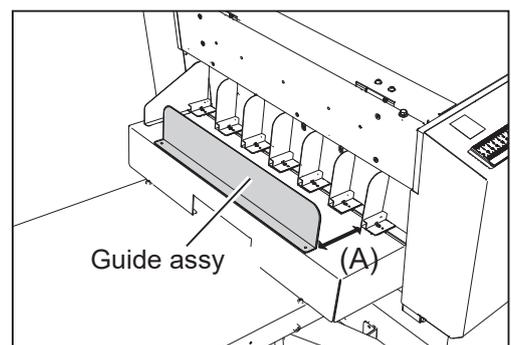
- It improves document alignment by slightly shifting the **guide** to the position as shown in the figure when the document alignment is poor.
- It improves document alignment by setting the **guide** to the position as shown in the figure when the document is processed with gutter slits and the finished products are long.



- 6 Set the **guide assy** (for the **card stacker**) by adjusting the position to the finished product length so that it is positioned vertically to the ground.

REFERENCE

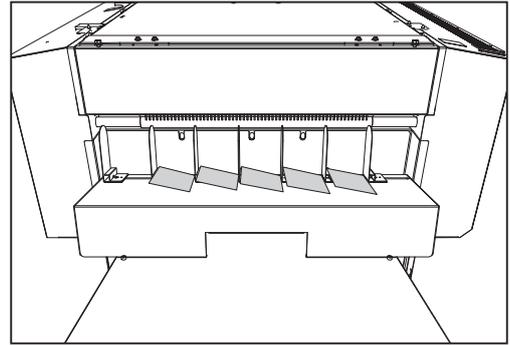
Adjust the distance (A) which is between the **guide** to the **guide assy** according to the document length.



- 7** The finished products are ejected on the **card stacker** when the STOP key or the TEST key is pressed or one minute has elapsed.

REFERENCE

- Pressing the START key ejects the finished products temporarily stopped at the ejection section and continuously processes all documents on the **feed tray**.
- If you have entered number of sheets for preset count, the machine processes the document for the number of sheets entered.

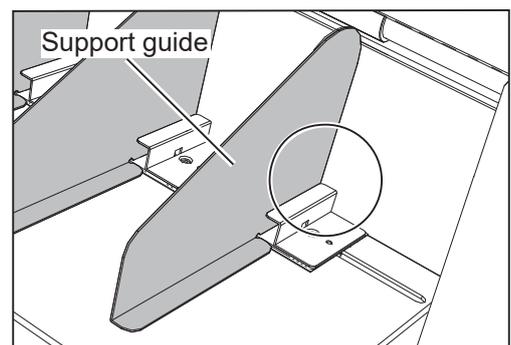
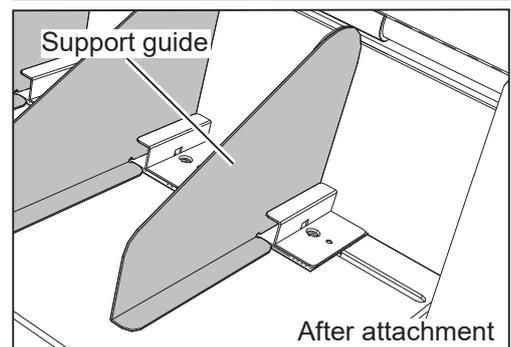
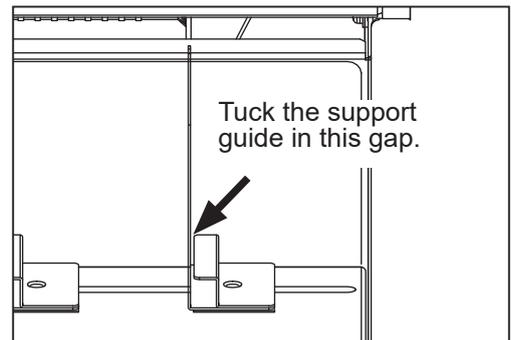


IMPORTANT

Set speed to **SLOW** when the JOB is processed without gutter slits in using light weight documents.

• How to Use the Support Guide (for Card Stacker)

- 1** When the length of the finished products is longer than the guide length, attach the **support guides** (for the **card stacker**) to the **guides**.



REFERENCE

When moving the **guide** after setting the **support guide**, move it by holding the indicated part in the figure, not holding the **support guide**. If you move the **guide** by holding the **support guide**, the **support guide** may bend.

Module Hanger

You can hang the edges of the top plate of the unused module on the **module hanger**. Two **module hangers** (upper and lower) are equipped with the main unit and enable you to hang two modules.

- 1 Hang the module on the **module hanger** so that both edges of the top plate of the module and the **module hanger** are parallel.

IMPORTANT

When hanging the module on the **module hanger**, make sure that the both edges are aligned with the **module hanger**.

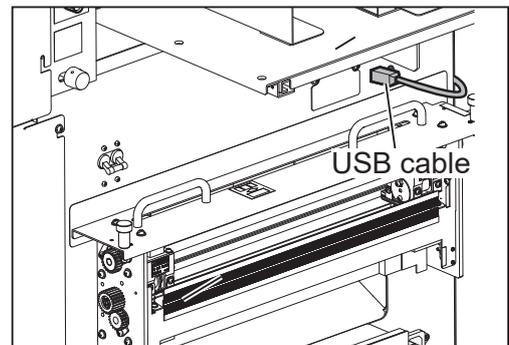
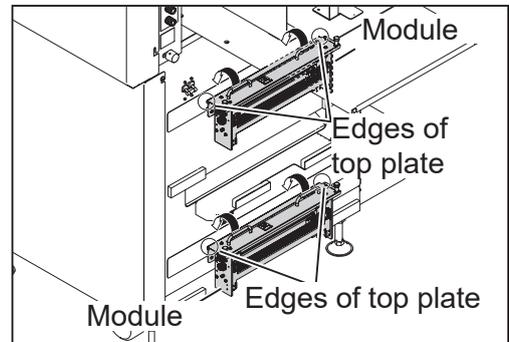
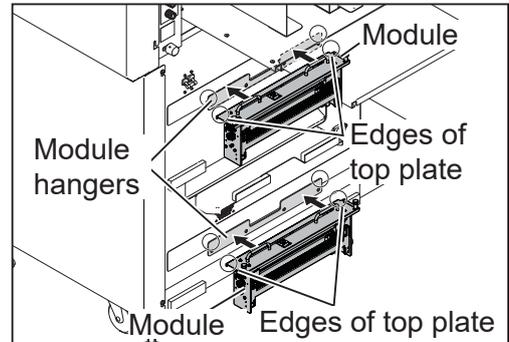
IMPORTANT

After hanging the module on the **module hanger**, check again that the both edges are hung on the **module hanger**.

Do not move the main unit with the module hung on the **module hanger**. Doing so may drop the module.

IMPORTANT

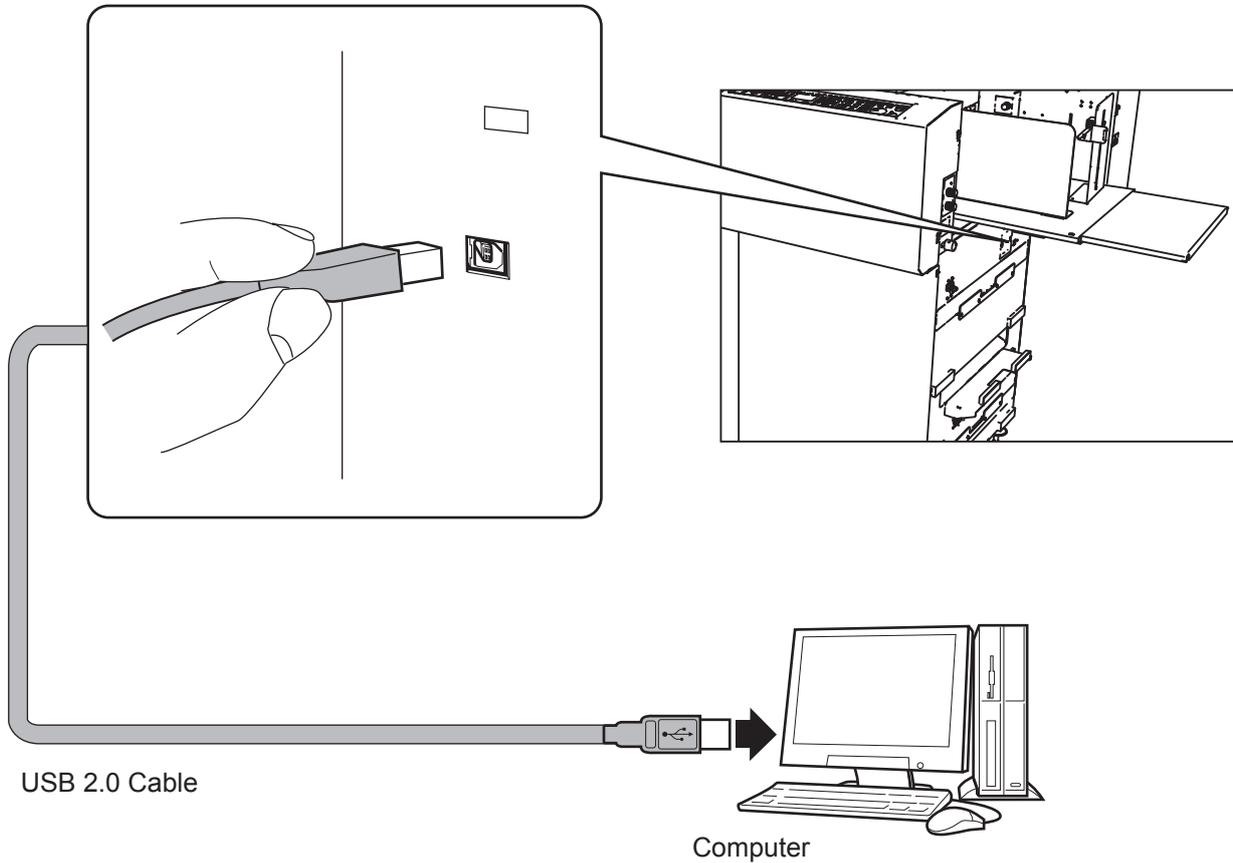
When hanging the module on the **module hanger** or unhooking it from the **module hanger**, be careful not to bring the module in contact with the USB cable. Doing so may damage the USB terminal/port.



How to Connect the DC-646 to Your Computer

Prepare an USB 2.0 Cable (A/B 4-pin).

Plug the USB terminals into the USB port of the DC-646 and the USB port on your computer.
USB cable must be within 3 m long.



REFERENCE

Do not connect the DC-646 to your computer until the driver of the PC Controller is installed.

1

Before Using This Machine

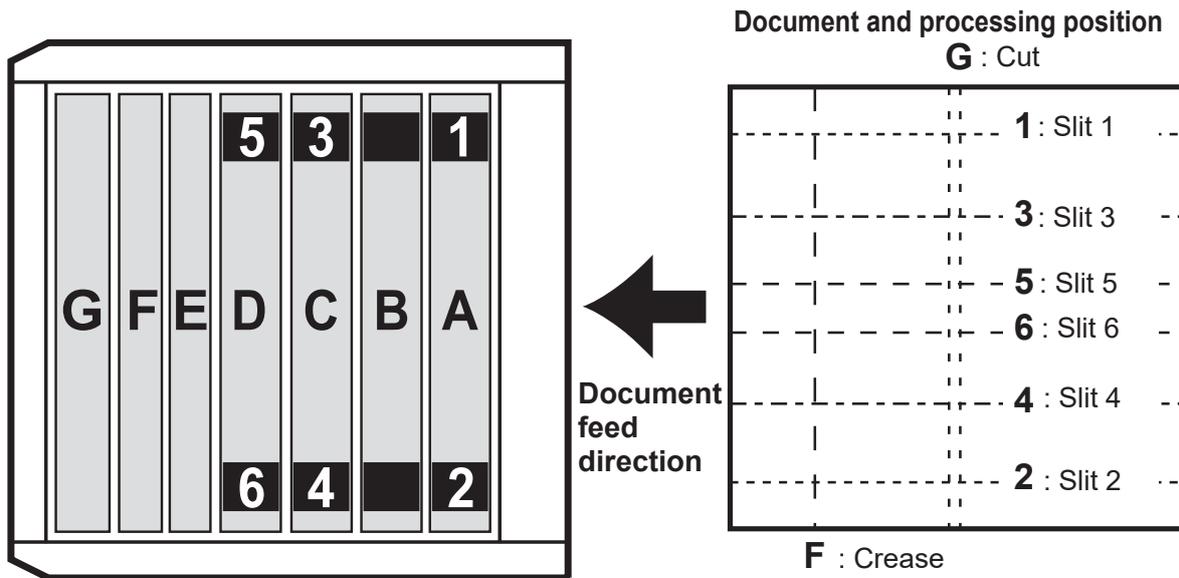
Before Preparing a Document

The DC-646 can save up to 250 patterns of JOB. JOB contents can be programmed either via computer or on the control panel. This section describes items required to program a JOB.

SLIT: The DC-646 has six slitters. Two slitters (1, 2) are for the margins and the remaining four slitters are for the center area of the document.

CUT: There is a guillotine cutter that performs cuts perpendicular to the document feed direction. The DC-646 can cut up to 30 cuts on one document.

CREASE: There is a creaser that performs creases perpendicular to the document feed direction. The DC-646 can crease up to 20 creases on one document.

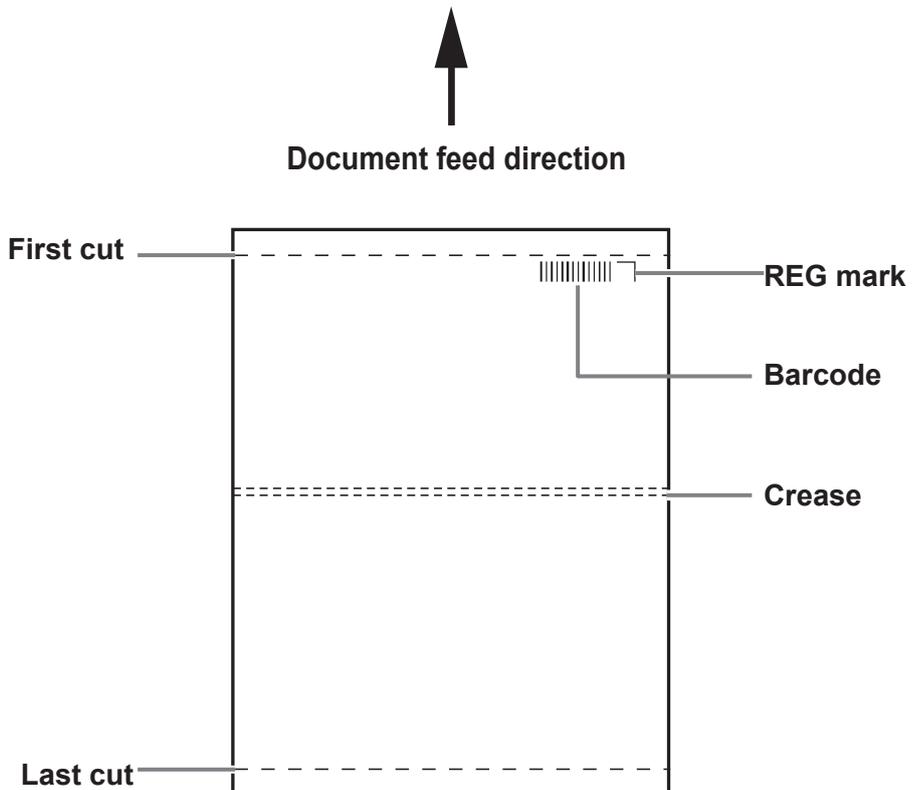
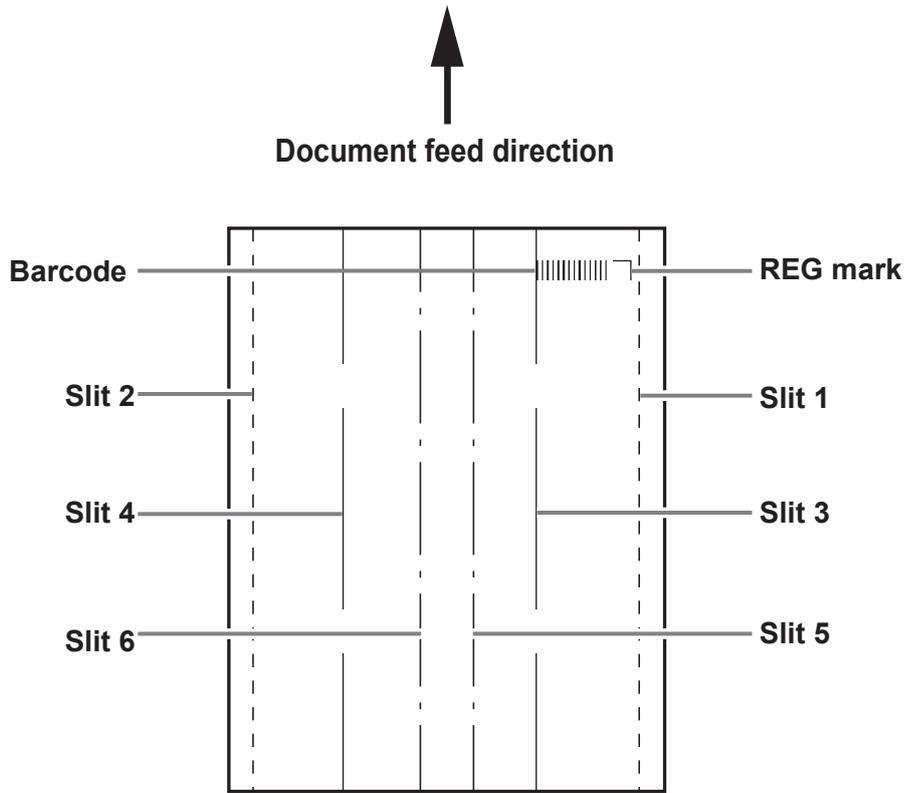


No.	Name	Function
A	1	Slot 1 (for Margin slitter module) Cuts off the margin of the operator's side and the non-operator's side.
	2	
B	Slot 2 (for Standard module / Slitter module / Cross tool module / Rotary tool module)	Cuts or perforates a document parallel to the document feed direction. * Cuts or perforates a document perpendicularly to the document feed direction with the cross tool module installed.
C	3	Slot 3 (for Standard module / Slitter module / Rotary tool module) Cuts or perforates a document parallel to the document feed direction.
	4	
D	5	Slot 4 (for Standard module / Slitter module / Rotary tool module) Cuts or perforates a document parallel to the document feed direction.
	6	
E	- Gutter deflector	Waste cut off by module A, B, C and D is dropped into the waste box.
F	- Creaser module	Creases a document perpendicularly to the document feed direction.
G	- Cutter module	Cuts a document perpendicularly to the document feed direction.

IMPORTANT

- When removing various modules of this machine, always re-install the modules properly as shown in the above figure. It is especially important that the **slitter modules** are installed in correct positions with correct orientation when module B, C, and D are installed again.
- Slitter modules for the DC-645 cannot be used in the DC-646.

Definition of Programming Terms



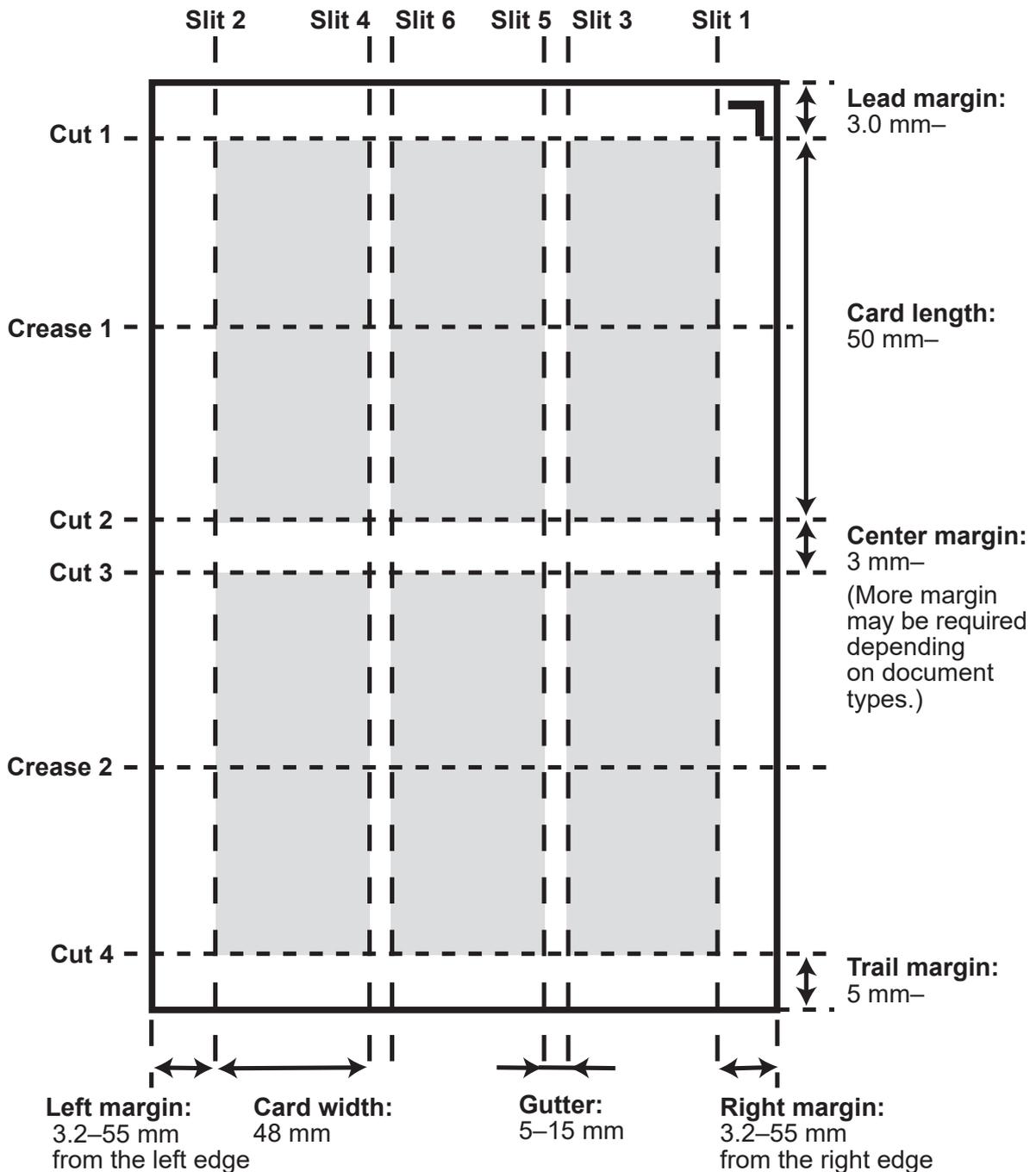
Slit/Cut/Crease Limitations

There are limitations for slit/cut/crease process on the DC-646.

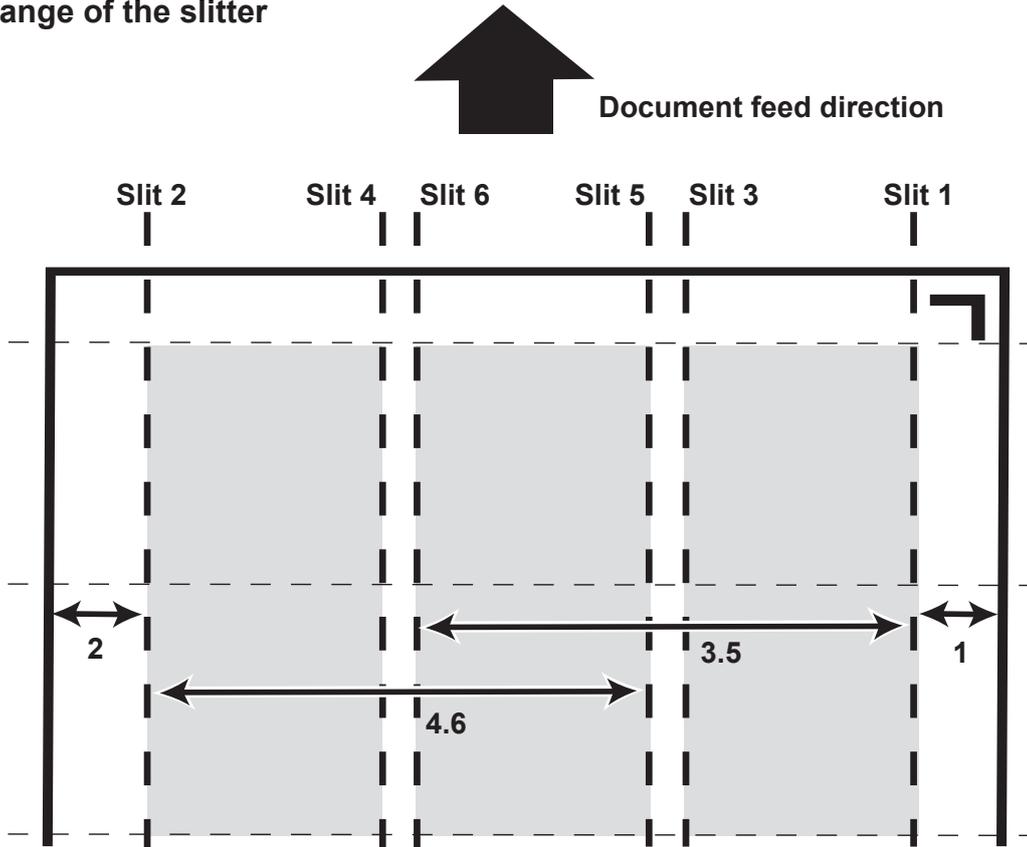


Document feed direction

- Slit** : Up to six slits can be made on one document.
Up to eight slits can be made with the optional modules.
Slit 1 and Slit 2 are for cutting the margins at both side edges.
- Cut**: Up to 30 cuts can be made on one document.
- Crease**: Up to 20 creases can be made on one document.



Moving range of the slitter



1. Moving range of the slitter 1

3.2 to 55 mm (The width stands at 0 when it is not set.)

2. Moving range of the slitter 2

Width of document-(3.2 to 55) mm (The width stands at 0 when it is not set.)

3. Moving range of the slitter 3

48 to (Width of document-48) mm (The width stands at 0 when it is not set.)

* However, a 48 mm or wider distance is required between entered values of the slitter 3 and the slitter 4.

4. Moving range of the slitter 4

48 to (Width of document-48) mm (The width stands at 0 when it is not set.)

* However, a 48 mm or wider distance is required between entered values of the slitter 3 and the slitter 4.

5. Moving range of the slitter 5

48 to (Width of document-48) mm (The width stands at 0 when it is not set.)

* However, a 48 mm or wider distance is required between entered values of the slitter 5 and the slitter 6.

* However, a 5 mm or more difference is required between entered values of the slitter 3 and slitter 5.

6. Moving range of the slitter 6

48 to (Width of document-48) mm (The width stands at 0 when it is not set.)

* However, a 48 mm or wider distance is required between entered values of the slitter 5 and the slitter 6.

* However, a 5 mm or more difference is required between entered values of the slitter 4 and slitter 6.

*Limitation of the range for each slitter varies by entered values for other slitters.

Before Preparing a Document

REG Mark (Registration mark)

The DC-646 automatically compensates for image drift, one of the common problems on digital printers. It detects the image drift caused on each page by reading a REG mark with the built-in laser sensor and adjusts the cut/slit/crease position accordingly.

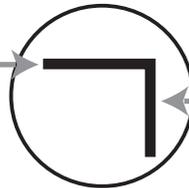
When using a REG mark, enter the REG mark position in a JOB and set **Read REG mark** is set. To use this function, each document must have a REG mark printed on it. Please refer to the following instructions for specifications and a position of REG mark.

1. Specifications

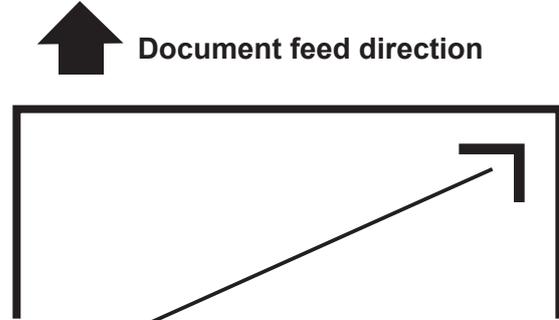
REG mark consists of two straight and perpendicular lines.

- When **REG mark spec** is set to **Standard**:
 Line length: 5 mm or more
 Line thickness: 0.4 mm or more
- When **REG mark spec** is set to **Bold**:
 Line length: 10 mm
 Line thickness: 2 mm or more

Lead mark: corrects for image drift in this direction.



Document feed direction



Side mark: corrects for image drift in this direction.

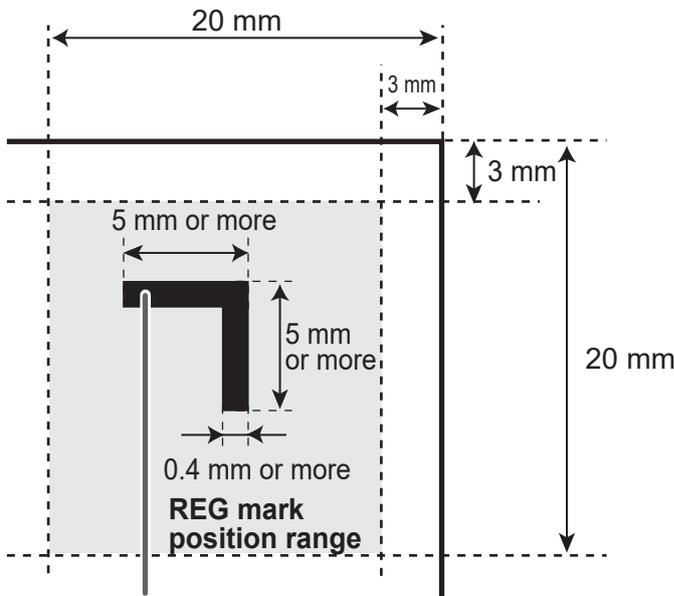
2. Position

Use a pen tool, etc. of your software application to draw two straight and perpendicular lines.

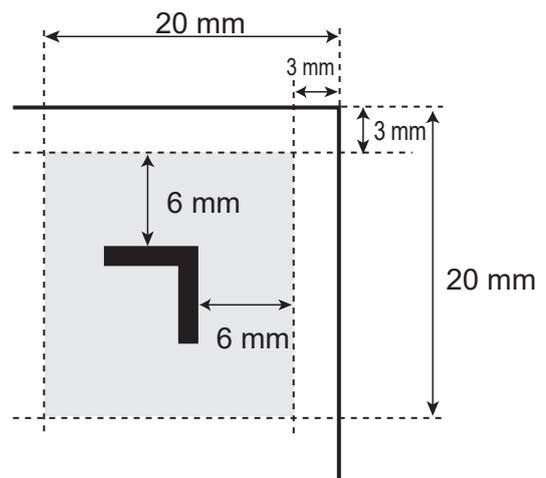
- When **REG mark spec** is set to **Standard**:
 Document feed direction: The whole REG mark should be within 3 to 20 mm from the lead edge.
 Document width direction: The whole REG mark should be within 3 to 20 mm from the right edge.

REFERENCE

The figure below shows the best position to print the REG mark.

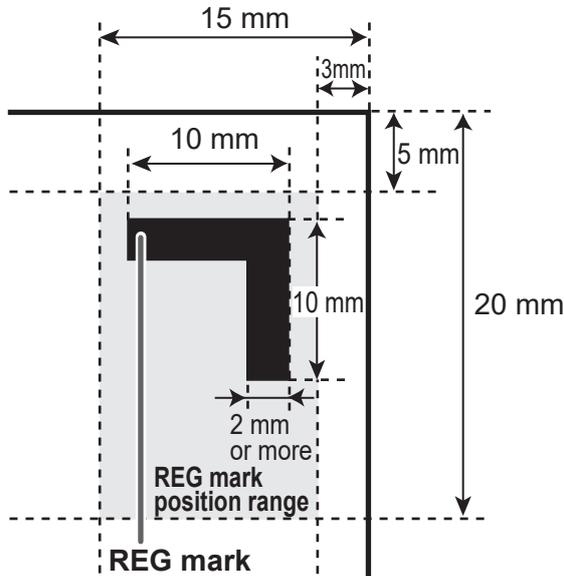


REG mark



• When **REG mark spec** is set to **Bold**

Document feed direction: The whole REG mark should be within 5 to 20 mm from the lead edge.
 Document width direction: The whole REG mark should be within 3 to 15 mm from the right edge.



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

Barcode (Automatic JOB selection)

By adding barcode which indicates a JOB number on each document, the DC-646 automatically sets up the machine and starts the JOB. An operator can press the START key and leave.

Even if multiple types of JOBS are loaded on the **feed tray** at one time, the DC-646 recognizes barcode on documents also with the built-in CCD scanner and automatically switches setup and finishes the JOBS.

To use this function, each document must have barcode printed on it. Please refer to the following instructions for specifications and a position of barcode.

1. Specifications

- Barcode type: CODE-39
- Start and Stop code: Required
- Minimum resolving power: 0.254 mm
- Thin bar: Thick bar: 1 : 2.5
- Bar height: 4 mm or more



IMPORTANT
 CODE-39 barcode must be used.

Before Preparing a Document

REFERENCE

Barcode may not be read even it is within the specifications depending on the print quality of a printer and document type. If this is the case, enlarging the barcode may enable it to be read.

Use the barcode generator function equipped on your software application or use barcode generator software.

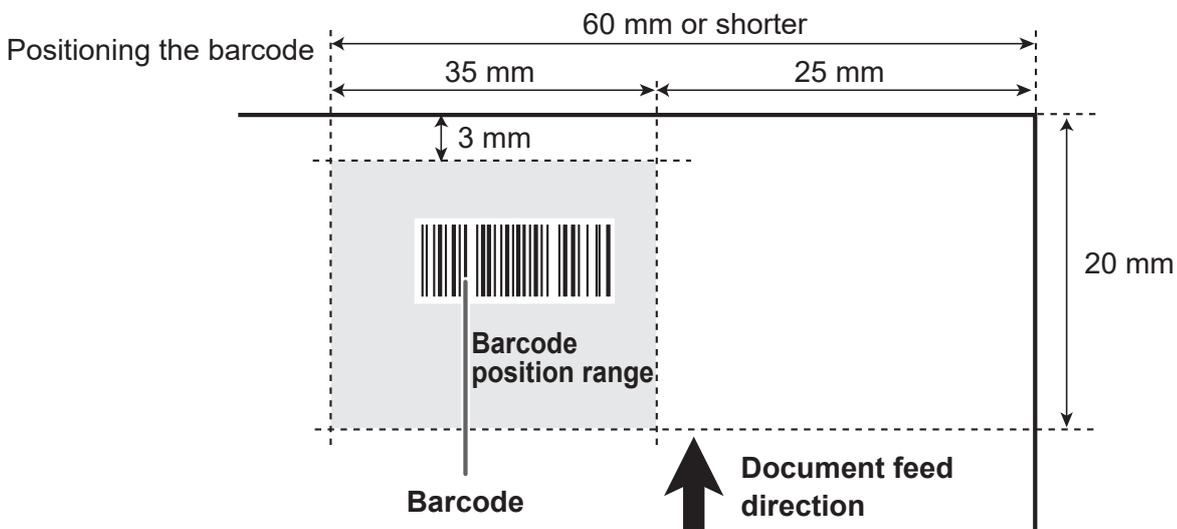
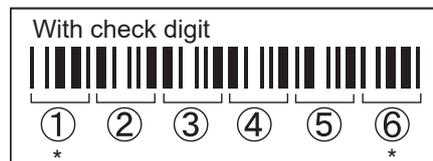
2. Position

Document feed direction: The whole barcode should be within 3 to 20 mm from the lead edge.

Document width direction: The whole barcode should be within 25 to 60 mm from the right edge.

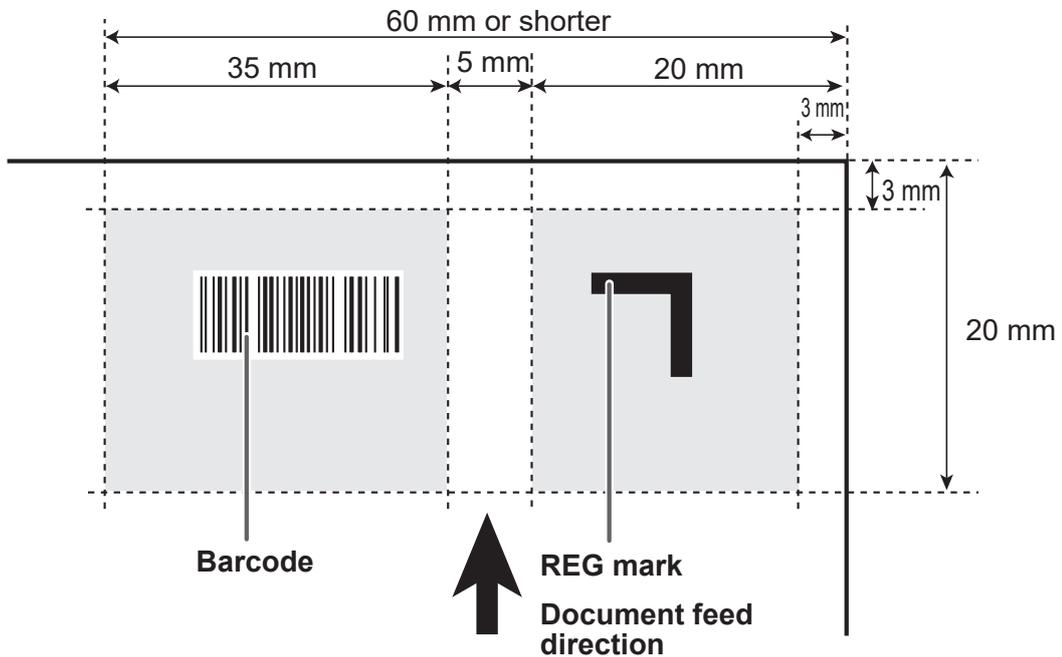
(See below)

- ① is the start code designator for CODE-39. Enter *.
- ② is the hundreds digit data of the JOB number.
(Example: When the JOB number is 250, the data is **2**.)
- ③ is the tens digit data of the JOB number.
(Example: When the JOB number is 250, the data is **5**.)
- ④ is the ones digit data of the JOB number.
(Example: When the JOB number is 250, the data is **0**.)
- ⑤ is the check digit. (Corresponding to with or without)
- ⑥ is the stop code of CODE-39. Enter *.

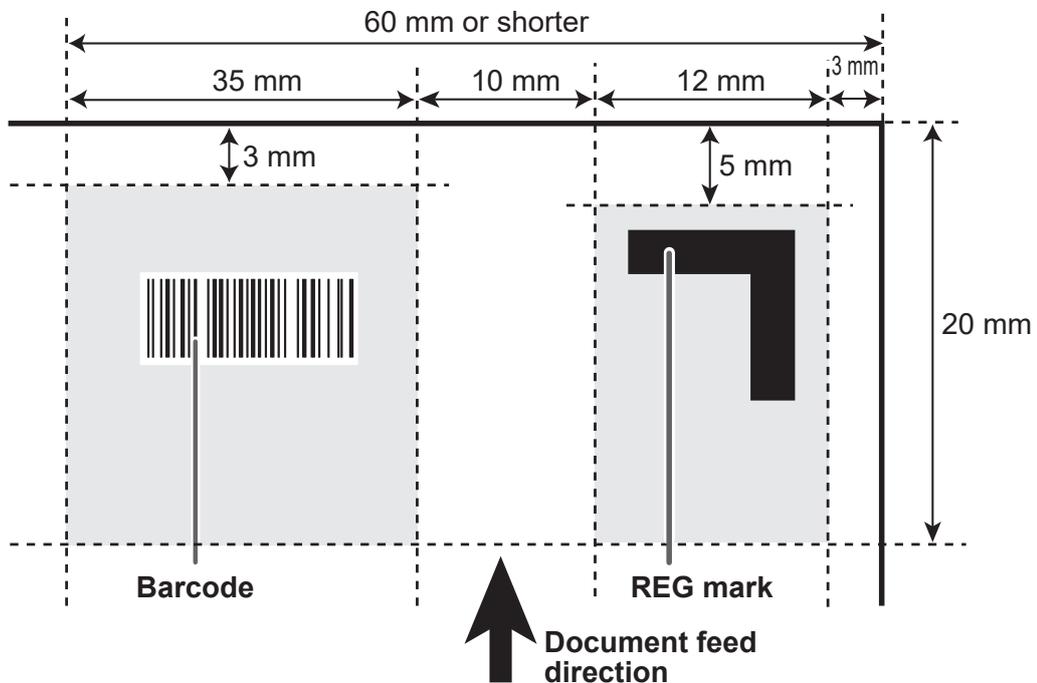


When both REG mark and barcode are printed on one document

- When REG mark spec is set to **Standard**



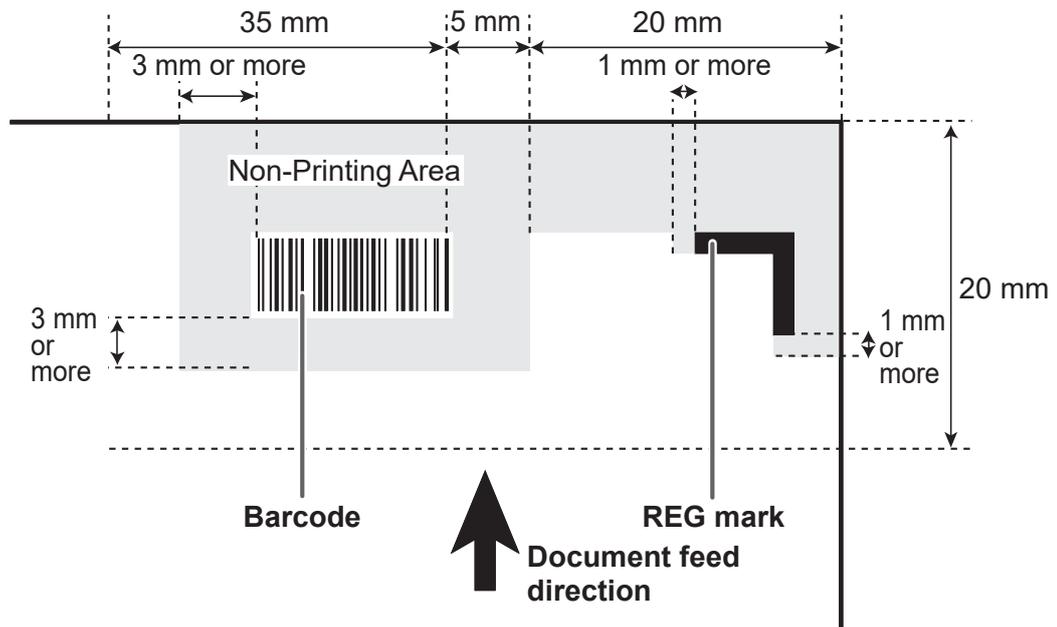
- When REG mark spec is set to **Bold**



A REG mark or barcode located out of the specified printing area cannot be detected properly. Take account of the possible variation in the printed position of a REG mark and barcode when they are arranged on a document.

Before Preparing a Document

Non-Printing Area

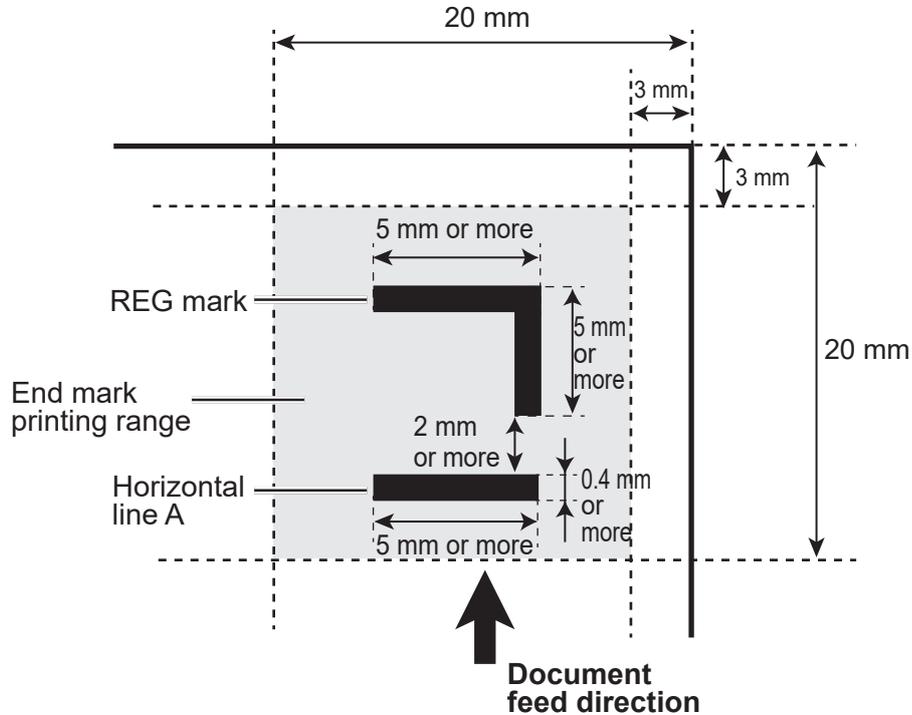


- No part of the image to be printed should enter into the gray-colored area.
- No other printings than REG mark or barcode should enter into the gray-colored area.

• **Shape and position of end mark**

An end mark consists of a REG mark from the document lead edge and a horizontal line **A** as shown in the figure below.

If the end mark is not printed properly, the machine does not operate normally.

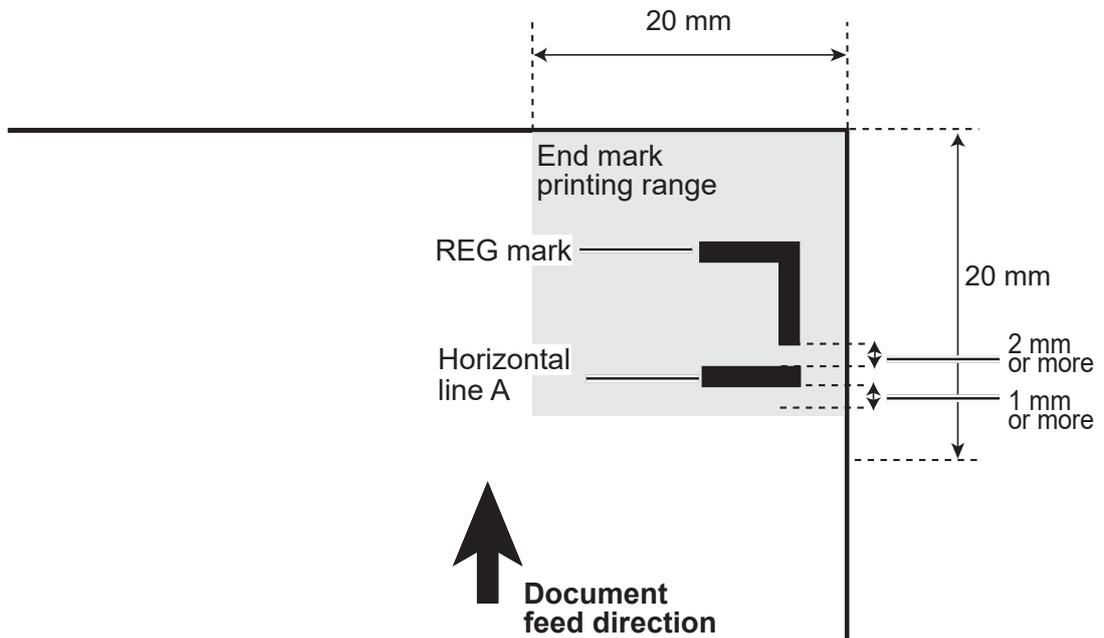


• **Notes on end mark printing area**

Nothing should be printed in the following range:

- between the document lead edge and the REG mark
- between the REG mark and the horizontal line **A** (2 mm or more)
- 1 mm or more after the horizontal line **A**

No printing should enter into the gray-colored area.



Chapter 2

Programming a JOB on the Control Panel

This chapter describes how to program a JOB on the control panel of the DC-646.

.....

Programming a JOB on the Control Panel	30
Programming a JOB in Advanced Mode	34
Programming a JOB in Simple Mode	43
Correcting the JOB Settings	46

.....

Programming a JOB on the Control Panel

The DC-646 can save up to 250 patterns of JOBS.

This chapter describes how to program and change a JOB on the control panel of the DC-646.

Make sure to read the procedure carefully to program a JOB properly.

Before programming a JOB, accurately measure the positions of slits, cuts and creases in mm/inch.

Slitter: There are a total of six slitters. Two slitters are for the right and left margins and four slitters cuts the document.

Cutter: There is a guillotine cutter that performs cuts perpendicular to the document feed direction. The DC-646 can cut up to 30 cuts on one document.

Creaser: There is a creaser that performs creases perpendicular to the document feed direction. The DC-646 can crease up to 20 positions on one document.

The DC-646 provides two programming modes, the **advanced mode** and the **simple mode**. Select either mode in **Settings2** before programming a JOB.

Advanced mode: You need to select module for slot 2 to slot 4 before entering processing positions. You can set slit positions alternately from side to side in order of modules along the document feed direction. The screen displays **Slit1** to **Slit6**.

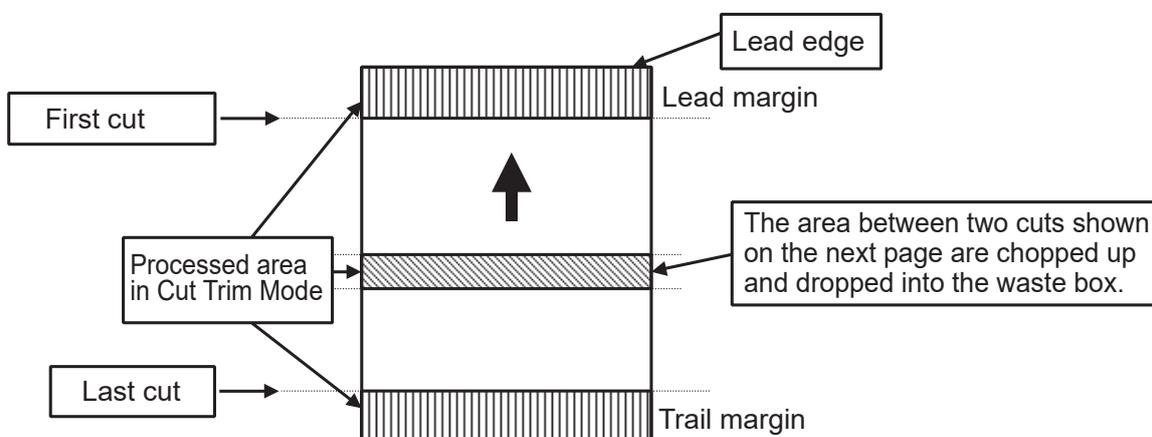
* Screens for **Slit3** and the rest of the slits are not displayed depending on the combination of modules in the slots.

Simple mode: Optimum module setup in slot 2 to slot 4 is displayed by entering processing positions. You can set slit positions in order, from the right side of the document along the document feed direction. The screen displays **SlitA** to **SlitF**.

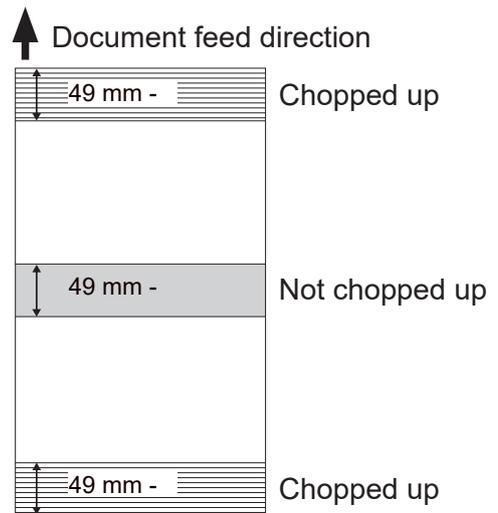
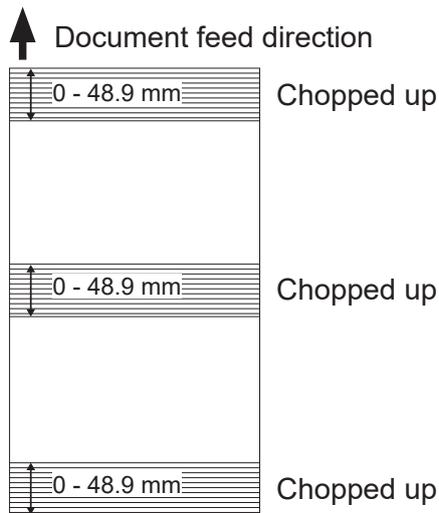
Cut Trim Mode

There are three modes in this function.

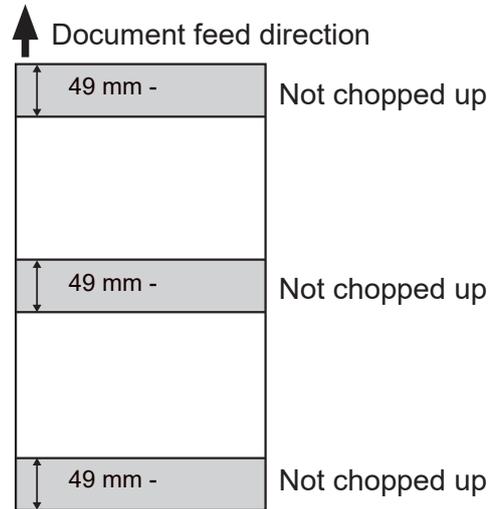
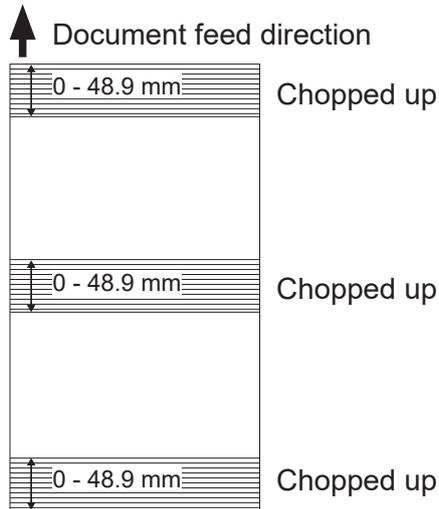
- **Full bleed mode:** The area (lead margin) between the lead edge and first cut, the area (trail margin) between the last cut and trail edge, and the area (gutter) (0–48.9 mm long) between two cuts are considered to be waste and are chopped up and dropped into the waste box.
- **No bleed mode:** Gutters of 48.9 mm or shorter are chopped up and dropped into the waste box.
- **Process all:** All of the cut pieces are ejected to the exit tray except that lead margin and gutters of 27.9 mm or shorter and the trail margin of 48.9 mm or shorter are chopped up and dropped into the waste box.



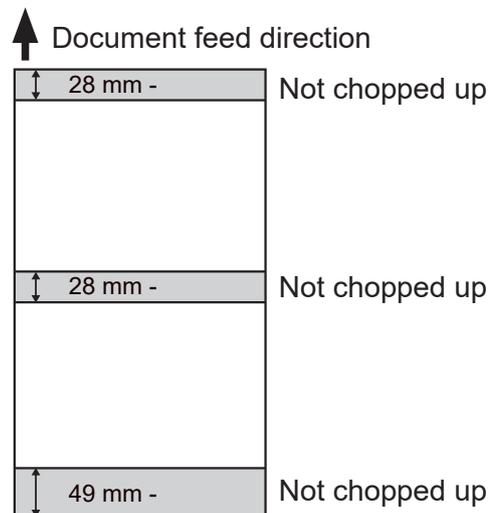
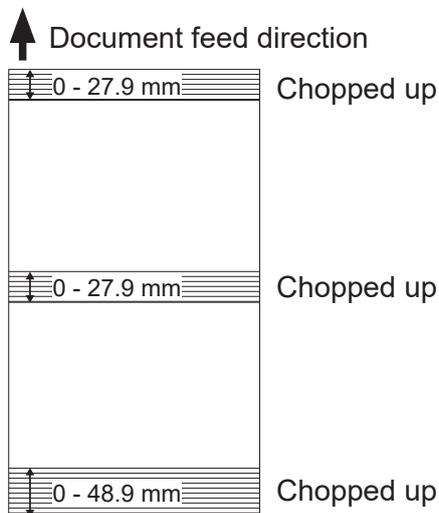
• Full bleed mode



• No bleed mode



• Process all



Programming a JOB on the Control Panel

The following items should be entered to program a JOB.

JOB number

Select a JOB number in which the JOB currently being programmed is saved.

JOB name

Enter a JOB name using the NUMERIC keys.

Select Module (Module selection in slot 2 to slot 4)

Select modules to install in slot 2 to slot 4.

Select Tool (Displayed when using optional rotary tool module and/or optional cross tool module)

Select a tool of the modules to install in slot 2 to slot 4.

Width

Enter the width of a document.

Length

Enter the length of a document.

REG mark position

When using the REG mark reading function:

Enter the distance between the lead edge of the document and the REG mark and the distance between the right edge of the document and the REG mark.

REG mark spec

This sets a reading function for a bold REG mark printed on a specially treated document.
(→ P.23 IMPORTANT)

Read REG mark

This sets an operation mode when REG mark is detected. Reading the REG mark and correcting the print position gap improve accuracy of document processing.

Slit position

Enter the distances between the right edge of the document and each slit position.

The DC-646 can slit up to six positions on one document. (It can slit up to eight positions when the optional slitter modules are installed.)

Cut trim mode

Lead margin, trail margin, and any gutter cuts (48.9 mm or shorter) are chopped up and dropped into the waste box.

Cut position

Enter the distances between the lead edge of the document and each cut position.

The DC-646 can cut up to 30 positions on one document.

Crease position (Perpendicular to the document feed direction)

Enter the distance between the lead edge of the document and each crease position.

The DC-646 can crease up to 20 positions on one document.

Tool position of cross tool module (When CPM (cross tool module) is used)

Enter the distance between the right edge of the document and perforation start/end positions.

Tool position of rotary tool module (When RTM (rotary tool module) is used)

Enter the distance between the lead edge of the document and perforation start/end positions.

Air knife

Compressed air is blown out from the front of documents to loosen them, preventing a double feed.

Side blow fan (Option: ASIA, TAIWAN)

Air is blown out from the side of documents to loosen them, preventing a double feed.

Fan reg (Fan register)

Document skewing in the feeding area is corrected.

Slitter guide

When no slitters are in use, these slitters act as document guides to stabilize the document conveyance. Recommended for light weight documents.

Auto trail cut

This performs dummy cuts for dropping the trail margin cut easily.

Crease depth

This sets the depth of a crease when a document is creased.

Usually set this to **MID**.

Set this to **MAX** for heavy weight documents and **MIN** for light weight documents.

Speed

Select the processing speed.

Selecting **SLOW** improves finishing accuracy.

Programming a JOB in Advanced Mode

The DC-646 provides two programming modes, the **advanced mode** and the **simple mode**. You can select either mode by your preference. When programming a JOB in the **advanced mode**, select **Advanced mode** under **Slitter entry** in **Settings2** before programming one.

Advanced mode: You need to select modules for slot 2 to slot 4 before entering processing positions. You can set slit positions alternately from side to side in order of modules along the document feed direction. The screen displays **Slit1** to **Slit6**.

* Screens for **Slit3** and the rest of the slits are not displayed depending on the combination of modules in the slots.

Hints for entering a JOB:

- Pressing the SET key goes on to the next step.
- Pressing the CURSOR (Up) key returns to the previous step.
- Pressing the CURSOR (Down) key goes on to the next step.
- Pressing the STOP key during JOB entering returns to the standby screen.
- Pressing the RETURN key returns to the previous screen.

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

Standard: standard module	Perf: perforation tool
Slitter: slitter module	Micro: micro perforation tool
CPM: cross tool module (option)	SI-Score: slit-score tool
RTM: rotary tool module (option)	Score: score tool

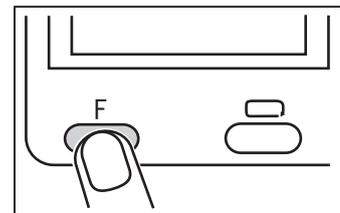
REFERENCE

Refer to the instruction manual of each optional module for programming a JOB with an optional module.

1

Make sure that the standby screen is displayed on the LCD panel.

Press the F key to display the **Select menu** screen.



REFERENCE

When the standby screen is displayed, you can use the following keys as shortcut keys.

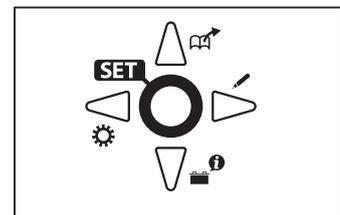
CURSOR (Up) key: Displays the JOB number retrieving screen.

CURSOR (Down) key: Displays modules installed in each slot.

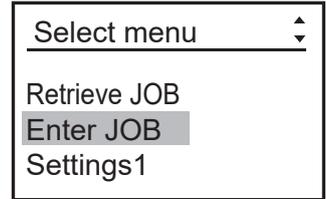
When the **CPM (cross tool module (option))** and/or the **RTM(s) (rotary tool module (option))** is/are installed, the name(s) of the tool(s) that is/are required to set is/are displayed.

CURSOR (Left) key: Displays the **Settings1** screen.

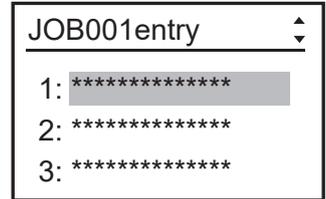
CURSOR (Right) key: Displays the **JOB entry** screen.



2 Select **Enter JOB** using the CURSOR (Up/Down) key and press the SET key.

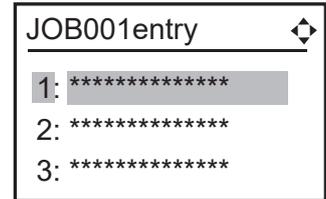


3 Select a JOB number (001–250) using the NUMERIC keys or the CURSOR (Up/Down) key and then press the SET key.



REFERENCE

The JOB number of the locked JOB is highlighted. (→P.55 Locking a Saved JOB)



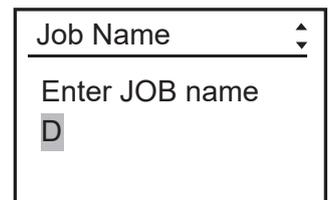
4 Enter a JOB name using the NUMERIC keys, and then press the SET key. Up to 30 characters in the table below can be entered.

Key	Pressing the same key switches character.									
1	1	!	"	\$	%	&	'	()	
2	A	B	C	a	b	c	2			
3	D	E	F	d	e	f	3			
4	G	H	I	g	h	i	4			
5	J	K	L	j	k	l	5			
6	M	N	O	m	n	o	6			
7	P	Q	R	S	p	q	r	s	7	
8	T	U	V	t	u	v	8			
9	W	X	Y	Z	w	x	y	z	9	
0	0									
C	Clear									
◀	Moves the cursor to the left.									
▶	Space, Moves the cursor to the right.									

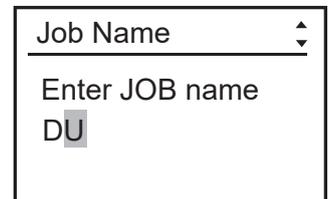
• **Example: Entering DUPLO in JOB001**

1. Press the <3> key and the CURSOR (Right) key.

- Pressing the CLEAR key deletes one character.



2. Press the <8> key two times and the CURSOR (Right) key.



Programming a JOB in Advanced Mode

3. Press the <7> key and the CURSOR (Right) key.

4. Press the <5> key three times and the CURSOR (Right) key.

5. Press the <6> key three times and the CURSOR (Right) key.
Press the SET key or the CURSOR (Down) key.

- 5 Select Module**
Use the CURSOR (Right/Left) key to select **Standard**, **Slitter**, **RTM (rotary tool module (option))**, or **CPM (cross tool module (option))** for slot 2, and press the SET key or the CURSOR (Down) key.
If slot 2 is not used for processing, select **Standard**.

- 6 Select Module**
Use the CURSOR (Right/Left) key to select **Standard**, **Slitter**, or **RTM (rotary tool module (option))** for slot 3, and press the SET key or the CURSOR (Down) key.
If slot 3 is not used for processing, select **Standard**.

- 7 Select Module**
Use the CURSOR (Right/Left) key to select **Standard**, **Slitter**, or **RTM (rotary tool module (option))** for slot 4, and press the SET key or the CURSOR (Down) key.
If slot 4 is not used for processing, select **Standard**.

- 8 Document Size Width**
Enter the width (mm) of the document using the NUMERIC keys, and press the SET key or the CURSOR (Down) key. The value must be between 210.0 to 370.0 mm.

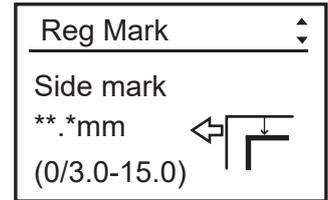
- 9 Document Size Length**
Enter the length (mm) of the document using the NUMERIC keys, and press the SET key or the CURSOR (Down) key. The value must be between 210.0 to 999.9 mm.

10

Reg Mark Side mark

When processing a JOB by reading a **REG mark**, enter the distance between the right edge of the document and the **side mark** using the NUMERIC keys and press the SET key or the CURSOR (Down) key. The value can be set in a range of 3.0 to 15.0 mm.

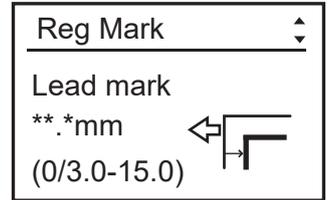
If you enter 0, the screen skips to step 14.



11

Reg Mark Lead mark

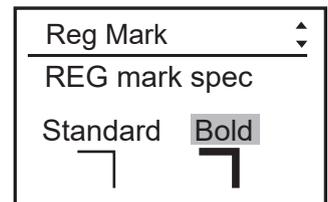
When processing a JOB by reading a **REG mark**, enter the distance between the lead edge of the document and the **lead mark** using the NUMERIC keys, and press the SET key or the CURSOR (Down) key. The value can be set in a range of 3.0 to 15.0 mm.



12

Reg Mark REG mark spec

When using specially treated documents (→ P.23 IMPORTANT), print a bold REG mark on them in advance. Then, select **Bold** and press the SET key or the CURSOR (Down) key. Normally select **Standard**.



IMPORTANT

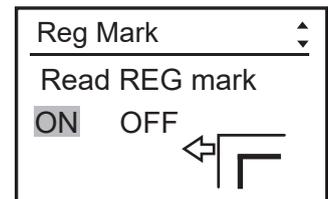
- The setting screen of **REG mark spec** does not appear if either **Side mark** or **Lead mark** does not have a value entry. To set **REG mark spec**, return to steps 10 and 11 and enter values for **Side mark** and **Lead mark**.
- If there are scratches or stains in the printing range of the REG mark, the position may not be corrected. If the read side of the document is rough and glossy, the CCD scanner may not be able to read the REG mark and the barcode. (The document may diffusely reflect light.)

When using specially treated documents (glossy documents), print a bold REG mark on them in advance. Then, select **Bold** for **REG mark spec**.

13

Read REG mark

When using **Read REG mark** (REG mark reading) function, use the CURSOR (Right/Left) key to select **ON** and press the SET key or the CURSOR (Down) key. When not using this function, select **OFF** and press the SET key or the CURSOR (Down) key.



IMPORTANT

The setting screen of **Read REG mark** does not appear if either **Side mark** or **Lead mark** does not have a value entry. To turn **ON** this function, return to steps 10,11, and 12 and enter values for **Side mark** and **Lead mark**.

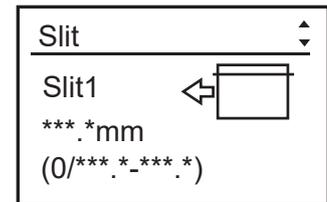
Programming a JOB in Advanced Mode

14

Slit

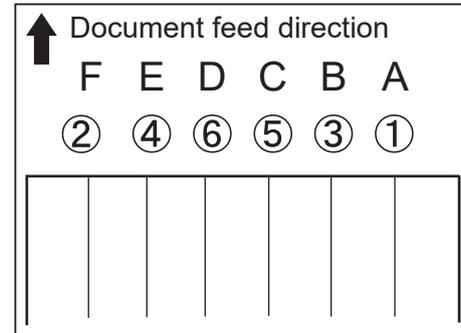
Enter the distance from the right edge of the document to the position for **Slit1** using the NUMERIC keys, and press the SET key or the CURSOR (Down) key.

Values that you can enter are displayed in (0/***.*-***.*).



REFERENCE

- Simple mode: Slits are set in alphabetical order from **Slit A** to **Slit F**.
- Advanced mode: Slits are set in numerical order as shown in the figure on the right.

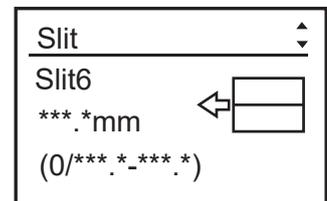


15

Enter the value for **Slit2** to **Slit6** in a similar way to step 14.

REFERENCE

- No screen appears for the slot in which the **slitter module** is not installed.



- The message as shown on the right appears if slit positions that make a gutter slit less than 5 mm that is out of the specifications are entered.

When this JOB is processed, gutter slits are not ejected into the waste box but on the **exit tray**.

Change slit positions so that a gutter slit is 5 mm or more.

The gutter slits are less than 5mm. Gutter are output on the

exit tray.

- The message as shown on the right appears if there are three or more gutter slits.

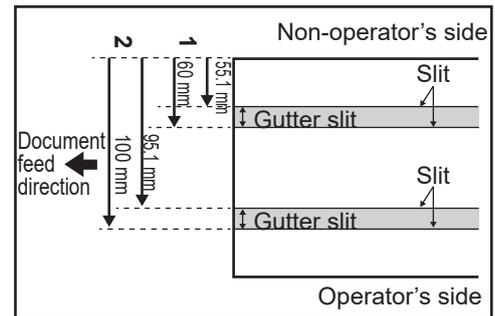
When this JOB is processed, gutter slits are not ejected into the waste box but on the **exit tray**.

More than 2 gutter slits. The gutter slits are output on the exit tray.

- Gutter slits, slits, and the **RTM (rotary tool module (option))** are allocated to the locations that prevent the sensor from sensing a document. The message appears when the following conditions of **1** and **2** are met simultaneously.
 - 1:** (55.1 to 60 mm)
 - 2:** (95.1 to 100 mm)
 Re-enter slit locations so that either of these conditions is outside the specified range.

Slit/RTM is at 55.1-60mm and 95.1-100mm. Change Slit/RTM

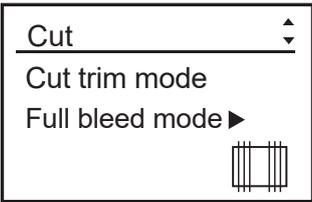
positions.



16

Cut trim mode

Use the CURSOR (Right/Left) key to select **Full bleed mode**, **No bleed mode** or **Process all**, and press the SET key or the CURSOR (Down) key.



Full bleed mode: Chops up the lead margin, the trail margin, and the gutters of 48.9 mm or shorter.

No bleed mode: Chops up the gutters of 48.9 mm or shorter.

Process all: Ejects all of the cut pieces to the **exit tray** except that the lead margin and the gutters of 27.9 mm or shorter and the trail margin of 48.9 mm or shorter are chopped up.

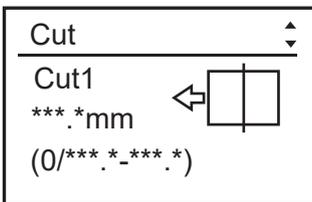
REFERENCE

If there is no lead margin or trail margin on the document, select **No bleed mode**.

17

Cut

Enter the distance from the lead edge of the document to the position for **Cut1** using the NUMERIC keys and press the SET key or the CURSOR (Down) key. This value must be smaller than that set for the document length.

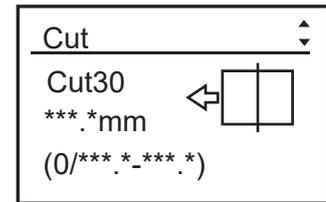


REFERENCE

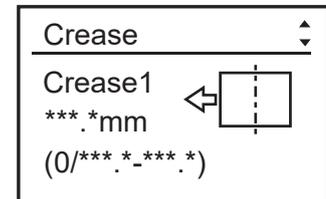
If you enter **0** or the value of the cut position is in the area of 5 mm from the trail edge, the **Crease** screen appears.

Programming a JOB in Advanced Mode

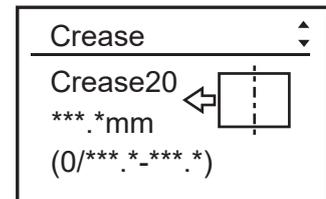
- 18 Cut**
Enter the value for **Cut2** to **Cut30** in a similar way to step 17. This value must be **previous cut position +3 mm or more**. The value for the last cut must be under **the document length -5 mm**. When you require fewer than 30 cuts, enter **0** after the last cut setting and then press the SET key or the CURSOR (Down) key.



- 19 Crease**
Enter the distance from the lead edge of the document to the position for **Crease1** using the NUMERIC keys and press the SET key or the CURSOR (Down) key. This value must be smaller than that set for the document length.



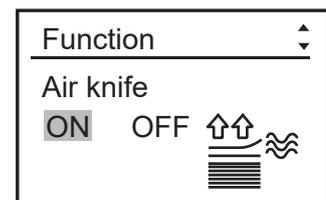
- 20 Crease**
Enter the value for **Crease2** to **Crease20** in a similar way to step 19. This value must be between the value for **the previous crease position set +0.1 mm or more** and the value set for document length. If you require fewer than 20 creases, enter **0** after the last crease setting and then press the SET key or the CURSOR (Down) key.



- 21 Air knife**
Use the CURSOR (Right/Left) key to turn **ON/OFF** the **Air knife** and press the SET key or the CURSOR (Down) key.

REFERENCE

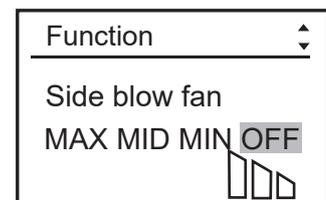
Turn **ON** this function when processing documents with excessive static electricity or heavy weight documents.



- 22 Side blow fan (Option: ASIA, TAIWAN)**
Use the CURSOR (Right/Left) key to select **MAX, MID, MIN,** or **OFF** and press the SET key or the CURSOR (Down) key.

REFERENCE

Set this function to **MAX** when processing documents with excessive static electricity or heavy weight documents. Set this to **MIN** or **OFF** when processing light weight documents.



- 23 Fan reg**
Use the CURSOR (Right/Left) key to select **MAX, MID, MIN,** or **OFF**, and press the SET key or the CURSOR (Down) key.

REFERENCE

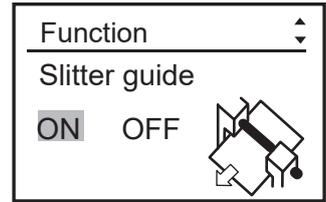
Set this function to **MIN** or **OFF** when processing light weight documents to prevent document jams.



24

Slitter guide

Use the CURSOR (Right/Left) key to turn **ON** the **Slitter guide** when using the module in the slot as a **slitter guide**, or turn **OFF** when not using it as a **slitter guide**, and press the SET key or the CURSOR (Down) key. When this function is **ON**, the module that is not used for performing a JOB acts as a document guide to stabilize the document conveyance. Even when it is **OFF**, the **margin slitter** acts as a guide.



REFERENCE

If you use the **rotary tool module** or the **slitter module**, you can set this function to **ON**.

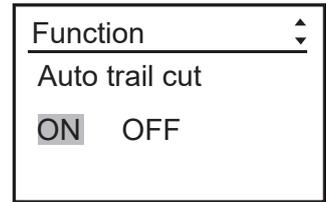
25

Auto trail cut

Use the CURSOR (Right/Left) key to select **ON** or **OFF**, and press the SET key or the CURSOR (Down) key.

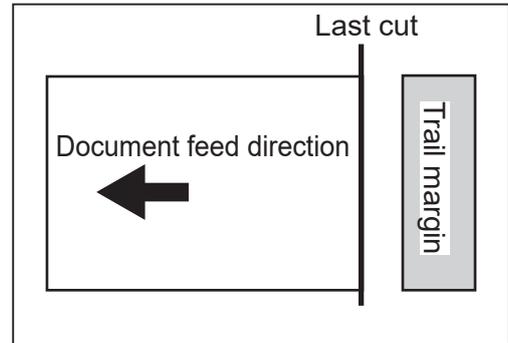
ON: Dummy cut is performed.

Set this to **ON** when the trail margin does not drop easily.



REFERENCE

- **Dummy cut :**
The DC-646 performs cutting operation three times without a document to be cut at the position where the document is fed for the distance of the trail margin plus extra length. This is effective for dropping a document, such as when the trail margin is jammed between the roller and the lower tool of the cutter.
- **Trail margin:**
Means a margin of the trail edge of a document produced when the last cut is performed.



26

Crease depth

Use the CURSOR (Right/Left) key to select **MAX**, **MID**, or **MIN**, and press the SET key or the CURSOR (Down) key.

Normally set this to **MID**.

Set this to **MAX** for heavy weight documents and **MIN** for light-weight documents.



REFERENCE

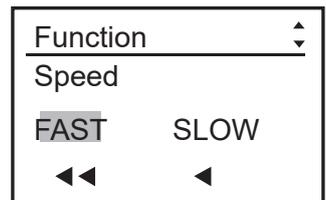
- Default is **MAX**.
- The above screen appears only when a value is entered to **Crease**. (→P.40 Crease)

27

Speed

Use the CURSOR (Right/Left) key to select **FAST** or **SLOW** and press the SET key or the CURSOR (Down) key.

Setting this to **SLOW** improves the finishing accuracy.



REFERENCE

If finishing accuracy cannot be obtained because of roller slip due to slippery documents (UV coated documents, etc.), select **SLOW**.

Programming a JOB in Advanced Mode

- 28** To save the JOB001, select **YES** and press the SET key.
To cancel the settings, press the STOP key.

Job001entry	▲
Enter JOB001?	
YES	NO

REFERENCE

- If you are selecting an already stored JOB number, the messages **Overwrite JOB***** or **Save as different JOB no.** appears on the screen.
If you select **Overwrite JOB***** and press the SET key, the JOB is overwritten.
- If you overwrite the locked JOB, the message as shown on the right appears.
To overwrite the locked JOB, unlock the JOB first.
(→P.56 Unlocking a JOB)

Job001entry	▲▼
Overwrite JOB***	
Save as	
different JOB no	

This JOB is
locked.
Cannot overwrite

REFERENCE

- If you select **Save as different JOB no.** and press the SET key, a list of JOB numbers appears on the screen.
Use the CURSOR (Up/Down) key to select JOB number, and press the SET key. Every time you press the CURSOR (Right/Left) key, the setting details of the highlighted JOB number are displayed.

JOB001entry	◀▶
1: DUPLO	
2: [No Data]	
3: [No Data]	

- 29** The message **Saving JOB** appears on the screen and the JOB settings are saved.
The JOB number with its name which you have just saved is displayed.

REFERENCE

When a JOB is retrieved, saved, or the power is turned **ON**, function settings in the JOB overwrites the setting made in **Settings1** and **Settings3**.

001: DUPLO	

Sheets	0

Programming a JOB in Simple Mode

The DC-646 provides two programming modes, the **advanced mode** and the **simple mode**.

When programming a JOB in the **simple mode**, select **Simple mode** under **Slitter entry** in the **Settings2** before programming one.

(→P.63 Function Setting 2)

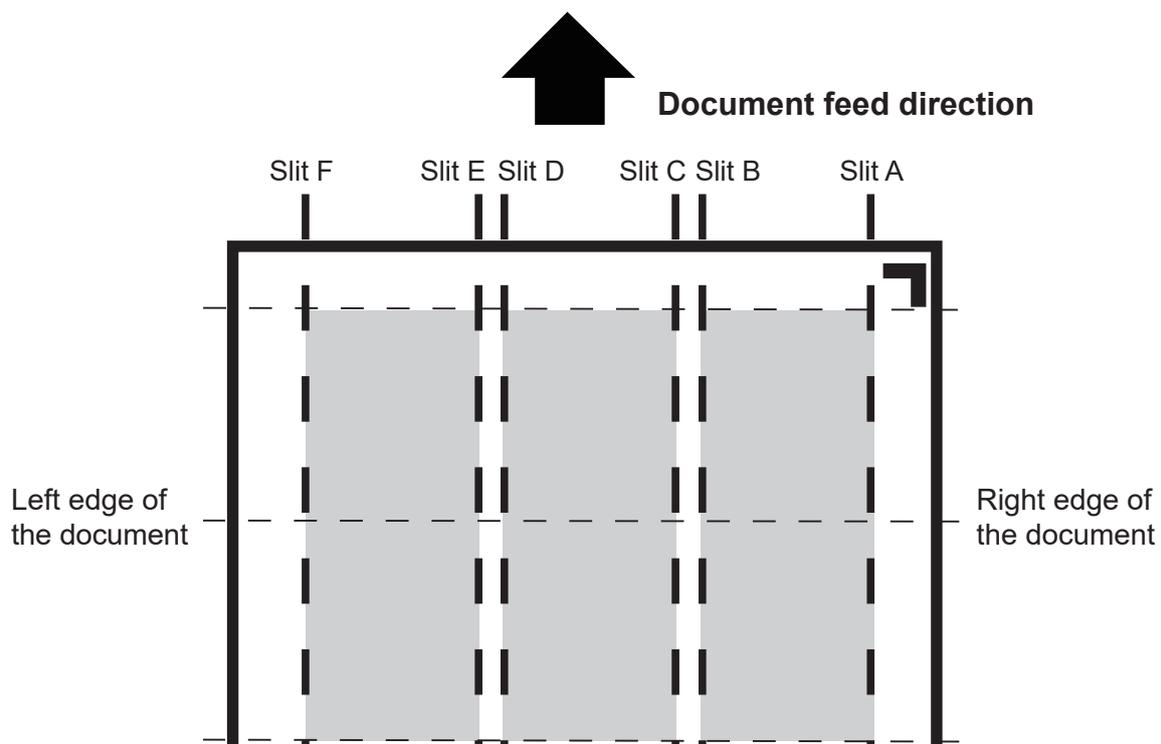
Simple mode: Optimum module setup in slot 2 to slot 4 is displayed by entering processing positions. The screen displays **SlitA** to **SlitF**. Set slit positions in order from the right side (**Slit A**) of a document along the document feed direction.

Hints for entering a JOB:

- Pressing the SET key goes on to the next step.
- Pressing the CURSOR (Up) key returns to the previous step.
- Pressing the CURSOR (Down) key goes on to the next step.
- Pressing the STOP key during JOB entering returns to the standby screen.
- Pressing the RETURN key returns to the previous screen.

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

Standard: standard module	Perf: perforation tool
Slitter: slitter module	Micro: micro perforation tool
CPM: cross tool module (option)	SI-Score: slit-score tool
RTM: rotary tool module (option)	Score: score tool

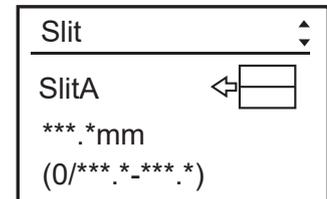


Programming a JOB in Simple Mode

- 1 Follow steps 1 to 11 and steps 15 to 18 of Programming a JOB in Advanced Mode. (→P.34 Programming a JOB in Advanced Mode)

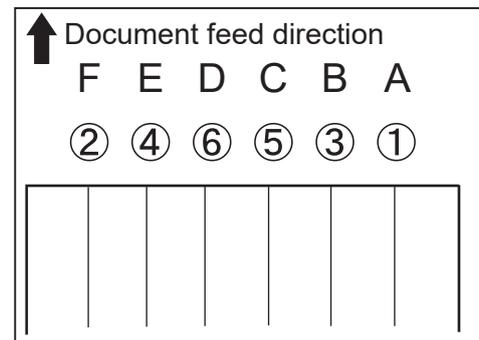
- When only slitter modules are installed in slot 3 and slot 4. (Neither the **CPM (cross tool module)** nor the **RTM (rotary tool module)** are used.)

- 2 **Slit**
Enter the distance from the right edge of the document to the position for **Slit A** using the NUMERIC keys, and then press the SET key or the CURSOR (Down) key.
In the **simple mode**, **SlitA** to **SlitF** are displayed.

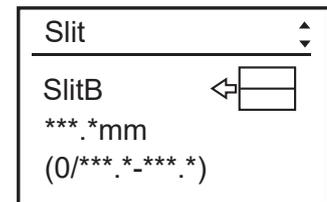


REFERENCE

- Simple mode: Slits are set in alphabetical order from **Slit A** to **Slit F**.
- Advanced mode: Slits are set in numerical order as shown in the figure on the right.



- 3 **Slit**
Enter the distance from the right edge of the document to the **Slit B** using the NUMERIC keys and press the SET key or the CURSOR (Down) key.
When you require fewer than six slits, enter **0** after the last slit setting and then press the SET key.



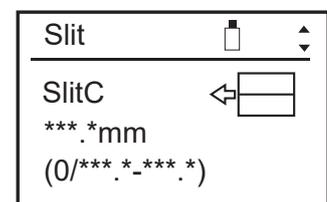
REFERENCE

When saving a JOB with side margins of 48–55 mm in the **simple mode**:

Right margin: Enter 0 for **SlitA** and 48–55 for **SlitB**.

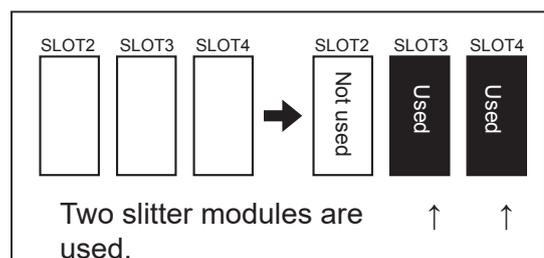
Left margin: Enter 48–55 for the width of the last slit but one and the document width for the last slit width.

- 4 Enter the distance from the right edge of the document to the **SlitC** using the NUMERIC keys and press the SET key or the CURSOR (Down) key.



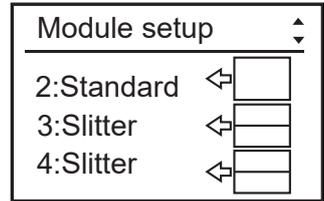
REFERENCE

The number of  icons indicates how many **slitter modules** are used for the JOB. If the **slitter modules** are used both in **SLOT3** and **SLOT4** as shown in the figure on the right, two of the  icons are displayed on the LCD panel.

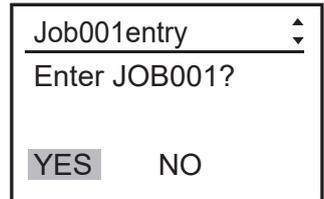


- 5 Enter values for **SlitD** to **SlitF** in a similar way.
- 6 Proceed with steps 23 to 34 of Programming a JOB in Advanced mode.
(→ P.39 Programming a JOB in Advanced mode)

7 **Module setup**
Check that the modules in slot 3 and slot 4 are the **slitter modules**. The figure on the right shows that standard module is used in slot 2 and the **slitter modules** are used in slot 3 and slot 4.

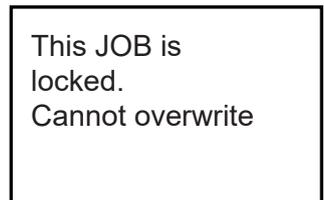
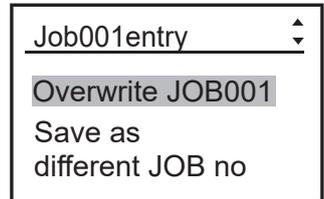


8 The display as shown on the right appears on the screen. To save the JOB001, select **YES** and press the SET key. To cancel the settings, press the STOP key.



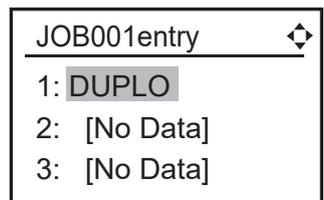
REFERENCE

- If you have selected an already stored JOB number, the messages **Overwrite JOB***** or **Save as different JOB no.** appears on the screen.
If you select **Overwrite JOB***** and press the SET key, the JOB is overwritten.
- If you overwrite the locked JOB, the message as shown on the right appears.
To overwrite the locked JOB, unlock the JOB first.
(→P.56 Unlocking a JOB)

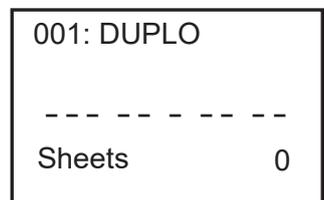


REFERENCE

- If you select **Save as different JOB no.** and press the SET key, a list of JOB numbers appears on the screen.
Use the CURSOR (Up/Down) key to select JOB number and press the SET key. Every time you press the CURSOR (Right/Left) key, the setting details of the highlighted JOB number are displayed.



9 The message **Saving JOB** appears on the screen and the JOB settings are saved. The JOB number with its name which you have just saved is displayed.



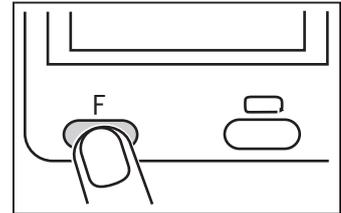
REFERENCE

When a JOB is retrieved, a JOB is saved, or the power is turned **ON**, function settings in the JOB overwrites the setting made in **Settings1** and **Settings3**.

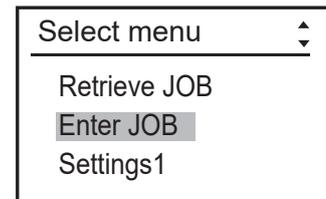
Correcting the JOB Settings

This section describes how to correct the JOB settings and to overwrite them.

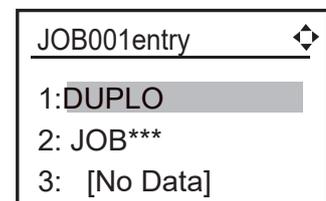
- 1 Make sure that the standby screen is displayed on the LCD panel. Press the F key.



- 2 Use the CURSOR (Down) key to select **Enter JOB** and press the SET key.



- 3 The JOB numbers are displayed in ascending order. Use the CURSOR (Up/Down) key to select the JOB number and press the SET key.

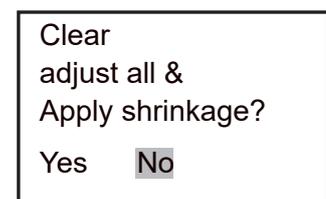


- 4 Press the SET key or CURSOR (Down) key to select an item. Follow the steps in Programming a JOB in Advanced Mode for each setting.
(→P.34 Programming a JOB in Advanced Mode)

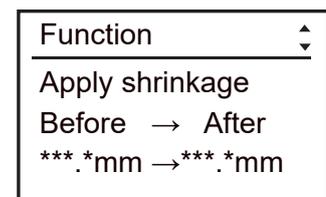
REFERENCE

If you retrieve and correct the stored JOB with the **Apply shrinkage** or the **Adjust all** function, the details of the function are displayed after the **Speed** screen of step 27 in Programming a New JOB (Advanced Mode).

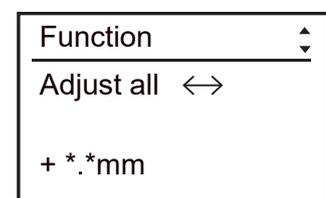
1. If you select **Yes** on the **Clear adjust all & Apply shrinkage?** screen, the correction value of **Adjust all** is reset. If you select **No**, the correction value is not changed.



2. Correction details of **Apply shrinkage** are displayed. Confirm the details and press the CURSOR (Down) key.



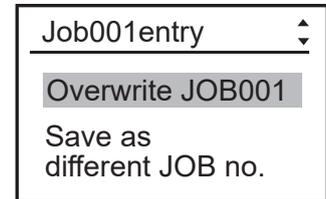
3. Correction details of **Adjust all** ↔ are displayed. Confirm the details and press the CURSOR (Down) key.



4. Correction details of **Adjust all** ⇅ are displayed.
 Confirm the details and press the CURSOR (Down) key.

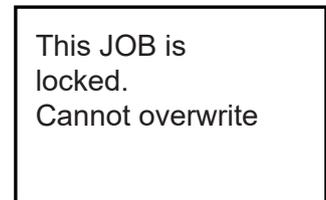


- 5 When setting for the last item is completed, the display as shown on the right appears.
 If you save the changes as the currently selected JOB number, press the CURSOR (Up/Down) key to select **Overwrite JOB001**, and then press the SET key.
 If you save them as a different JOB number, press the CURSOR (Up/Down) key to select **Save as different JOB no.** and then press the SET key.

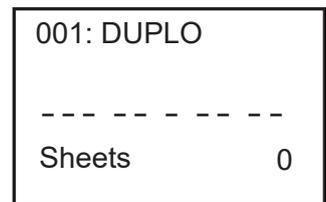


REFERENCE

If you overwrite the locked JOB, the message as shown on the right appears.
 To overwrite the locked JOB, unlock the JOB first.
 (→P.56 Unlocking a JOB)



- 6 The message **Saving JOB** appears on the screen and the changed JOB settings are saved.
 The standby screen reappears.
 The JOB number and the JOB name that have just been saved are displayed.



Chapter 3

Basic Operations

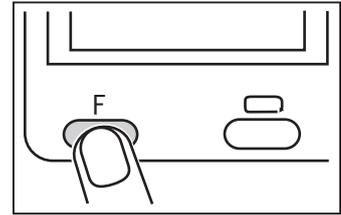
This chapter describes the operating sequence from turning ON the DC-646 until completing process.

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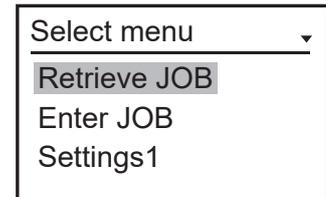
Processing a JOB by Retrieving

This section describes the procedure to process documents by selecting a JOB from **Retrieve JOB no.** or **Retrieve JOB log**.

- 1 Make sure that the standby screen is displayed on the LCD panel. Press the F key.



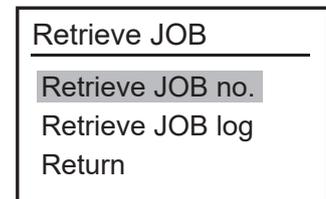
- 2 Select **Retrieve JOB** and press the SET key.



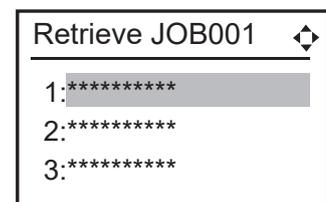
- 3 Use the CURSOR (Up/Down) key to select **Retrieve JOB no.** or **Retrieve JOB log** and press the SET key.

Retrieve JOB no.: JOB numbers appear in ascending order.

Retrieve JOB log: JOB numbers appear in descending order of entry from the latest processed JOB number.

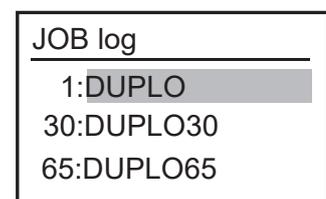
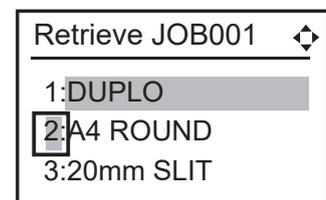
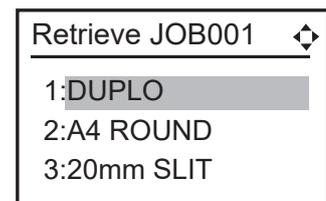


- 4 Use the CURSOR (Up/Down) key to select a JOB and press the SET key.



REFERENCE

- If you press the CURSOR (Right/Left) key with the cursor under the JOB number, you can confirm the details of the JOB number that you have selected.
- After selecting **Retrieve JOB no.**, you can select **JOB no.** using the NUMERIC keys.
- The JOB number of the locked JOB is highlighted. (→P.55 Locking a Saved JOB)
- Retrieving a JOB number from **Retrieve JOB log**
Processed JOBS are saved in the DC-646 as JOB log. Ten of the latest processed JOBS are saved and older JOBS exceeding 10 are deleted in chronological order.



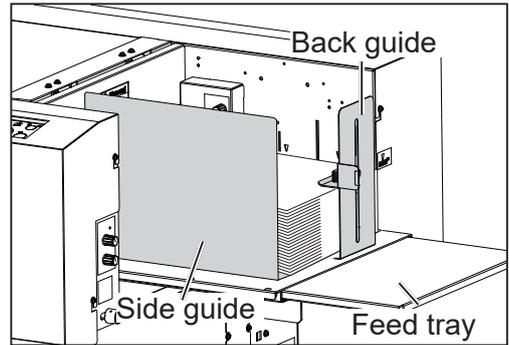
- The JOB number of the locked JOB is highlighted.
(→P.55 Locking a Saved JOB)

JOB log	
1:	DUPLO
30:	DUPLO30
65:	DUPLO65

- 5** Prepare appropriate documents for the JOB selected, then loosen the stack of the documents by flipping through the sheets.

IMPORTANT

The height of the document stack should not exceed the **MAX** level.

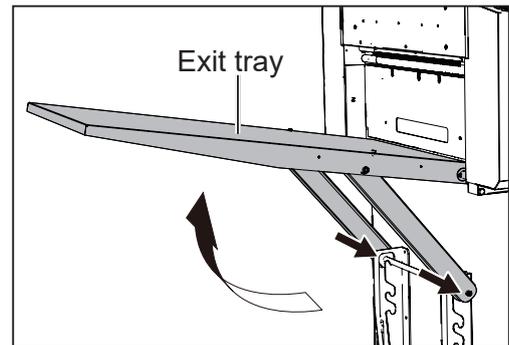


- 6** Attach the **side guide** (for the **feed tray**) and the **back guide** (for the **feed tray**) according to the document size.
(→P.11 Loading Documents)

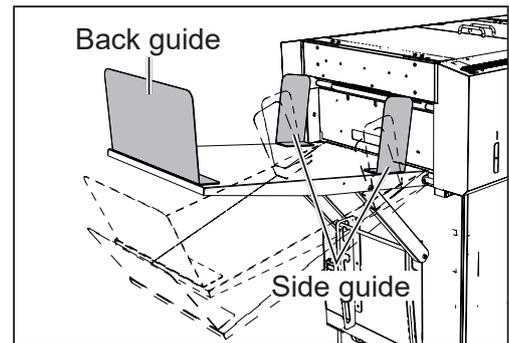
- 7** As shown in the figure on the right, lift the **exit tray**.
(→P.12 Setting the Exit Tray)

REFERENCE

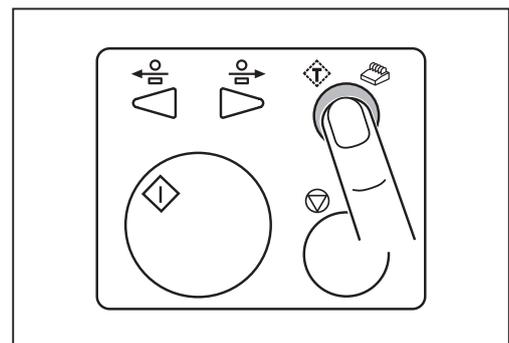
- When the finished product size is A3 (11"×17") or longer, it is recommended to set the **exit tray** in a downward position.
- If the finished products are adhered to the **exit tray** due to static electricity, set the **exit tray** in a downward position.



- 8** Attach the **back guide** (for the **exit tray**) and the two **side guides** (for the **exit tray**).
(→P.12 Setting the Exit Tray)

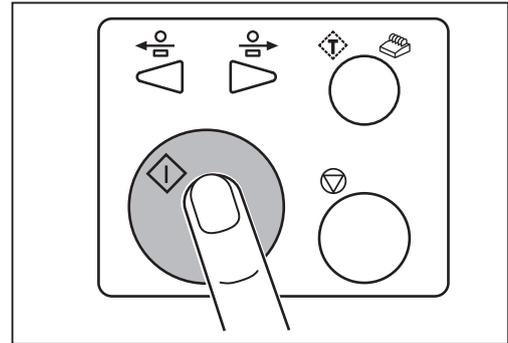


- 9** Press the TEST key to process a test run for one sheet.
Confirm that the finished product is processed as it is programmed. If not, make a fine adjustment in Function Setting.
(→P.57 Function Setting)



Processing a JOB by Retrieving

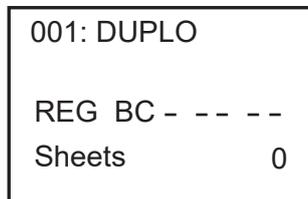
- 10 If you have already finalized the number of documents to be processed, use the NUMERIC keys to enter the number of documents.
- 11 Make sure that the LED on the START key is green, and then press the START key. If it is red, the DC-646 is having an error. Follow the instruction displayed on the LCD panel.
- 12 When the processing is completed, the standby screen reappears.



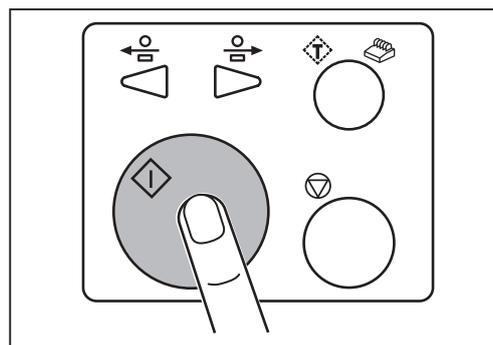
Processing a JOB in Pause Feeding Mode

This section describes the procedure to process a JOB by using the **pause feeding mode**. Use the **pause feeding mode** for small amount of documents such as when checking a finished product.

- 1 Make sure that the standby screen is displayed on the LCD panel.



- 2 Press and hold the START key when the machine is ready for operation to enter the **pause feeding mode**.



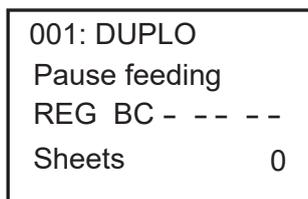
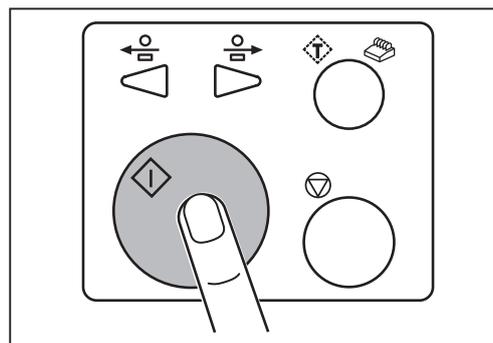
REFERENCE

In the **pause feeding mode**, the **feed tray** rises and stops with the **feed tray** kept its level.

- 3 Press and hold the START key in the **pause feeding mode** to start operation.

REFERENCE

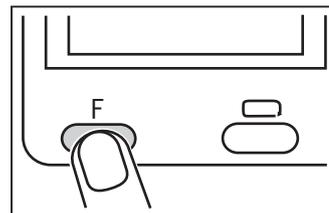
If you press and hold the START key during operation, the machine enters the **pause feeding mode**.



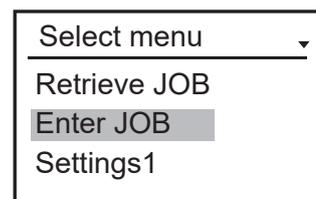
Deleting a Saved JOB

This section describes the procedure to delete saved JOBS.

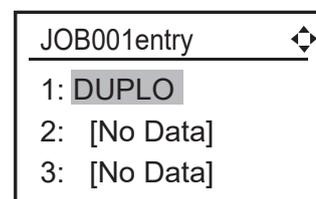
- 1 Make sure that the standby screen is displayed on the LCD panel. Press the F key.



- 2 Use the CURSOR (Up/Down) key to select **Enter JOB** and press the SET key.



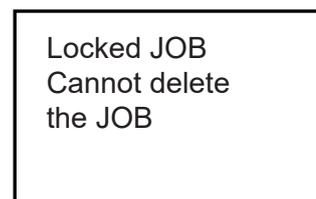
- 3 Use the CURSOR (Up/Down) key to select a JOB and press and hold the CLEAR key.



REFERENCE

If you delete the locked JOB, the message as shown on the right appears.

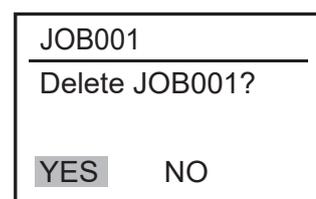
To delete the locked JOB, unlock the JOB first.
(→P.56 Unlocking a JOB)



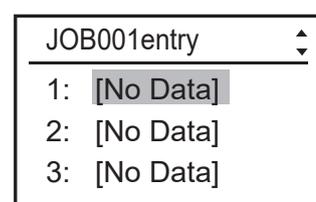
- 4 Use the CURSOR (Right/Left) key to select **YES** or **NO**. If you select **YES** and press the SET key, the JOB is deleted. If you select **NO** and press the SET key, the previous screen reappears.

REFERENCE

- If you press the STOP key, the previous screen reappears.
- If you press the RETURN key, the previous screen reappears.



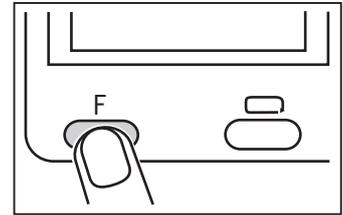
- 5 The JOB is deleted and the JOB name is **No Data**.



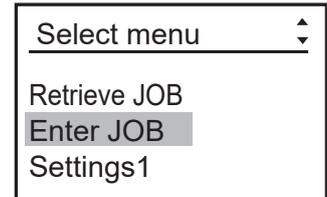
Locking a Saved JOB

This section describes the procedure to lock saved JOBS.
Locked JOBS cannot be overwritten.

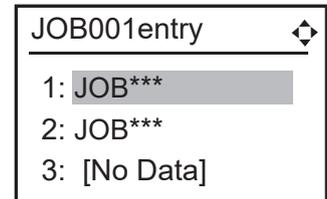
- 1 Make sure that the standby screen is displayed on the LCD panel. Press the F key.



- 2 Use the CURSOR (Up/Down) key to select **Enter JOB** and press the SET key.



- 3 The JOB numbers are displayed in ascending order. Use the CURSOR (Up/Down) key to select a JOB number and press and hold the SET key.

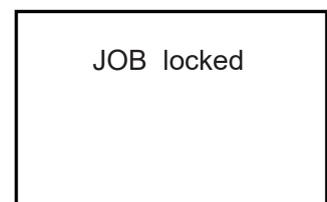


- 4 Use the CURSOR (Right/Left) key to select **YES** or **NO**. If you select **YES** and press the SET key, the JOB is locked. If you select **NO** and press the SET key, the previous screen reappears.

REFERENCE

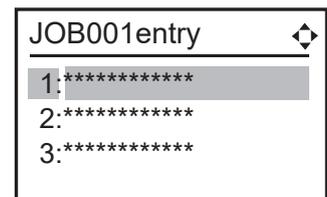
- If you press the STOP key, the previous screen reappears.
- If you press the RETURN key, the previous screen reappears.

- 5 **JOB locked** appears.



REFERENCE

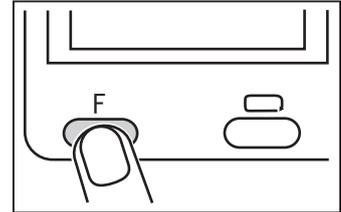
The JOB number of the locked JOB is highlighted.



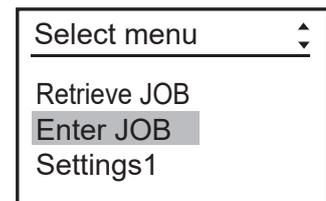
Unlocking a JOB

Locked JOBS cannot be overwritten.
Unlock the JOB and then overwrite it.

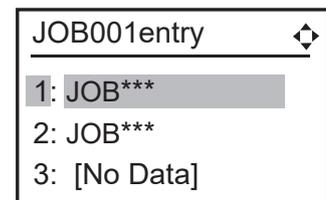
- 1 Make sure that the standby screen is displayed on the LCD panel. Press the F key.



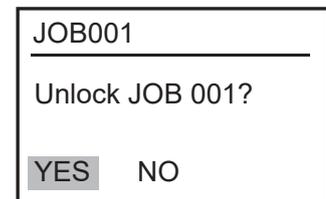
- 2 Use the CURSOR (Up/Down) key to select **Enter JOB** and press the SET key.



- 3 The JOB numbers are displayed in ascending order. Use the CURSOR (Up/Down) key to select a JOB number, and then press and hold the SET key.



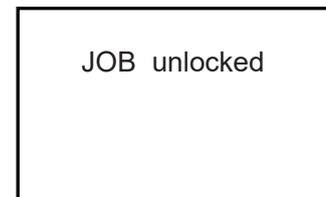
- 4 Use the CURSOR (Right/Left) key to select **YES** or **NO**. If you select **YES** and press the SET key, the JOB is unlocked. If you select **NO** and press the SET key, the previous screen reappears.



REFERENCE

- If you press the STOP key, the previous screen reappears.
- If you press the RETURN key, the previous screen reappears.

- 5 The JOB is unlocked and **JOB unlocked** appears.



Function Setting

< Function Setting 1 >

Air knife

Compressed air is blown out from the front of documents to loosen them, preventing a double feed. Default is **ON**.

Side blow fan (Option: ASIA, TAIWAN)

Air is blown out from the side of documents to loosen them, preventing a double feed. Default is **OFF**.

Fan reg (Fan register)

This suctions the document to the **conveyance belt** for skew correction. Default is **MAX**.

Read REG mark

This sets an operation mode when a REG mark is detected. Sensing the REG mark and handling operations at the regular position improve accuracy of documents handling. Default is **ALL**.

Read REG (REG mark reading accuracy)

This sets REG mark reading accuracy. Default is **Normal**.

REG mark spec

This sets a reading function for a bold REG mark printed on a specially treated document. (→ P.23 IMPORTANT)

Slitter guide

When no slitters are in use for performing a JOB, these slitters act as document guides to stabilize the document conveyance. Default is **OFF**.

Cut trim mode

The lead margin, the trail margin, and any gutter cuts (48.9 mm or shorter) are chopped up and dropped into the waste box. If there is no lead margin or trail margin on the document, select **No bleed mode**.

Crease depth

This sets the depth of a crease when a document is creased.

Speed

This is used to select processing speed from **FAST** or **SLOW**.

Auto trail cut

This performs a dummy cut for the trail margin of a document and helps the trail margin drops into the waste box smoothly.

REFERENCE

Saved settings for each function except for **Read REG (REG mark reading accuracy)** are automatically set when a JOB is retrieved.

Settings that are changed after the JOB is retrieved is active until the power is turned **OFF** or another JOB is retrieved.

The settings for **Read REG (REG mark reading accuracy)** is active after the power is turned **OFF** as well.

Function Setting

< Function Setting 2 >

DBL detection (double feed detection)

This detects a double feed (two or more sheets are fed at once). Default is **ON**.

Read Barcode (Barcode reading)

This reads a barcode printed on a document and automatically programs it for a JOB. Default is **ALL**.

Barcode digit

When reading a 2-digit barcode, use **2Digits**. When reading a 3-digit barcode, use **3Digits**.

REFERENCE

For detailed information, contact your dealer.

Reject

Double-fed documents or documents with reading an error (REG mark or Barcode) are ejected to the **reject tray** automatically.

Waste detection

This sets the detection timing of **waste box full**. If **waste box full** is detected, **waste box full** message appears on the LCD panel. Default is **ON**.

Feeder capacity

The elevator level can be adjusted to three levels according to the document quantity. Default is **MAX**.

Basic mode

You can select **Simple mode** or **Advanced mode** for entering a JOB.

CPM on pos adj (When the CPM (cross tool module (option)) is installed only)

This adjusts processing start position of the **CPM (cross tool module)**.

CPM off pos adj (When the CPM (cross tool module (option)) is installed only)

This adjusts processing end position of the **CPM (cross tool module)**.

RTM on pos adj (When the RTM (rotary tool module (option)) is installed only)

This adjusts processing start position of the **RTM (rotary tool module)**.

RTM off pos adj (When the RTM (rotary tool module (option)) is installed only)

This adjusts processing end position of the **RTM (rotary tool module)**.

REFERENCE

Settings for each function are active after the power is turned **OFF** as well.

< Function Setting 3 >

Apply shrinkage

In case printed documents are shrunk by heat generated on a digital printer, if the original document size and document size after shrunk are entered, the DC-646 automatically calculates the shrinkage ratio and adjusts cutting and creasing positions accordingly.

This function compensates for the shrinkage in the feed direction only.

REFERENCE

Apply shrinkage can be programmed for a JOB.

The saved settings are automatically set when the JOB is retrieved.

Settings that are temporarily changed and not saved are active until the power is turned **OFF** or another JOB is retrieved.

< STACKER >

Batch separation

The machine pauses for the time entered on the **Gap timing** screen, and then resumes a series of processing.

End mark

Processing is executed with the interval set in **Batch separation** between a document with end mark printed on it and the next one.

Stack priority

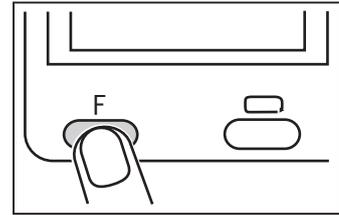
This sets speed of a finished product to be ejected from the exit of the machine to the **exit tray**.

REFERENCE

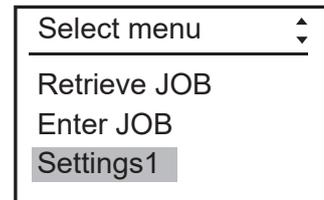
STACKER is active after the power is turned **OFF** as well. You cannot program this for a JOB.

Function Setting 1

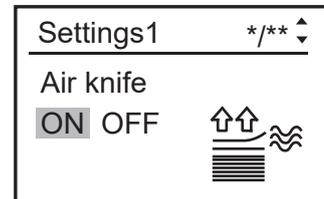
1 Make sure that the standby screen is displayed on the LCD panel. Press the F key.



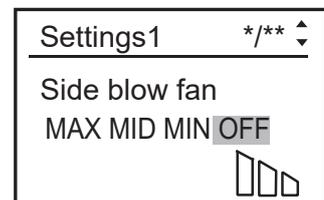
2 Use the CURSOR (Up/Down) key to select **Settings1** and press the SET key.



3 Air Knife
Compressed air is blown out from the front of documents to loosen them, preventing a double feed.
Use the CURSOR (Right/Left) key to select **ON** or **OFF** and press the CURSOR (Down) key.
When using light weight documents, select **OFF**.



4 Side blow fan (Option: ASIA, TAIWAN)
Air is blown out to the edge of the document to easily separate documents when they are fed.
Use the CURSOR (Right/Left) key to select **MAX**, **MID**, **MIN** or **OFF** and press the CURSOR (Down) key.



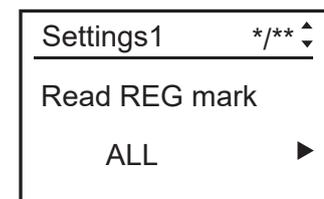
5 Fan reg
Document skewing in the **feeding area** is corrected.
Use the CURSOR (Right/Left) key to select **MAX**, **MID**, **MIN** or **OFF** and press the CURSOR (Down) key.



REFERENCE

Select **MIN** or **OFF** for light weight documents to prevent a document jam.

6 Read REG mark
Set the number of documents on which REG mark is read.
Use the CURSOR (Right/Left) key to select **ALL**, **Only first sht**, **Every**sht**, ****.*mm or more**, or **OFF** and press the CURSOR (Down) key.



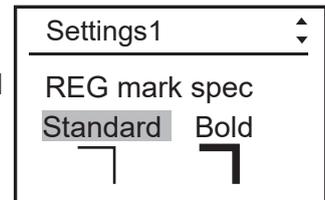
REFERENCE

- **Every**sht:** You can set 2 to 9999.
For example, if you set two sheets, REG mark is read once in two sheets (1st, 3rd, 5th, ...). Rejected sheets are included in the number.
- ****.*mm or more:** You can set 0.2 to 12.0. If you set ****mm** and the difference between the REG mark and the current slit position is under **** mm**, the slit position does not move. ****.*mm or more** is used when the difference is large and REG mark needs to be compensated.

7

REG mark spec

When using specially treated documents (→ P.23 IMPORTANT), print a bold REG mark on them in advance. Then, select **BOLD** and press the SET key or the CURSOR (Down) key.



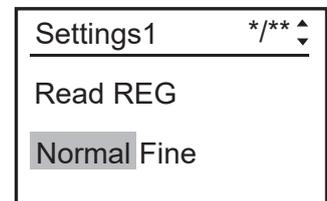
8

Read REG (REG mark reading accuracy)

Selected accuracy is enabled when REG mark is read.

Normal: Reads REG mark with normal accuracy.

Fine: Improves REG mark reading accuracy and compensates printing position misalignment finer. Changing the setting from **Normal** to **Fine** for higher reading accuracy decreases processing speed as compared with **Normal**.



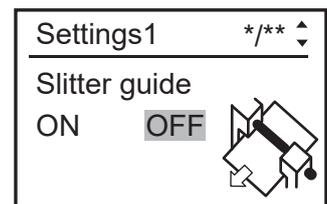
9

Slitter guide

When no slitters are in use for performing a JOB, these slitters act as document guides to stabilize the document conveyance. Recommended for light weight documents.

Use the CURSOR (Right/Left) key to select **ON** or **OFF** and press the CURSOR (Down) key.

Even when setting is **OFF**, the **margin slitter** acts as a guide.

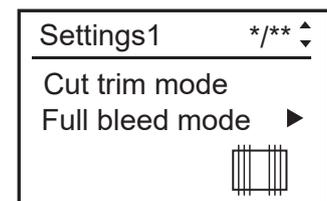


10

Cut trim mode

The lead margin, the trail margin and gutters are chopped up and dropped into the **waste box**.

Use the CURSOR (Right/Left) key to select **Full bleed mode**, **No bleed mode**, or **Process all** and press the CURSOR (Down) key.



Full bleed mode: Chops up the lead margin and the trail margin, and gutters of 48.9 mm or shorter, then drops into the **waste box**.

No bleed mode: Chops up gutters of 48.9 mm or shorter.

Process all: Ejects all of the cut pieces to the exit tray, except that the lead margin and gutters of 27.9 mm or shorter and the trail margin of 49.8 mm or shorter are chopped up.

REFERENCE

- If the document has no lead margin or trail margin, select **No bleed mode**.
- The above screen appears only when a value is entered to **Cut**. (→P.40 Cut)

Function Setting

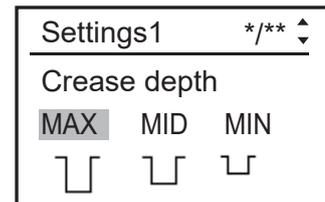
11

Crease depth

Set **Crease depth** function when creasing on the document. Use the CURSOR (Right/Left) key to select **MAX**, **MID**, or **MIN** and press the CURSOR (Down) key.

REFERENCE

- Set this to **MAX** for heavy weight documents and **MIN** for light weight documents.
- The above screen appears only when a value is entered to **Crease**. (→P.40 Crease))

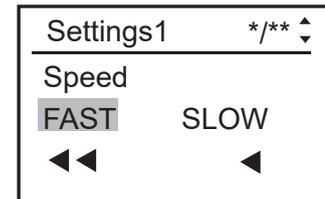


12

Speed

Use the CURSOR (Right/Left) key to select **FAST** or **SLOW** and press the CURSOR (Down) key.

If finishing accuracy cannot be obtained because of roller slip due to slippery documents (UV coated documents, etc.), select **SLOW**.



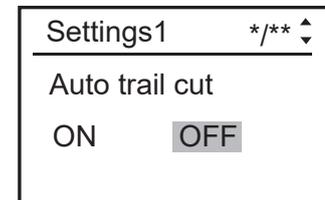
13

Auto trail cut

Use the CURSOR (Right/Left) key to select **ON** or **OFF** and press the CURSOR (Down) key.

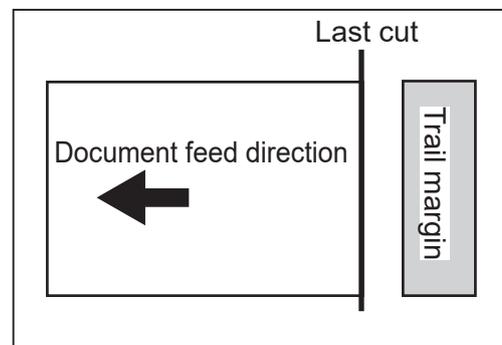
ON: Processes an optimum trail margin cut for a JOB. Set this to **ON** when the trail margin does not drop easily. Default is **OFF**.

OFF: Does not perform the **auto trail cut** regardless of the length of the trail margin.



REFERENCE

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



14

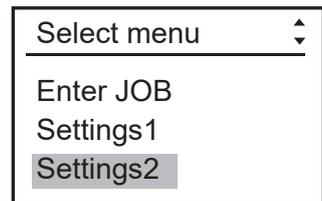
Press the SET key.

IMPORTANT

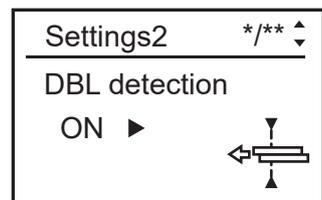
- If you exit **Function Setting** without pressing the SET key, the function set are not saved.
- If you press the SET key before completing **Function Setting**, the setting you have just entered is saved and the standby screen appears.

Function Setting 2

- 1 Press the F key to display the **Select menu** screen.
Use the CURSOR (Up/Down) key to select **Settings2** and press the SET key.



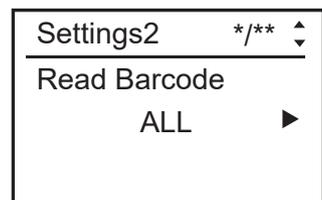
- 2 **DBL detection (Double feed detection)**
This detects a double feed (two or more sheets are fed at once).
Use the CURSOR (Right/Left) key to select **ON** or **OFF** and press the CURSOR (Down) key.



IMPORTANT

A double feed may not be detected if you use rough-textured documents.

- 3 **Read Barcode**
This sets whether to perform automatic setup by reading the barcode.
Use the CURSOR (Right/Left) key to select **ALL**, **Only first sht** or **OFF**, and the CURSOR (Down) key.

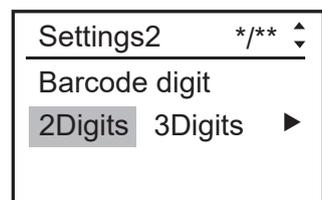


ALL: Reads barcode on every document and sets a JOB.

Only first sht: Reads barcode on the first document and sets a JOB.

OFF: Does not a read barcode.

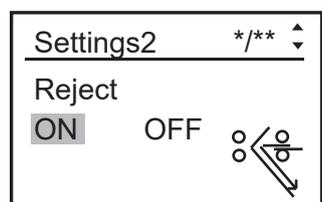
- 4 **Barcode digit**
Use the CURSOR (Right/Left) key to select **2Digits** or **3Digits** and press the CURSOR (Down) key.



IMPORTANT

For detailed information, contact your dealer.

- 5 **Reject**
Double-fed documents or documents with CCD reading an error are ejected to the **reject tray** automatically. If an error occurs three times continuously, processing stops.
Use the CURSOR (Right/Left) key to select **ON** or **OFF** and press the CURSOR (Down) key.



REFERENCE

A document of 670 mm or longer is not ejected on the **reject tray**.

Function Setting

6 Waste detection

This sets the detection timing of **waste box full**. When **waste box full** is detected, an error message appears on the LCD panel.

Use the CURSOR (Right/Left) key to select **MAX**, **MID**, or **OFF** and press the CURSOR (Down) key.

MAX: Detects **full** when the waste comes to 70% of the waste box.

MID: Detects **full** when the waste comes to half of the waste box.



REFERENCE

- The dotted line in the figure on the LCD panel is a rough guide of **waste box full**.
- This function is only for when processing light weight documents or short documents.

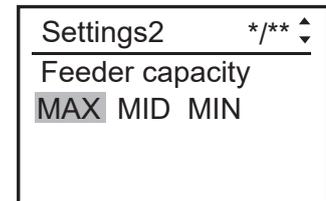
7 Feeder capacity

The elevator level can be adjusted to the three levels below according to the document quantity.

Use the CURSOR (Right/Left) key to select **MAX**, **MID**, or **MIN** and press the CURSOR (Down) key.

MAX: When loading high quantity of documents

MIN: When loading low quantity of documents

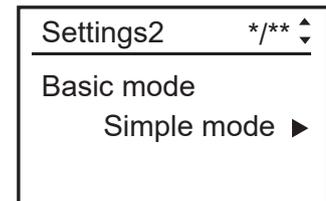


8 Basic mode

You can select **Simple mode** or **Advanced mode** for entering a JOB. Use the CURSOR (Right/Left) key to select **Simple mode** or **Advanced mode** and press the CURSOR (Down) key.

Simple mode: The appropriate modules are automatically designed after you entered all the processing values.

Advanced mode: You can set all the modules and tools alternately from side to side in order of module along the document feeding direction.



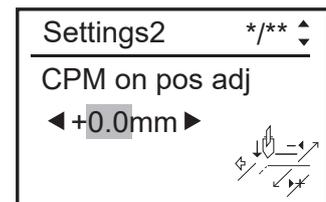
9 CPM on pos adj

You can adjust a processing start position when the **CPM (cross tool module (option))** is installed.

Use the CURSOR (Right/Left) key to select shift direction (+/-), and use the NUMERIC key to enter a value. Then press the CURSOR (Down) key.

+: Shifts a processing start position toward the operator's side.

-: Shifts a processing start position toward the non-operator's side.



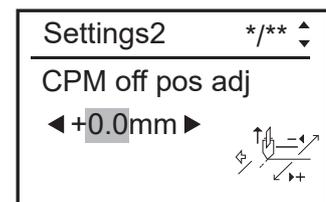
10 CPM off pos adj

You can adjust a processing end position when the **CPM (cross tool module (option))** is installed.

Use the CURSOR (Right/Left) key to select a shift direction (+/-) and use the NUMERIC key to enter a value. Then press the CURSOR (Down) key.

+: Shifts a processing end position toward the operator's side.

-: Shifts a processing end position toward the non-operator's side.

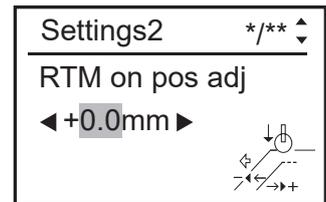


11 RTM on pos adj

You can adjust a processing start position when the **RTM (rotary tool module (option))** is installed.

Use the CURSOR (Right/Left) key to select shift direction and use the NUMERIC key to enter a value. Then press the CURSOR (Down) key.

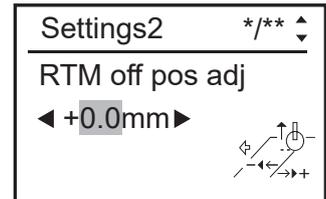
- + : Shifts a processing start position toward the document rear edge from its reference position.
- : Shifts a processing start position toward the document lead edge from its reference position.

**12 RTM off pos adj**

You can adjust a processing end position when the **RTM (rotary tool module (option))** is installed.

Use the CURSOR (Right/Left) key to select shift direction and use the NUMERIC key to enter a value. Then press the CURSOR (Down) key.

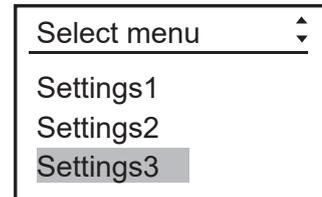
- + : Shifts a processing end position toward the document rear edge from its reference position.
- : Shifts a processing end position toward the document lead edge from its reference position.

**13** Press the SET key.**IMPORTANT**

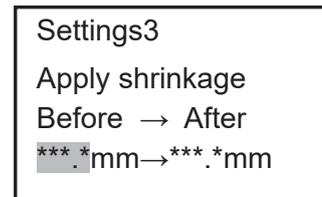
- If you exit **Function Setting** without pressing the SET key, the function set are not saved.
- If you press the SET key before completing **Function Setting**, the setting you have just entered is saved and the standby screen reappears.

Function Setting 3

- 1 Press the F key to display the **Select menu** screen.
Use the CURSOR (Up/Down) key to select **Settings3** and press the SET key.



- 2 **Apply shrinkage**
In case printed documents are shrunk by heat generated on a digital printer, if the original document size and the document size after shrunk are entered, the DC-646 automatically calculates the shrinkage ratio and adjusts cutting and creasing positions accordingly.
Use the NUMERIC keys to enter the original document length (Before), and enter the shrunk document length (After).



REFERENCE

If you press and hold the CLEAR key, the value of **Before** and **After** returns to the one that was entered to **Length**.

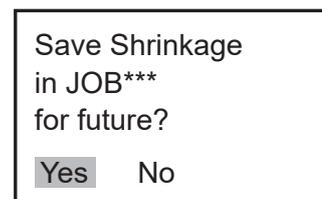
- 3 Press the SET key.

IMPORTANT

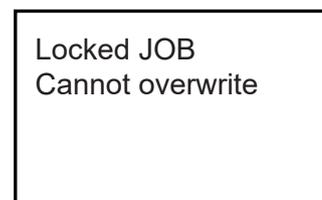
- If you exit **Function Setting** without pressing the SET key, the function set are not saved.
- If you press the SET key before completing **Function Setting**, the setting you have just entered is saved and the standby screen reappears.

REFERENCE

- The message as shown on the right appears if you change value(s) only for **Apply shrinkage** in step 2.



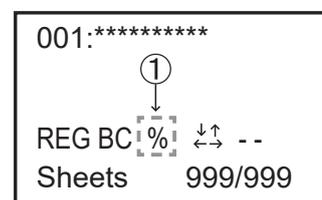
- If you overwrite the locked JOB, the message as shown on the right appears.
To overwrite the locked JOB, unlock the JOB first.
(→P.56 Unlocking a JOB)



- 4 The standby screen appears.

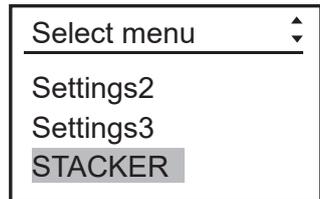
REFERENCE

% is displayed at the location of ① only when **Apply shrinkage** is set in **Settings3**.

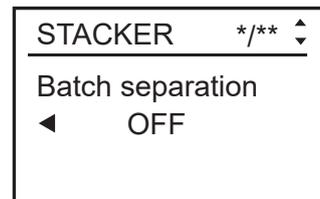


Stacker

- 1** Press the F key to display the **Select menu** screen.
Use the CURSOR (Up/Down) key to select **STACKER** and press the SET key.



- 2** **Batch Separation**
This selects a setting for the operation in the interval after a few documents preset are processed or after the end mark is read until the next document is processed.
Use the CURSOR (Right/Left) key to select **Automatic**, **Manual**, or **OFF** and press the CURSOR (Down) key.

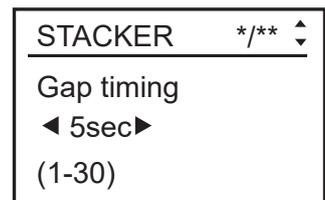


Automatic: Pausing is canceled according to the set time and then the operation resumes automatically. Even if the set time has not elapsed, pressing the START key cancels batch separation and resumes the operation.

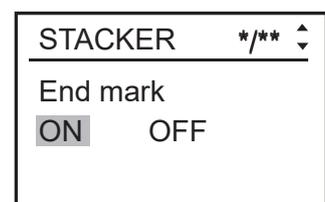
Manual: Press the START key to cancel batch separation and resume the operation.

OFF: Normal operation is performed.

- 3** **Gap timing**
If you have selected **Automatic** on the **Batch separation** screen in step 2, set a recovery time from pausing.
Use the CURSOR (Right/Left) key to set **Gap timing**, and press the CURSOR (Down) key.
You can set it in the range of 1 sec. to 30 sec.
Default is **5sec**.



- 4** **End mark**
Use the CURSOR (Right/Left) key to select **ON** or **OFF**, and then press the CURSOR (Down) key.



ON: Select **ON** when you use the **End mark** function.

Processing is executed with the interval set in **Batch separation** between a document with end mark printed on it and the next one.

OFF: Select **OFF** when you do not use the **End mark** function.

IMPORTANT

When the number for the preset count is set, the **End mark** function is not available even if it is set to **ON**.

Function Setting

5

Stack priority

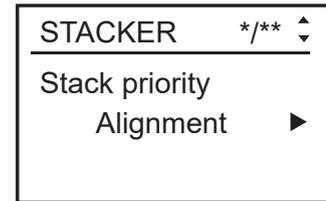
Set speed of a finished product to be ejected from the exit of the machine to the **exit tray**.

Use the CURSOR (Right/Left) key to select **Alignment** or **Speed**.

Alignment: Gives priority to alignment of finished products.
Decreases processing speed.

Speed: Gives priority to processing speed. Reduces accuracy of alignment of finished products.

Default is **Alignment**.



6

Press the SET key.

The standby screen reappears.

IMPORTANT

- If you exit **Function Setting** without pressing the SET key, the function set are not saved.
- If you press the SET key before completing **Function Setting**, the setting you have just entered is saved and the standby screen reappears.

Adjust All (in Vertical/Horizontal Direction)

Adjust All \leftrightarrow (in a vertical direction)

This corrects a document position in a vertical direction against the JOB set.

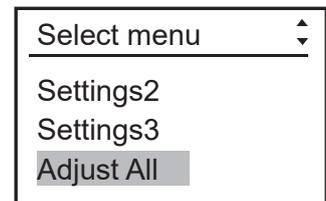
Adjust All \updownarrow (in a horizontal direction)

This corrects a document position in a horizontal direction against the JOB set.

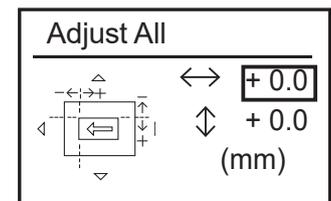
REFERENCE

You can program **Adjust All** $\leftrightarrow/\updownarrow$ for a JOB. The saved settings are automatically set when the JOB is retrieved. Settings that are temporarily changed and not saved are active until the power is turned **OFF** or another JOB is retrieved.

- 1 Press the F key to display the **Select menu** screen.
Use the CURSOR (Up/Down) key to select **Adjust All** and press the SET key.



- 2 **Adjust All \leftrightarrow (in a vertical direction)**
This function corrects a document position in a vertical direction against the JOB set (mm).
 1. Use the CURSOR (Up/Down) key to select moving direction (+/-).
 2. Use the NUMERIC keys to enter a value and then press the CURSOR (Down) key.



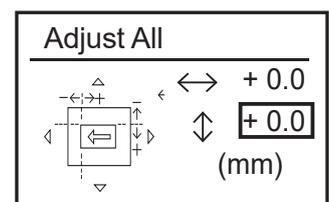
REFERENCE

When both ****.*mm or more** under **Read REG mark** and **Adjust All \leftrightarrow** are set, the values are summed up.

- 3 **Adjust All \updownarrow (in a horizontal direction)**

This function corrects a document position in a horizontal direction against the JOB set (mm).

1. Use the CURSOR (Up/Down) key to select moving direction (+/-)
2. Use the NUMERIC keys to enter a value and then press the CURSOR (Down) key.



REFERENCE

When both ****.*mm or more** under **Read REG mark** and **Adjust All \updownarrow** are set, the values are summed up.

Adjust All (in Vertical/Horizontal Direction)

- 4 Press the SET key.

IMPORTANT

- If you exit **Function Setting** without pressing the SET key, the function settings are not saved.
- If you press the SET key before completing **Function Setting**, the setting you have just entered is saved and the standby screen reappears.

REFERENCE

- The messages as shown on the right appear if the crease position is out of specifications as the result from the calculation of the values of **Adjust All** (for both directions) and **Apply shrinkage**.
Re-enter a value for the crease position, **Adjust All**, or **Apply shrinkage**.

The last crease position becomes invalid.
All adjustments

and shrinkage are cleared.

- If you overwrite the locked JOB, the message as shown on the right appears.
To overwrite the locked JOB, unlock the JOB first.
(→P.56 Unlocking a JOB)

Locked JOB
Cannot overwrite

- If you have changed the value of **Adjust All**↔ in step 2 or **Adjust All**↕ in step 3, the message as shown on the right appears.

Save AdjustAll in JOB*** for future?
 Yes No

IMPORTANT

If you select **Yes** and press the SET key, setting is saved both in **Adjust All** and in the JOB.

If you select **No** and press the SET key, setting is saved in **Adjust All** only.

Save Shrinkage & Adj. All in JOB*** for future?
Yes No

- 5 The standby screen appears.

REFERENCE

↕↔ is displayed at the location of ① only when **Adjust ALL**↔ or **Adjust All**↕ is set in **Function Settings**

001:*****
REG BC % ①
Sheets 999/999

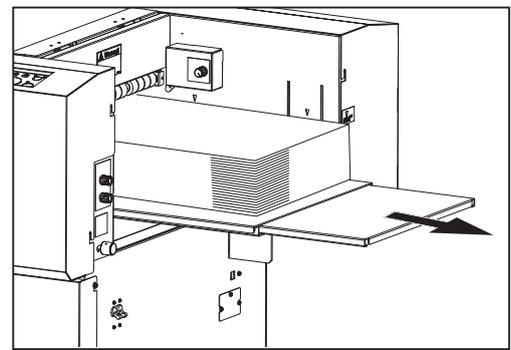
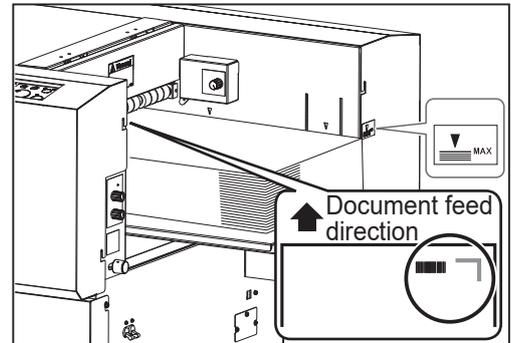
Processing a JOB with a Barcode

By adding a barcode which indicates a JOB number on each document, the DC-646 automatically sets up the machine and starts processing the JOB.

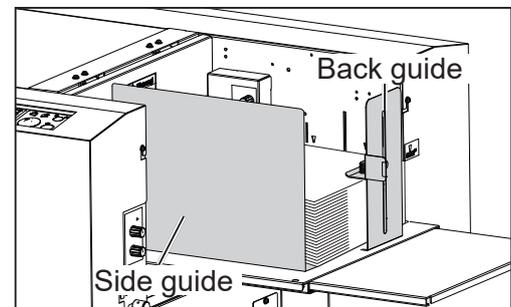
- 1 Prepare appropriate documents for the JOB selected. Loosen the stack of documents by flipping through the sheets and load them on the **feed tray** so that the **barcode** or **REG mark** printed side is facing upward and is located at the upper right to the document feed direction.

REFERENCE

- The height of the document stack should not exceed the **MAX** level.
- To set a document that is vertically long, pull out the **feed tray** to accommodate the length of the document.



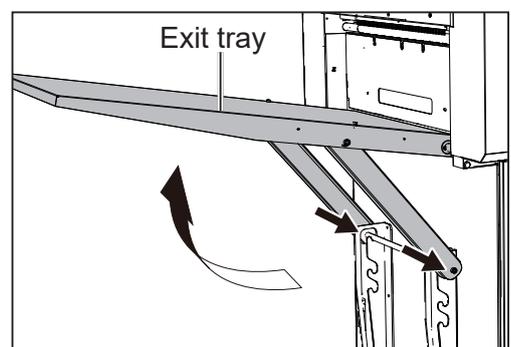
- 2 Attach the **side guide** (for the **feed tray**) and the **back guide** (for the **feed tray**) according to the document size.



- 3 Lift the **exit tray** as shown in the figure on the right. Attach the guide to the opening between the **exit tray** and the machine.

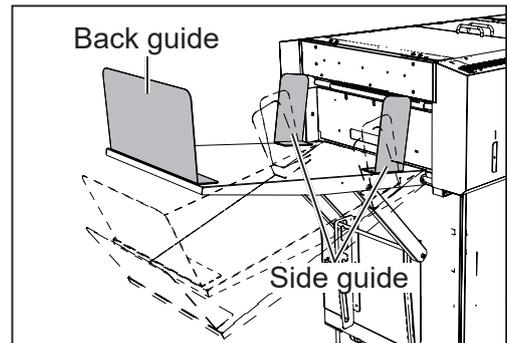
REFERENCE

- When the finished product size is A3 (11"×17") or longer, it is recommended to set the **exit tray** in a downward position.
- If the finished products are adhered to the **exit tray** due to static electricity, set the **exit tray** in a downward position.



Processing a JOB with a Barcode

- 4 Attach the **back guide** (for the **exit tray**) and the two **side guides** (for the **exit tray**). Set the **back guide** (for the **exit tray**) perpendicular to the floor.



- 5 Set **Read Barcode** to **ON** in **Settings2**. (→P.63 Function Setting 2)

IMPORTANT

Make sure that **BC** is displayed on the standby screen after setting is completed.

001: *****

REG BC - - - -
Sheets 999/999

- 6 By pressing the **START** key, the built-in CCD reads the barcoded **JOB** number, then starts processing the suitable **JOB**.
- 7 The finished products are ejected to the **exit tray**.

IMPORTANT

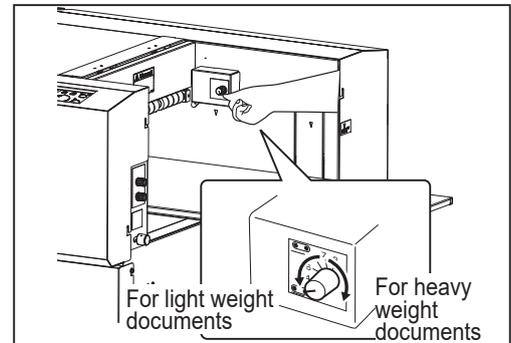
Slit waste accumulates in the **waste box**. Open the **front cover** and remove them periodically. Accumulation of waste may cause a document jam.

Adjusting Feeder

Elevator Level (Feed tray) Adjustment

The elevator level should be adjusted in the following cases:

1. The machine does not feed.
→ Turn the **level adjustment knob** in a counterclockwise direction (to a smaller number).
The level of the elevator is raised.
2. The machine feeds multiple sheets at once. (double feed)
→ Turn the **level adjustment knob** in a clockwise direction (to a larger number).
The level of the elevator is lowered.

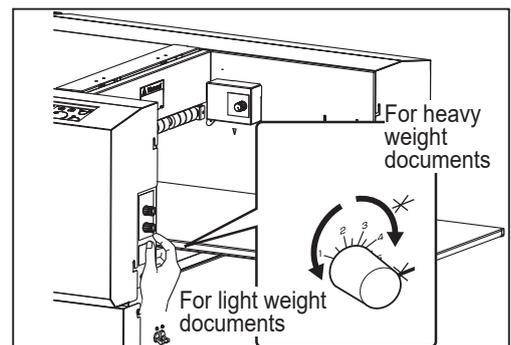


Level adjustment knob

Separator Adjustment

The height of the separator should be adjusted in the following cases:

1. The machine does not feed.
→ Turn the **separator adjustment knob** in a clockwise direction (to a larger number).
The position of the separator is lowered.
2. The machine feeds multiple sheets at once. (double feed)
→ Turn the **separator adjustment knob** in a counterclockwise direction (to a smaller number).
The position of the separator is raised.

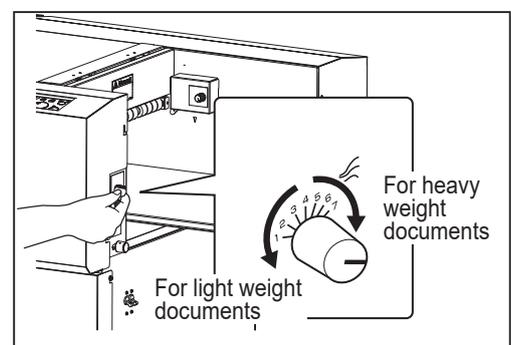


Separator adjustment knob

Airflow Adjustment

The amount of airflow should be adjusted in the following cases:

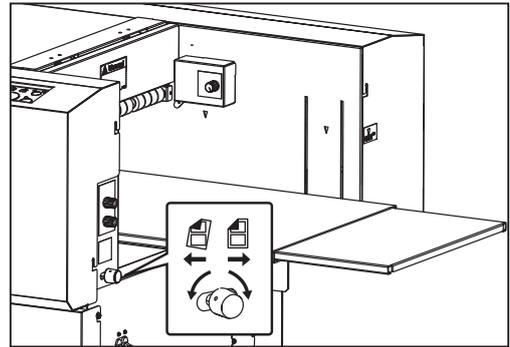
1. The machine does not feed.
→ Turn the **airflow adjustment knob** in a clockwise direction (to a larger number).
The amount of airflow is increased.
2. The machine feeds multiple sheets at once. (double feed).
→ Turn the **airflow adjustment knob** in a counterclockwise direction (to a smaller number).
The amount of airflow is decreased.



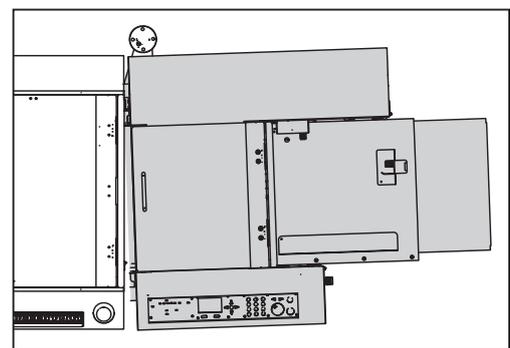
Airflow adjustment knob

Skew Compensation

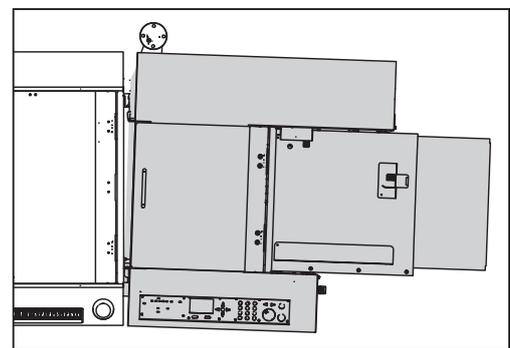
- 1 If the finished products are cut obliquely, adjust skew using the **skew adjustment knob**.



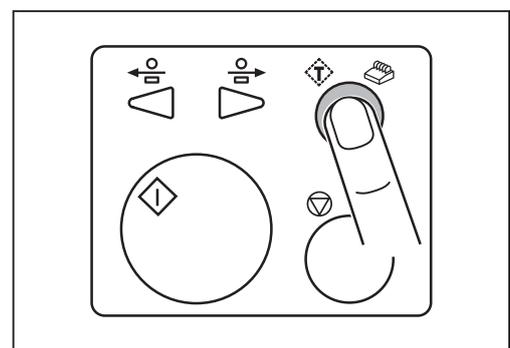
Clockwise: Turning the knob slightly shifts the lead edge of the document toward the operator's side.



Counterclockwise: Turning the knob slightly shifts the lead edge of the document toward the non-operators side.



- 2 Press the TEST key to perform a test run for one sheet and check the finished products.



- 3 If the skew remains, repeat steps 1 and 2 again.

Curled Document / Light Weight Document

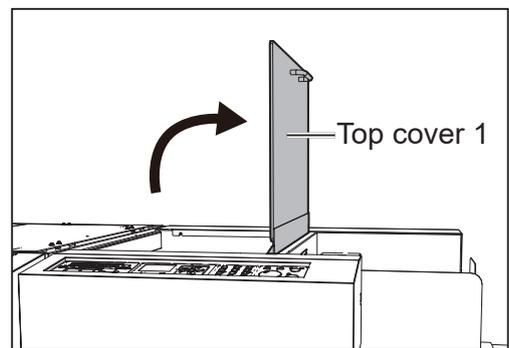
If a document rolls up or is not successfully fed because it is light weight or curled, use the **upper guide**.

IMPORTANT

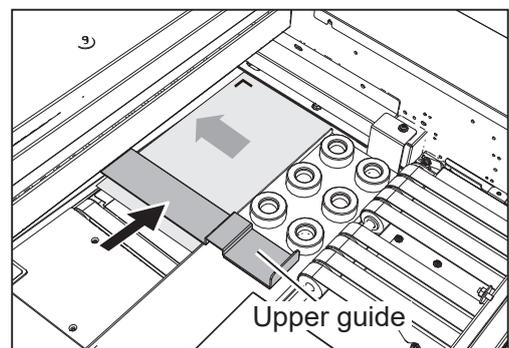
When you use light weight documents, make the following settings to stabilize the document feed when entering a JOB. (→P.60 Function Setting 1)

- Set **Side blow fan** (Option: ASIA, TAIWAN) to **MIN** or **OFF**.
- Set **Fan reg** to **MIN** or **OFF**.
- Set **Slitter guide** to **ON**. (→P.60 Function Setting 1)

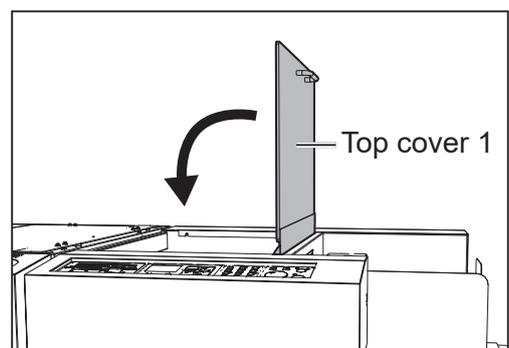
- 1 Open the **top cover 1**.



- 2 Adjust the **upper guide** position as shown in the figure on the right.

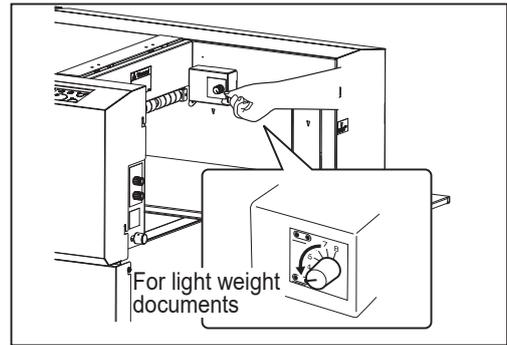


- 3 Close the **top cover 1**.

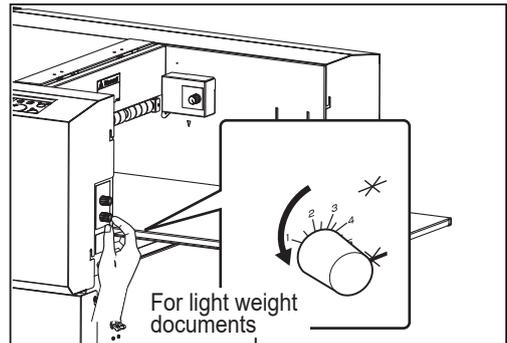


Curled Document/ Light Weight Document

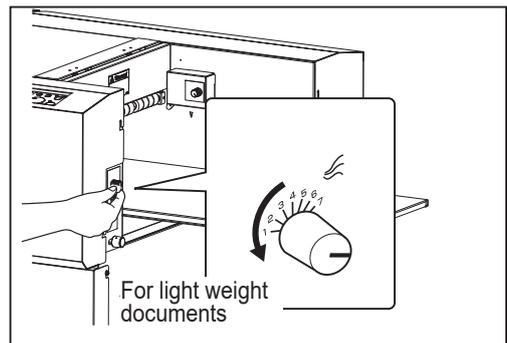
- 4 Turn the **level adjustment knob** in a clockwise direction to lower the elevator level.



- 5 Turn the **separator adjustment knob** in a counterclockwise direction to raise the separator position.



- 6 Turn the **airflow adjustment knob** in a counterclockwise direction to decrease the amount of airflow.



Chapter 4

Programming a JOB for DC-646 Via Computer (PC Controller)

This chapter describes how to install the PC Controller in your computer and set up a JOB via the computer.

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What is PC Controller?

PC Controller is a software used to program a JOB for the DC-646 on your computer. Installation of this software enables the user to program and edit JOBS for the DC-646, with preview image of the document, as well as save JOB data and execute a JOB from the computer.

Before Installation

The following computer specifications are necessary to run the PC Controller.

- CPU: 1 GHz or faster
- Display resolution: 1200x768 pixel or more
- RAM: 1 GB or more
- Free hard-disk space: 500 MB or more
- Operating system: Windows 8.1 (32bit/64bit)
Windows 10 (32bit/64bit)
- Interface: USB 2.0 Full speed
- CD-ROM drive: (Used for installing the PC Controller)
- USB cable: Type AB, 3 m or shorter

IMPORTANT

- WindowsInstaller is not installed in some operating systems and an error may occur when the PC Controller is installed.
In this case, it is required to install the latest WindowsInstaller by downloading via network, or install it by using the install program of WindowsInstaller in the PC Controller install disk.
- How to install WindowsInstaller by using the PC Controller install disk.
 1. Open **Setup\WindowsInstaller3 1** folder.
 2. Double-click **WindowsInstaller-KB893803-v2-x86.exe**.
 3. Follow the instructions of the installer for installation.

REFERENCE

Do not connect the computer and the DC-646 before the driver of the PC Controller is installed.

PC Controller Installation Procedure

IMPORTANT

- Windows 10 and Windows 8.1 allow multiple users on one computer at the same time. Please make sure that only one user is logged in when the PC Controller is installed.
- If you are requested to enter a password of administrator account during installation of the PC Controller, enter the password of the user with administrative rights shown.
- The following instructions use the screenshots appeared on Windows 10. If you are using Windows 8.1, the screenshots vary.
- If you upgrade the PC Controller, the data (*.M646, *.Am646, *.Jm646) that has been saved or modified is deleted from the installation folder (ex.: C:\Duplo Seiko Corp\DC-646 PC Controller V1.XX) of the previous version. Back up the data before upgrading the PC Controller if necessary.

After installing the new version of the PC Controller, the installation folder (ex.: C:\Duplo Seiko Corp\DC-646 PC Controller V1.XX) of the previous version remains. It is recommended that you delete the folder manually. (The upgraded PC Controller works correctly even if the folder is not deleted.)

- A **SmartScreen warning** message may appear while installation is in progress. Click **More info**, and then click **Run anyway** to proceed with the installation. This software has been thoroughly tested and can be used without any problems.



- 1 Make sure that the DC-646 is turned **OFF**. Turn the computer **ON** to start the Windows.
- 2 Insert the CD-ROM that came with the DC-646 into your computer's CD-ROM drive.
- 3 A message appears in the lower right corner of the screen. Click the message.

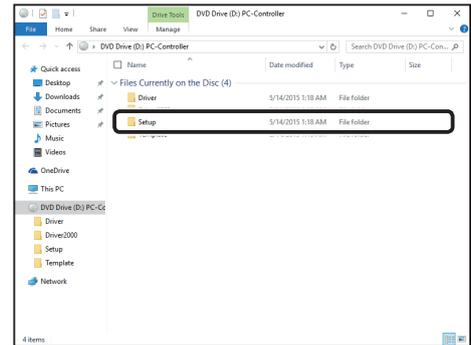


- 4 The **Auto Play** screen appears. Click **Open folder to view files**.

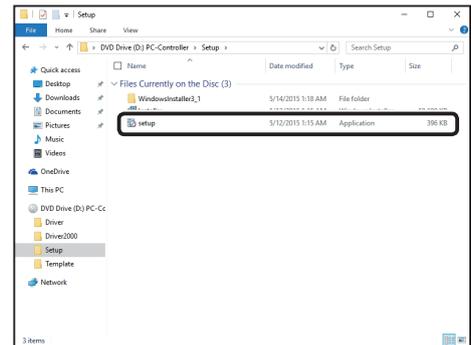


PC Controller Installation Procedure

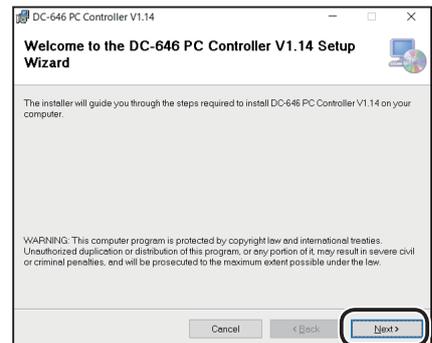
- 5 Double-click the **Setup** folder.



- 6 Double-click the **Setup** icon.



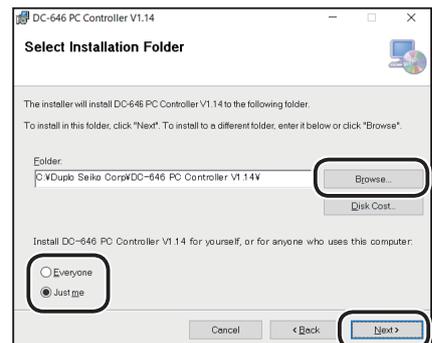
- 7 Click **Next**.



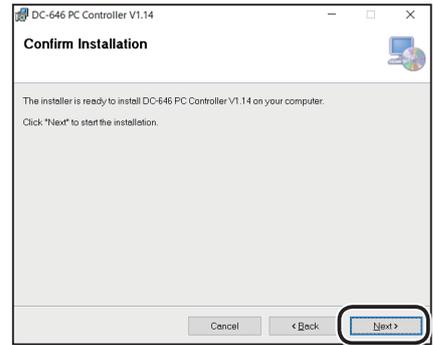
- 8 Specify a folder for installing the PC Controller.
Everyone: Multiple users on the same computer
Just me: Only one user on the computer
Select either one, and click **Next**.

REFERENCE

To install the PC Controller in a certain place, click **Browse**, then specify a folder to install the PC Controller in.



9 Click **Next**.



REFERENCE

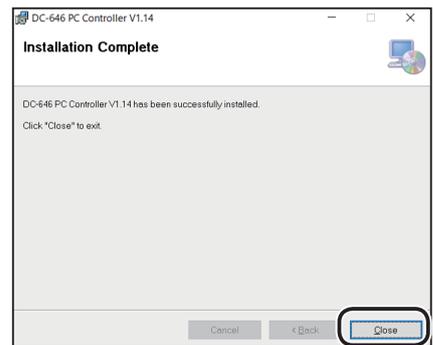
User Account Control dialog may appear while installation is in progress. Click **Yes** to proceed with the installation.



10 Click **Close**.

IMPORTANT

Proceed to the driver installation.

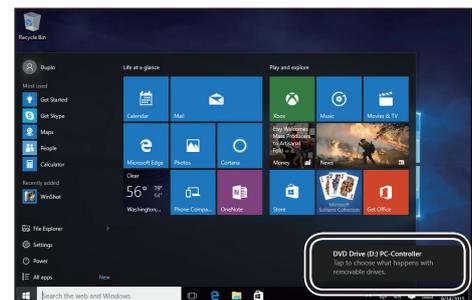


Driver Installation Procedure

IMPORTANT

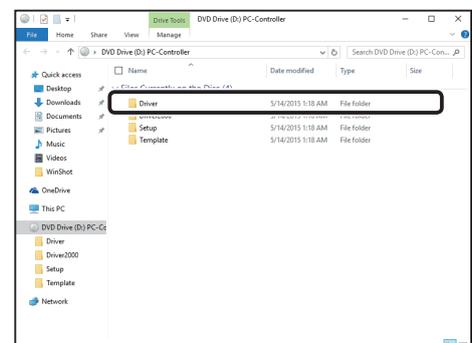
- Windows 10 and Windows 8.1 allow multiple users on one computer at the same time. Please make sure that only one user is logged in when the PC Controller is installed.
- If you are requested to enter a password of the administrator account during installation of the PC Controller, enter the password of the user with administrative rights shown.
- The following instructions use the screenshots appeared on Windows 10. If you are using Windows 8.1, the screenshots vary.
- There are two types (32-bit, 64-bit) of the DC-646 driver for Windows 10 and Windows 8.1.

- 1 Make sure that the DC-646 is turned **OFF**.
Turn the computer **ON** to start the Windows.
- 2 Insert the CD-ROM that came with the DC-646 into your computer's CD-ROM drive.
- 3 A message appears in the lower right corner of the screen. Click the message.



- 4 **Auto Play** screen appears.
Click **Open folder to view files**.

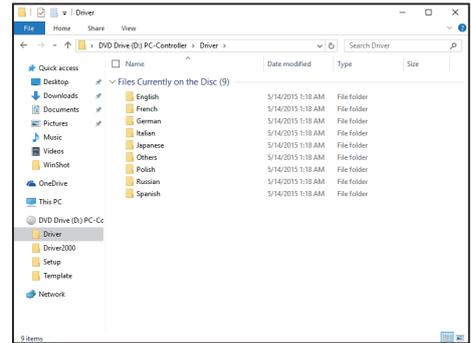
- 5 Double-click the **Driver** folder.



6 Double-click the folder of the language to be used.

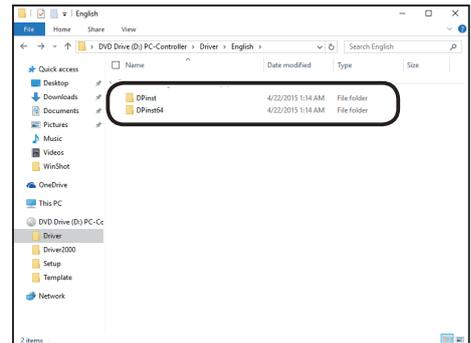
REFERENCE

Select the language folder of OS used. Select the **Others** folder when there is no corresponding language folder.



7 If you are using a 32-bit computer, double-click the **DPinst** folder. If you are using a 64-bit computer, double-click the **DPinst64** folder.

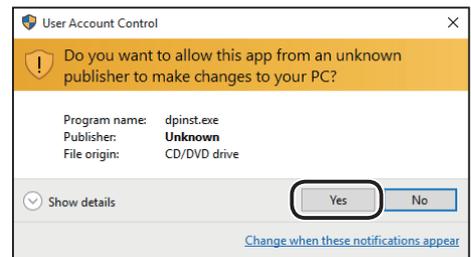
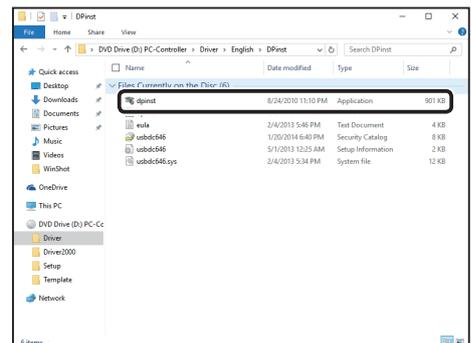
If you are using a 64-bit computer, double-click the **DPinst64** folder.



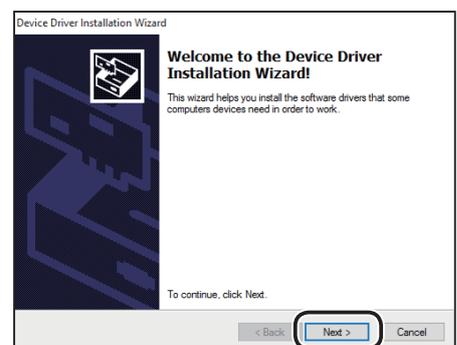
8 Double-click **dpinst.exe** in the folder.

REFERENCE

User Account Control dialog may appear while installation is in progress. Simply click **Yes** to proceed with the installation.



9 Click **Next**.



Driver Installation Procedure

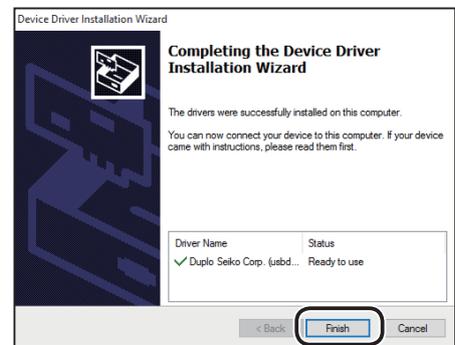
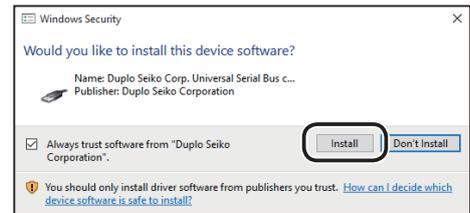
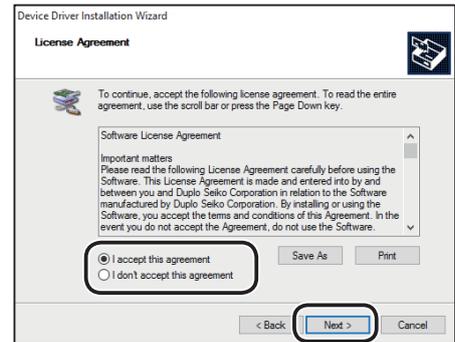
- 10 Read the **Software License Agreement**. Select **I accept this agreement**, and then click **Next**.

REFERENCE

If **Windows Security** screen appears while installation is in progress, simply click **Install** to proceed with the installation.

This software has been thoroughly tested and can be used without any problems.

- 11 Click **Finish** to close the installation file.



- 12 Connect the DC-646 and your computer with a USB cable and then turn **ON** the DC-646.

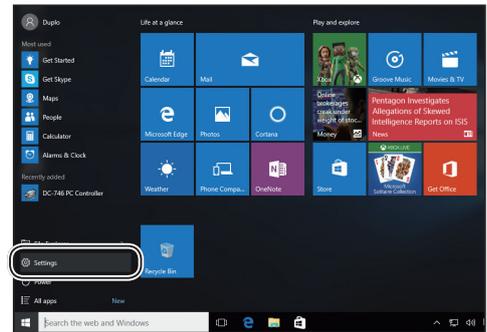
IMPORTANT

USB cable (type AB): The cable length must be 3 m or shorter.

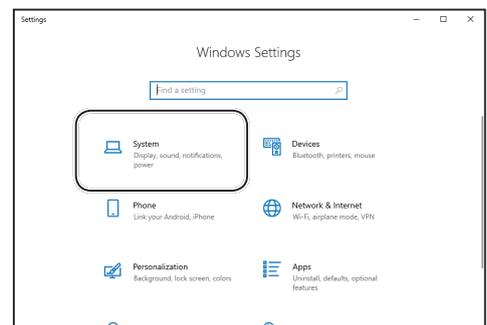
• Checking whether the driver is successfully installed

- Windows 10

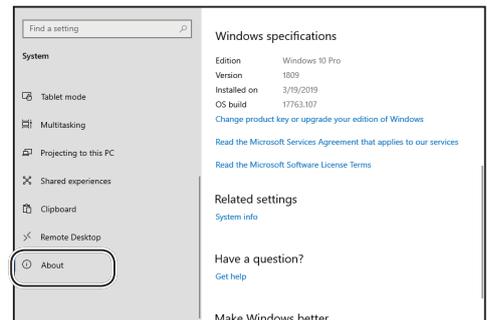
1 From the start menu, click **Settings**.



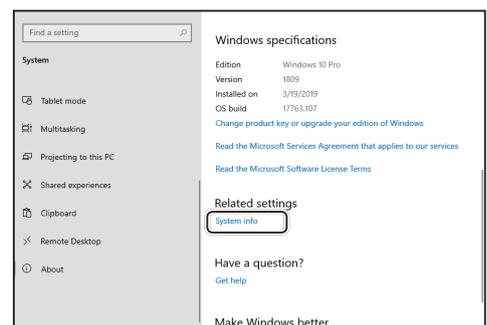
2 Click **System**.



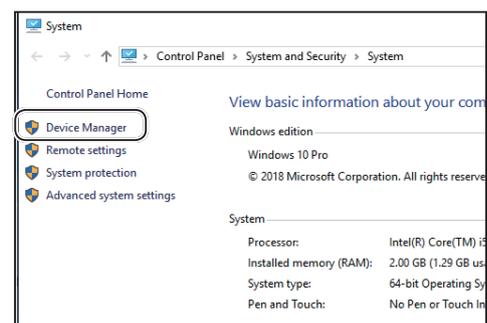
3 Click **About**.



4 Click **System info** under **Related settings**.

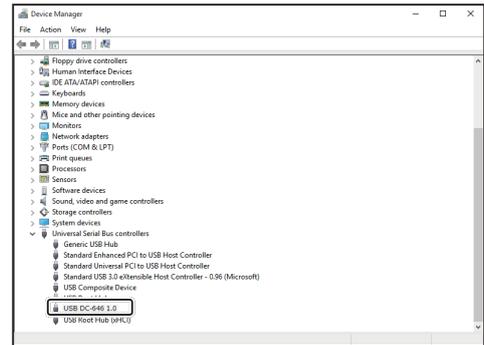


5 Click **Device Manager**.



Driver Installation Procedure

- 6** Installation is successful if the **Device Manager** dialog indicates that **USB DC-646 *.*** is saved in **Universal Serial Bus controllers**.

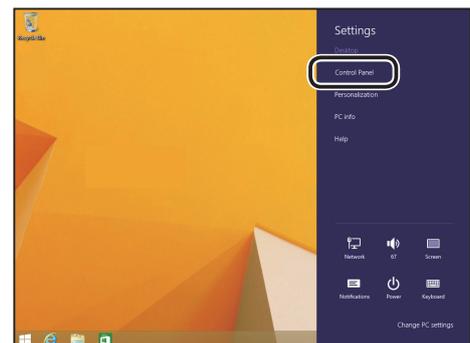


- Windows 8.1

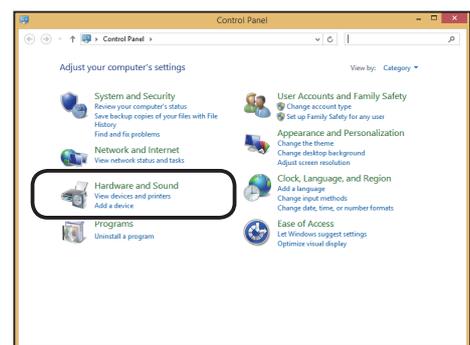
- 1** Click **Settings** charm.



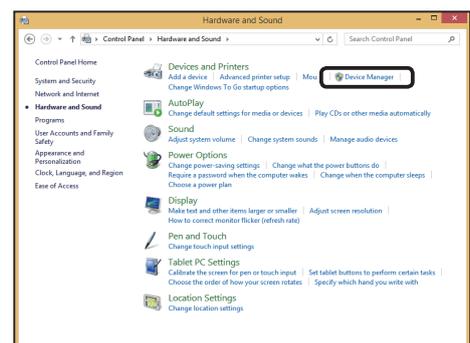
- 2** Click **Control panel**.



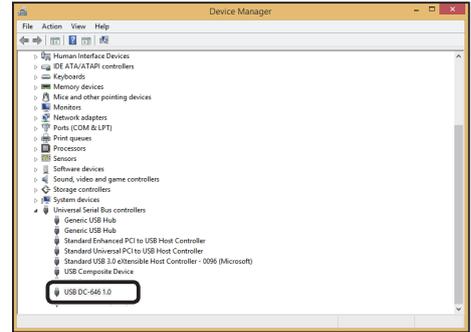
- 3** Click **Hardware and Sound**.



- 4** Click **Device Manager**.



- 5 Installation is successful if the **Device Manager** dialog indicates that the **USB DC-646 *.*** is saved in the **Universal Serial Bus controllers**.



PC Controller Uninstallation Procedure

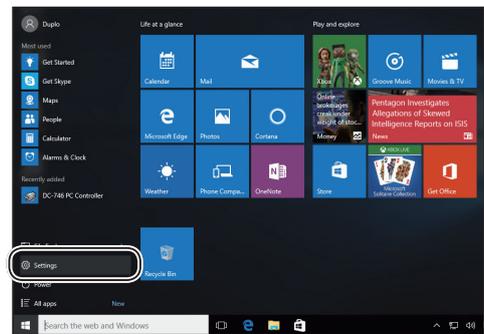
IMPORTANT

- Windows 10 and Windows 8.1 allow multiple users on one computer at the same time. Please make sure that only one user is logged in when the PC Controller is uninstalled.
- For Windows 10 and Windows 8.1, if **User Account Control** dialog appears during uninstallation of the PC Controller, click **Yes**. If you are requested to enter a password of the administrator account, enter the password of the user with administrative rights shown.

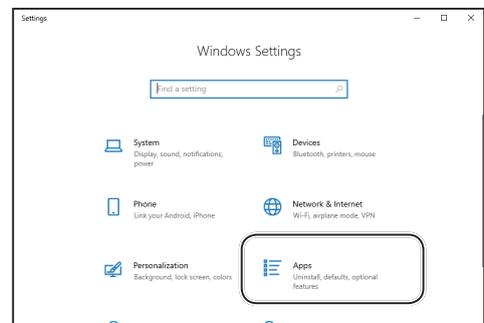
1 Make sure that the DC-646 is turned **OFF**.
Turn the computer **ON** to start the Windows.

- Windows 10

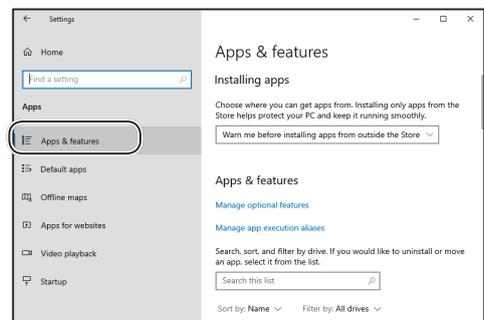
2 From the start menu, click **Settings**.



3 Click **Apps**.

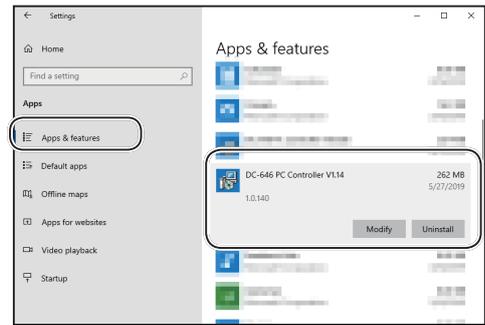


4 Click **Apps & features**.

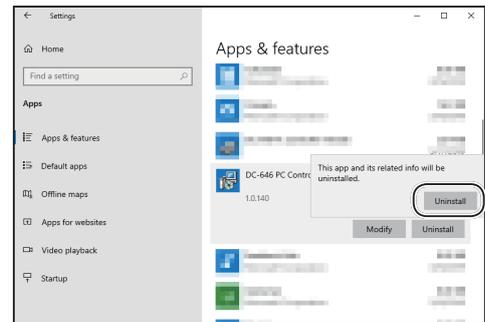


PC Controller Uninstallation Procedure

- 5 From the list of **Apps & features**, select **DC-646 PC Controller V*.**** and click **Uninstall**.

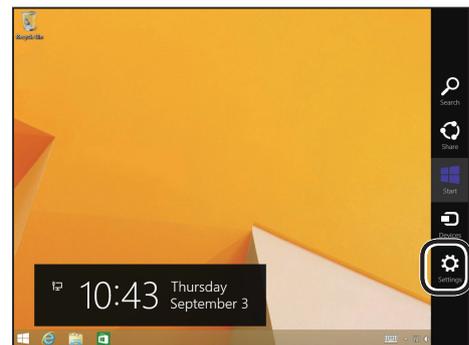


- 6 Click **Uninstall**.

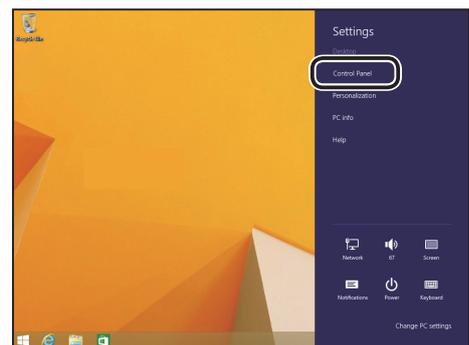


- Windows 8.1

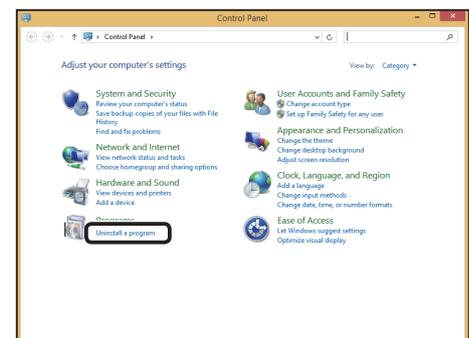
- 2 1. Click **Settings** charm.



2. Click **Control panel**.



- 3 Click **Uninstall a program** under **Programs**.

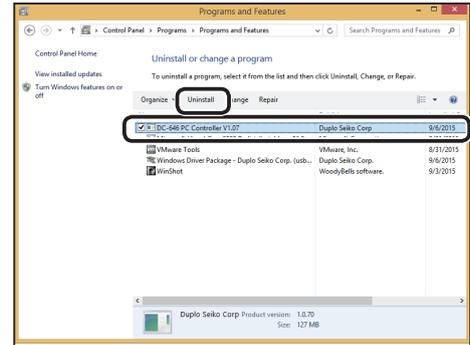


4

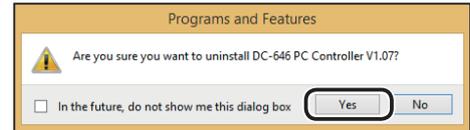
Programming a JOB for DC-646 Via Computer (PC Controller)

PC Controller Uninstallation Procedure

- 4 From the **Uninstall or change a program** list, select **DC-646 PC Controller V*.**** and click **Uninstall**.



- 5 Click **Yes**.



Driver Uninstallation Procedure

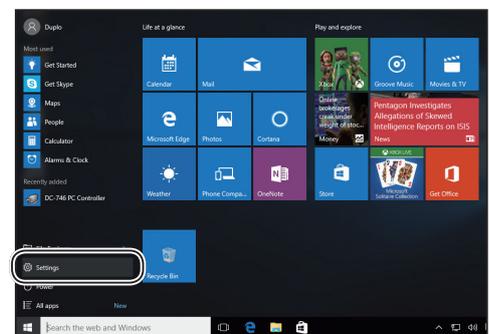
IMPORTANT

- Windows 10 and Windows 8.1 allow multiple users on one computer at the same time. Please make sure that only one user is logged in when the PC Controller is uninstalled.
- If **User Account Control** dialog appears during uninstallation of the PC Controller, click **Yes**. If you are requested to enter a password of the administrator account, enter the password of the user with administrative rights shown.

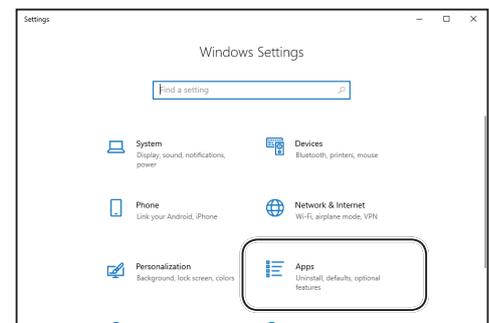
1 Make sure that the DC-646 is turned **OFF**.
Turn the computer **ON** to start the Windows.

- Windows 10

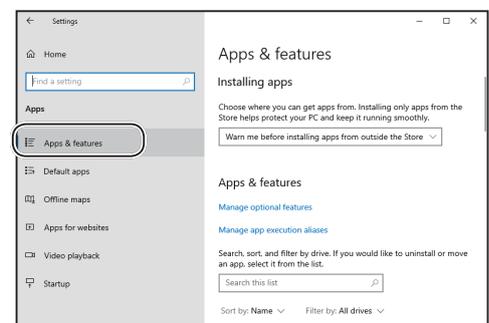
2 From the start menu, click **Settings**.



3 Click **Apps**.



4 Click **Apps & features**.

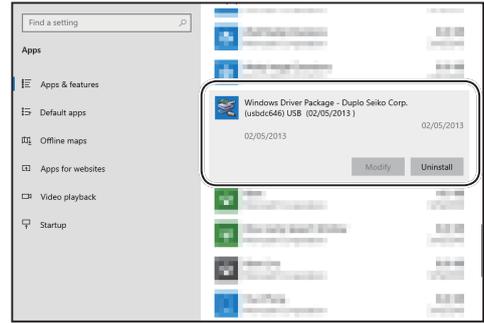


4

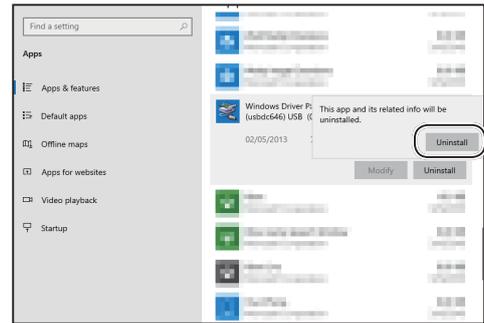
Programming a JOB for DC-646 Via Computer (PC Controller)

Driver Uninstallation Procedure

- From the list of **Apps & features**, select **Windows Driver Package - Duplo Seiko Corp. (usbdc646) USB** and click **Uninstall**.

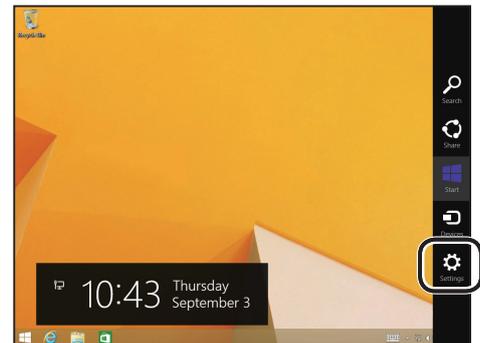


- Click **Uninstall**.

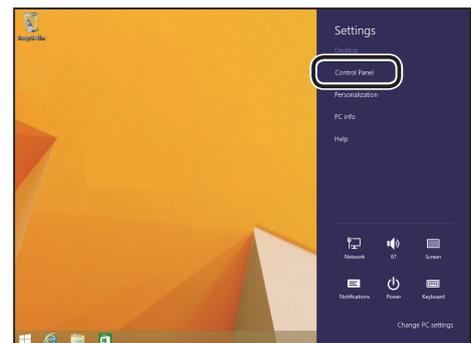


- Windows 8.1

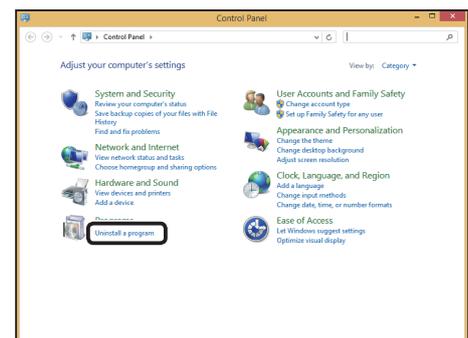
1. Click **Settings** charm.



2. Click **Control panel**.

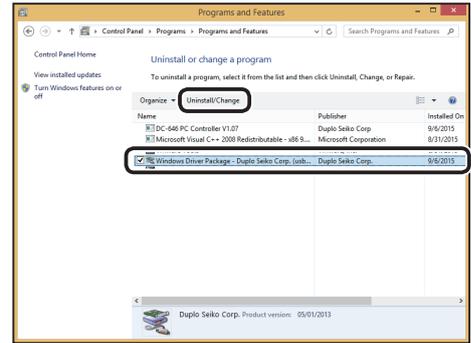


3. Click **Uninstall a program** under **Programs**.

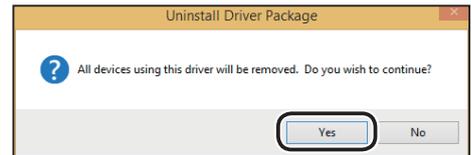


Driver Uninstallation Procedure

- 4 From the **Uninstall or change a program** list, select **Windows Driver Package - Duplo Seiko Corp.** and click **Uninstall/Change**.



- 5 Click **Yes**.



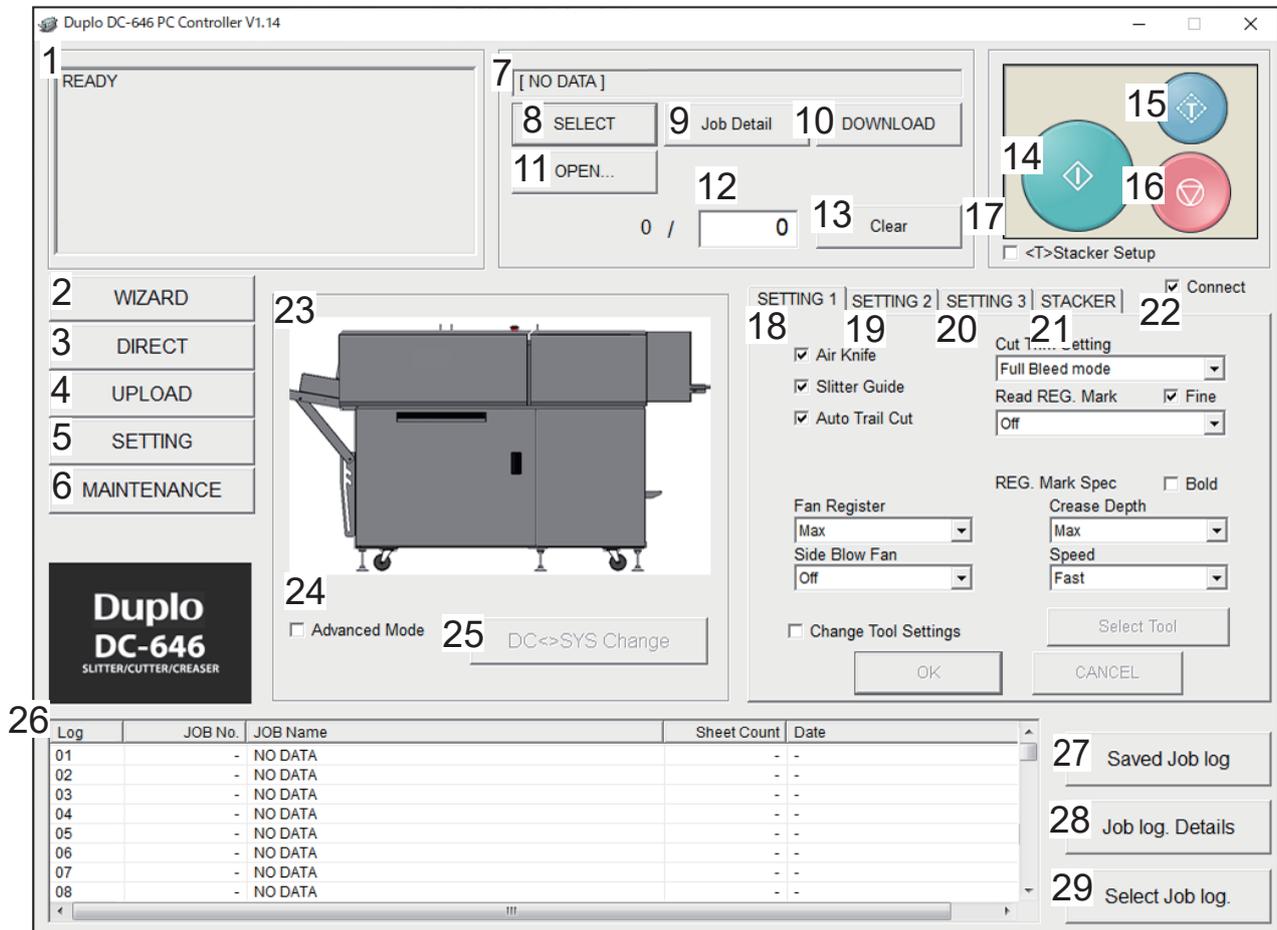
Driver Update

- 1** Uninstall the previously installed driver according to the driver uninstallation procedure.
(→P.91 Driver Uninstallation Procedure)
- 2** Install a new driver according to the driver installation procedure.
(→P.82 Driver Installation Procedure)

PC Controller Setting

Main Menu

The main menu appears when the PC Controller is launched.
Select a sub menu from the main menu screen to make settings.



4

Programming a JOB for DC-646 Via Computer (PC Controller)

Number	Item	Function
1	System status 1	Displays the current machine status by letters.
2	WIZARD	Programs a JOB in Wizard format. Displays a preview of a JOB being programmed. You can program a JOB while checking details of a JOB setting.
3	DIRECT	Directly enter values to program a JOB. It is recommended to program a JOB in this mode rather than in the WIZARD mode when the dimensions are already finalized.
4	UPLOAD	Reads a JOB from the DC-646 and saves it on a computer.
5	SETTING	Sets the default values for the PC Controller.
6	MAINTENANCE	For service person use only for setting the machine and so on. A password is required to access this.
7	JOB Name	Displays a name of a JOB currently selected.
8	SELECT	Reads saved JOBS in the DC-646 and selects one from them.
9	Job Detail	Displays details of an entered JOB.
10	DOWNLOAD	Downloads a JOB saved on a computer to the DC-646.

PC Controller Setting

Number	Item	Function
11	OPEN	Opens a JOB saved on a computer.
12	Preset Count	Presets the number of sheets to be processed for a JOB.
13	Clear	Clears the number of preset count.
14	START key	Click this to process a JOB. Lights up in green in the standby mode. Inactive while the machine is running or having an error.
15	TEST key	Click this to process only one sheet.
16	STOP key	Click this to stop a running process.
17	Stacker Setup	Select the Stacker Setup check box and click the TEST key to process only one sheet of documents and stop it at a document ejecting position. Then click the STOP key or the TEST key to eject it to the exit tray. At that time, if you click the START key, the DC-646 ejects it to the exit tray and then continues the JOB.
18	SETTING 1	Sets Air Knife, Slitter Guide, Auto Trail Cut, Cut Trim Setting, REG mark reading accuracy, Read REG. Mark, REG. Mark Spec, Fan Register, Side Blow Fan, Crease Depth, Speed, and Change Tool Settings.
19	SETTING 2	Sets Read Barcode, Reject, Double Feed Detection, Feeder Capacity, Waste Full Detect Level, CPM on pos Adj. (option), CPM off pos Adj. (option), RTM on pos Adj. (option), RTM off pos Adj. (option), and IFS off (disconnect).
20	SETTING 3	Sets Apply Shrinkage, Adjust All, and Adjust Fold Position.
21	STACKER	Sets Batch Separation, Stack priority, and End mark. (Displayed only when IFS off is activated).
22	Connect	Select the Connect check box to control function limit of the control panel in the DC-646.
23	System status 2	Displays the current machine status by figure (icons and color).
24	Advanced Mode	Select the Advanced Mode check box to put the machine in the advanced mode . Clear the check box to put the machine in the simple mode .
25	DC<>SYS Change	Changes views of the system. (Active except DC ONLY)
26	JOB Log	Displays JOBS processed with the PC Controller when the START key or the TEST key is clicked and saved on a computer as logs. You can save up to 50 JOBS lately processed. If the number of saved JOBS exceeds 50, they are deleted in chronological order.
27	Saved Job log	Displays a JOB log programmed and saved with the PC Controller.
28	Job log. Details	Displays details of a JOB in the JOB log.
29	Select Job log.	Click this to download a JOB being selected from the JOB log.

REFERENCE

Note when opening the JOBS

If you click **SETTING** and select the **Enable re-editing Wizard JOB data** check box on the **DEFAULT** tab, if you retrieve the JOB that was programmed in the **WIZARD mode**, the JOB data is displayed on the **WIZARD** screen.

If you have programmed a JOB in the **DIRECT mode**, the JOB data is displayed on the **DIRECT** screen.

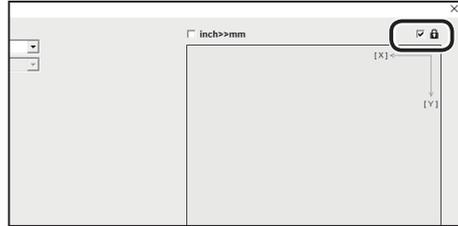
If you re-enter values for processing positions on the **DIRECT** screen for a JOB programmed in the **WIZARD mode**, the JOB data is not displayed on the **WIZARD** screen.

Locking a JOB

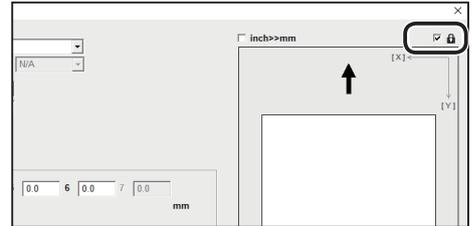
This section describes the procedure to lock a JOB in order to prevent the JOB from being overwritten.

- 1 Select the check box in the upper right part of the screen (**WIZARD** or **DIRECT**).

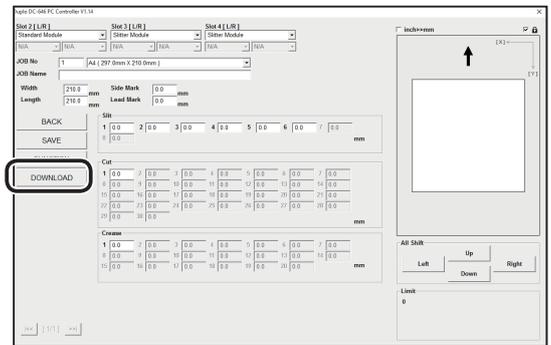
• WIZARD



• DIRECT



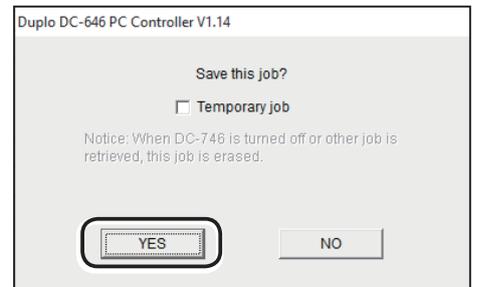
- 2 Click **DOWNLOAD**.



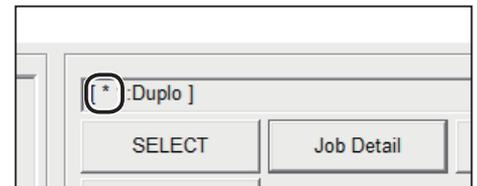
- 3 Click **YES**.
Clicking **NO** returns to the previous screen without downloading the JOB.

REFERENCE

- To save the JOB temporarily, select the **Temporary job** check box.
- When the DC-646 is turned **OFF** or another JOB is retrieved, the temporarily saved JOB is deleted.



- 4 * is displayed in front of the name of a locked JOB.

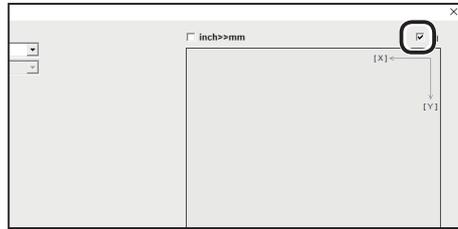


Unlocking a JOB

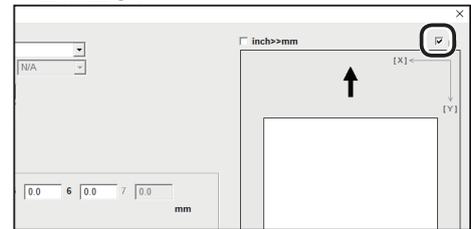
This section describes the procedure to unlock a locked JOB.

- 1 Clear the check box in the upper right part of the screen (**WIZARD** or **DIRECT**).

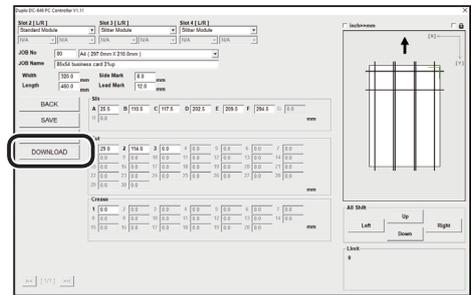
• WIZARD



• DIRECT



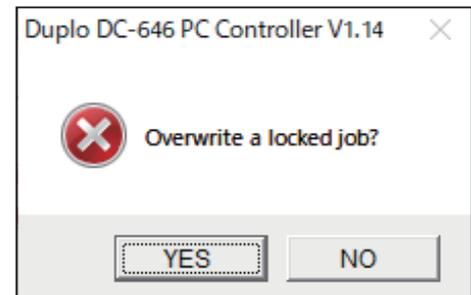
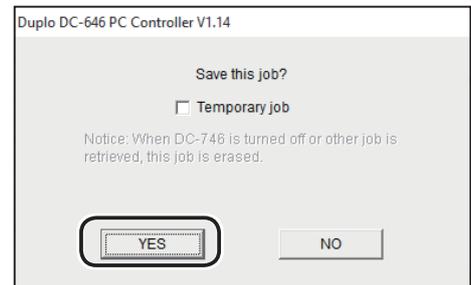
- 2 Click **DOWNLOAD**.



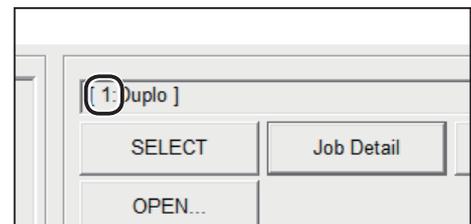
- 3 Click **YES**.
Clicking **NO** returns to the previous screen without downloading the JOB.

REFERENCE

- To save the JOB temporarily, select the **Temporary job** check box.
- When the DC-646 is turned **OFF** or another JOB is retrieved, the temporarily saved JOB is deleted.
- If you overwrite the locked JOB, the message as shown on the right appears.
To overwrite the locked JOB, click **Yes**.
Clicking **No** returns to the previous screen without saving it.



- 4 * is not displayed for an unlocked JOB.
(→P.97 Locking a JOB)



WIZARD

The DC-646 can save up to 250 patterns of JOBS.

This section describes the procedure for programming a JOB in the **Wizard mode** with preview display. Following items should be entered to program a JOB.

Slot 2, 3, 4

Select an optional module for the JOB when necessary.

JOB No.

Select a JOB number to be programmed. (1–250)

JOB Name

Enter a name to the JOB to be programmed.

Paper Size

Enter the size of a document.

Finished Size

Specify the size of finished cards/processed documents.

Cards per document

Specify how many cards are to be aligned in a crosswise and in a lengthwise direction.

Trim

Specify the position of the first cut and right margin slit.

Gutter Slits (Distance between finished documents (left/right))

When aligning two or three cards in a crosswise direction, it is possible to have a gutter slit between each card.

Gutter Cuts (Distance between finished documents (top/bottom))

When aligning two or more cards in a lengthwise direction, it is possible to have a gutter cut between each card.

Crease

Specify the position of the crease on the cards.

Up to 20 creases can be set on a document.

Inch>> mm

The values entered in inches are converted to ones in millimeters automatically.

Air Knife

Air is blown out to loosen documents, preventing a double feed.

Fan Register

Document skewing in the **feeding area** is corrected.

PC Controller Setting

Reg. Mark

Reading the REG mark and correcting the print position gap improve accuracy of document processing.

REG. Mark Spec

This sets a reading function for a bold REG mark printed on a specially treated document.
(→ P.23 IMPORTANT)

Slitter Guide

When the **slitter module** is not used, it acts as a document guide to stabilize the document conveyance.

Recommended for light weight documents.

Cut Trim Setting

The lead margin, the trail margin, and any gutters shorter than 49 mm are chopped up and dropped into the waste box.

Crease Depth

This sets the depth of a crease when a document is creased.

Speed

This sets the processing speed.

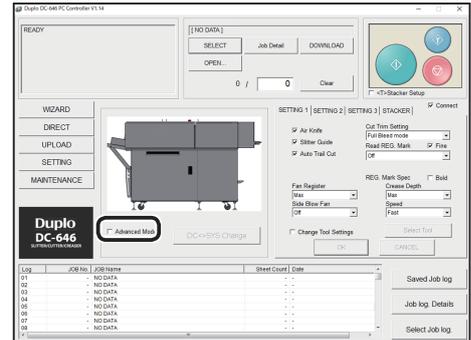
Auto Trail Cut

This sets the trail margin cut of a document.

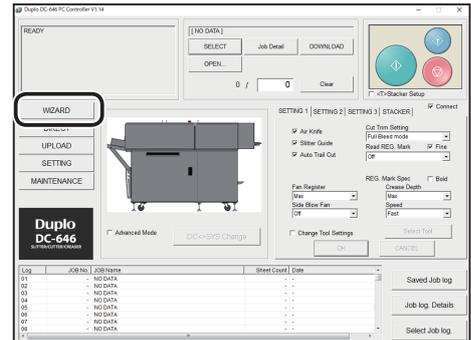
Side Blow Fan (Option: ASIA, TAIWAN)

Air is blown out to loosen documents, preventing a double feed.

- Select a JOB programming mode.
When the **Advanced Mode** check box is selected, the **advanced mode** is selected.
When it is cleared, the **simple mode** is selected.



- Click **WIZARD**.

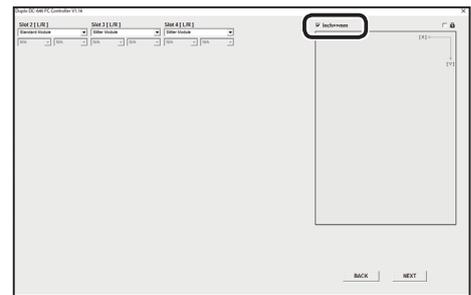


- Inch>> mm**
If you select the **Inch>> mm** check box, the values entered in inches are converted to ones in millimeters and displayed.

REFERENCE

The values entered before selecting the check box are not converted.
Make sure to select the check box before entering values. You can enter values to three places of decimals in inches.

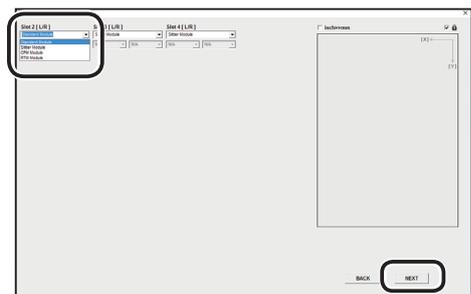
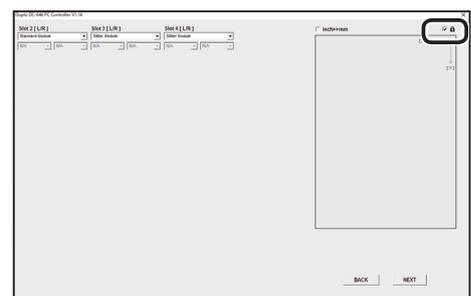
- If you select the check box in the upper right part of the screen (**WIZARD** or **DIRECT**), you can lock the JOB.
(→P.97 Locking a JOB)



- Select a module from the **Slot 2 [L/R]** box and click **NEXT**.
Standard Module
Slitter Module
CPM (Cross Tool Module)(option)
RTM (Rotary Tool Module)(option)

REFERENCE

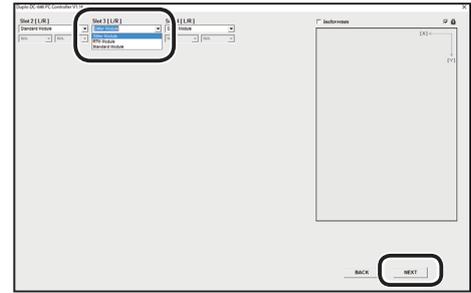
Refer to the instruction manual of each optional module for programming a JOB with an optional module.



PC Controller Setting

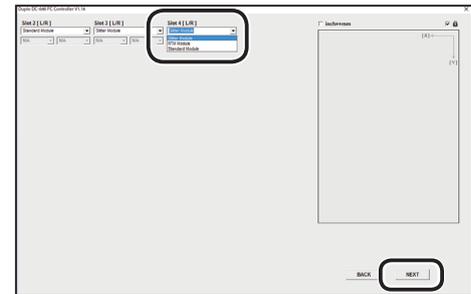
- 6** Select a module from the **Slot 3 [L/R]** box and click **NEXT**.

Slitter Module
RTM (Rotary Tool Module)(option)
Standard Module



- 7** Select a module from the **Slot 4 [L/R]** box and click **NEXT**.

Slitter Module
RTM (Rotary Tool Module)(option)
Standard Module

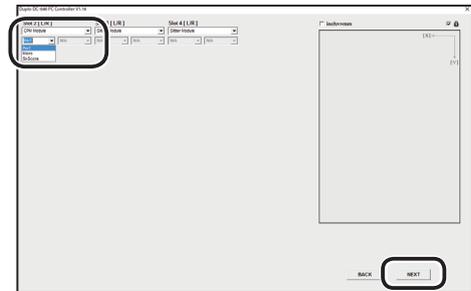


- 8** If you have selected **CPM (Cross Tool Module)** or **RTM (Rotary Tool Module)** in the **Slot 2 [L/R]** box in step 5, select a tool for the selected module from the **Tool** box. Then click **NEXT**.

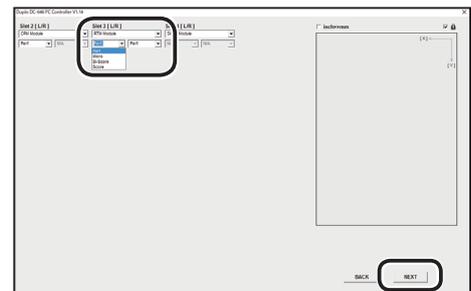
CPM (Cross Tool Module): Select a tool.
Perf., Micro, SI-Score

RTM (Rotary Tool Module): Select a tool for the left tool and the right tool.

Perf., Micro, SI-Score, Score



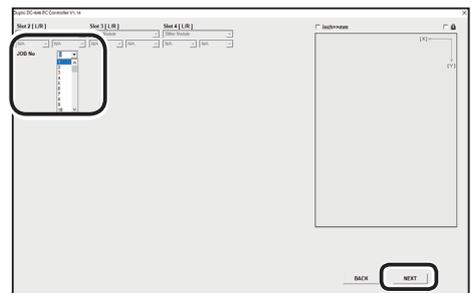
- 9** If you have selected **RTM (rotary tool module (option))** in the **Slot 3 [L/R]** box or **Slot 4 [L/R]** box in steps 6 and 7, select a tool for each slot in a similar way to step 8.



- 10** Select a **JOB** number from the **JOB No** box and click **NEXT**.

REFERENCE

You can set from 1 to 250.



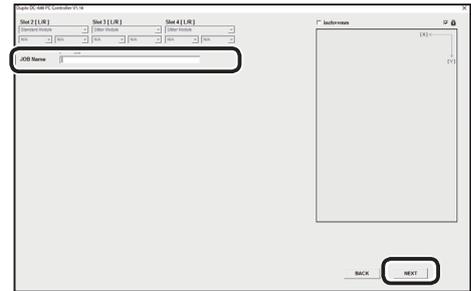
- 11** Enter a JOB name in the **JOB Name** box and click **NEXT**.

You can enter up to 30 characters.

REFERENCE

Usable characters;

- Alphabetical letters (A to Z, a to z)
- Numeric characters
- Symbols



- 12** **Paper Size**

- Custom Size

Select **Custom Size** when using documents of other size than the standard size.

Enter a value of document width and length and click **NEXT**.

REFERENCE

You can set **Custom Size** in the following range.

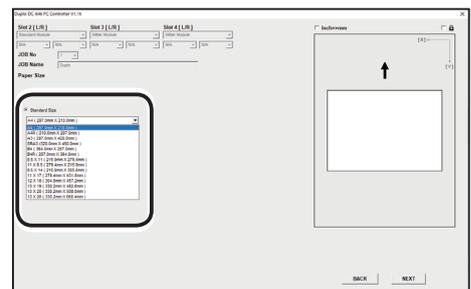
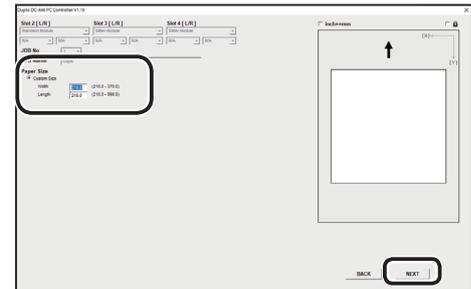
Width: 210 to 370 mm

Length: 210 to 999.9 mm

- Standard Size

Click **Standard Size** and select from the **Paper Size** box.

Then click **NEXT**.



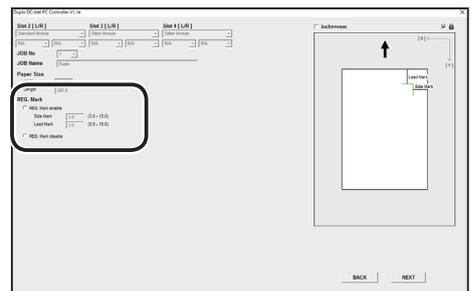
- 13** **REG. Mark**

Click **REG. Mark enable** to use the REG mark reading function.

Enter the distance from the right edge of the document to the side mark in the **Side Mark** box, then click **NEXT**.

Enter the distance from the lead edge of the document to the lead mark in the **Lead Mark** box, then click **NEXT**.

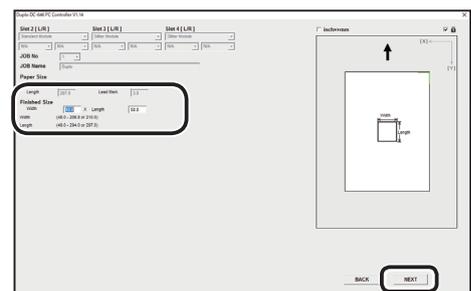
When not using this function, click **REG. Mark disable**, then click **NEXT**.



- 14** **Finished size**

Enter a value of the finished document width in the **Width** box and click **NEXT**.

Then enter a value of the finished document length in the **Length** box and click **NEXT**.



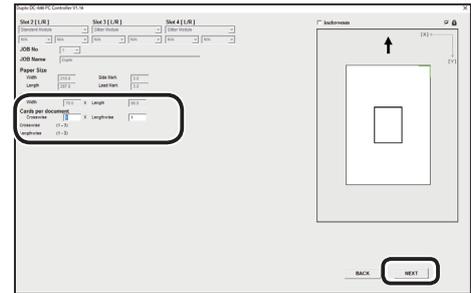
PC Controller Setting

15

Cards per document

Enter the number of cards (in the crosswise direction) in the **Crosswise** box and click **NEXT**.

Then enter the number of cards (in the lengthwise direction) in the **Lengthwise** box and click **NEXT**.



16

Layout

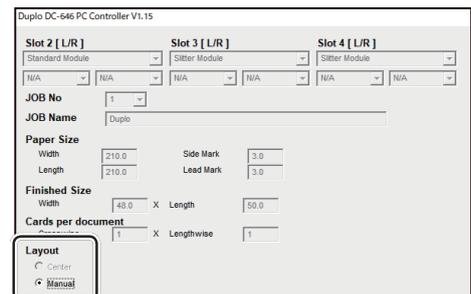
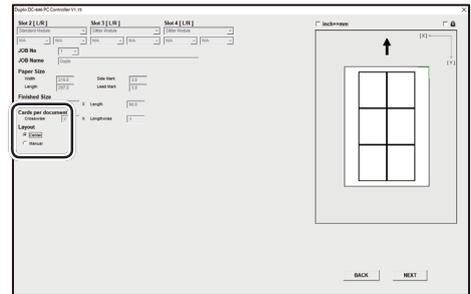
Set the layout of the finished product.

Center: Automatically sets margins so that the finished product is made in the center of the document. If you have selected this, you can enter only one value for **Gutter Slits** and for **Gutter Cuts**, which makes the same width of margins in the slit direction and in the cut direction. Proceed to step 18.

Manual: Enter values to set margins. If you have selected this, proceed to step 17.

REFERENCE

You cannot select **Center** if the JOB is being programmed without a margin that makes the finished product in the center of the document.



17

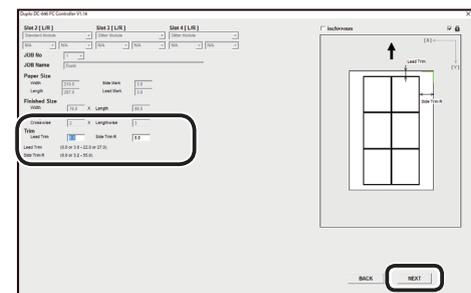
Trim

Set the margins of a document.

Enter a value of the lead margin in the **Lead Trim** box and click **NEXT**.

Then enter a value of the right margin in the **Side Trim R** box and click **NEXT**.

Enter **0** for no trim.



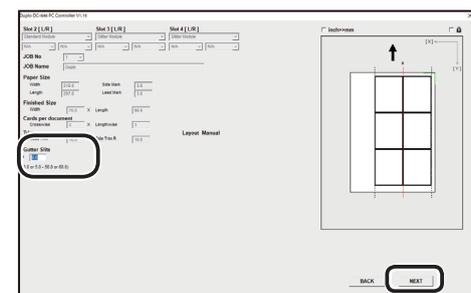
18

Gutter Slits

Set the gutter slit width (width between each card) (vertical cutting).

After entering one numerical value, click **NEXT**.

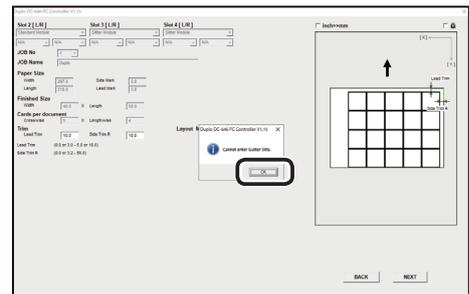
Then enter the next value. Set all the gutter slit widths. Enter **0** if there is no gutter slit between cards.



REFERENCE

e.g. If you have selected **Slitter Module** in the **Slot 3 [L/R]** box and **Slot 4 [L/R]** box, you can enter up to six slit positions.

If you entered **5** in the **Crosswise** box of **Cards per document** as shown in the figure on the right, the DC-646 cannot process gutter slit and **Cannot enter Gutter Slits dialog** appears. Click **OK**.



19

Gutter Cuts

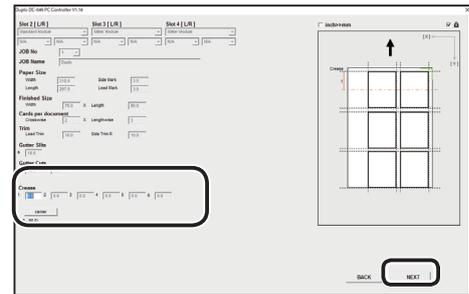
Set the gutter cut width (horizontal cutting).
After entering one numerical value, click **NEXT**.
Then enter the next value.
Set all the gutter cut widths.
Enter **0** if there is no gutter cut between cards.



20

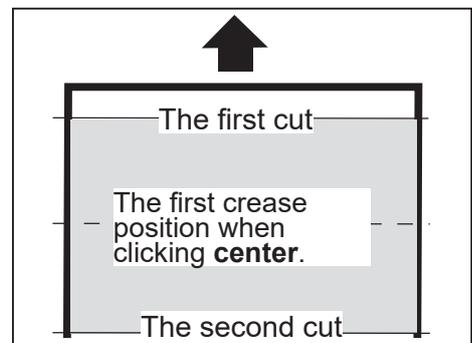
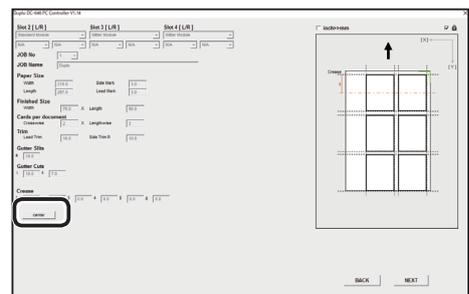
Crease

Set the crease positions.
After entering one numerical value, click **NEXT**.
Then enter the next value.
Set all the crease positions, then click **NEXT**.
Enter **0** if there is no crease.



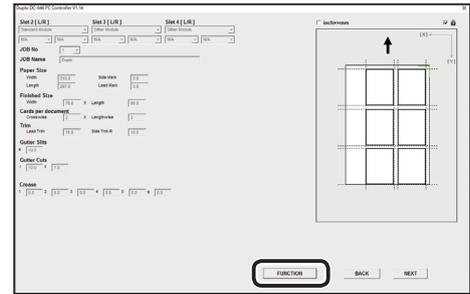
REFERENCE

- You can set up to 20 crease positions on a document.
- **center** appears while you are entering the crease positions.
Click **center**, the first crease can be set in the center of the distance between the first cut and the second cut.



PC Controller Setting

- 21 Click **FUNCTION**.



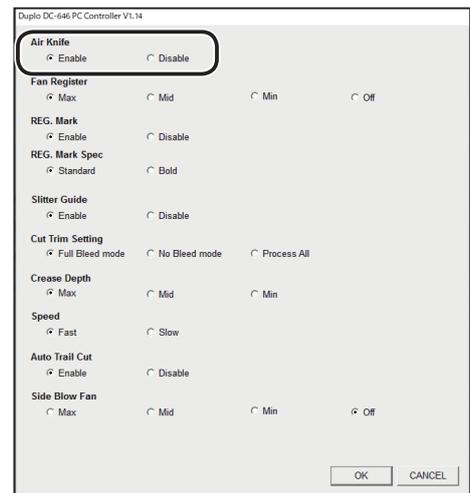
- 22 The function setting screen appears.

1. Air Knife

Compressed air is blown out to loosen the documents, preventing a double feed. Select **Enable** or **Disable**.

REFERENCE

Select **Disable** for light weight documents. Select **Enable** when processing documents with excessive static electricity or heavy weight documents.

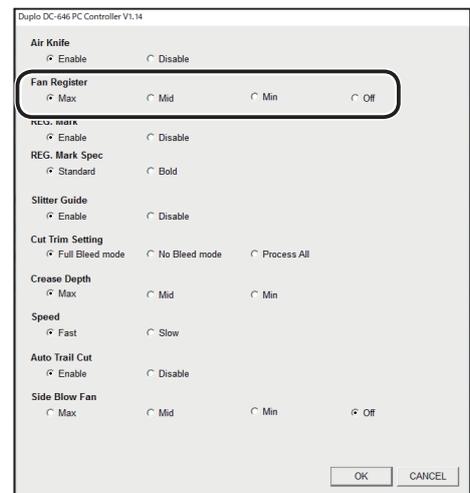


2. Fan Register

This suctions the document to the conveyance belt for skew correction. Select **Max**, **Mid**, **Min**, or **Off**.

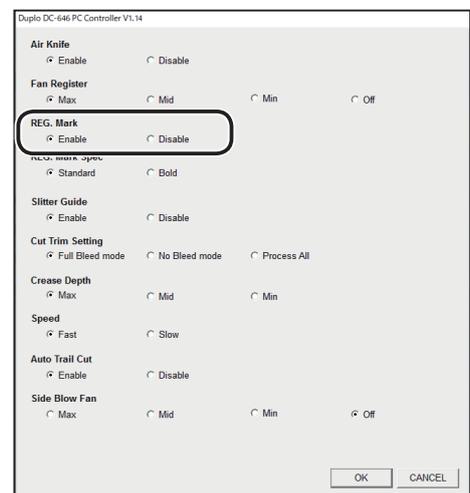
REFERENCE

Select **Min** or **Off** when processing light weight documents to prevent a document jam.



3. REG. Mark

If you are using the REG mark reading function, select **Enable**.



4. **REG. Mark Spec**

Select **Standard** or **Bold**.

When using specially treated documents, print a bold REG mark on them in advance and then select **Bold**.

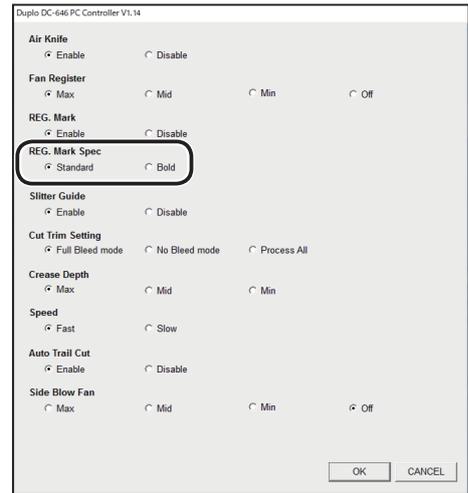
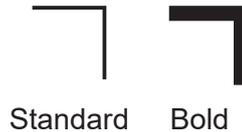
Normally select **Standard**.

If the REG mark cannot be read, select **Bold**.

REFERENCE

Guidelines for **REG. mark spec**

- **Standard**: 0.4 mm and more
- **Bold**: 2 mm and more

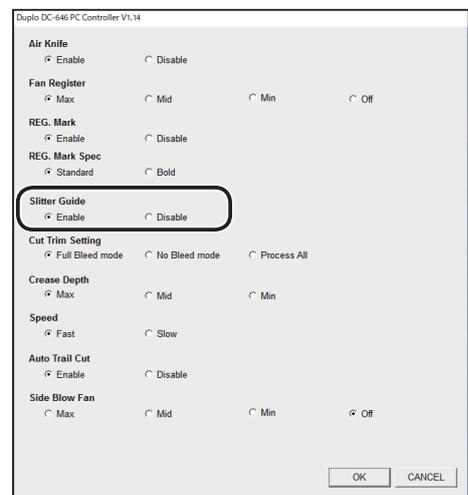


5. **Slitter Guide**

When using the module in the slot as a slitter guide, select **Enable**. When not using it as a slitter guide, select **Disable**.

REFERENCE

Enable is recommended for light weight documents. **RTM (rotary tool module (option))** and **Slitter Module** can be used as slitter guides.



6. **Cut Trim Setting**

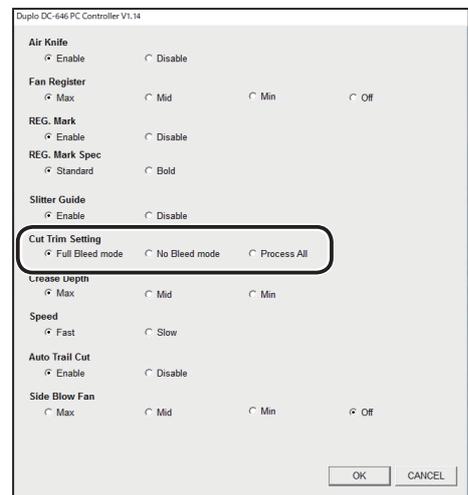
Full Bleed Mode: The lead margin and the trail margin are chopped up and dropped into the waste box.

No Bleed Mode: Gutters shorter than 49 mm are chopped up and dropped into the waste box.

Process All: All of cut pieces are ejected to the **exit tray**, except that gutters shorter than 28 mm and trail margin shorter than 49 mm are chopped up and dropped into the waste box.

REFERENCE

If there is no lead margin or trail margin on a document, select **No bleed mode**.



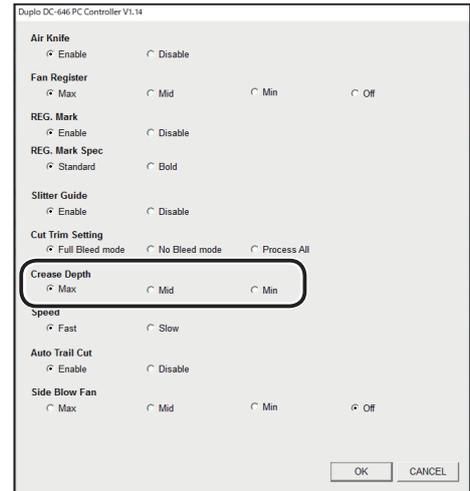
7. Crease Depth

Select **Max**, **Mid**, or **Min**.

Set this to **Max** for heavy weight documents and **Min** for light weight documents.

REFERENCE

Default is **Max**.



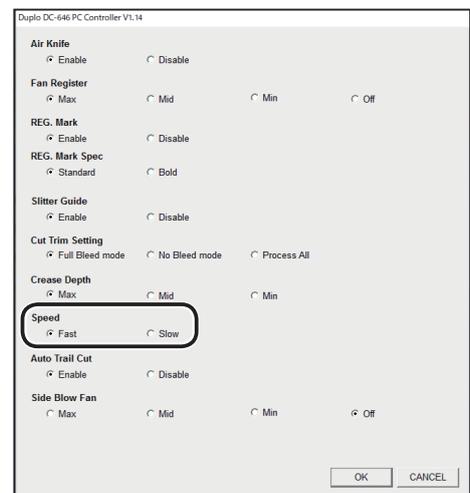
8. Speed

Select **Fast** or **Slow**.

Selecting **Slow** improves finishing accuracy.

REFERENCE

If finishing accuracy cannot be obtained because of roller slip due to slippery documents (UV coated documents, etc.), select **Slow**.



9. Auto Trail Cut

Select the trail margin cut of document.

Enable: Processes optimum trail margin cut for a JOB.

Disable: Does not perform the auto trail cut regardless of the length of the trail margin.

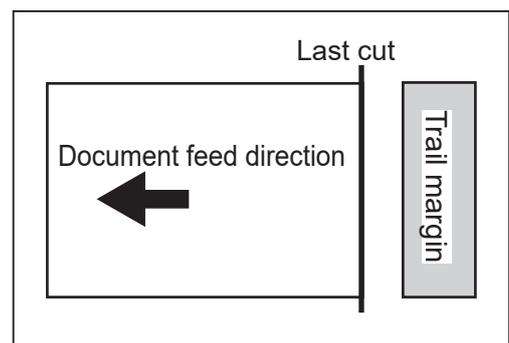
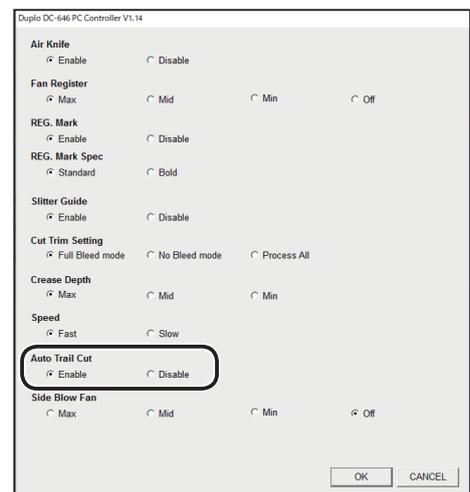
REFERENCE

Default is **Disable**.

- **Dummy cut :**

The DC-646 performs cutting operation three times without a document to be cut at the position where the document is fed for the distance of the trail margin plus extra length. This is effective for dropping a document, such as when the trail margin is jammed between the roller and the lower tool of the cutter.

- **Trail margin:** Means a margin of the trail edge of the document produced when the last cut is performed.



10. Side Blow Fan (Option: ASIA, TAIWAN)

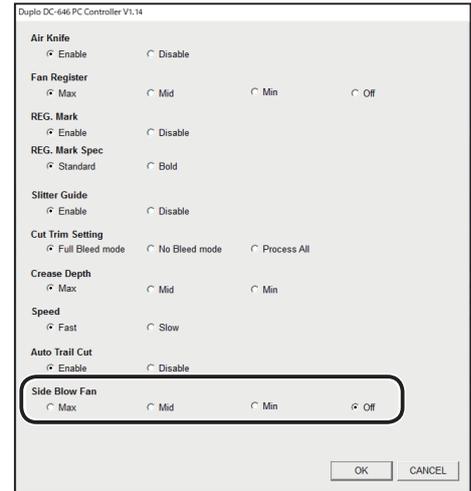
Select **Max**, **Mid**, **Min** or **Off**.

REFERENCE

Select **Max** when processing documents with excessive static electricity or heavy weight documents.

Select **Min** or **Off** when processing light weight documents.

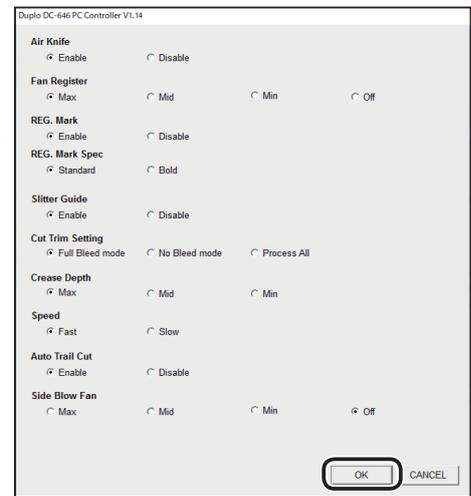
Use this function when document feed is unstable even when **Air Knife** is set to **Enable**.



23

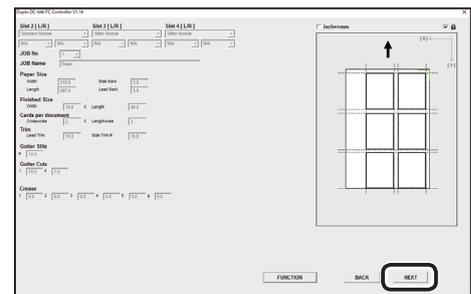
Check the contents of the function settings, then click **OK**.

Clicking **CANCEL** returns to the **WIZARD** screen without changing the settings.



24

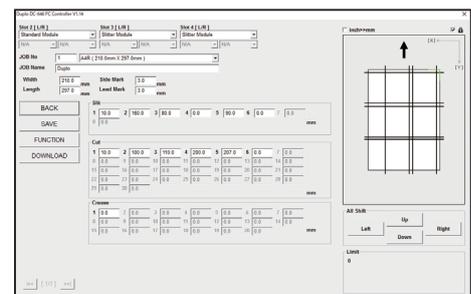
Click **NEXT**.



25

Check the JOB details.

To change the details, click the item and re-enter it.



4

REFERENCE

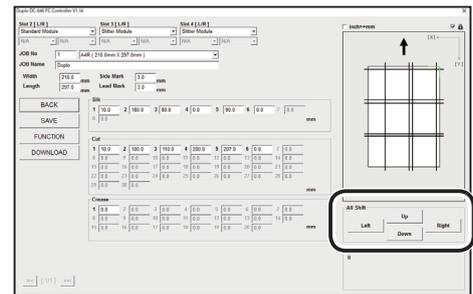
You can fine-adjust the setting positions of the JOB.

Up: Each click on **Up** decreases values by 0.1 mm in a vertical direction. (Upward)

Down: Each click on **Down** increases values by 0.1 mm in a vertical direction. (Downward)

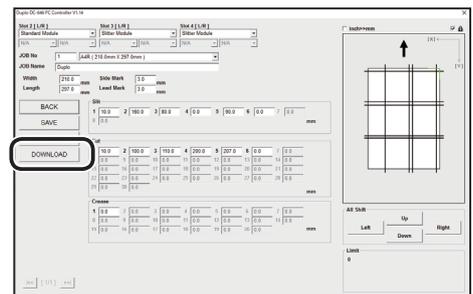
Left: Each click on **Left** increases values by 0.1 mm in a horizontal direction. (To the left)

Right: Each click on **Right** decreases values by 0.1 mm in a horizontal direction. (To the right)



26

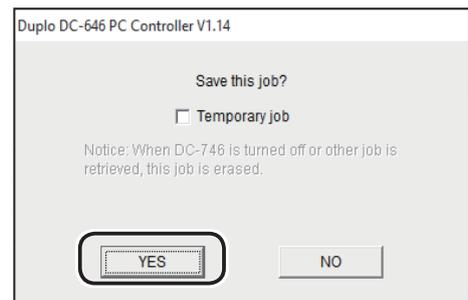
- To save this JOB in the DC-646:
 - Click **DOWNLOAD**.



- Click **YES**.
Clicking **NO** returns to the previous screen without downloading the JOB.

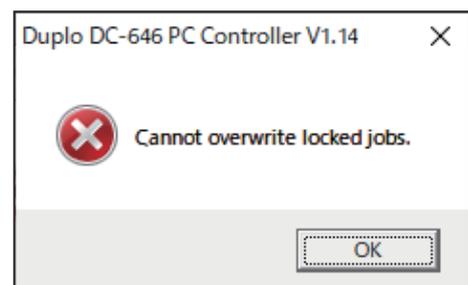
REFERENCE

- To save the JOB temporarily, select the **Temporary job** check box.
- When the DC-646 is turned **OFF** or another JOB is retrieved, the temporarily saved JOB is deleted.



REFERENCE

If you download the data to the locked JOB, the message on the right appears.
To overwrite the locked JOB, unlock the locked JOB first.
(→P.98 Unlocking a JOB)



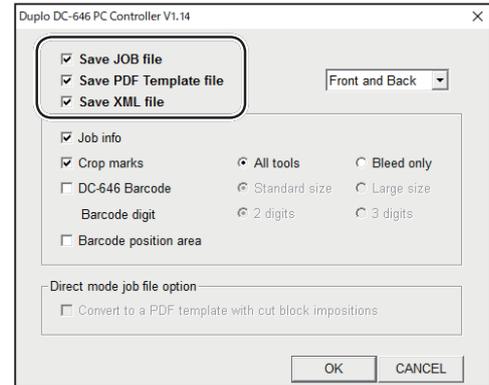
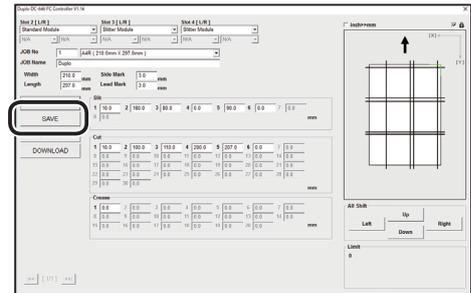
- Click **OK**.



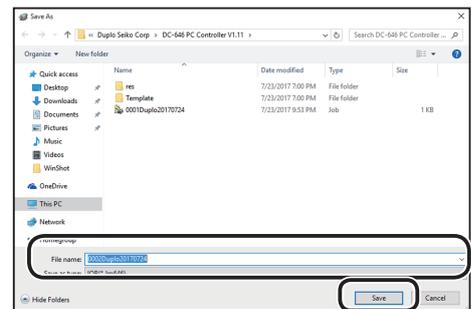
- To save this JOB on your computer:
 - Click **SAVE**.

REFERENCE

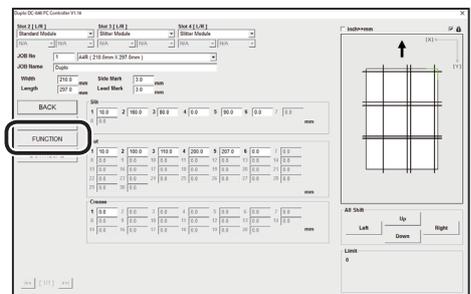
When clicking **SETTING** on the main menu screen, and selecting the **PDF Template creator** check box and the **XML file creator** check box on the **DEFAULT** tab, the screen as shown on the right appears at the time of saving the JOB.
 (→P.121 • PDF Template creator)
 (→P.149 How to Create a PDF Template)
 (→P.122 • XML file creator)



- Specify a file to save the JOB and click **Save**.



- Function setting
Click **FUNCTION**.
Set functions in a similar way to steps 21 and 22.



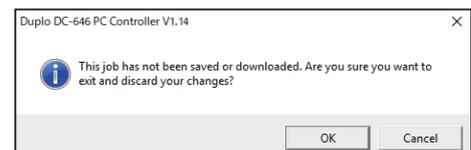
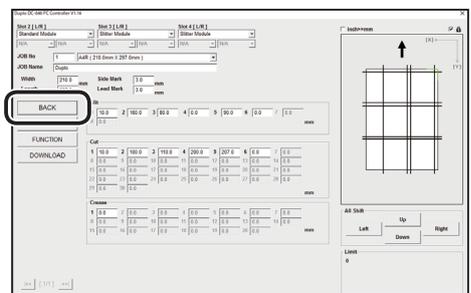
- Click **BACK** to return to the main menu screen.

REFERENCE

The message as shown on the right appears when the settings (values, functions) are changed and not saved or downloaded.

To return to the menu screen without saving or downloading the data, click **OK**.

To save or download it, click **Cancel**.

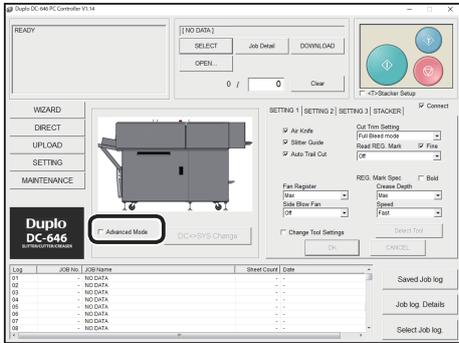


PC Controller Setting

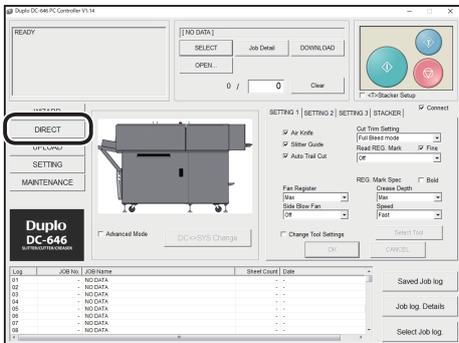
DIRECT

This section describes the procedure of **Direct entry** programming a JOB in the **DIRECT mode**.

- 1 Select a JOB programming mode.
When the **Advanced Mode** check box is selected, the **advanced mode** is selected.
When it is cleared, the **simple mode** is selected.



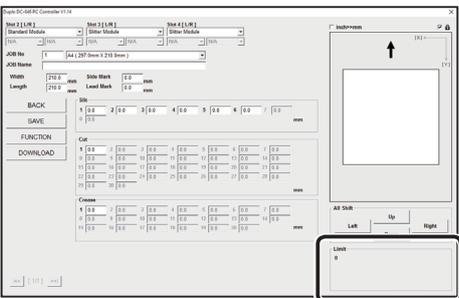
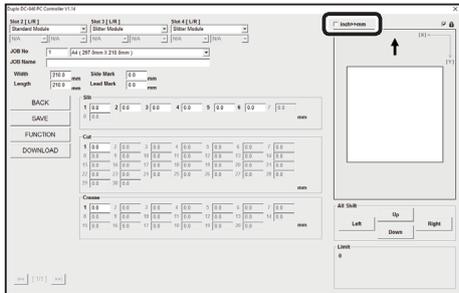
- 2 Click **DIRECT**.



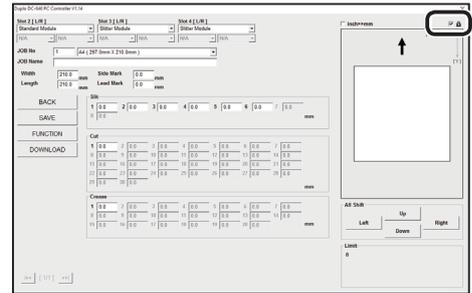
- 3 [Inch>> mm]
If you select the **Inch>> mm** check box, the values entered in inches are converted to ones in millimeters and displayed.

REFERENCE

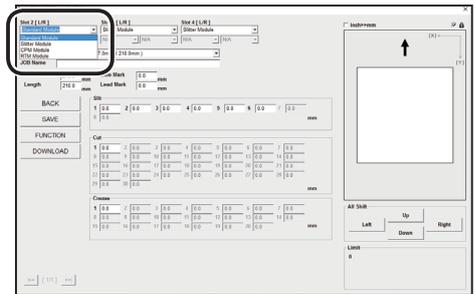
- The values entered before selecting the check box are not converted.
Make sure to select the check box before entering values.
- The value limit appears in the lower right side of the screen.
Refer to it when you program a JOB.



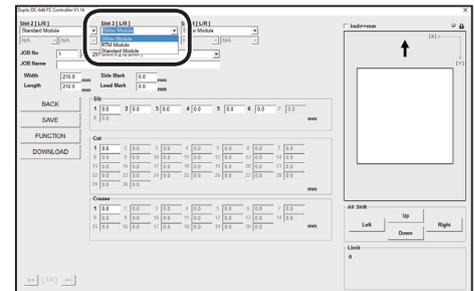
- 4** If you select the check box in the upper right part of the screen (**DIRECT**), you can lock the JOB.
(→P.97 Locking a JOB)



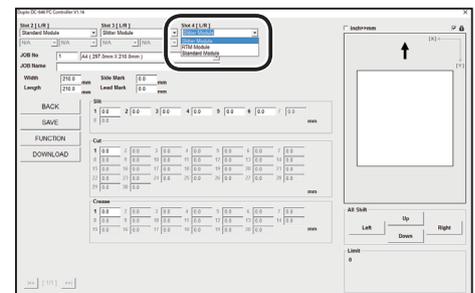
- 5** Select a module from the **Slot 2 [L/R]** box.
Standard Module
Slitter Module
CPM (Cross Tool Module) (option)
RTM (Rotary Tool Module) (option)



- 6** Select a module from the **Slot 3 [L/R]** box.
Slitter Module
RTM (Rotary Tool Module) (option)
Standard Module



- 7** Select a module from the **Slot 4 [L/R]** box.
Slitter Module
RTM (Rotary Tool Module) (option)
Standard Module



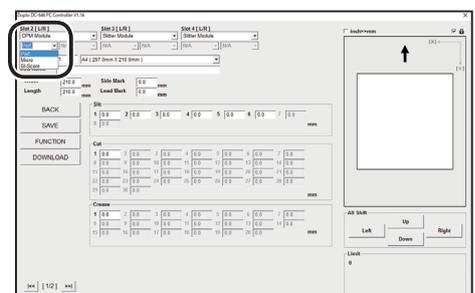
- 8** If you have selected **CPM (cross tool module (option))** or **RTM (rotary tool module (option))** in the **Slot 2 [L/R]** box in step 5, select a tool for the selected module from the **Tool** box.

CPM (Cross Tool Module): Select a tool.

Perf., Micro, SI-Score

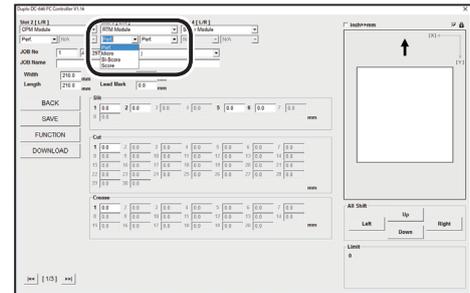
RTM (Rotary Tool Module): Select a tool for the left tool and the right tool.

Perf., Micro, SI-Score, Score

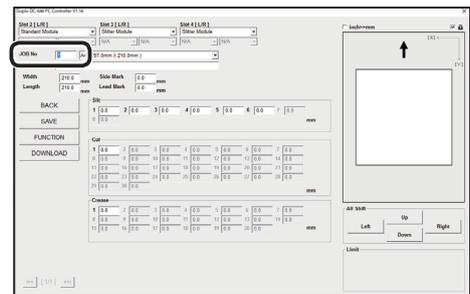


PC Controller Setting

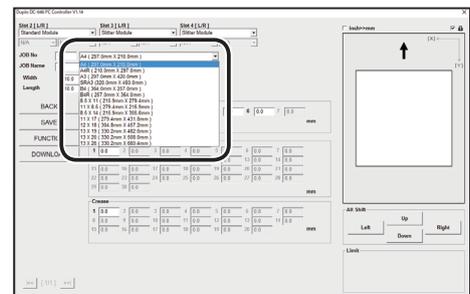
- 9** If you have selected **RTM (rotary tool module (option))** in the **Slot 3 [L/R]** or **Slot 4 [L/R]** box in steps 6 and 7, select a tool for each slot in a similar way to step 8.



- 10** Enter a JOB number in the **JOB No.** box. You can set from 1 to 250.



- 11** **Paper size (Standard size)**
Select a document size from the **Paper size** box.

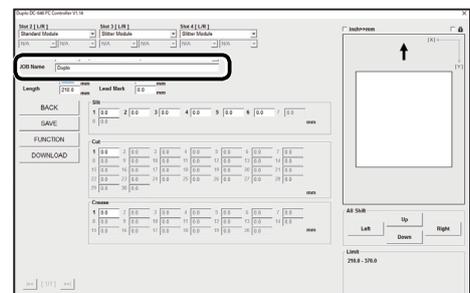


- 12** Enter a JOB name in the **JOB Name** box. You can enter up to 30 characters.

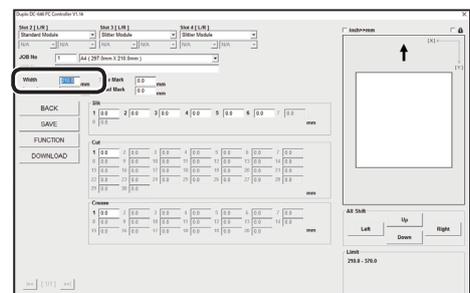
REFERENCE

Usable characters;

- Alphabetical letters (A to Z, a to z)
- Numeric characters
- Symbols

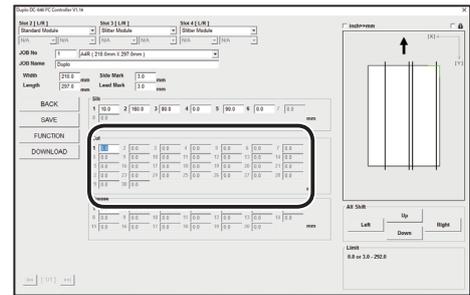


- 13** **Width (Custom size)**
To use custom size documents, enter a value of the document width in the **Width** box. If you have selected standard size in step 11, the selected document width value appears here.

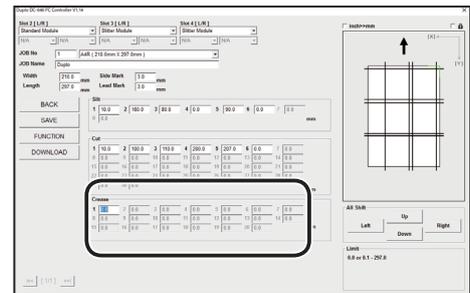


PC Controller Setting

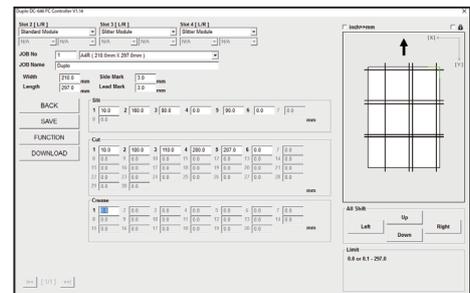
- 18** **Cut**
Click each **Cut** box, then enter the distance from the lead edge of the document to the cut position.
Up to 30 cuts can be set.
Enter **0** when finishing the cut setting.



- 19** **Crease**
Click each **Crease** box, then enter the distance from the lead edge of the document to the crease position.
Up to 20 creases can be set.
Enter **0** when finishing the crease setting.



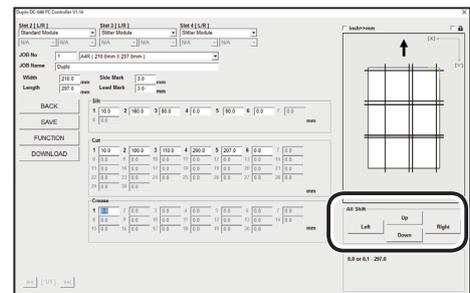
- 20** Check the JOB details.
To change the details, click the item and re-enter a value.



REFERENCE

You can fine-adjust the setting positions of the JOB.

- Up:** Each click on **Up** decreases values by 0.1 mm in a vertical direction. (Upward)
- Down:** Each click on **Down** increases values by 0.1 mm in a vertical direction. (Downward)
- Left:** Each click on **Left** increases values by 0.1 mm in a horizontal direction. (To the left)
- Right:** Each click on **Right** decreases values by 0.1 mm in a horizontal direction. (To the right)

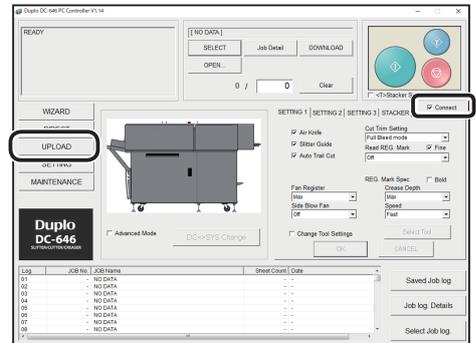


- 21** From here, follow step 25 and its following steps in WIZARD. (→ P.110)

UPLOAD

This section describes the procedure to read JOBS (upload) from the DC-646 to your computer.

- 1 Select the **Connect** check box to connect the line. Click **UPLOAD**.



- 2
 - **Uploading all JOBS from the DC-646**
 1. Click **ALL JOBS** and click **UPLOAD**.

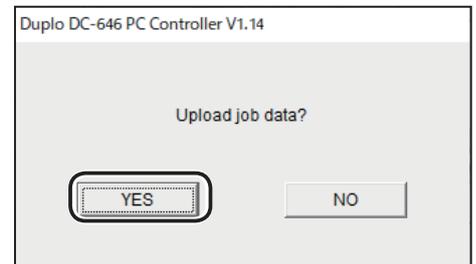
REFERENCE

JOB No. 1 to 250 are saved in one file.



2. Click **YES**.

Clicking **NO** returns to the previous screen without uploading it.

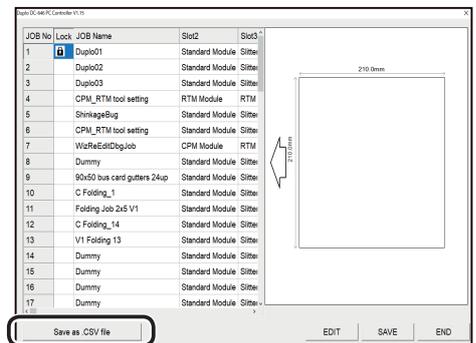


3. A list of JOB data is displayed after uploading is completed.

- Clicking **Save as CVS file** saves the data as a CVS file on the computer.

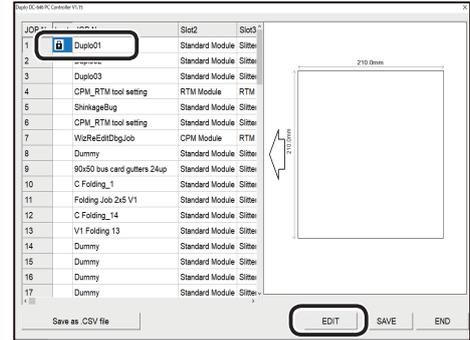
REFERENCE

You cannot download this CSV file.



PC Controller Setting

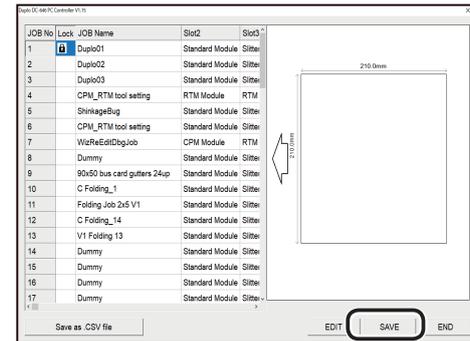
- Select and click a JOB from the JOB list and click **EDIT**. The details of the selected JOB appears. To change the values, click the field to change and re-enter a value.



- Clicking **SAVE** saves the corrected JOB on the computer.

REFERENCE

- You can download this saving file.
- The  icon is displayed for the locked JOB.
- Clicking **END** finishes uploading it.



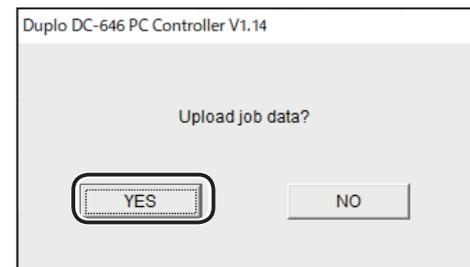
- **Uploading a specified JOB from the DC-646**

1. Click **JOB No.**.
Select the JOB number from the **JOB number** box.
Click **UPLOAD**.



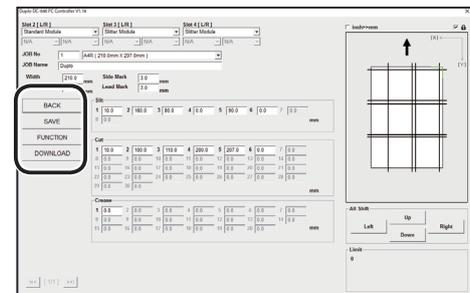
2. Click **YES**.

Clicking **NO** returns to the previous screen without uploading it.



3. The details of the selected JOB appears.
To change the values, click the field to change and re-enter a correction value.

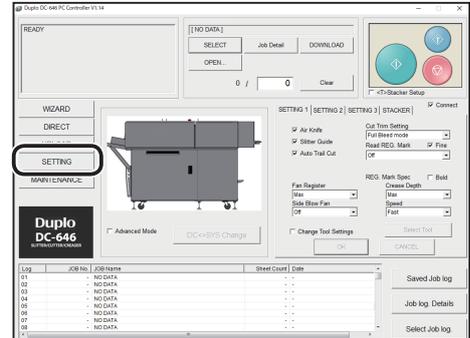
- Clicking **BACK** returns the screen to step 2.
- Clicking **FUNCTION** displays the function settings for the JOB.
- Clicking **SAVE** saves the corrected JOB on the computer. Designate the file name and place to save.
- Clicking **DOWNLOAD** downloads the corrected JOB in the DC-646.



SETTING

This section describes the procedure to set frequently used function on a computer.

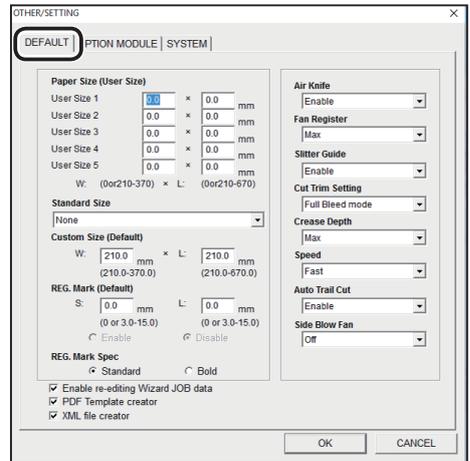
1 Click **SETTING**.



2 Click the **DEFAULT** tab.
Set each default setting.

REFERENCE

The optional items do not appear on this screen if you do not set the optional devices.

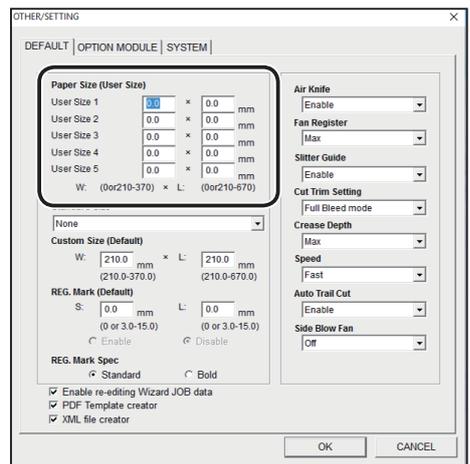


- **Paper Size (User Size):**

You can save a custom size document as **User Size**.
The size saved in here is saved in the **Standard Size** box.

It is convenient to save the custom size document that is frequently used.

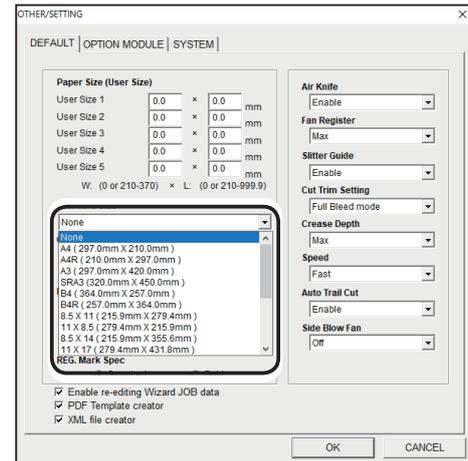
Up to five **User Sizes** can be saved.



PC Controller Setting

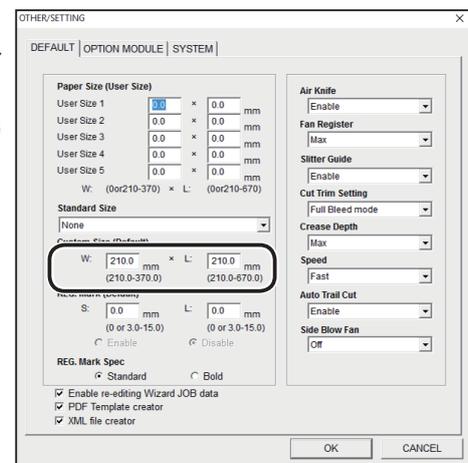
- **Standard Size:**

Select the default size from the **Standard Size** box. It is recommended that you set the most frequently used size.



- **Custom Size (Default):**

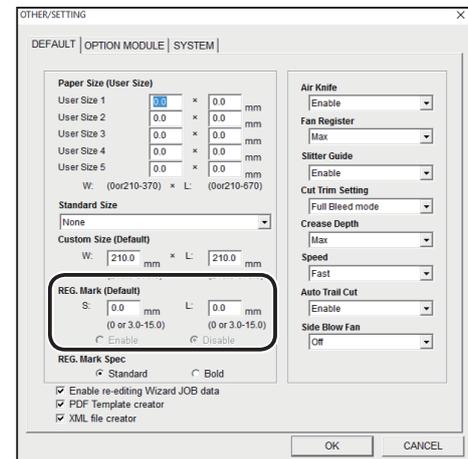
Set the default values when using documents of other size than the standard size. Enter each value in the **W:** (Width) box and **L:** (Length) box.



- **REG. Mark**

This sets the default position of the REG mark.

1. Enter the default position of the **side mark** in the **S:** box.
2. Enter the default position of the **lead mark** in the **L:** box.
3. Select **Enable** or **Disable**.



● **REG. Mark Spec**

Select **Standard** or **Bold**.

When using specially treated documents, print a bold REG mark on them in advance.

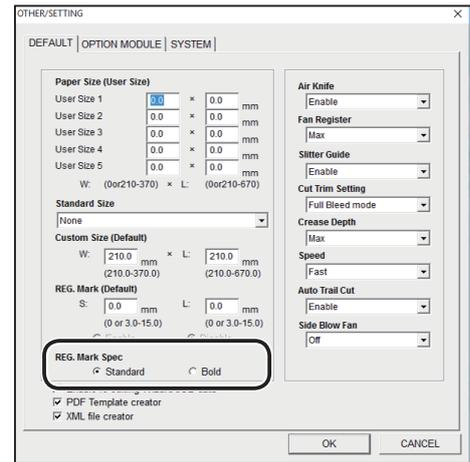
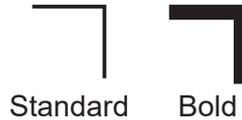
REFERENCE

Normally select **Standard**.

If the REG mark cannot be read, select **Bold**.

Guidelines for **REG. mark spec**

- **Standard:** 0.4 mm and more
- **Bold:** 2 mm and more



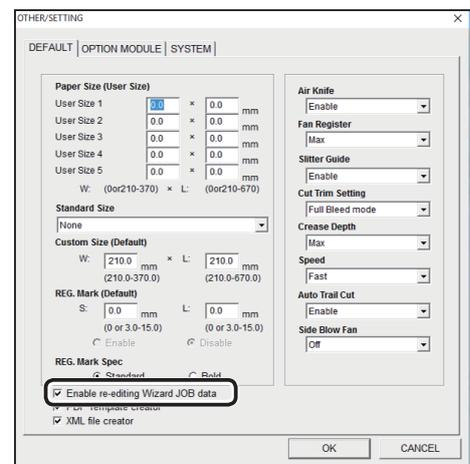
● **Enable re-editing Wizard JOB data:**

If you select this check box, the retrieved JOB data is displayed on the **WIZARD** screen.

REFERENCE

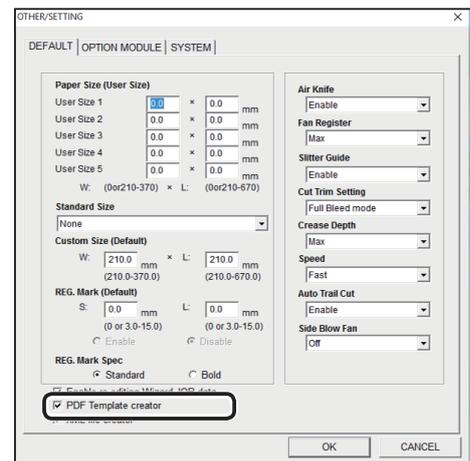
If you have programmed the JOB in the **DIRECT mode**, the JOB data is displayed on the **DIRECT** screen.

If you re-enter the data, which was programmed in the **WIZARD mode**, on the **DIRECT** screen, it is also displayed on the **DIRECT** screen.



● **PDF Template creator**

If you select the **PDF Template creator** check box, the JOB programmed can be saved as PDF template.



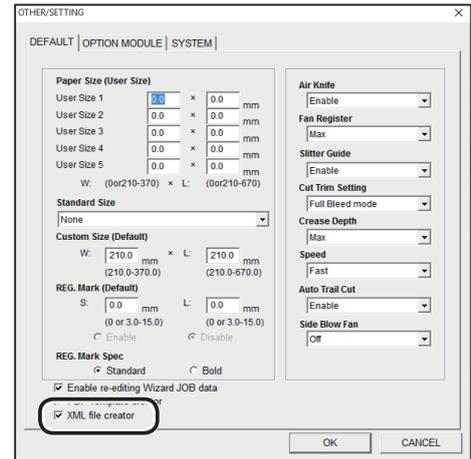
PC Controller Setting

- **XML file creator**

If you select the **XML file creator** check box, the JOB programmed can be saved as an XML file.

REFERENCE

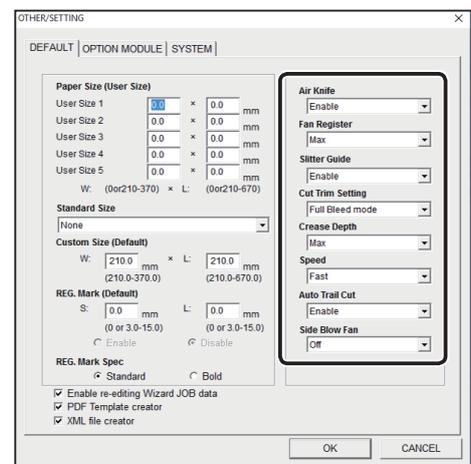
- JOB that was programmed or edited in the **advanced mode**, the settings for **RTM (rotary tool module (option))** and **CPM (cross tool module (option))** are not reflected in the XML file except **Cards per document** information.
- Contact your dealer for the specifications of **XML file**.



- **Default setting for the Functions**

Select each function setting box.

- Air Knife (Enable, Disable)**
- Fan Save (Max, Mid, Min, Off)**
- Slitter Guide (Enable, Disable)**
- Cut Trim Setting (Full Bleed Mode, No Bleed Mode, Process All)**
- Crease Depth (Max, Mid, Min)**
- Speed (Fast, Slow)**
- Auto Trail Cut (Enable Disable)**
- Side Blow Fan (Option: ASIA, TAIWAN)(Max, Mid, Min, Off)**



3

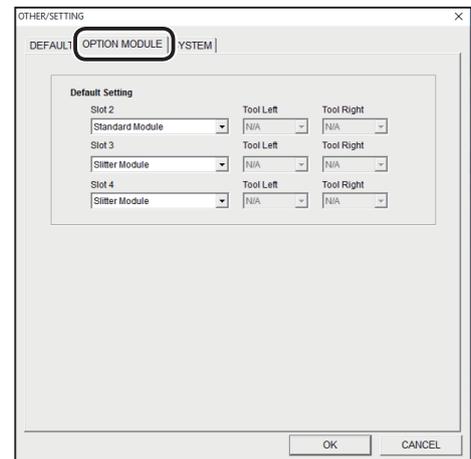
Click the **OPTION MODULE** tab.

- **Default setting**

Select the default setting for modules for slot 2 to slot 4 from each **Slot *** box.

If you have selected **CPM (Cross Tool Module)**, select a **CPM tool** from the **Tool Left** box.

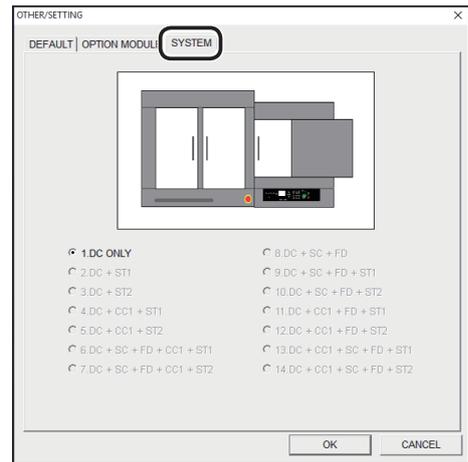
If you have selected **RTM (Rotary Tool Module)**, select a **RTM tool** from the **Tool Left** box and **Tool Right** box.



- Click the **SYSTEM** tab.
Select the system for connecting to the DC-646.
If you are using the DC-646 alone, select **1. DC ONLY**.
Click the radio key of the system configuration that you want to select.

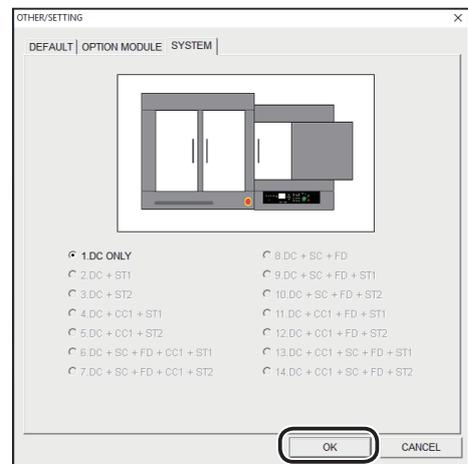
REFERENCE

You can change the setting only when either of connected units to the DC-646 is set on the **MAINTENANCE** screen



- Check the contents.
When setting is completed, click **OK**.

Clicking **CANCEL** returns to the main menu screen without changing the settings.



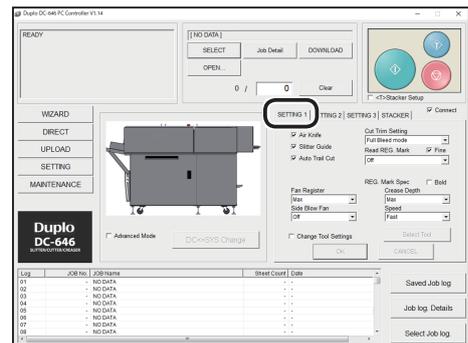
SETTING 1

- Click the **SETTING 1** tab.

REFERENCE

Side Blow Fan and **Read REG. Mark** appear when these settings are set to **enable** on the **OPTION MODULE** tab of the **MAINTENANCE** screen.

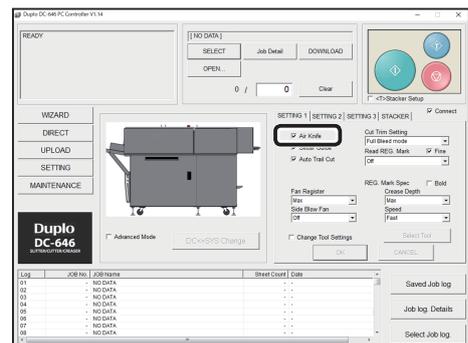
The **MAINTENANCE** setting screen is locked with the password. To change the **MAINTENANCE** setting, contact our service person.



- Air Knife**
Compressed air is blown out to loosen the documents, preventing a double feed.
When using the **Air Knife** function, select the **Air Knife** check box to enable this function.

REFERENCE

Clear the check box for light weight documents.
Select the check box when processing documents with excessive static electricity or heavy weight documents.



PC Controller Setting

3

Slitter Guide

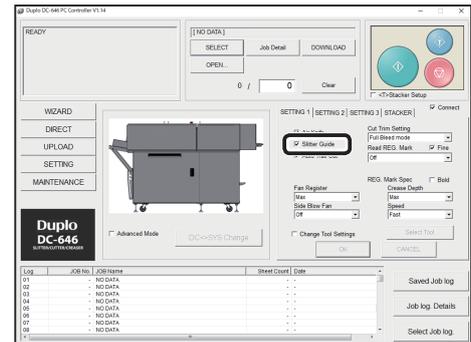
When no modules are used for performing a JOB, these modules act as document guides to stabilize the document conveyance.

Select the **Slitter Guide** check box when using the modules as slitter guides.

REFERENCE

Recommended for light weight documents.

RTM (rotary tool module (option)) and **Slitter Module** can be used as **slitter guides**.



4

Auto Trail Cut

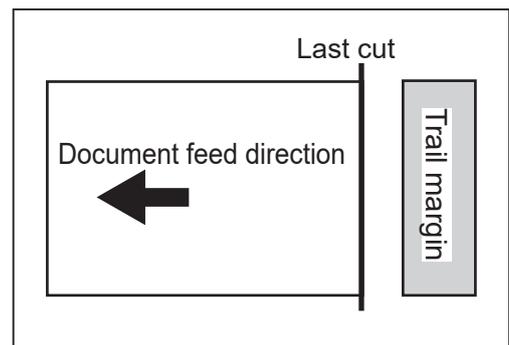
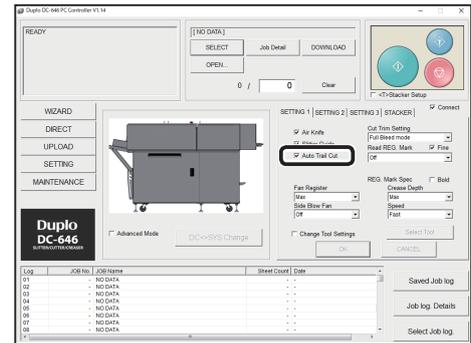
Select the **Auto Trail Cut** check box to enable this function.

Enable: Processes optimum trail margin cut for a JOB.

Disable: Does not perform the auto trail cut regardless of the length of the trail margin.

REFERENCE

- Trail margin: A margin of the trail edge of the document produced when the last cut is performed.



5

Fan Register

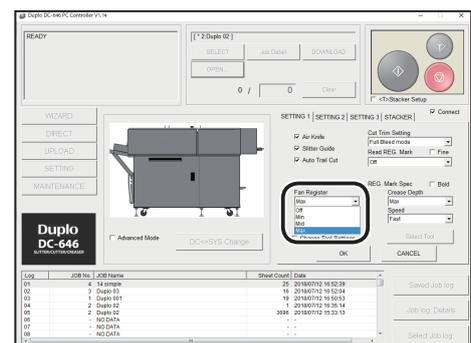
This suctions a document to the **conveyance belt** for skew correction.

Select a level from the **Fan Save** box.

Off, Min, Mid, Max

REFERENCE

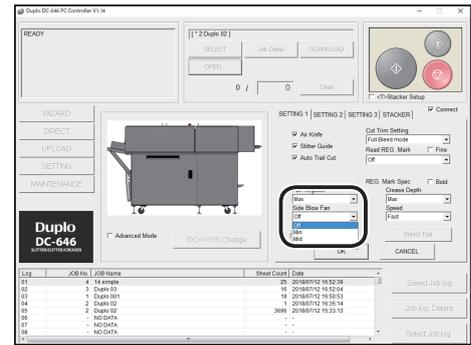
Select **OFF** for light weight documents to prevent a document jam.



- 6 Side Blow Fan (Option: ASIA, TAIWAN)**
Air is blown out to loosen documents.
Select a level from the **Side Blow Fan** box.
Off, Min, Mid, Max

REFERENCE

Select **Max** when processing document with excessive static electricity or heavy weight documents.
Select **Min** or **Off** for light weight documents.
Use this function when document feed is unstable even when **Air knife** is set to **Enable**.

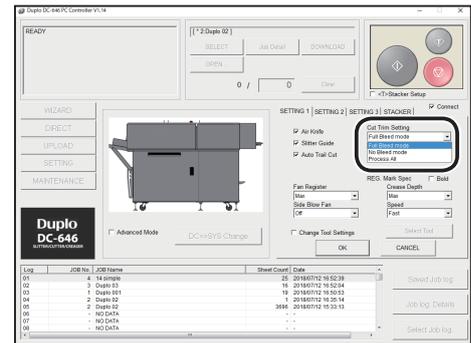


- 7 Cut Trim Setting**
Select from the **Cut Trim Setting** box.

Full Bleed Mode: Lead margin and trail margin are chopped up and dropped into the waste box.

No Bleed Mode: Gutters shorter than 49 mm are chopped up and dropped into the waste box.

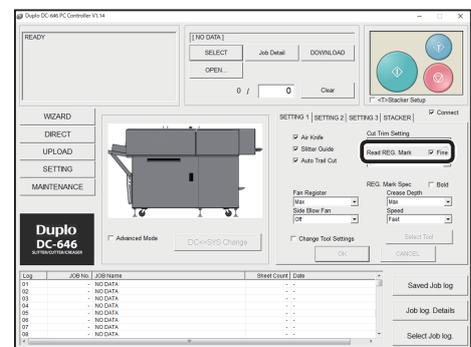
Process All: All of cut pieces are ejected to the **exit tray**, except that gutters shorter than 28 mm and trail margin shorter than 49 mm are chopped up and dropped into the waste box.



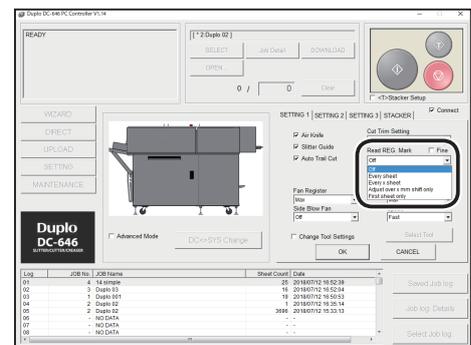
REFERENCE

Select **No Bleed Mode** when there is no lead or trail margin.

- 8 Read REG Mark (REG mark reading accuracy)**
This sets REG mark reading accuracy.
Selected accuracy is enabled when REG mark is read.
When the **Fine** check box is cleared:
Reads REG mark with normal accuracy.
When the **Fine** check box is selected:
Improves REG mark reading accuracy and compensates printing position misalignment finer.
Selecting the check box for higher reading accuracy decreases processing speed as compared with clearing it.



- 9 Read REG. Mark**
Select from the **Read REG. Mark** box.
Off
Every sheet
Every x sheet (2 to 9999 counts)
Adjust over x mm shift only (0.2 to 12.0 mm)
First sheet only

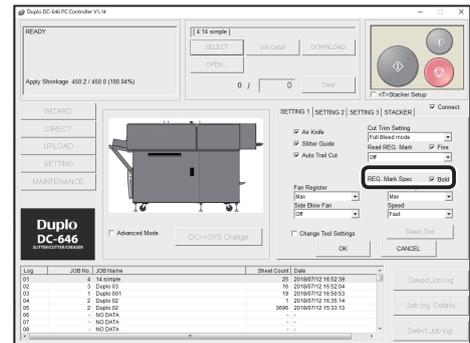


PC Controller Setting

10

REG. Mark Spec

When using specially treated documents, print a bold REG mark on them in advance. Then select the **BOLD** check box for **REG. Mark Spec.** (→P.23 IMPORTANT)
Normally clear the check box.



11

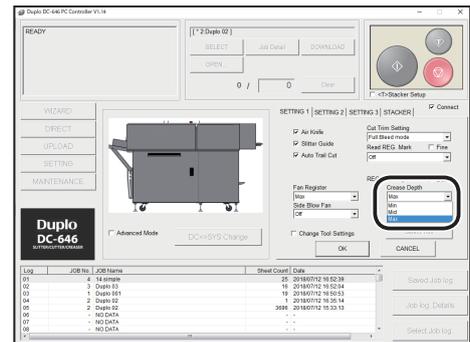
Crease Depth

This sets the depth of the crease. Select from the **Crease Depth** box.

Min
Mid
Max

REFERENCE

Select **Max** for heavy weigh documents and **Min** for light weight documents.



12

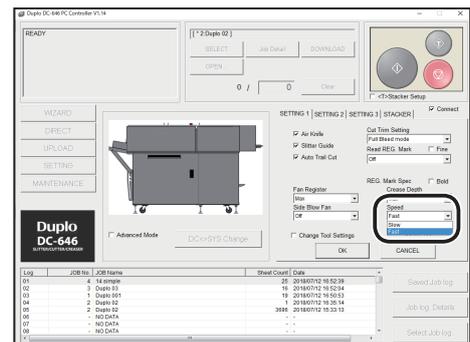
Speed

Select from the **Speed** box.

Slow
Fast

REFERENCE

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

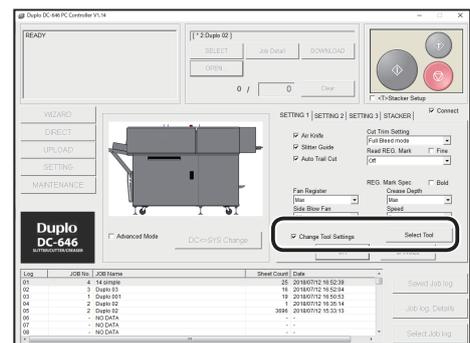


13

Change Tool Settings

Change the tool settings for the Modules in the **Slot 2 [L/R] to Slot 4[L/R].**

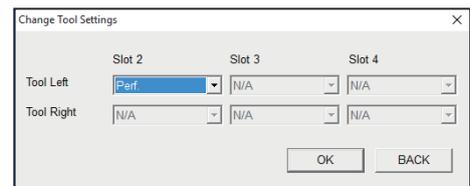
1. Select the **Change Tool Settings** check box, and click **Select Tool**.



2. Select each tool of slot 2 to slot 4 from the **Tool Left** box or **Tool Right** box.

You can select the tools when you set **CPM (cross tool module (option))** or **RTM (rotary tool module (option))** in slot 2 to slot 4.

When setting is completed, click **OK**.



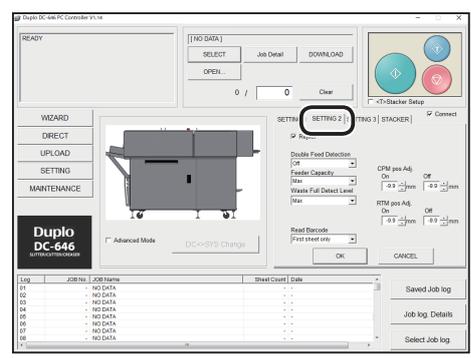
Clicking **BACK** returns to the previous screen without changing the settings.

SETTING 2

1 Click the **SETTING 2** tab.

REFERENCE

Read Barcode and **Reject** appear when these settings are set to **enable** on the **OPTION MODULE** tab of the **MAINTENANCE** screen. The **MAINTENANCE** setting screen is locked with the password. To change the **MAINTENANCE** setting, contact our service person.

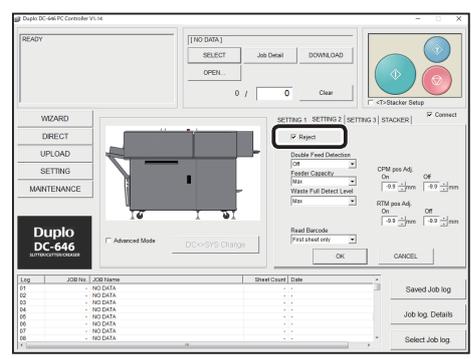


2 **Reject**

This function ejects the double-fed documents and the documents with a CCD reading error to the **reject tray**. Then, it continues to process the next document. If an error occurs three times continuously, processing stops. Select the **Reject** check box to enable this function.

REFERENCE

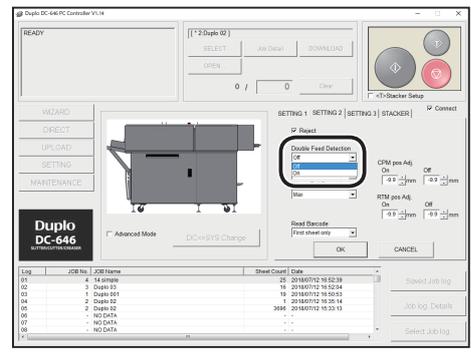
A document of 670 mm or longer is not ejected on the **reject tray**.



3 **Double Feed Detection**

This function detects a double feed. Select from the **Double Feed Detection** box.

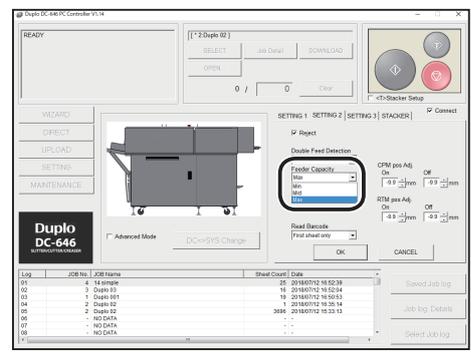
- Off
- On



4 **Feeder Capacity**

You can adjust the elevator height in three levels. Select from the **Feeder Capacity** box.

- Min:** For small amount of documents
- Mid**
- Max:** For large amount of documents



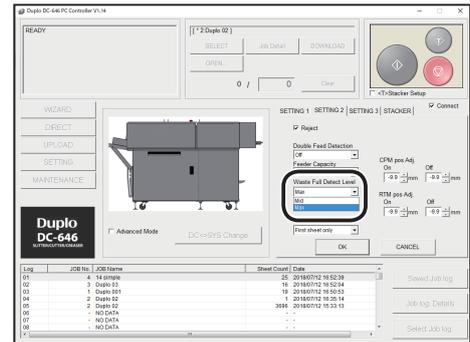
4

Programming a JOB for DC-646 Via Computer (PC Controller)

PC Controller Setting

- 5 Waste Full Detect Level**
This function detects the waste strips amount in the **waste box**. When **waste box full** is detected, a message appears on the screen.
Select from the **Waste Full Detect Level** box.

Mid
Max

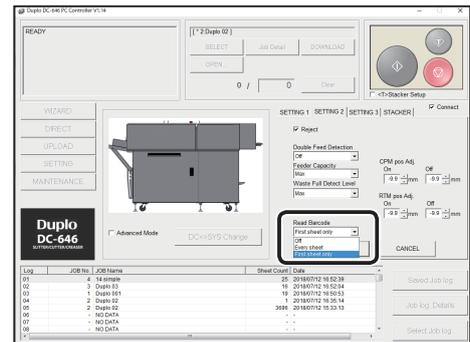


- 6 Read Barcode**
This sets whether to perform automatic setup by reading the barcode.

OFF: Does not read barcode.

Every sheet: Reads barcode on every document and sets a JOB.

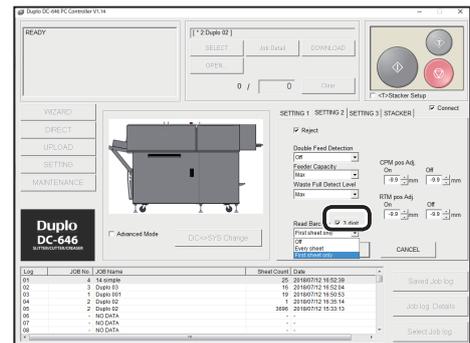
First sheet Only: Reads barcode on the first document and sets a JOB.



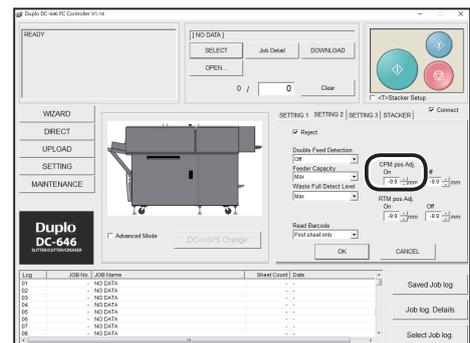
- 7 3 digit (barcode)**
When processing documents with 3-digit barcode printed, select the **3 digit** check box.

REFERENCE

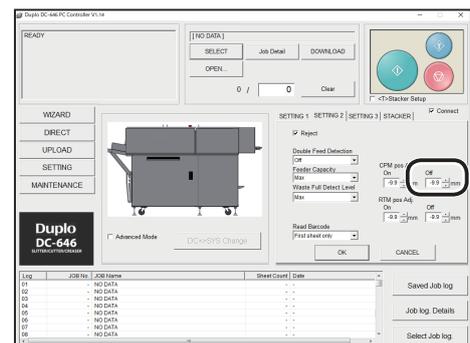
For detailed information, contact your dealer.



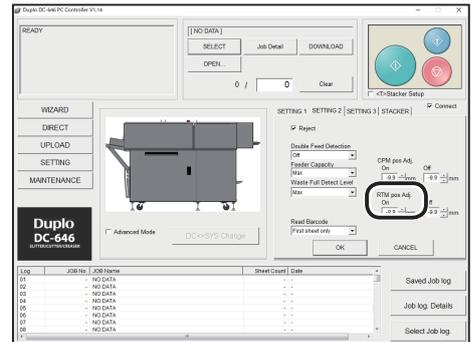
- 8 CPM on pos Adj (CPM (Cross Tool Module) on position Adjustment)**
(only when the **CPM (cross tool module (option))** is installed.)
This adjusts a processing start position of the tool of the **CPM (cross tool module (option))**.
Refer to the CPM (Cross Tool Module) Instruction Manual.



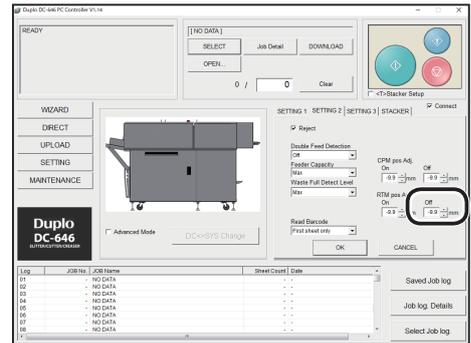
- 9 CPM off pos Adj (CPM (Cross Tool Module) off position Adjustment)**
(only when the **CPM (cross tool module (option))** is installed.)
This adjusts a processing end position of the tool of the **CPM (cross tool module (option))**.
Refer to the CPM (Cross Tool Module) Instruction Manual.



- 10 RTM on pos Adj (RTM (Rotary Tool Module) on position Adjustment)**
 (only when the **RTM (rotary tool module (option))** is installed)
 This adjusts a processing start position of the tool of the **RTM (rotary tool module (option))**.
 Refer to the RTM (Rotary Tool Module) Instruction Manual.



- 11 RTM off pos Adj (RTM (Rotary Tool Module) off position Adjustment)**
 (only when the **RTM (rotary tool module (option))** is installed.)
 This adjusts a processing end position of the tool of the **RTM (rotary tool module (option))**.
 Refer to the RTM (Rotary Tool Module) Instruction Manual.



SETTING 3

- 1** Click the **SETTING 3** tab.

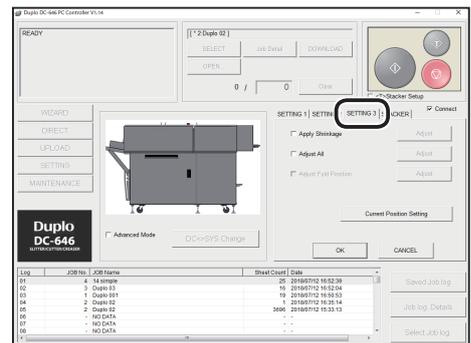
REFERENCE

Adjust Fold Position appears when any folder machine is set to **enable** on the **OPTION MODULE** tab of **MAINTENANCE**.

The **MAINTENANCE** setting screen is locked with the password.

To change the **MAINTENANCE** setting, request it of our service person.

(Refer to the Instruction Manual of each folding machine.)

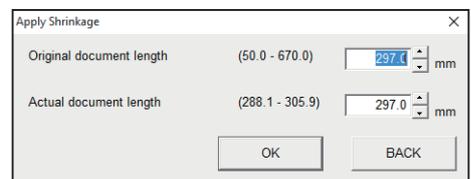
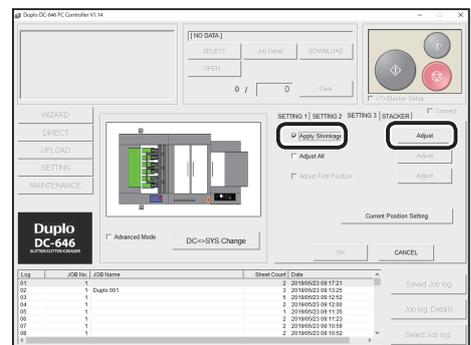


- 2 Apply Shrinkage**
 In case printed documents are shrunk by heat generated on digital printer, by entering the original document size and document size after shrunk, the DC-646 automatically calculates the shrinkage ratio and adjusts the cutting and creasing position accordingly.

- 1. Select the **Apply Shrinkage** check box to enable this function.
 Then click **Adjust**.

- 2. Enter the document length before printing in the **Original document length** box.
 Enter the document length after printing in the **Actual document length** box.

- 3. Click **OK**.
 Clicking **BACK** cancels the entered value.



REFERENCE

This function compensates for the shrinkage in the feed direction only.

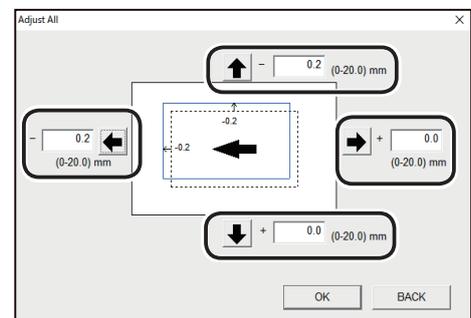
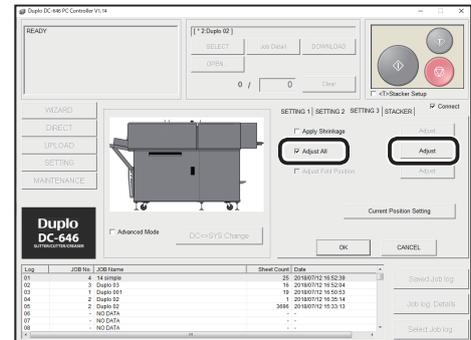
3 Adjust All

This function corrects the document position in a vertical/horizontal direction against the JOB set (mm).

1. Select the **Adjust all** check box to enable this function. Then click **Adjust**.

2. Click the text-box of which you want to change the processing position, then enter a value for shifting.

3. Click **OK**.
Clicking **BACK** cancels the entered value.

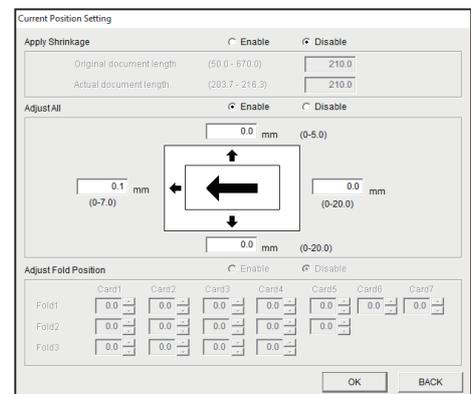
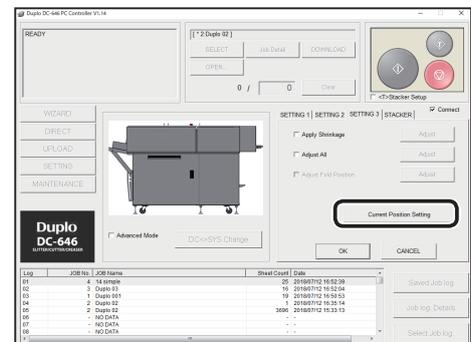


4 1. Click **Correct position setting**.

2. The current position settings for **Apply Shrinkage**, **Adjust All** and **Adjust Fold Position** are displayed. To change the settings, click the text-box that you want to change and enter a value.

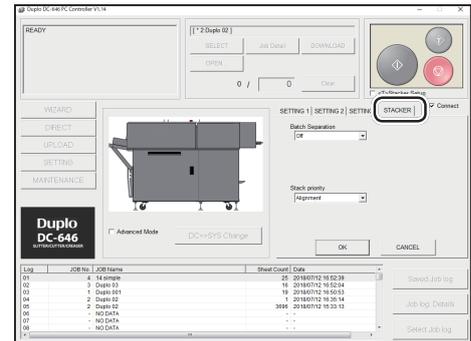
Clicking **OK** saves the setting and returns to the previous screen.

Clicking **BACK** cancels the entered value.



STACKER

1 Click the **STACKER** tab.

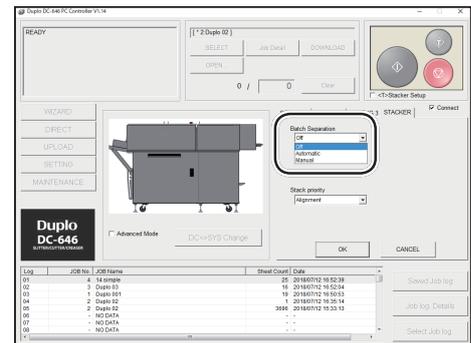


2 **Batch Separation**

OFF: Starts processing documents without a time interval. Proceed to step 5.

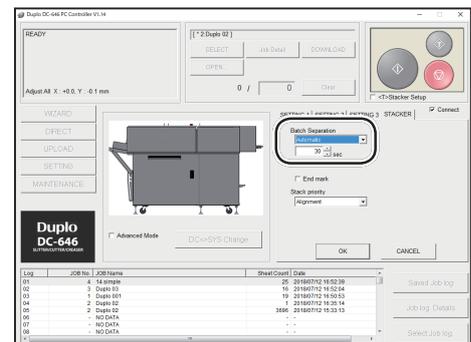
Automatic: Pausing is canceled according to the set time and then the operation resumes automatically. Even when the set time has not elapsed, pressing the START key resumes the operation.

Manual: Press the START key to resume the operation.



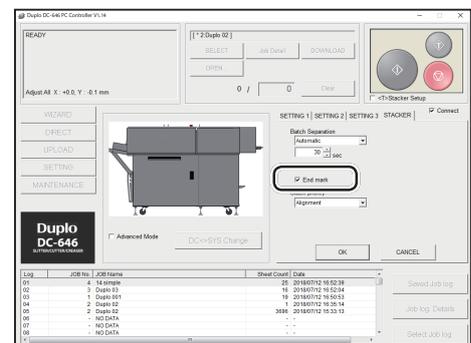
3 **Gap timing**

If you have selected **Automatic** on the **Batch Separation** screen in step 2, click the **up/down** icon to set a recovery time from pausing. Set it in the range of 1 sec to 30 sec. Default is 5 sec.



4 **End mark**

If you have selected **Automatic** or **Manual** on the **Batch Separation** screen in step 2, **End mark** setting appears. If you select the **End mark** check box, processing is executed with the interval set in **Batch Separation** between a document with end mark printed on it and the next one.



IMPORTANT

When the number for the preset count is set, the **End mark** function is not available even if it is set to **ON**.

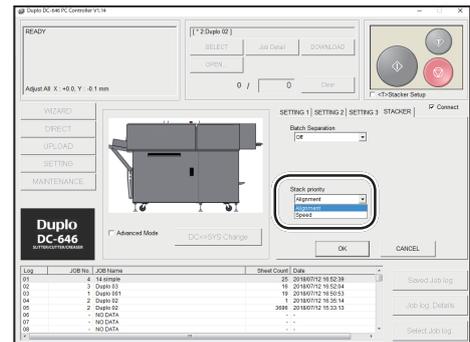
PC Controller Setting

- 5 Stack priority**
Set speed of a finished product to be ejected from the exit of the machine to the **exit tray**.

Alignment: Gives priority to alignment of finished products. Decreases processing speed.

Speed: Gives priority to processing speed. Reduces accuracy of alignment of finished products.

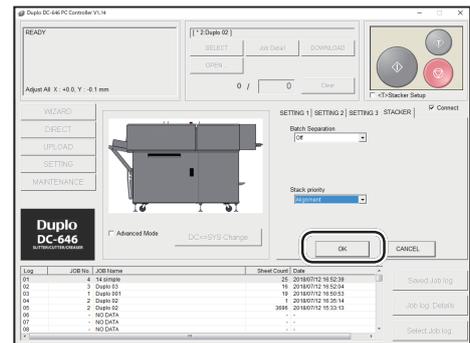
Default is **Alignment**.



- 6** If you save the settings for **SETTING1** to **SETTING3** and **STACKER**, click **OK**. Clicking **CANCEL** returns to the main menu screen without saving the settings.

REFERENCE

If you have changed the settings for **SETTING1** to **SETTING3** and **STACKER**, you need to click **OK** or **CANCEL** to proceed to another operation.



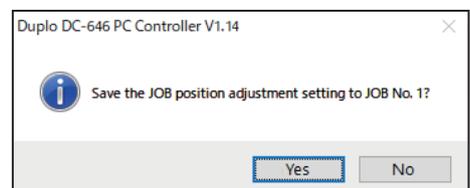
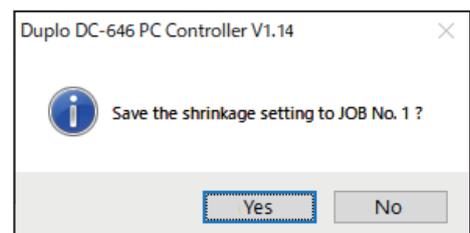
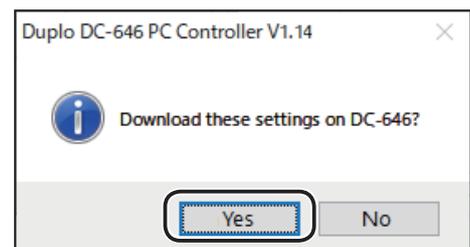
- 7** Clicking **Yes** starts downloading the JOB.

Clicking **No** returns to the previous screen without downloading it.

REFERENCE

If you enter values on the **Apply Shrinkage** screen and the **Adjust All** screen, and then overwrite the JOB, the screens on the right appears.

If you save the settings in the JOB displayed, click **Yes**. If not, click **No**.

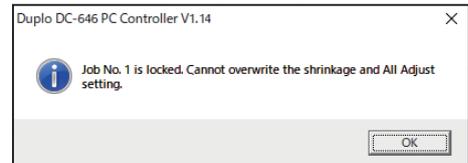
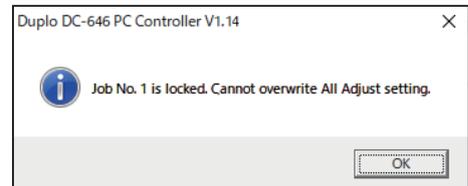
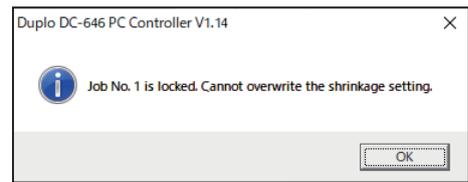


REFERENCE

If you enter values on the **Apply Shrinkage** screen and the **Adjust All** screen, and then overwrite the locked JOB, **Job No.** is locked. Cannot overwrite the shrinkage setting.** or **Job No.** is locked. Cannot overwrite All Adjust setting.** appears.

Click **OK**.

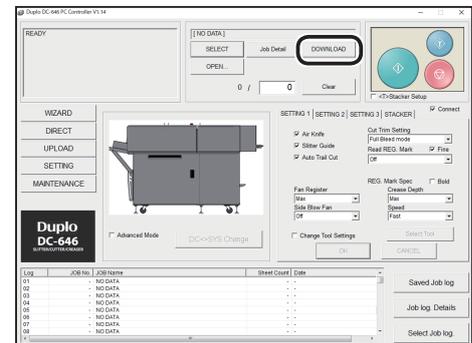
If you correct the locked JOB, unlock the locked JOB first.



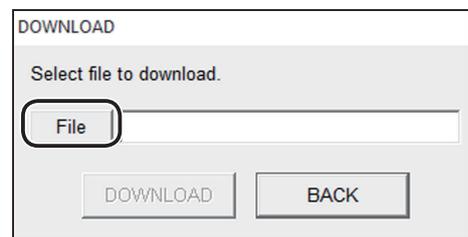
DOWNLOAD

This section describes the procedure of **DOWNLOAD**, saving JOBS saved on the computer in the DC-646.

- 1 Select the **Connect** check box to connect the line. Click **DOWNLOAD**.



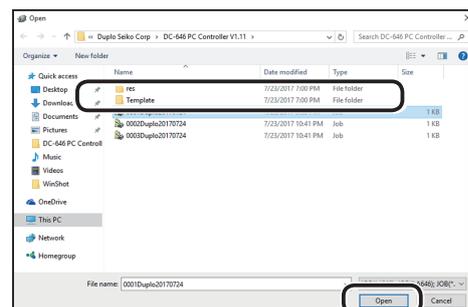
- 2 Click **File**.



- 3 Select the file to be saved in the DC-646 and click **Open**.

REFERENCE

- Extension of the file saving one JOB: **.Jm646**
- Extension of the file saving all JOBS: **.Am646**



PC Controller Setting

- 4 Check whether the JOB file to be saved in the DC-646 is selected. Then click **DOWNLOAD**.

REFERENCE

When sending one JOB (with extension: **.Jm646**), if that JOB number already exists in the DC-646 memory, then a screen confirming whether to overwrite the existing JOB with this JOB appears.



IMPORTANT

If the file extension is **.Am646**, the maximum JOBS that can be saved in the DC-646 are all saved.

When saving a file with **.Am646** in the DC-646, all JOBS saved in the DC-646 at that time are overwritten.

The dialog appears, confirming whether to overwrite all JOBS when sending the data.

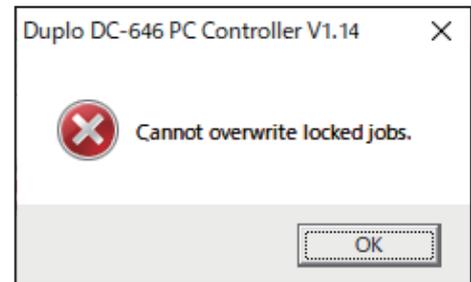
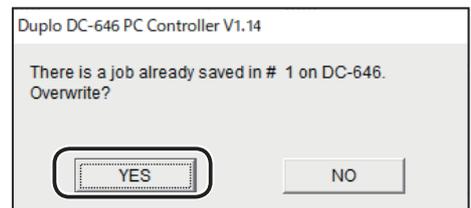
- 5 To overwrite the data, click **YES**.

REFERENCE

If you download the data to the locked JOB, the message as shown on the right appears.

To overwrite the locked JOB, unlock the locked JOB first.

(→P.98 Unlocking a JOB)



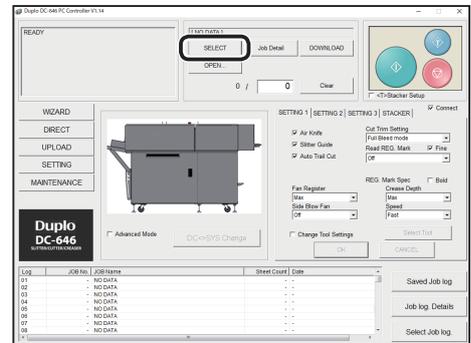
- 6 Click **OK**.



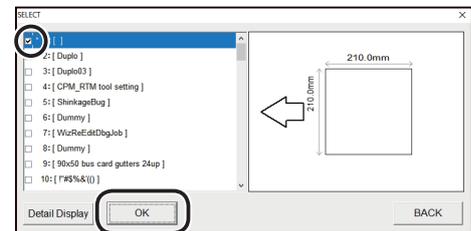
SELECT

This section describes the procedure of **SELECT**, retrieving a JOB for the DC-646 from the computer and processing it.

1 Click **SELECT**.



2 After uploading the JOB data from the DC-646, JOB numbers and JOB names are displayed. Click the **JOB No.** box that you want to process, then click **OK**.

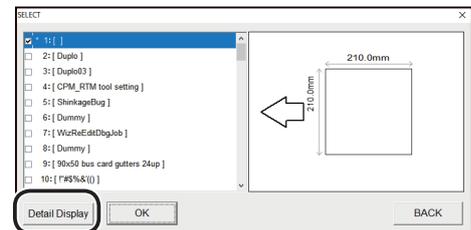


Clicking **BACK** returns to the previous screen without selecting a JOB.

- Editing the JOB data
 1. The JOB details are displayed by clicking **Detail Display**.

REFERENCE

* is displayed in front of the JOB name of locked JOB. (→P.97 Locking a JOB)



2. If you change the settings, you can re-enter a correction value on this screen.

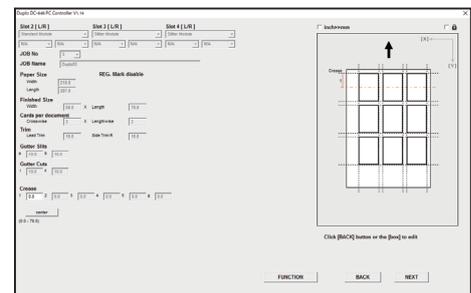
Click **NEXT**.

Clicking **FUNCTION** displays the contents of the function settings for the JOB.

REFERENCE

If you have programmed the JOB in the **DIRECT mode**, the JOB data is displayed on the **DIRECT** screen.

If you re-enter the data, which was programmed in the **WIZARD** mode, on the **DIRECT** screen, it is also displayed on the **DIRECT** screen.



4

PC Controller Setting

- The JOB details appears on the **DIRECT** screen. Clicking **BACK** returns to the screen of JOB data list.

Clicking **FUNCTION** displays the function settings of the JOB.

To save the corrected JOB on the computer, click **SAVE** and then specify a file name and location to save.

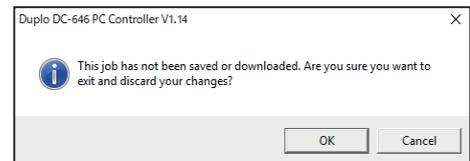
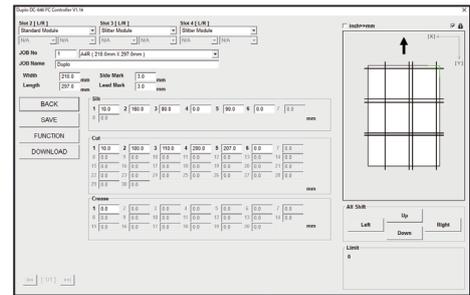
To save the corrected JOB in the DC-646, click **DOWNLOAD**.

REFERENCE

The message as shown on the right appears if the settings (values, functions) are changed and not saved or downloaded.

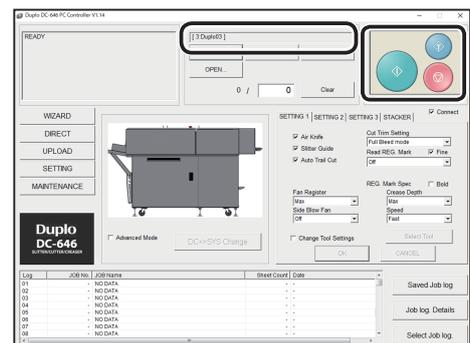
To return to the menu screen without saving or downloading the data, click **OK**.

To save or download it, click **Cancel**.



- The screen in step 2 appears. Click **OK**.

- The selected JOB number and JOB name are displayed in the upper part of the main menu screen. Click **Start** or **Test**. The selected JOB is processed.

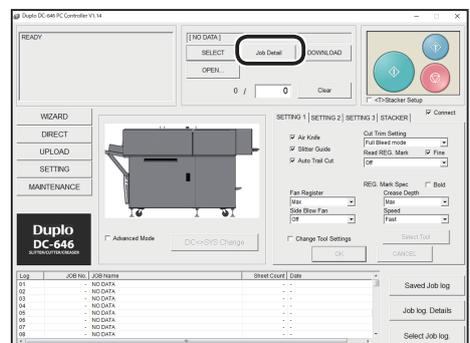


JOB Detail

- Click **Job Detail**.

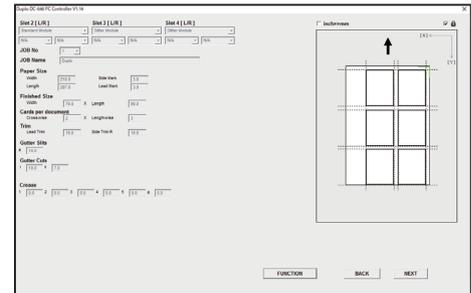
If you have programmed the JOB in the **WIZARD mode**, proceed to step 2.

If you have programmed the JOB in the **DIRECT mode**, proceed to step 3.



2 The details of the JOB which is displayed in the upper part of the main menu screen is displayed. If you have programmed the JOB in the **WIZARD mode**, the JOB data are displayed on the **WIZARD** screen.

- Clicking **BACK** enables you to edit the items from the last entering area to the first entering area. Right-click the field to enter a correction value.
- Clicking **FUNCTION** displays the functions of the JOB.



When editing is completed, click **NEXT**.

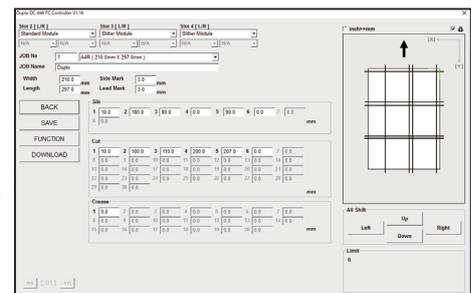
REFERENCE

If you click **SETTING** and select the **Enable re-editing Wizard JOB data** check box on the **DEFAULT** tab, the JOB data is displayed on the **WIZARD** screen.

If you have programmed a JOB in the **DIRECT mode**, the JOB data is displayed on the **DIRECT** screen. If you re-enter the data, which was programmed in the **WIZARD mode**, on the **DIRECT** screen, it is also displayed on the **DIRECT** screen.

3 The details of the JOB is displayed on the **DIRECT** screen.

- Clicking **BACK** returns to the previous screen.
- Clicking **FUNCTION** displays the function settings for the JOB.
(→ P.99 to P.110, steps 21 to 25 of WIZARD)
- Clicking **DOWNLOAD** saves the corrected JOB data in the DC-646.
(→ P.110, step 25 of WIZARD)
- To save the corrected JOB on the computer, click **SAVE** and then specify a file name and location to save. (→ P.110, step 25 of WIZARD)

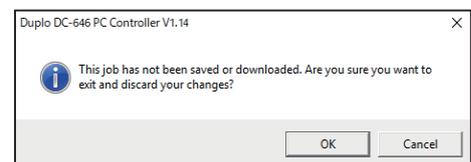


REFERENCE

The message as shown on the right appears when the settings (values, functions) are changed and not saved or downloaded.

To return to the menu screen without saving or downloading the data, click **OK**.

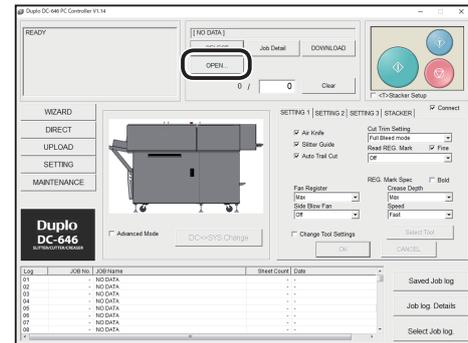
To save or download it, click **Cancel**.



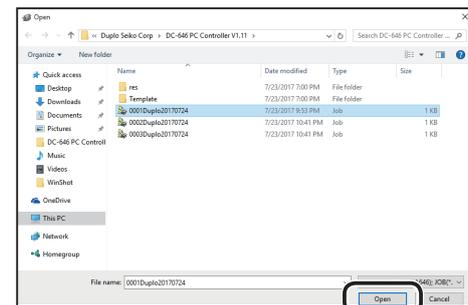
PC Controller Setting

OPEN

- 1 Click **OPEN**.

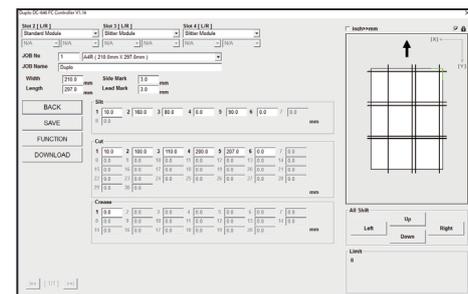


- 2 A list of JOB files programmed on the PC Controller are displayed. Select a file and click **Open**.



- 3 Click the text box of the item to be corrected and re-enter a correction value.

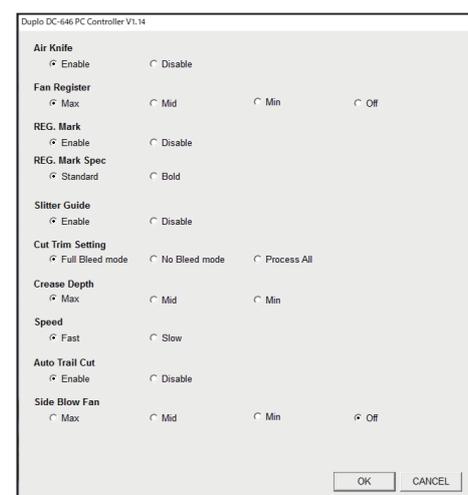
- Clicking **BACK** returns to step 1.
- Clicking **SAVE** saves the JOB data as a file in the computer.



- Clicking **FUNCTION** displays the function settings for the JOB. To change the settings, click the radio key that you want to select.

Clicking **OK** saves the setting and returns to the previous screen.

Clicking **CANCEL** returns to the previous screen without changing them.



- Clicking **DOWNLOAD** saves the JOB data in the DC-646.
 1. Click **YES**.
Clicking **NO** returns to the previous screen without saving it.

REFERENCE

To save the JOB temporarily, check the **Temporary job** box.
When the DC-646 is turned **OFF** or another JOB is retrieved, the temporarily saved JOB is deleted.

2. To overwrite the locked JOB, click **YES**.
Clicking **NO** returns to the previous screen without downloading it.

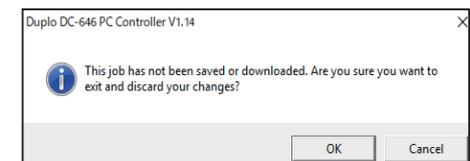
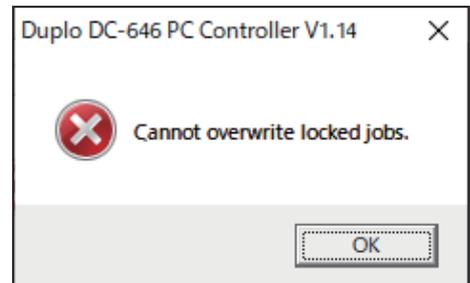
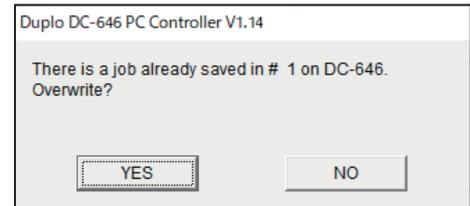
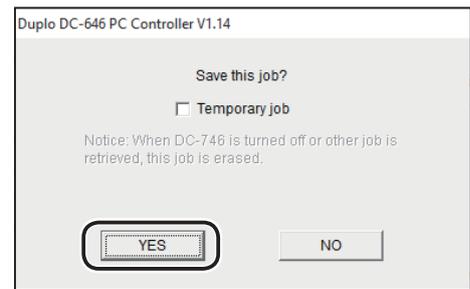
REFERENCE

If you download the data to the locked JOB, the message as shown on the right appears.
To overwrite the locked JOB, unlock the locked JOB first.
(→P.98 Unlocking a JOB)

3. Download is completed.
Click **OK**.

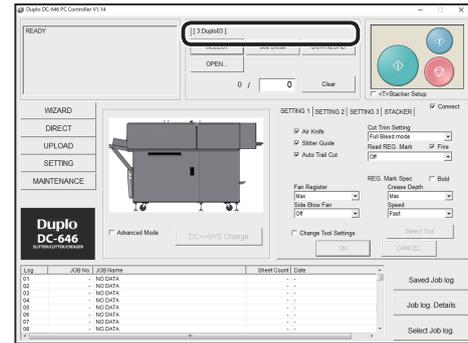
REFERENCE

- If you have programmed the JOB in the **DIRECT mode**, the JOB data is displayed on the **DIRECT** screen.
If you re-enter the data, which was programmed in the **WIZARD mode**, on the **DIRECT** screen, it is also displayed on the **DIRECT** screen.
- The message as shown on the right appears when the settings (values, functions) are changed and not saved or downloaded.
To return to the menu screen without saving or downloading the data, click **OK**.
To save or download it, click **Cancel**.



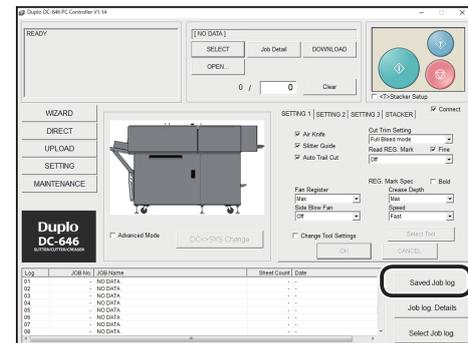
PC Controller Setting

- 4 The selected JOB number and JOB name are displayed in the upper part of the main menu screen. Click the START key or TEST key to start the JOB.

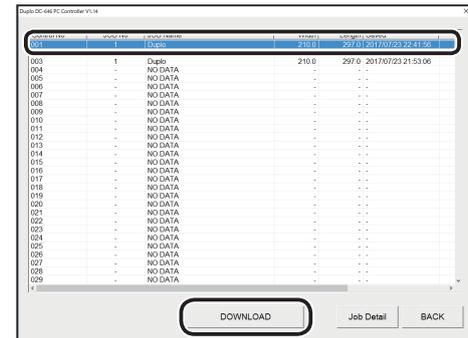


Saved JOB Log

- 1 Click **Saved Job log**.

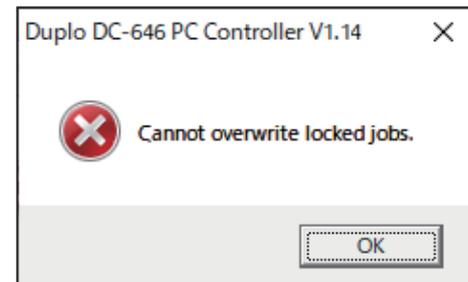


- 2 The list of saved JOB log is displayed. Up to 999 JOBS are logged in the list. Click the file that you want to save in the DC-646. Click **DOWNLOAD**.



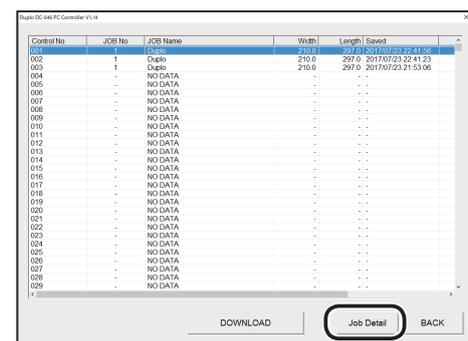
REFERENCE

- If you download the data to the locked JOB, the message on the right appears. To overwrite the locked JOB, unlock the locked JOB first. (→P.98 Unlocking a JOB)



REFERENCE

- You can also retrieve a JOB after confirming the settings.
 - Select a JOB from the list of **saved JOB log** and click **Job Detail**.



- To change the details, click the text box of the item and re-enter a value.
Click **NEXT**.

Clicking **FUNCTION** displays the function settings of the JOB.

REFERENCE

If you have programmed the JOB in the **DIRECT** mode, the JOB data is displayed on the **DIRECT** screen. If you re-enter the data, which was programmed in the **WIZARD mode**, on the **DIRECT** screen, it is also displayed on the **DIRECT** screen.

- The JOB details appears on the **DIRECT** screen. Clicking **BACK** returns to the screen of JOB data list.

Clicking **FUNCTION** displays the function settings of the JOB.

To save the corrected JOB on the computer, click **SAVE** and then specify a file name and location to save.

To save the corrected JOB in the DC-646, click **DOWNLOAD**.

- Click **YES**.
The JOB is saved and the previous screen appears.
To save the JOB data temporarily, select the **Temporary job** check box.

REFERENCE

If the DC-646 is turned OFF or another JOB is retrieved, the temporarily saved JOB is deleted.

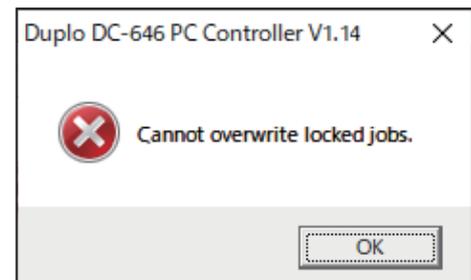
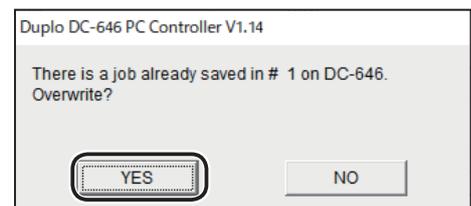
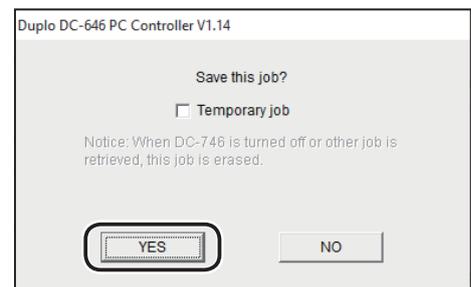
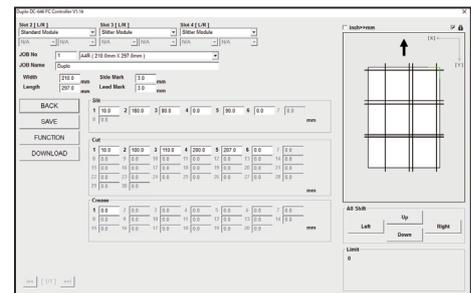
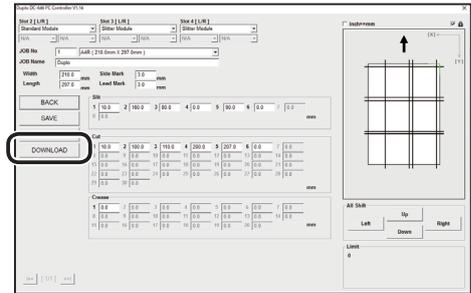
- To overwrite the data, click **YES**.

Clicking **NO** returns to the previous screen.

REFERENCE

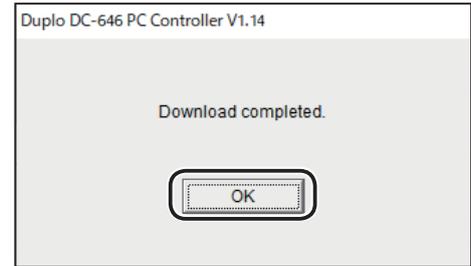
If you download the data to the locked JOB, the message on the right appears.
To overwrite the locked JOB, unlock the locked JOB first.

(→P.98 Unlocking a JOB)

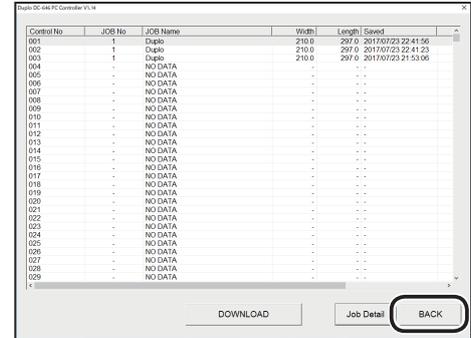


PC Controller Setting

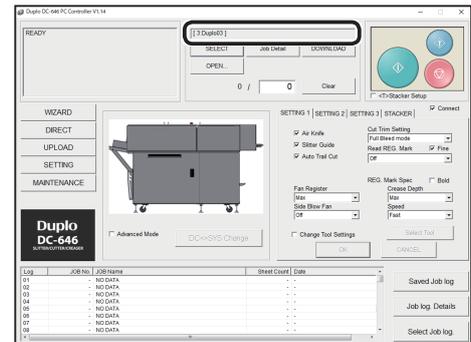
4 Click **OK**.



5 Click **BACK**.



6 The selected JOB number and JOB name are displayed in the upper part of the main menu screen. Click the **START** key or **TEST** key to start the JOB.



JOB Log. Details

The processed JOBS are saved as JOB log in the DC-646.

Up to latest 50 processed JOBS are saved.

If the number of saved JOBS exceeds 50, they are deleted in chronological order.

1 The JOB logs are displayed in the lower part of the main menu screen. Select a JOB and click **JOB log. Details**.

REFERENCE

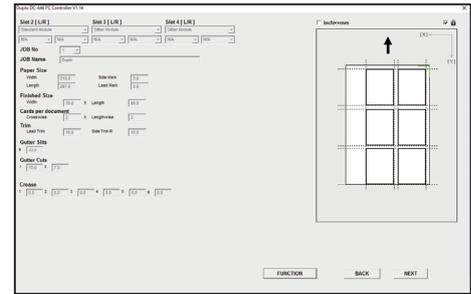
Clicking **Log**, **JOB No.**, **JOB Name**, **Sheet count** and **Date** changes the sorting order of the JOB log between ascending and descending.



2 If you have programmed the JOB in the **WIZARD mode**, the JOB data are displayed on the **WIZARD** screen.

- Clicking **BACK** enables you to edit the items from the last entering area to the first entering area. Right-click the field to enter a correction value.
- Clicking **FUNCTION** displays the functions of the JOB.

When editing is completed, click **NEXT**.



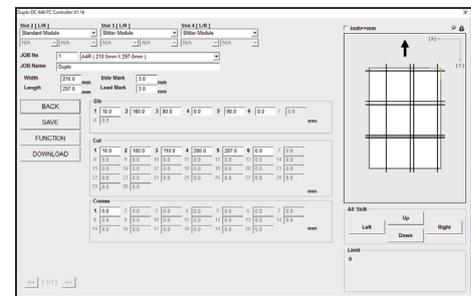
REFERENCE

If you click **SETTING** and select the **Enable re-editing Wizard JOB data** check box on the **DEFAULT** tab, the JOB data is displayed on the **WIZARD** screen.

If you have programmed a JOB in the **DIRECT mode**, the JOB data is displayed on the **DIRECT** screen. If you re-enter the data, which was programmed in the **WIZARD mode**, on the **DIRECT** screen, it is also displayed on the **DIRECT** screen.

3 The details of the JOB appears on the **DIRECT** screen. Check the details and click **DOWNLOAD**.

- To save the corrected JOB on the computer, click **SAVE** and then specify a file name and location to save.
- Clicking **FUNCTION** displays the function settings of the JOB
- Clicking **BACK** returns to the previous screen.
- Clicking **DOWNLOAD** saves the corrected JOB in the DC-646.

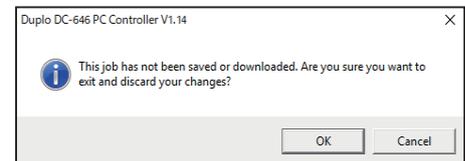


REFERENCE

The message as shown on the right appears when the settings (values, functions) are changed and not saved or downloaded.

To return to the menu screen without saving or downloading the data, click **OK**.

To save or download it, click **Cancel**.

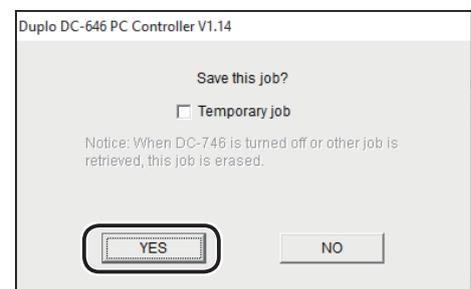


4 If a JOB of the same number is already saved, the message as shown on the right appears. If you download the data temporarily, click **YES**. Clicking **NO** cancels saving the data, and return to the previous screen.

REFERENCE

To save the JOB temporarily, select the **Temporary job** check box.

If the JOB data is temporarily saved, it is deleted when the DC-646 is turned **OFF** or another JOB is selected.

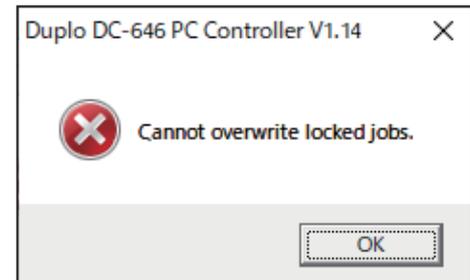
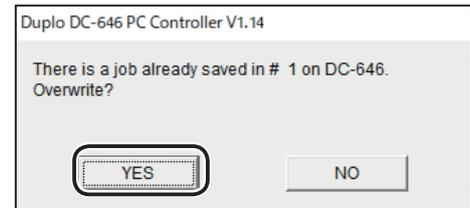


PC Controller Setting

- 5 To overwrite the data, click **YES**.

REFERENCE

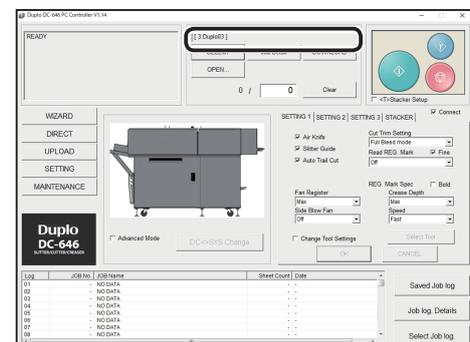
If you download the data to the locked JOB, the message as shown on the right appears.
To overwrite the locked JOB, unlock the locked JOB first.
(→P.98 Unlocking a JOB)



- 6 Click **OK**.

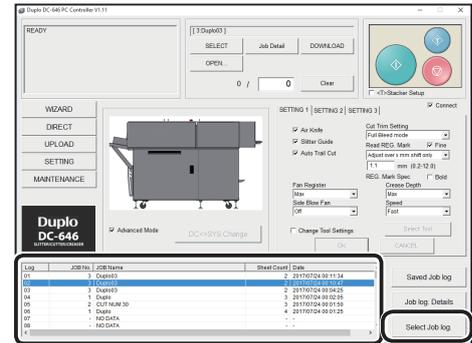


- 7 The selected JOB number and JOB name are displayed in the upper part of the main menu screen. Click the **START** key or **TEST** key to start the JOB.

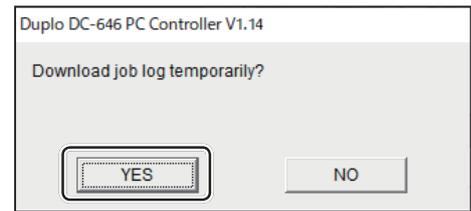


Select JOB Log

- The JOB logs are displayed in the lower part of the main menu screen. Click the JOB log that you want to retrieve, then click **Job log. Details**. The JOB is temporarily downloaded.



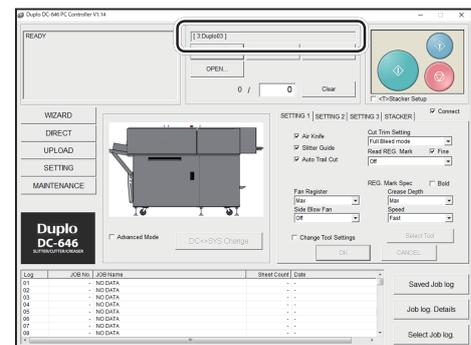
1. Click **YES**.



2. Click **OK**.

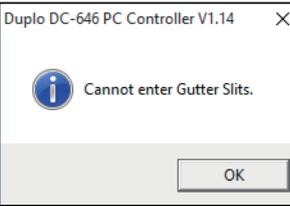
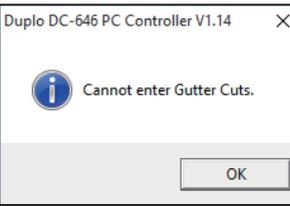
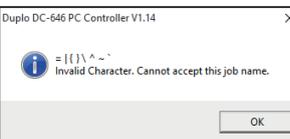
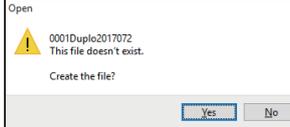


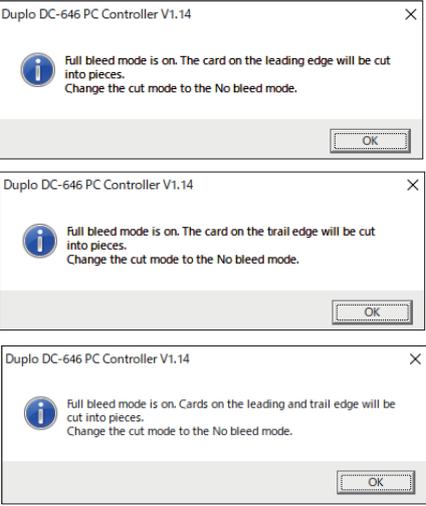
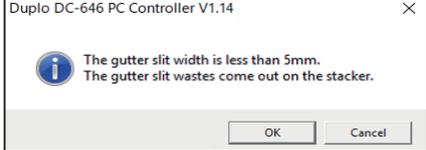
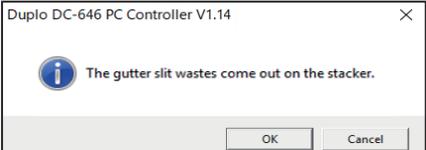
- The selected JOB number and JOB name are displayed in the upper part of the main menu screen. Click the **START** key or **TEST** key to start the JOB.



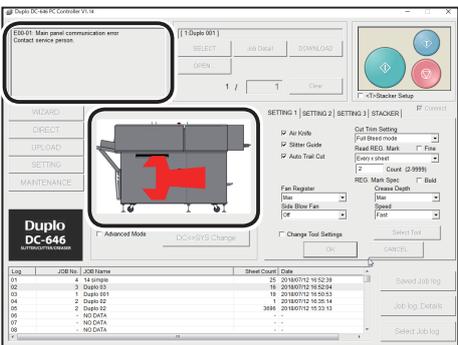
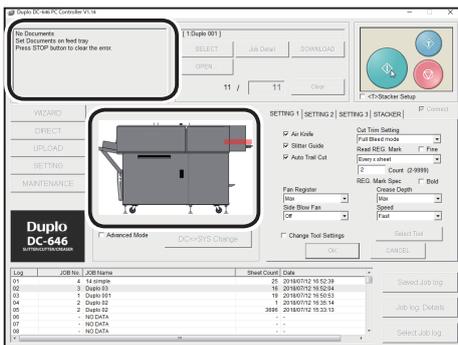
4

Messages

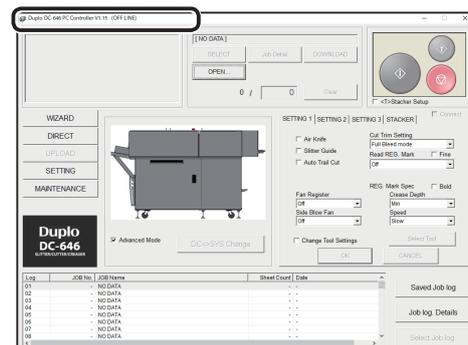
Display	Countermeasure
	<p>Cannot enter Gutter Slits because the number of Cards per document in the horizontal direction (Crosswise) is either one or more than the limit of the setting.</p>
	<p>Cannot enter Gutter Cuts because the number of Cards per document in a vertical direction (Lengthwise) is either one or more than the limit of the setting.</p>
	<p>The JOB name contains a character that cannot be used.</p>
	<p>Communication Error (001-***) The PC Controller cannot recognize the DC-646. Check the following.</p> <ol style="list-style-type: none"> 1. Is the USB cable securely connecting the computer and the DC-646? 2. Is the DC-646 turned ON? 3. (Windows) Is USB DC-646 Ver*. * saved as a USB controller in the Device Manager] dialog? 4. Is the USB cable 3 meters or shorter? <p>Communication Error (002, 003, 004) 1. Restart the DC-646 and the computer. 2. Is the USB cable 3 meters or shorter?</p>
	<p>The DC-646 is in operation.</p> <ol style="list-style-type: none"> 1. Either wait for the JOB to quit or press the STOP key on the DC-646 to abort the JOB. 2. The DC-646 is not ready to operate. End function setting, entry, and JOB select mode and proceed to the operation mode (regular state). 3. An error has occurred on the DC-646. Check the message displayed on the LCD panel and clear the error according to the Troubleshooting Instructions described in Chapter 5 in this manual.
	<p>The entered file name is not found. Enter a correct name.</p>

Display	Status and Solution
	<p>When a JOB (no lead margin or no trail margin, two or more cuts) is processed with the Cut Trim Setting set to Full bleed mode, the first row of cards or the last row of cards on the document will be cut into pieces. Then the Cut Trim Setting will be set to No bleed mode.</p>
	<p>The gutter slits are less than 5 mm. The gutter slits are output on the exit tray on this JOB.</p>
	<p>The gutter slits are output on the exit tray on this JOB.</p>
	<p>The gutter slits are output on the exit tray on this JOB. Pressing OK continues the processing. The screen appears when a stored JOB in the DC-646 is retrieved and then the START key is clicked.</p>

Messages on the System Status 1/2 Display

Display	Countermeasure
	<p>Service person call messages:</p> <ul style="list-style-type: none"> • Main-panel communication error • CCD error • Elevator error • Crease lower error • Memory read error • Memory write error • I/O Communication error • Cooling fan lock error • Main-slitter communication error <p>Solution: Turn OFF the DC-646 and turn it ON again. If the same message appeared again, write down the message and contact our service person.</p>
	<p>Other error messages:</p> <p>An error message appears on the System Status 1 display. The error occurred area flashes on and off on the System Status 2 display.</p> <p>Solution: The solution appears on the System Status 1 display. Resolve the error according to the instructions.</p>

- When the title bar is **OFF LINE**.
The PC Controller cannot communicate with the DC-646.
Check the followings:
 - Is the DC-646 turned **ON**?
 - Is the DC-646 connected to the computer with the USB cable properly?



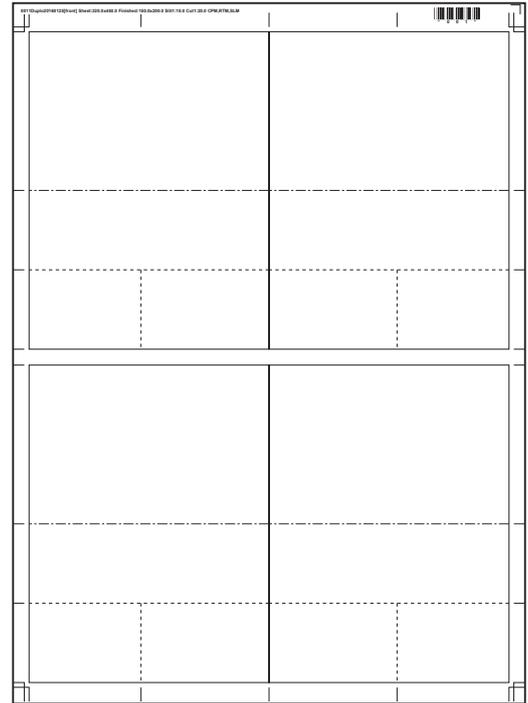
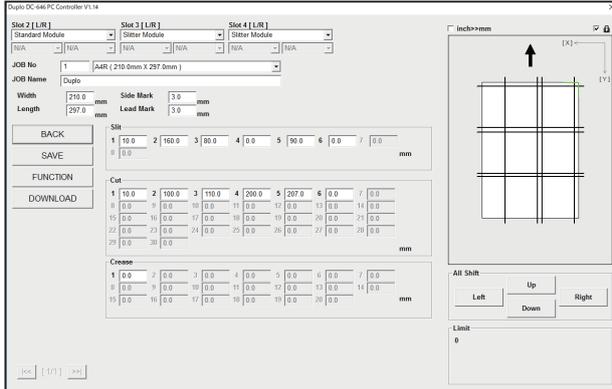
PDF Template

How to Create a PDF Template

- PDF Template

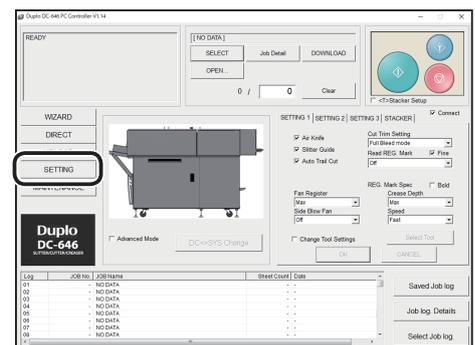
When saving a JOB programmed by using the PC Controller, you can programme a PDF template.

(→P.155 How to Use Template)



The layout created on the JOB can be saved in PDF.

1. Click **SETTING**.



PDF Template

- Click the **DEFAULT** tab.
Set each default setting.

OTHER/SETTING

DEFAULT | OPTION MODULE | SYSTEM

Paper Size (User Size)

User Size 1: 0.0 x 0.0 mm
 User Size 2: 0.0 x 0.0 mm
 User Size 3: 0.0 x 0.0 mm
 User Size 4: 0.0 x 0.0 mm
 User Size 5: 0.0 x 0.0 mm

W: (0or210-370) x L: (0or210-670)

Standard Size: None

Custom Size (Default):
 W: 210.0 mm x L: 210.0 mm
 (210.0-370.0) (210.0-670.0)

REG. Mark (Default):
 S: 0.0 mm L: 0.0 mm
 (0 or 3.0-15.0) (0 or 3.0-15.0)

REG. Mark Spec:
 Standard Bold

Enable re-editing Wizard JOB data
 PDF Template creator
 XML file creator

Air Knife: Enable
 Fan Register: Max
 Slitter Guide: Enable
 Cut Trim Setting: Full Bleed mode
 Crease Depth: Max
 Speed: Fast
 Auto Trail Cut: Enable
 Side Blow Fan: Off

OK CANCEL

- If you select the **PDF Template creator** check box, the JOB programmed can be saved as a PDF template.

OTHER/SETTING

DEFAULT | OPTION MODULE | SYSTEM

Paper Size (User Size)

User Size 1: 0.0 x 0.0 mm
 User Size 2: 0.0 x 0.0 mm
 User Size 3: 0.0 x 0.0 mm
 User Size 4: 0.0 x 0.0 mm
 User Size 5: 0.0 x 0.0 mm

W: (0or210-370) x L: (0or210-670)

Standard Size: None

Custom Size (Default):
 W: 210.0 mm x L: 210.0 mm
 (210.0-370.0) (210.0-670.0)

REG. Mark (Default):
 S: 0.0 mm L: 0.0 mm
 (0 or 3.0-15.0) (0 or 3.0-15.0)

REG. Mark Spec:
 Standard Bold

Enable re-editing Wizard JOB data
 PDF Template creator
 XML file creator

Air Knife: Enable
 Fan Register: Max
 Slitter Guide: Enable
 Cut Trim Setting: Full Bleed mode
 Crease Depth: Max
 Speed: Fast
 Auto Trail Cut: Enable
 Side Blow Fan: Off

OK CANCEL

- Program a JOB and click **SAVE**.

Alupio DC-647PC Controller v1.14

Job 1 (JOB) Slitter Module Job 4 (JOB) Slitter Module

JOB No: 1 Job Name: [Auto] (210.0mm x 210.0mm)

Width: 210.0 mm Side Mark: 1.0 mm
 Length: 210.0 mm Lead Mark: 1.0 mm

SAVE

PURCHASE DOWNLOAD

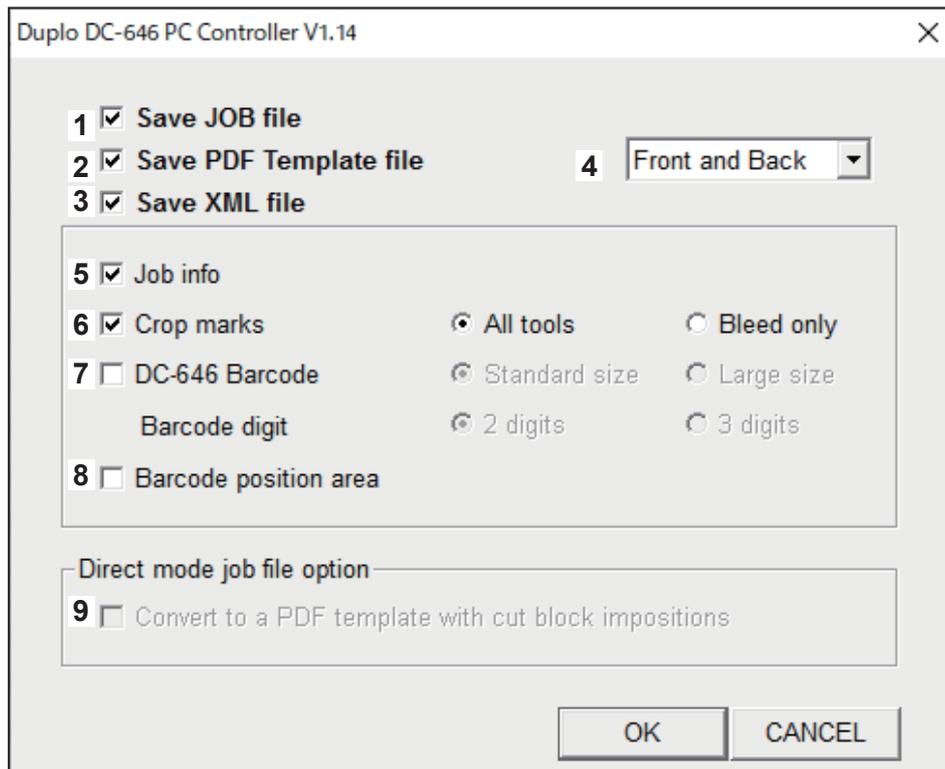
Cut:
 1 [10.0] 2 [100.0] 3 [110.0] 4 [200.0] 5 [207.0] 6 [0.0] / [0.0]
 7 [0.0] 8 [0.0] 9 [0.0] 10 [0.0] 11 [0.0] 12 [0.0] 13 [0.0] 14 [0.0]
 15 [0.0] 16 [0.0] 17 [0.0] 18 [0.0] 19 [0.0] 20 [0.0] 21 [0.0] 22 [0.0]

Crease:
 1 [0.0] 2 [0.0] 3 [0.0] 4 [0.0] 5 [0.0] 6 [0.0] / [0.0]
 8 [0.0] 9 [0.0] 10 [0.0] 11 [0.0] 12 [0.0] 13 [0.0] 14 [0.0]

Incision: [Diagram showing a grid with a vertical line and an arrow pointing up]

All Shift: Left Up Right Down

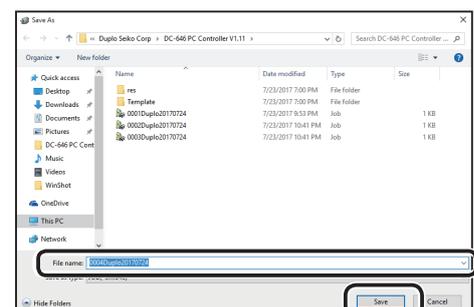
Link: 6

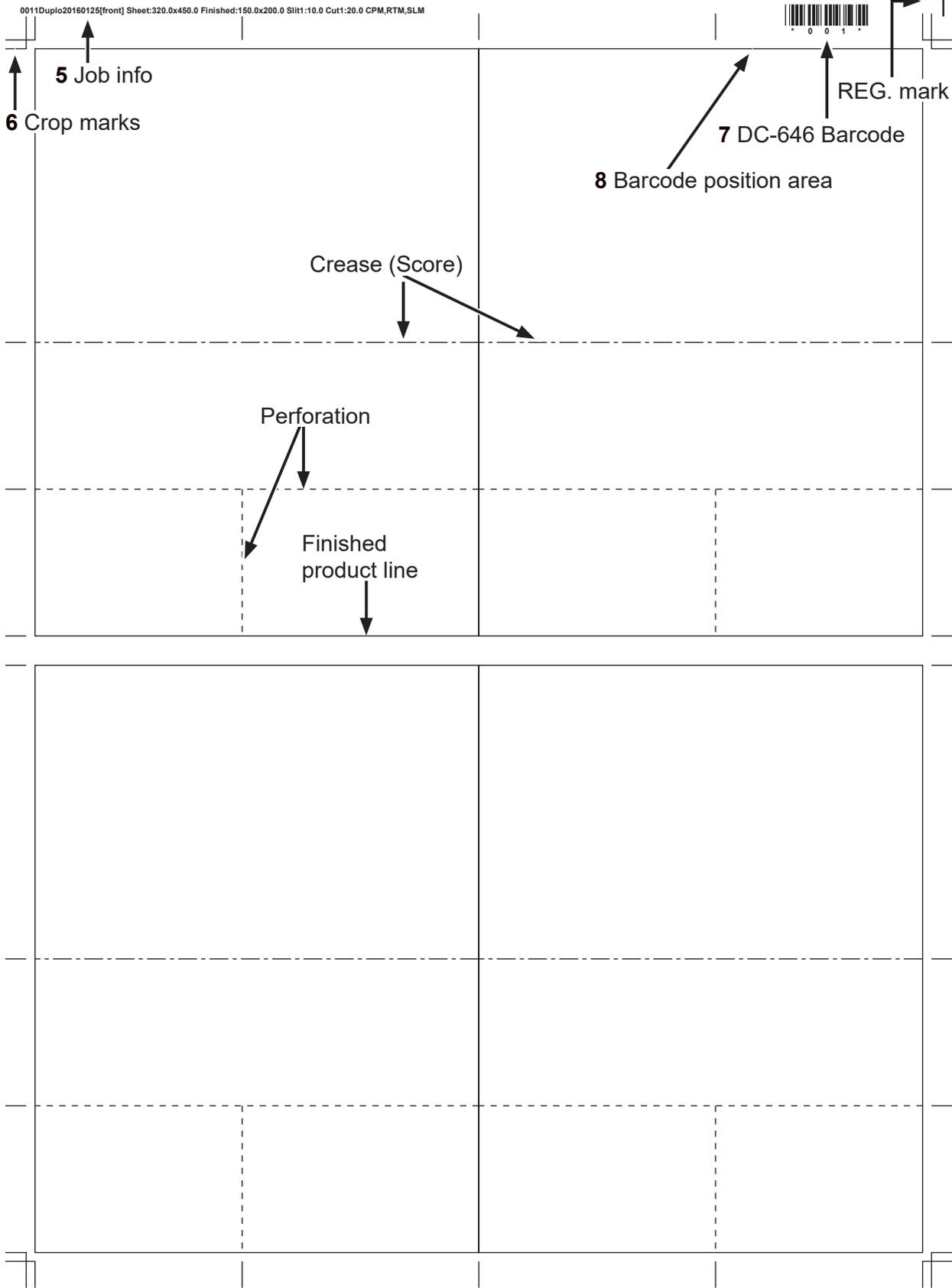


4

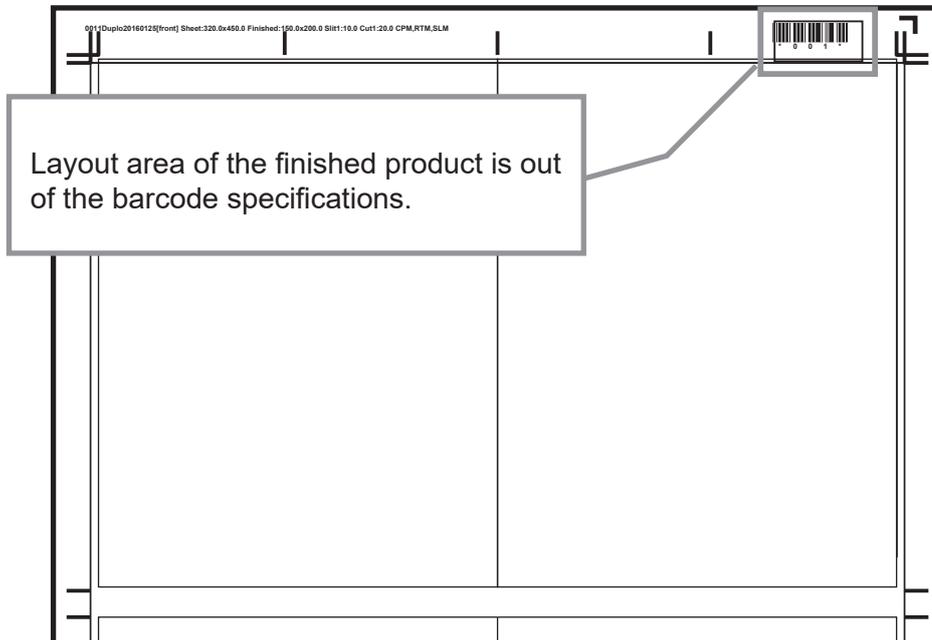
Number	Item	Function
1	Save JOB file	Saves JOB data on the computer.
2	Save PDF Template file	Converts JOB data to PDF and saves as a template.
3	Save XML file	Converts JOB data to an XML file and saves it.
4	PDF page	Select Front page only , Back page only , or Front and Back .
5	Job info	Allocates a JOB name on a PDF template.
6	Crop marks	Creates crop marks on a PDF template. All tools : Creates crop marks and tool marks. Bleed only : Creates crop marks only.
7	DC-646 Barcode	Creates barcode on a PDF template. Standard size : Creates standard size barcode. Large size : Creates barcode that is 1.5 times the size of standard. You can also select 2 digits or 3 digits from Barcode digit . (Contact our service person.)
8	Barcode position area	Users can paste their own barcode on a PDF template.
9	Convert to a PDF template with cut block impositions	Converts the JOB programmed in the DIRECT mode to a PDF template with cut block impositions in the same size as created in the WIZARD mode , and saves it.

3 Specify a file in which to save the JOB and click **Save**.





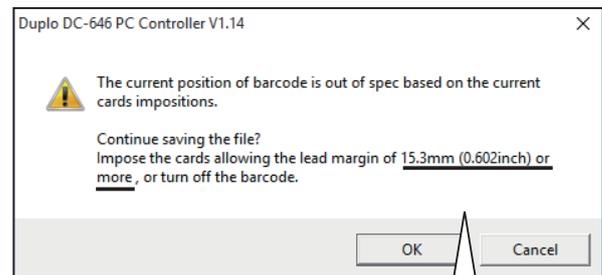
- Notes on creating a PDF template
Messages appears for the following case.
- If a barcode is out of the specifications.



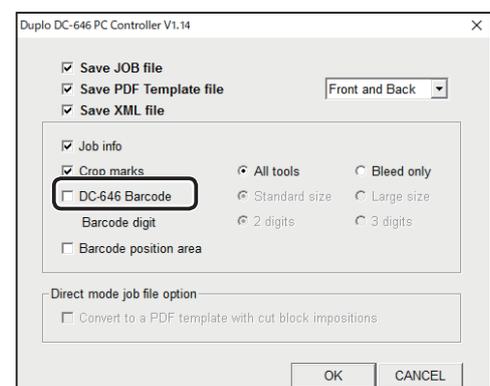
Imposed positions of the finished product differ depending on the barcode size. If the imposed positions are out of the specifications, the alert screen as shown on the right appears. Clicking **OK** saves barcode position as being out of the specifications. Clicking **Cancel** cancels saving PDF file and **JOB entering screen** reappears.

Re-enter a larger value than the one displayed on the message for the **first cut** on the **JOB entering screen** in the **DIRECT mode**.

Alternatively, clear the **DC-646 Barcode** check box on the screen of the right that appears when clicking **SAVE**.



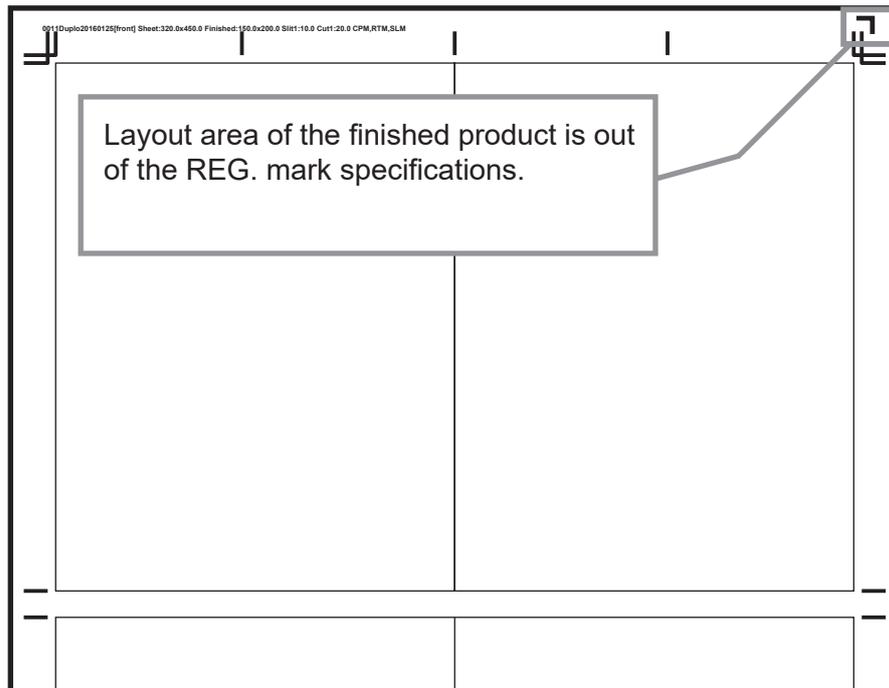
The value displayed here of the lead margin differs depending on barcode size.



4

PDF Template

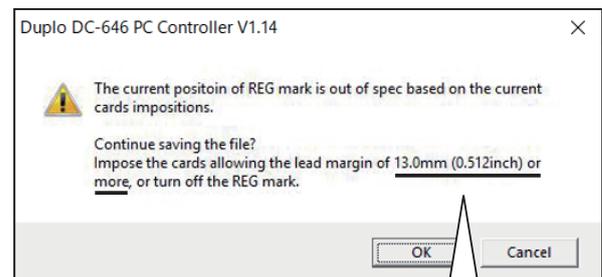
- If a REG mark is out of the specifications.



As shown in the figure above, if the layout area of the finished product is out of the REG mark specifications, the message as shown on the right appears.

Clicking **OK** saves REG mark position as being out of the specifications.

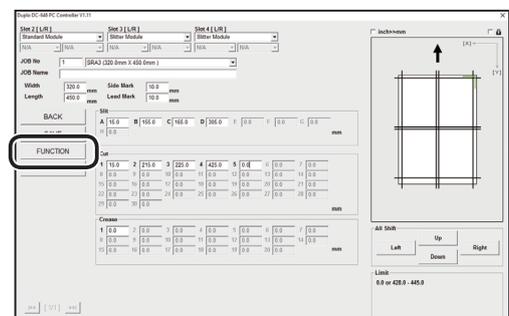
Clicking **Cancel** cancels saving a PDF file and **JOB entering** screen reappears.



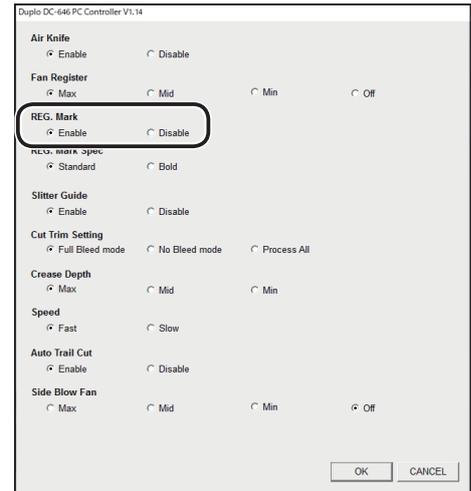
Re-enter a larger value than the one displayed on the message for the **first cut** on the **JOB entering screen** in the **DIRECT mode**.

The value displayed here of the lead margin differs depending on REG. mark position.

Alternatively, click **FUNCTION** on the **DIRECT** screen.

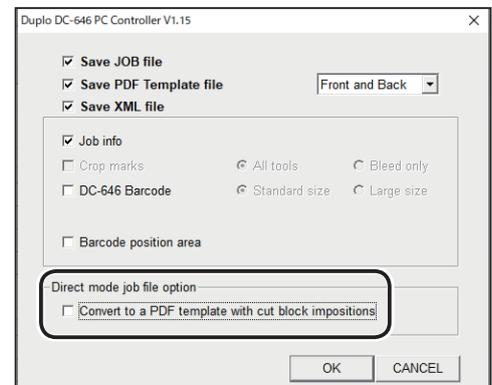


Select **Disable** under **REG. Mark**.



- Converting to a PDF template with cut block impositions

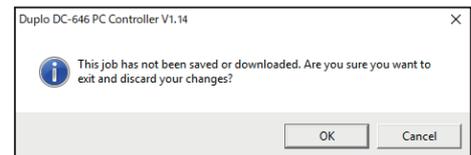
If you select the **Convert to a PDF template with cut block impositions** check box when saving the JOB in the **DIRECT mode**, the JOB can be converted to a PDF template with cut block impositions as programmed in the **WIZARD mode**, and can be saved. Finished products of the same size are converted to a PDF template.



If the JOB cannot be converted to a template with cut block impositions because there is no finished product of the same size, the message as shown on the right appears.

If you click **YES**, a PDF template with all the cut/crease lines is saved.

If you click **NO**, the **DIRECT** screen reappears.



How to Use Template

A template is a collection of JOB samples that the DC-646 can process. You can carry out the JOB that you select.

- 1 If you install the PC Controller, a shortcut of **DC-646Job Template** is automatically created on the desk top. Double-click the shortcut.



PDF Template

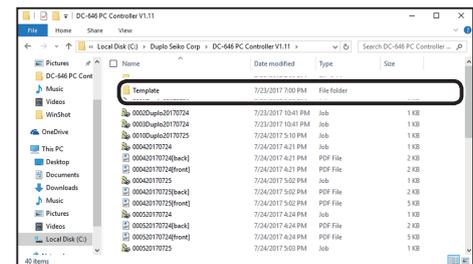
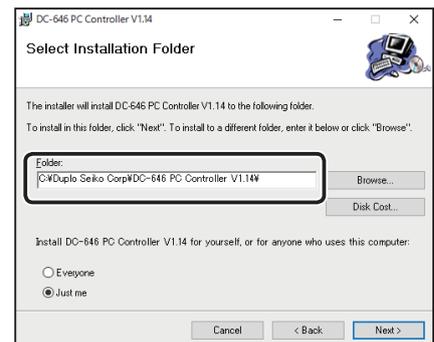
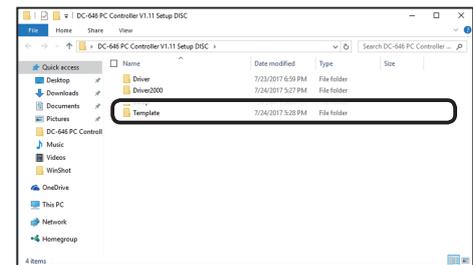
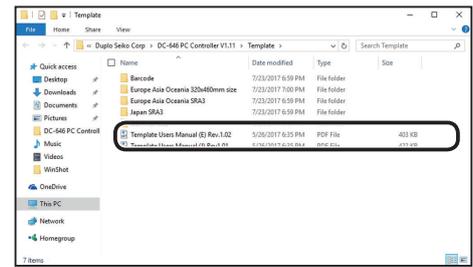
2 Details of the Template are described in the **Template Users Manual**.

Double-clicking **Template Users Manual (E) Rev.*.**** opens the PDF of **Template Users Manual**.

REFERENCE

Templates are also located in the other two locations than the one described on the above. You can use a template in either locations among those.

1. They are in the CD-ROM (that comes with the DC-646) used when the PC Controller and the driver are installed.
2. They are in the folder in which the PC Controller is installed.



Chapter 5

Troubleshooting

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

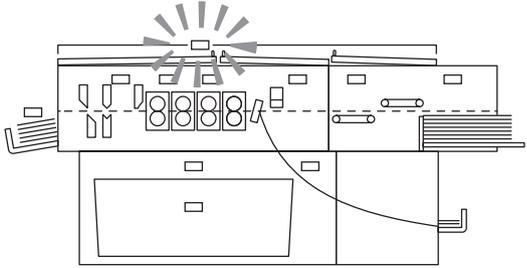
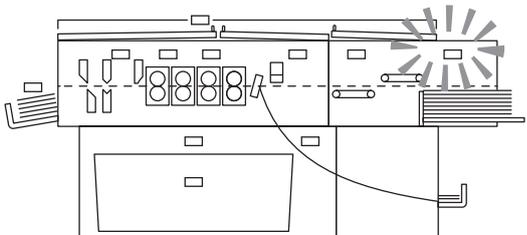
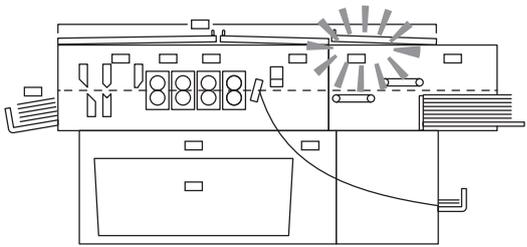
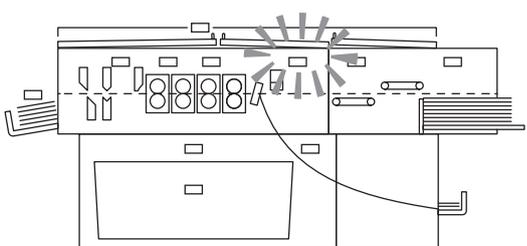
.....

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J9 WASTE BOX	187
J10 REJECT AREA	188
J11 WASTE BOX	191
J12 DOCUMENT LENGTH	192

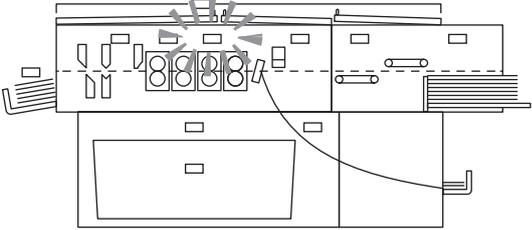
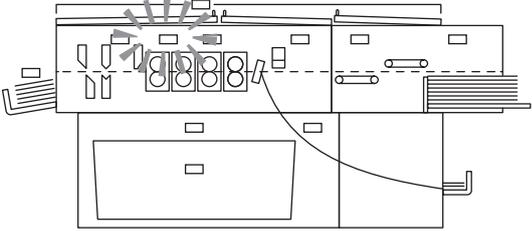
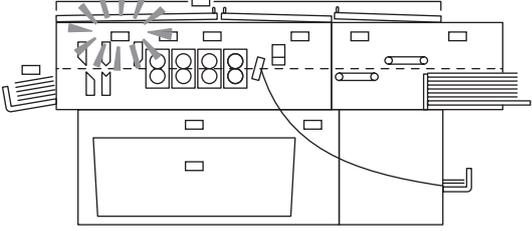
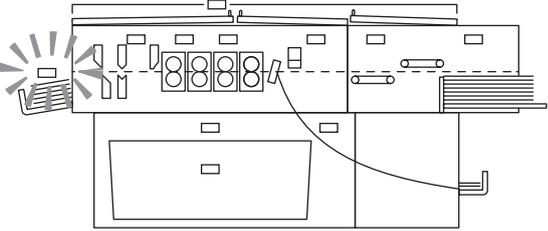
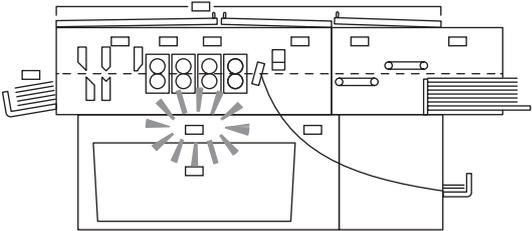
.....

If a Message Appears on the OK Monitor

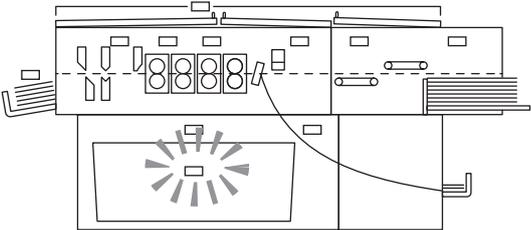
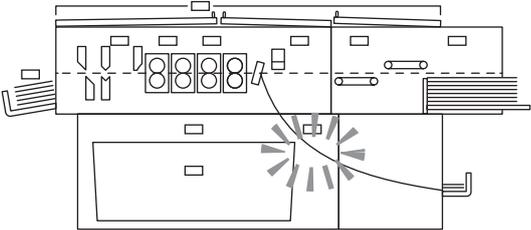
If a document jam or an error that the machine cannot correct has occurred, the **OK monitor** flashes where the error has occurred and messages appear on the LCD panel. Follow the procedure below to resolve the error.

Message	Countermeasure
	<ol style="list-style-type: none"> 1. The top cover 1, 2, 3, or the front cover 2 is open. 2. The emergency switch is pressed. <ol style="list-style-type: none"> 1. Close the top cover 1, 2, 3, or the front cover 2. (→P.xiii Interlock System for Safety) 2. Turning the switch to the right releases the emergency stop. (→P.xiv Emergency Stop Function)
	<p>There is no document on the feed tray.</p> <p>Load a document on the feed tray.</p>
	<ol style="list-style-type: none"> 1. A document remains in the skew adjustment area. 2. There is a document jam in the feed area or the feeding area. <ol style="list-style-type: none"> 1. Remove the document from the skew adjustment area. 2. Remove the document from the feed area or the feeding area and then press the STOP key. (→P.174 J3 FEED ERROR)
	<p>A document remains in the CCD area or there is a document jam in the CCD area.</p> <p>Remove the document from the CCD area and then press the STOP key. (→P.176 J4 CCD AREA)</p>

If a Message Appears on the OK Monitor

Message	Countermeasure
	<p>A document remains in slot 1 or slot 2. There is a document jam in slot 1 or slot 2.</p> <p>Remove the document from slot 1 or slot 2 and then press the STOP key. (→P.177 J5 MSM/SLOT2)</p>
	<p>A document remains in slot 3 or slot 4. There is a document jam in slot 3 or slot 4.</p> <p>Remove the document from slot 3 or slot 4 and then press the STOP key. (→P.180 J6 SLOT3/4)</p>
	<p>A document remains in the gutter area, cut or crease area. There is a document jam in the gutter area, cut or crease area.</p> <p>Remove the document from the gutter area, cut or crease area and then press the STOP key. (→P.182 J7 CUT, CREASE)</p>
	<p>A document remains in the document exit area. There is a document jam in the document exit area.</p> <p>Remove the document from the document exit area and then press the STOP key. (→P.185 J8 EXIT TRAY)</p>
	<p>A document remains in the margin cut area or the gutter area. There is a document jam in the margin cut area or the gutter area.</p> <p>Remove the document from the margin cut area or the gutter area and then press the STOP key. (→P.191 J11 WASTE BOX)</p>

If a Message Appears on the OK Monitor

Message	Countermeasure
	<ol style="list-style-type: none"> 1. Waste remains in the waste box. 2. The waste box has become full during processing a document. <ol style="list-style-type: none"> 1. Remove the waste from the waste box. 2. Remove the accumulated waste from the waste box and then press the STOP key. (→P.187 J9 WASTE BOX)
	<p>A document remains in the reject area. There is a document jam in the reject area.</p> <p>Remove the document from the reject area and then press the STOP key. (→P.188 J10 REJECT AREA)</p>

If a Message Appears

If an error has occurred, messages and figures appear on the LCD panel. In such a case, follow the procedure below to resolve the error.

Message	Status and Solution
<p>NO DOCUMENT</p> <p>Place document on feed tray  to clear</p>	<p>Status: There is no document on the feed tray. Solution: Load a document on the feed tray. (→P.11 Loading Documents)</p>
<p>J2-* FEED TRAY</p> <p>J2-*</p> <p>Feed tray overload  to clear</p>	<p>Status: Too many documents are loaded on the feed tray. Solution: The height of the document stack should not exceed the MAX level. (There is an indication on the right side of the feed tray.) Remove the documents and then press the STOP key.</p>
<p>J3-* FEED ERROR</p> <p>J3-*</p> <p>Remove document from feed area  to clear</p>	<p>Status: There is a document jam in the feed area or the feeding area. Solution: Remove the document from the feed area or the feeding area and then press the STOP key. (→P.174 J3 FEED ERROR)</p>
<p>J4-* CCD AREA</p> <p>J4-*</p> <p>Remove document from CCD area  to clear</p>	<p>Status: There is a document jam in the CCD area. Solution: Remove the document from the CCD area and then press the STOP key. (→P.176 J4 CCD AREA)</p>

If a Message Appears

Message	Status and Solution
<p data-bbox="151 271 453 353">J5-* MSM/SLOT2</p> <p data-bbox="151 488 453 674">J5-* Remove document from MSM/SLOT2 Ⓢ to clear</p>	<p data-bbox="486 271 1410 405">Status: There is a document jam in the margin slitter module or slot 2. Solution: Remove the document from the margin slitter module or slot 2 and then press the STOP key. (→P.177 J5 MSM/SLOT2)</p>
<p data-bbox="151 703 453 786">J6-* SLOT3/4</p> <p data-bbox="151 920 453 1106">J6-* Remove document from SLOT3/4 Ⓢ to clear</p>	<p data-bbox="486 703 1374 853">Status: There is a document jam in slot 3 or slot 4. Solution: Remove the document from slot 3 or slot 4 and then press the STOP key. (→P.180 J6 SLOT3/4)</p>
<p data-bbox="151 1135 453 1218">J7-* CUT.CREASE</p> <p data-bbox="151 1352 453 1538">J7-* Remove document from cut/crease area Ⓢ to clear</p>	<p data-bbox="486 1135 1394 1285">Status: There is a document jam in the cut or crease area. Solution: Remove the document from the cut or crease area and then press the STOP key. (→P.182 J7 CUT, CREASE)</p>
<p data-bbox="151 1568 453 1650">J8-* EXIT TRAY</p> <p data-bbox="151 1785 453 1971">J8-* Remove document from exit tray Ⓢ to clear</p>	<p data-bbox="486 1568 1399 1778">Status: There is a document jam in the document exit area. The exit tray has become full during processing. Solution: Remove the document from the exit area and then press the STOP key or remove the documents on the exit tray. (→P.185 J8 EXIT TRAY)</p>

Message	Status and Solution
<p>J9-* WASTE BOX</p> <p>Remove document from waste box Ⓢ to clear</p>	<p>Status: The waste box has become full during processing. Solution: Remove the accumulated waste from the waste box and then press the STOP key. (→P.187 J9 WASTE BOX)</p>
<p>J10-* REJECT AREA</p> <p>Remove document from reject area Ⓢ to clear</p>	<p>Status: There is a document jam in the reject area. Solution: Remove the document from the reject area and then press the STOP key. (→P.188 J10 REJECT AREA)</p>
<p>J11-* WASTE BOX</p> <p>Remove document from waste box Ⓢ to clear</p>	<p>Status: Waste that may cause a document jam remains in the waste box during processing. Solution: Remove the waste from the waste box and then press the STOP key. (→P.191 J11 WASTE BOX)</p>
<p>J12-*</p> <p>Machine stopped Document is too long</p> <p>Remove document from exit Ⓢ to clear</p>	<p>Status: The document length that was saved at JOB entry is different from that of the document that is actually fed. Solution: Check if the finished products at the exit area is correctly processed. (→P.192 J12 DOCUMENT LENGTH)</p>

If a Message Appears

Message	Status and Solution
<p>MSM-* LOCK</p> <p>Check document in MSM</p> <p>⏏ to clear</p>	<p>Status: The right (or left) tool of the margin slitter is locked. * shows R (right) or L (left).</p> <p>Solution: Remove the document from the margin slitter area and then press the STOP key. (→P.177 J5 MSM/SLOT2)</p>
<p>SLOT#-* LOCK</p> <p>Check document in SLOT</p> <p>⏏ to clear</p>	<p>Status: The right (or left) tool of the module in the slot (2–4) is locked. # shows a slot number. * shows R (right) or L (left).</p> <p>Solution: Remove the document from the slot (2–4) and then press the STOP key. (→P.177 J5 MSM/SLOT2, →P.180 J6 SLOT3/4)</p>
<p>CUTTER LOCK</p> <p>Check document in cutter area</p> <p>⏏ to clear</p>	<p>Status: The cutter is locked.</p> <p>Solution: Remove the document from the cutter area and then press the STOP key. (→P.182 J7 CUT, CREASE)</p>
<p>CREASER LOCK</p> <p>Check document in creaser area</p> <p>⏏ to clear</p>	<p>Status: The creaser is locked.</p> <p>Solution: Remove the document from the creaser area and then press the STOP key. (→P.182 J7 CUT, CREASE)</p>
<p>GUTTER# LOCK</p> <p>Check document in gutter area</p> <p>⏏ to clear</p>	<p>Status: The gutter deflector (1, 2) is locked. # shows a deflector number.</p> <p>Solution: Remove the document from the gutter deflector area and then press the STOP key. (→P.182 J7 CUT, CREASE)</p>
<p>SLOT# UPPER LOCK</p> <p>Check document in SLOT</p> <p>⏏ to clear</p>	<p>Status: The upper tool of the module in the slot (2–4) is locked. # shows a slot number.</p> <p>Solution: Remove the document from the slot (2–4) and then press the STOP key. (→P.177 J5 MSM/SLOT2, →P.180 J6 SLOT3/4)</p>
<p>CPM SLIDE LOCK</p> <p>Check document in SLOT2</p> <p>⏏ to clear</p>	<p>Status: The CPM (cross tool module) is locked.</p> <p>Solution: Remove the document from slot 2 and then press the STOP key. (→P.177 J5 MSM/SLOT2)</p>

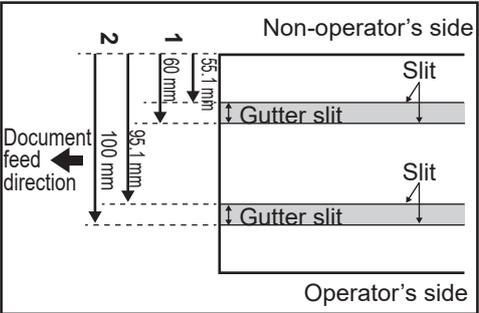
Message	Status and Solution
<p>REJECT LOCK</p> <p>Check document in reject area  to clear</p>	<p>Status: The reject area is locked. Solution: Remove the document from the reject area and then press the STOP key. (→P.188 J10 REJECT AREA)</p>
<p>CUTTER FLAP LOCK</p> <p>Check document cutter flap area  to clear</p>	<p>Status: The cutter flap is locked. Solution: Remove the document from the cut area. (→P.182 J7 CUT, CREASE)</p>
<p>NO MSM</p> <p>Set MSM  to clear</p>	<p>Status: The margin slitter module is not installed properly. Solution: Install the margin slitter module properly and then press the STOP key. (→P.177 J5 MSM/SLOT2)</p>
<p>SLOT# NO MODULE</p> <p>Set Module in SLOT  to clear</p>	<p>Status: The module in the slot (2–4) is not installed properly. # shows a slot number. Solution: Install the module in the slot (2–4) properly and then press the STOP key. (→P.177 J5 MSM/SLOT2, →P.180 J6 SLOT3/4)</p>
<p>SLOT# WRONG</p> <p>2 → RTM 3 → OK 4 → Slitter5_6</p>	<p>Status: A wrong module is installed in the slot (2–4). # shows a slot number. Solution: Install the displayed module in each slot. If OK is displayed, a correct module is installed in the slot. (The left display is an example. It differs depending on specifications.)</p>
<p>NO WASTE BOX</p> <p>Set Waste box  to clear</p>	<p>Status: The waste box is not set properly. Solution: Set the waste box properly and then press the STOP key. (→P.187 J9 WASTE BOX)</p>
<p>DOC. IN MACHINE</p> <p>Remove document from feed area</p>	<p>Status: A document remains in the feed area. Solution: Remove the document from the feed area. (→P.174 J3 FEED ERROR)</p>
<p>DOC. IN MACHINE</p> <p>Remove document from CCD area  to clear</p>	<p>Status: A document remains in the CCD area. Solution: Remove the document from the CCD area. (→P.176 J4 CCD AREA)</p>

If a Message Appears

Message	Status and Solution
DOC. IN MACHINE Remove document from MSM/SLOT2 Ⓢ to clear	Status: A document remains in the margin slitter module or slot 2. Solution: Remove the document from the margin slitter or slot 2. (→P.177 J5 MSM/SLOT2)
DOC. IN MACHINE Remove document from SLOT3/4	Status: A document remains in slot 3 or slot 4. Solution: Remove the document from slot 3 or slot 4. (→P.180 J6 SLOT3/4)
DOC. IN MACHINE Remove document from cut/crease area	Status: A document remains in the cut or crease area. Solution: Remove the document from the cut or crease area. (→P.182 J7 CUT, CREASE)
DOC. IN MACHINE Remove document from reject area	Status: A document remains in the reject area. Solution: Remove the document from the reject area. (→P.188 J10 REJECT AREA)
DOC. IN MACHINE Remove document from waste box	Status: Waste remains in the waste box. Solution: Remove the waste from the waste box. (→P.187 J9 WASTE BOX, →P.191 J11 WASTE BOX)
DOC. IN MACHINE Remove document from exit tray	Status: A document remains on the exit tray. Solution: Remove the document from the exit tray. (→P.185 J8 EXIT TRAY)
TOP COVER# OPEN Close cover	Status: The top cover (1–3) is open. # shows a top cover number. Solution: Close the top cover (1–3).
F-COVER OPEN Close cover	Status: The front cover is open. Solution: Close the front cover.

Message	Status and Solution
<p>EMERGENCY STOP</p> <p>Release Emergency SW</p>	<p>Status: Emergency stop. Solution: Turning the switch to the right releases the emergency stop. (→P.xiv Emergency Stop Function)</p>
<p>DOUBLE FEED</p> <p>Remove document in the machine Ⓢ to clear</p>	<p>Status: A double feed has occurred. Solution: Remove the document from the inside of the machine and then press the STOP key.</p>
<p>BC READ ERROR 1</p> <p>Cannot read barcode Ⓢ to clear</p>	<p>Status: The machine failed to read barcode. Solution: Press the STOP key to clear the error. If the barcode is printed out of specification, print it on an appropriate position. (→P.22 for barcode specifications)</p> <p>REFERENCE</p> <p>Barcode may not be read even it is within the specifications depending on the print quality of a printer and document type. If this is the case, enlarging the barcode may enable it to be read.</p>
<p>BC READ ERROR 2</p> <p>JOB ### is unknown Ⓢ to clear</p>	<p>Status: JOB### is not stored. ### shows a JOB number. Solution: Press the STOP key and then check JOB contents. (→P.22 for barcode specifications)</p>
<p>BC READ ERROR 3</p> <p>Check digit error Ⓢ to clear</p>	<p>Status: Check a digit error or a barcode error. Solution: Press the STOP key to clear the error and then check barcode. (Is digit correct? Are any alphabetical letters included?) Make a document with correct barcode.</p>
<p>REG READ ERROR 1</p> <p>Check document is not marked Ⓢ to clear</p>	<p>Status: The machine failed to read the REG mark because of blot on the document. Solution: Confirm that there is no blot on the document. (→P.22 for REG mark specifications)</p>
<p>REG READ ERROR 2</p> <p>Cannot read REG mark Ⓢ to clear</p>	<p>Status: The machine failed to read the REG mark. Solution: Press the STOP key and check whether the REG mark is correctly printed. (→P.22 for REG mark specifications)</p>

If a Message Appears

Message	Status and Solution
<p>REG READ ERROR 3</p> <p>Cannot read REG mark  to clear</p>	<p>Status: The machine failed to read the REG mark because it is not printed correctly.</p> <p>Solution: Press the STOP key, then check whether the REG mark is printed straight and the document is not skewed. (→P.22 for REG mark specifications)</p>
<p>REG READ ERROR 4</p> <p>Check REG position  to clear</p>	<p>Status: The machine failed to read the REG mark because of an incorrect REG mark position.</p> <p>Solution: Press the STOP key, then check the REG mark position and margin slitter position. If REG mark is printed out of specification, print it on an appropriate position. (→P.22 for REG mark specifications)</p>
<p>JOB ERROR</p> <p>Check JOB detail  to clear</p>	<p>Status: The machine cannot perform the JOB because of the false data received from a computer.</p> <p>Solution: Confirm the JOB contents and then press the STOP key.</p>
<p>JOB ERROR</p> <p>Slit/RTM is at 55.1-60mm and 95.1-100mm. Change Slit/RTM positions.  to clear</p>	<p>Status : Gutter slits and slits are allocated to the locations that prevent the sensor from sensing a document. The messages appear when the following conditions of 1 and 2 are met simultaneously.</p> <p>1: (55.1 to 60 mm) 2: (95.1 to 100 mm)</p>  <p>Solution : Press the STOP key to clear the error, then change the JOB details so that the gutter slits, slits or perforations of the RTM (rotary tool module (option)) is not overlapped with either range of 55.1–60 mm and 95.1–100 mm.</p>
<p>The gutter slits are output on the exit tray on this job.</p> <p>*Continue</p>	<p>Status : 1. The message appears when the slit positions that make the gutter slits less than 5 mm that is out of the specifications are entered and the JOB is about to be processed.</p> <p>2. The message appears when the slitters allocations disable the gutter deflector to drop the gutter slits and the JOB is about to be processed.</p> <p>Solution : Pressing the START key or the TEST key continues processing the JOB. When processing is continued, the gutter slits are not ejected to the waste box but are ejected to the exit tray.</p> <p>*  or  is displayed for * in the figure on the left.</p>

Message	Status and Solution
<p>The gutter slits are output on the exit tray on this job.</p> <p>⏏ to clear</p>	<p>Status : 1. The message appears when the slit positions that make the gutter slits less than 5 mm that is out of the specifications are entered and the barcode is read. 2. The message appears when the slitters allocations disable the gutter deflector to drop the gutter slits and the JOB is about to be processed.</p> <p>Solution : Press the STOP key to clear the error.</p>
<p>RTM pos. adj. in Setting 2 are invalid. Please correct.</p>	<p>Status: Processing positions of pattern 1 and pattern 2 by the rotary tool module are overlapped (on RTM on pos adj and RTM off pos adj screens in Settings2).</p> <p>Solution: Correct the value(s) so that the processing positions are not overlapped.</p>
<p>Apply shrink. or Adj. all setting are invalid. Please correct.</p>	<p>Status: Value(s) for Apply Shrinkage or Adjust All are out of specifications. (→P.216 Specifications)</p> <p>Solution: Enter correct value(s).</p>

If a Service Call Message Appears

Message	Status and Solution
<p data-bbox="153 331 456 421">E00-* MAIN-PANEL</p> <p data-bbox="153 546 456 741">E00-* Contact service person</p>	<p data-bbox="488 331 1406 465">Status: Communication error in the DC-646. Solution: Turn OFF the power and then turn ON again in a few seconds. If the same error message remains displayed, write down the message and contact our service person.</p>
<p data-bbox="153 772 456 862">E01-* CCD ERROR</p> <p data-bbox="153 987 456 1182">E01-* Contact service person</p>	<p data-bbox="488 772 1390 943">Status: Barcode or REG mark reading error. Solution: 1. Remove the document and press the STOP key. 2. Turn OFF the power and then turn ON again in a few seconds. If the same error message remains displayed, write down the message and contact our service person.</p>
<p data-bbox="153 1214 456 1303">E02-* ELEVATOR</p> <p data-bbox="153 1429 456 1624">E02-* Contact service person</p>	<p data-bbox="488 1214 1406 1429">Status: Error in the elevator. Solution: 1. Remove the documents from the feed tray and then press the STOP key. 2. Turn OFF the power and then turn ON again in a few seconds. If the same error message remains displayed, write down the message and contact our service person.</p>
<p data-bbox="153 1655 456 1744">E03-* CREASE LOWER</p> <p data-bbox="153 1870 456 2065">E03-* Contact service person</p>	<p data-bbox="488 1655 1406 1803">Status: Error in the lower tool area of the creaser module. Solution: Turn OFF the power and then turn ON again in a few seconds. If the same error message remains displayed, write down the message and contact our service person.</p>

Message	Status and Solution
<p data-bbox="177 277 486 477"> E04-* MEMORY ERROR </p> <p data-bbox="177 495 486 689"> E04-* Contact service person </p>	<p data-bbox="512 277 1437 409"> Status: Memory read error. Solution: Turn OFF the power and then turn ON again in a few seconds. If the same error message remains displayed, write down the message and contact our service person. </p>
<p data-bbox="177 719 486 918"> E05-* MEMORY ERROR </p> <p data-bbox="177 936 486 1131"> E05-* Contact service person </p>	<p data-bbox="512 719 1437 851"> Status: Memory communication error. Solution: Turn OFF the power and then turn ON again in a few seconds. If the same error message remains displayed, write down the message and contact our service person. </p>
<p data-bbox="177 1160 486 1359"> E06-* I/O COM </p> <p data-bbox="177 1377 486 1572"> E06-* Contact service person </p>	<p data-bbox="512 1160 1437 1292"> Status: Communication error in the DC-646. Solution: Turn OFF the power and then turn ON again in a few seconds. If the same error message remains displayed, write down the message and contact our service person. </p>
<p data-bbox="177 1624 486 1823"> E07-* COOLING FAN LOCK </p> <p data-bbox="177 1841 486 2036"> E07-* Contact service person </p>	<p data-bbox="512 1624 1437 1756"> Status: The cooling fan has stopped. Solution: Turn OFF the power and then turn ON again in a few seconds. If the same error message remains displayed, write down the message and contact our service person. </p>

If a Service Call Message Appears

Message	Status and Solution
<p>E08-*</p> <p>MAIN-SLITTER COM</p>	<p>Status: Communication error in the DC-646.</p> <p>Solution: Turn OFF the power and then turn ON again in a few seconds. If the same error message remains displayed, write down the message and contact our service person.</p>
<p>E08-*</p> <p>Contact service person</p>	

If a Document Jam Has Occurred

If a document jam has occurred, messages appear and the error area flashes on the LCD panel. Follow the procedure below to remove the jammed document.



WARNING

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

J2 FEED TRAY

Too many documents are loaded on the **feed tray**. Follow the procedure below to adjust the amount of document to proper one.

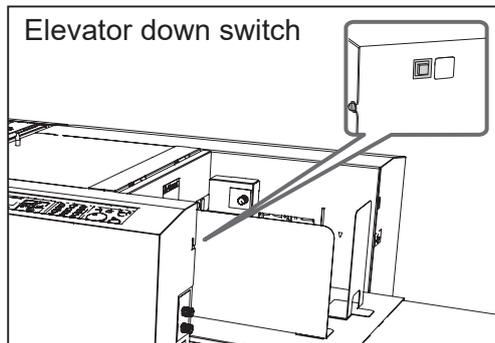
J2-*

Feed tray
overload

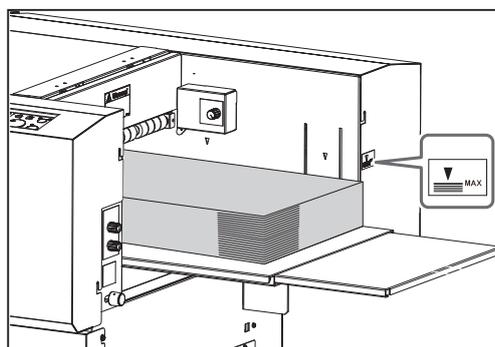
▽ to clear

- 1 Press and hold down the **elevator down switch** to lower the **feed tray** to the bottommost position.

Elevator down switch



- 2 Remove some documents so that the height of the document stack does not exceed the **MAX** level.

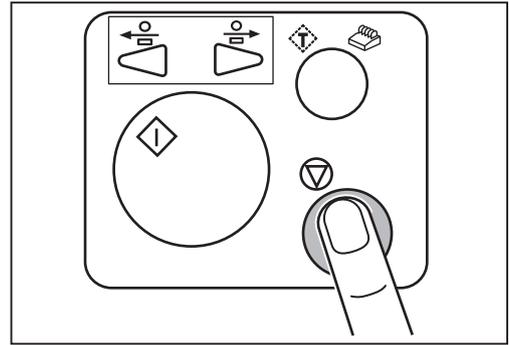


5

Troubleshooting

If a Document Jam Has Occurred

- 3 Press the STOP key to clear the error. The machine is reset and the error message is cleared.



J3 FEED ERROR

A document jam has occurred in the document feed area or the feeding area. Follow the procedure below to remove the jammed document.

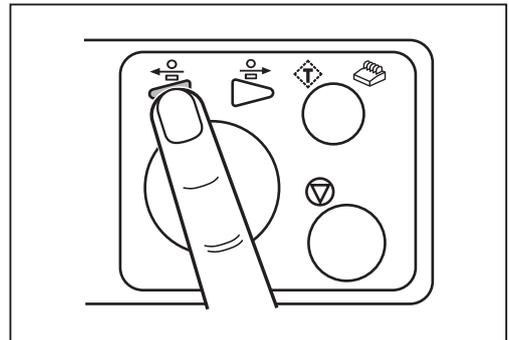
J3-*

Remove document
from feed area
▽ to clear

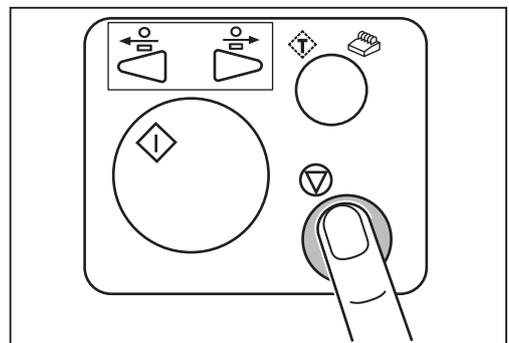
- 1 Press the JOG (Forth) key to eject the document.

IMPORTANT

- Be sure to close the **top cover** when you operate the machine. The machine does not work if the **top cover** is open.
- The JOG (Back) key is inactive if a document is jammed or remains in the infeed area.

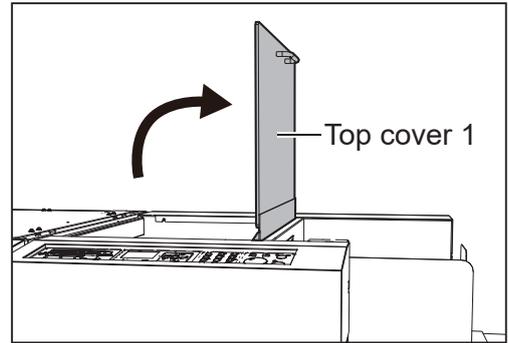


- 2 Press the STOP key to clear the error. The machine is reset and the error message is cleared.

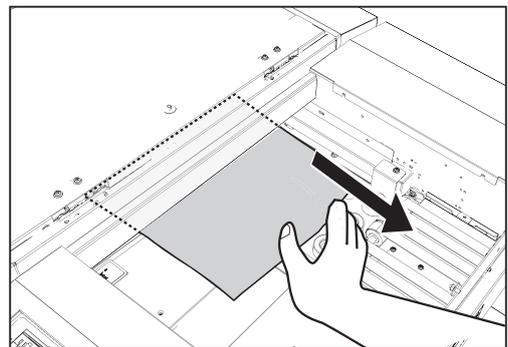


If the jammed document cannot be removed by the procedure above page, attempt to remove the document according to the following procedure.

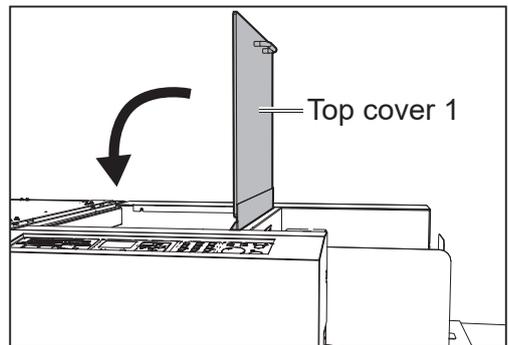
- 1 Open the **top cover 1**.



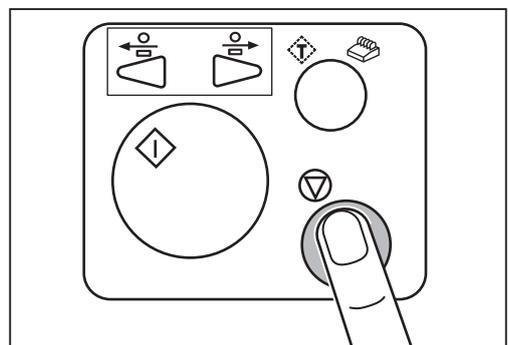
- 2 Remove the jammed document.



- 3 Close the **top cover 1**.



- 4 Press the STOP key to clear the error. The machine is reset and the error message is cleared.



If a Document Jam Has Occurred

J4 CCD AREA

A document jam has occurred in the CCD area.
Follow the procedure below to remove the jammed document.

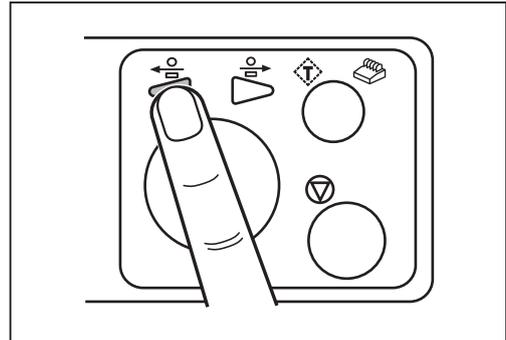
J4-*

Remove document
from CCD area
▽ to clear

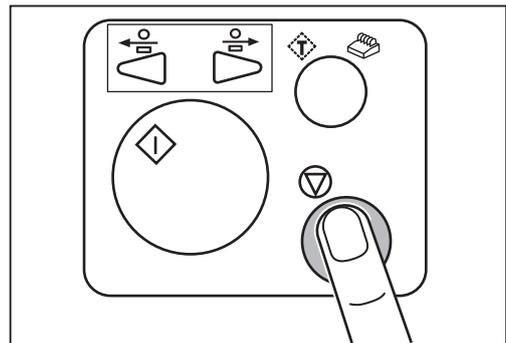
- 1 Press the JOG (Forth) key to eject the document.

IMPORTANT

The JOG (Back) key is inactive if a document is jammed or remains in the CCD area.

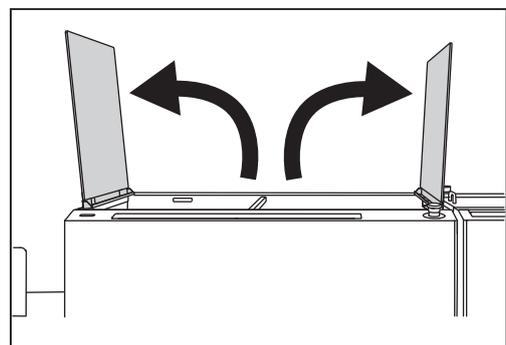


- 2 Press the STOP key to clear the error.
The machine is reset and the error message is cleared.

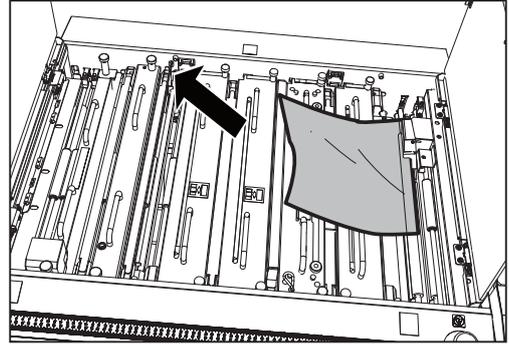


If the jammed document cannot be removed by the procedure above, attempt to remove the document according to the following procedure.

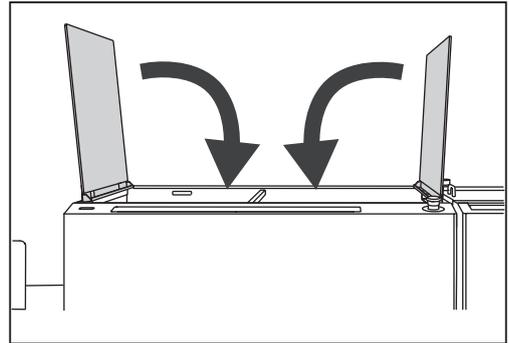
- 1 Open the **top cover 2** and the **top cover 3**.



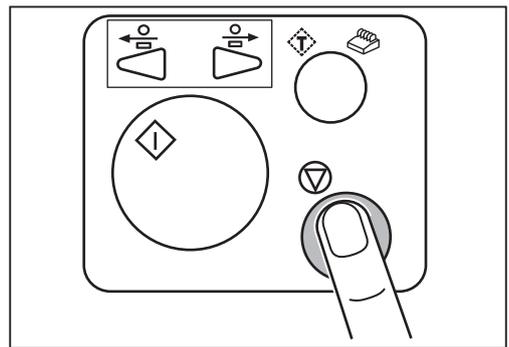
- 2 Remove the jammed document in the CCD area.



- 3 Close the top cover 2 and the top cover 3.



- 4 Press the STOP key to clear the error. The machine is reset and the error message is cleared.



J5 MSM/SLOT2

A document jam has occurred in the **margin slitter module** or slot 2.

Follow the procedure below to remove the jammed document.

REFERENCE

Follow the procedure below as well if **SLOT#-* LOCK**, **MSM-* LOCK**, or **SLOT# UPPER LOCK** appears.

J5-*

Remove document
from MSM/SLOT2

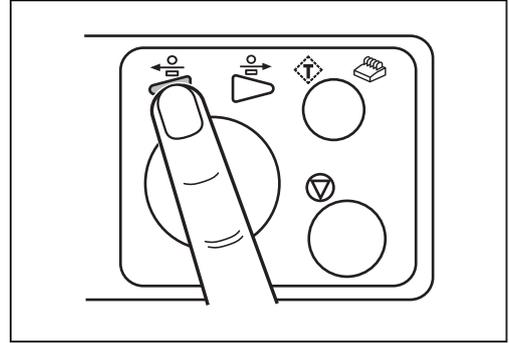
⏏ to clear

If a Document Jam Has Occurred

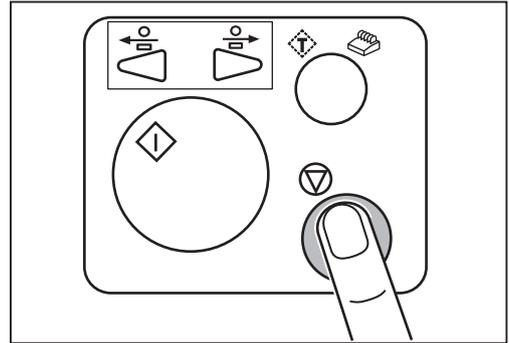
- 1 Press the JOG (Forth) key to eject the document.

IMPORTANT

The JOG (Back) key is inactive if a document is jammed or remains in the **margin slitter module** or slot 2.

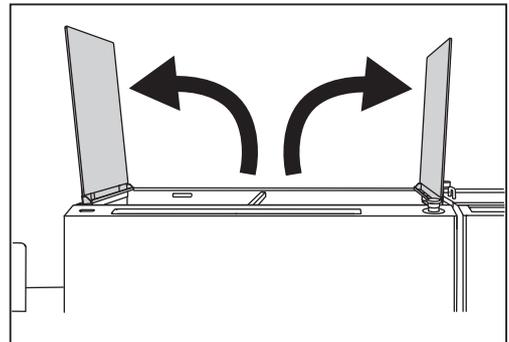


- 2 Press the STOP key to clear the error. The machine is reset and the error message is cleared.

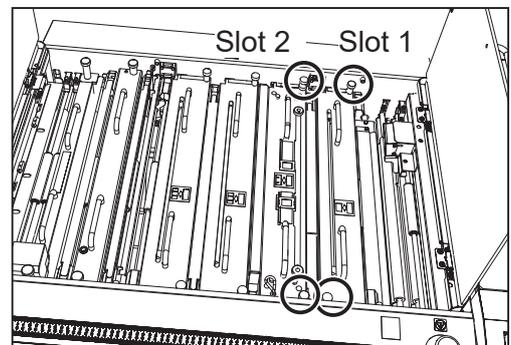


If the jammed document cannot be removed by the procedure above, attempt to remove the document according to the following procedure.

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

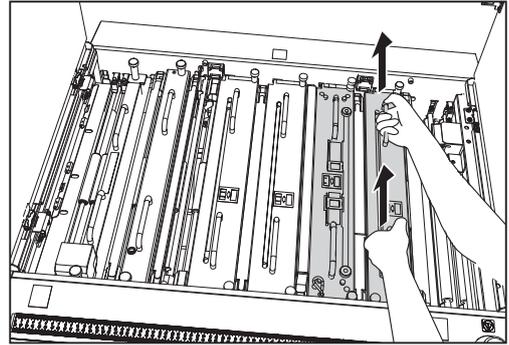


- 2 Loosen the fixing screws (two each) of the modules in slot 1 and slot 2.



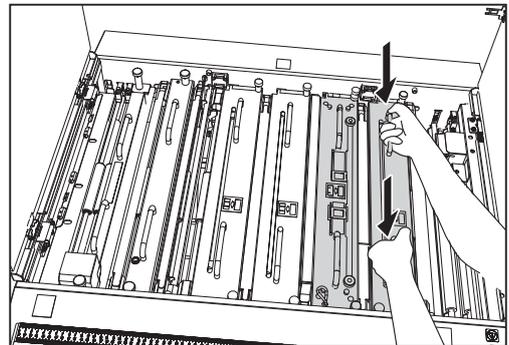
If a Document Jam Has Occurred

- 3 Grasp the handle to take out the module from slot 1 and slot 2 by lifting it up.

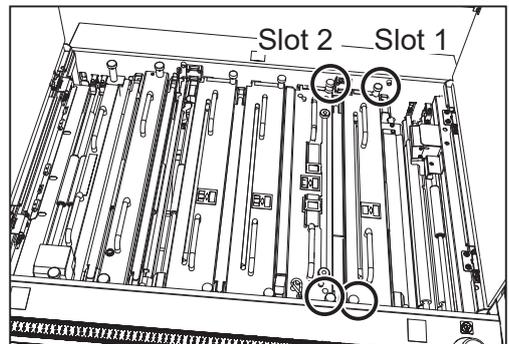


- 4 Remove the jammed document by using the supplied pliers.

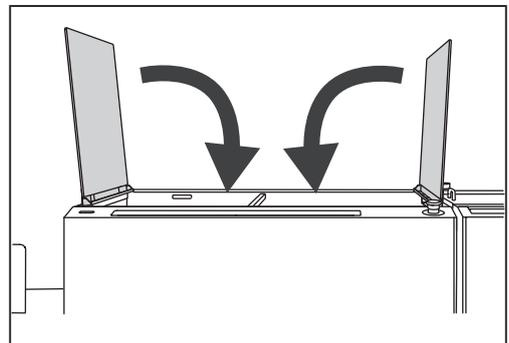
- 5 Slowly lower the module in slot 1 and slot 2. Check to see that the pins on both sides are securely fitted in the modules.



- 6 Tighten the fixing screws (two each) of the modules in slot 1 and slot 2.



- 7 Close the top cover 2 and the top cover 3.

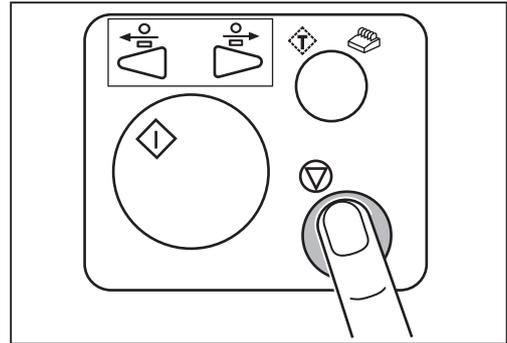


5

Troubleshooting

If a Document Jam Has Occurred

- 8 Press the STOP key to clear the error.
The machine is reset and the error message is cleared.

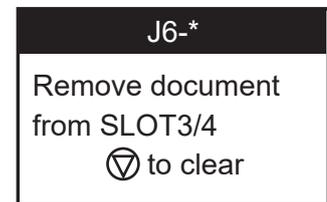


J6 SLOT3/4

A document jam has occurred in slot 3 or slot 4.
Follow the procedure below to remove the jammed document.

REFERENCE

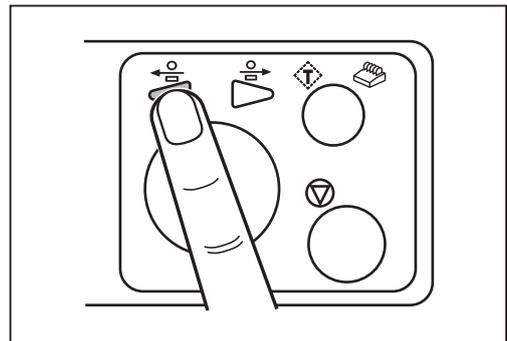
Follow the procedure below as well if **SLOT#-* LOCK** or **SLOT# UPPER LOCK** appears.



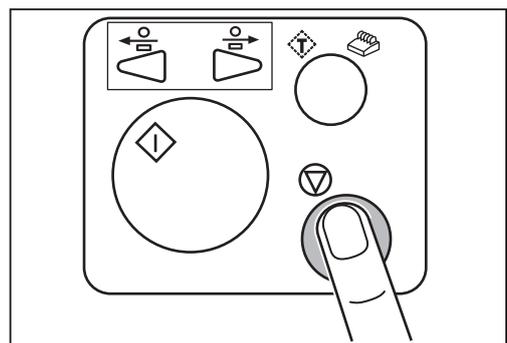
- 1 Press the JOG (Forth) key to eject the document.

IMPORTANT

The JOG (Back) key is inactive if a document is jammed or remains in slot 3 or slot 4.

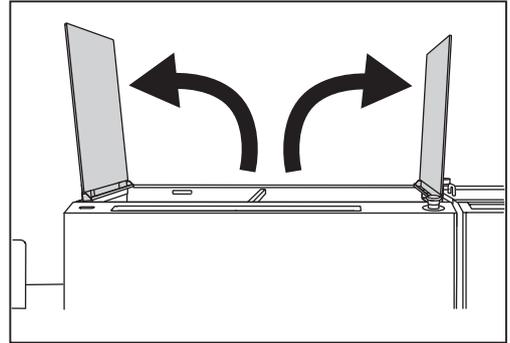


- 2 Press the STOP key to clear the error.
The machine is reset and the error message is cleared.

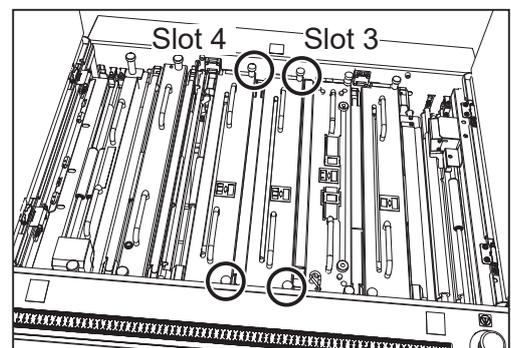


If the jammed document cannot be removed by the procedure above, attempt to remove the document according to the following procedure.

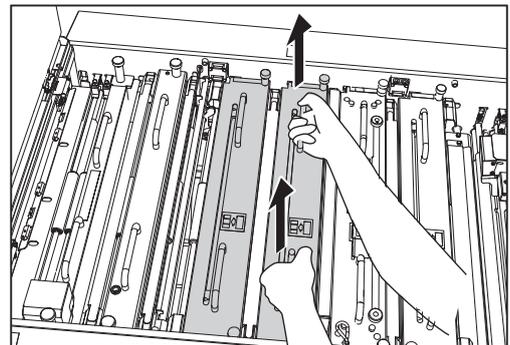
- 1 Open the **top cover 2** and the **top cover 3**.



- 2 Loosen the fixing screws (two each) of the modules in slot 3 and slot 4.

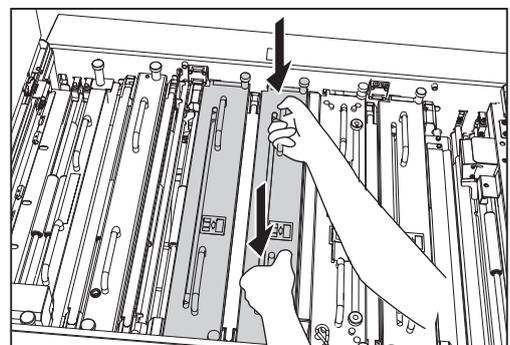


- 3 Grasp the handle to take out the modules from the slot 3 and slot 4 by lifting them up.



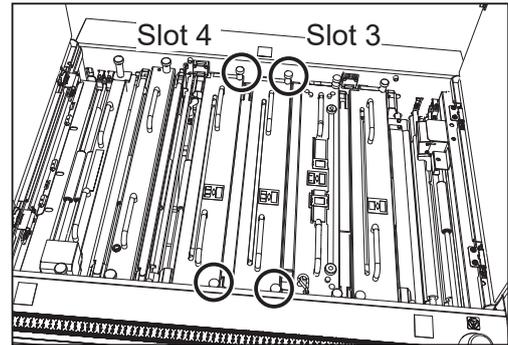
- 4 Remove the jammed document by using the supplied pliers.

- 5 Slowly lower the module in slot 3 and slot 4. Check to see that the pins on both sides are securely fitted in the modules.

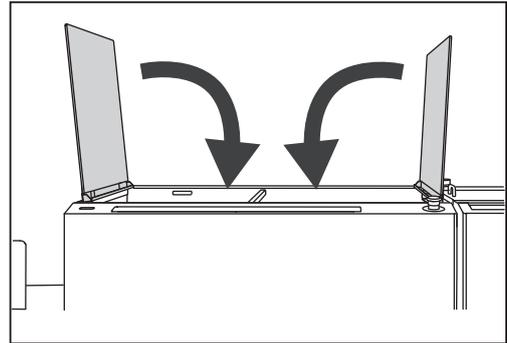


If a Document Jam Has Occurred

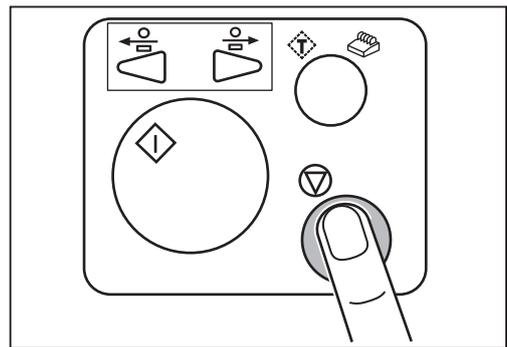
- 6 Tighten the fixing screws (two each) of the modules in slot 3 and slot 4.



- 7 Close the **top cover 2** and the **top cover 3**.



- 8 Press the STOP key to clear the error. The machine is reset and the error message is cleared.



J7 CUT, CREASE

A document jam has occurred in the **cutter module** or the **creaser module**.
Follow the procedure below to remove the jammed document.

REFERENCE

Follow the procedure below as well if **CUTTER LOCK** or **CREASER LOCK** appears.

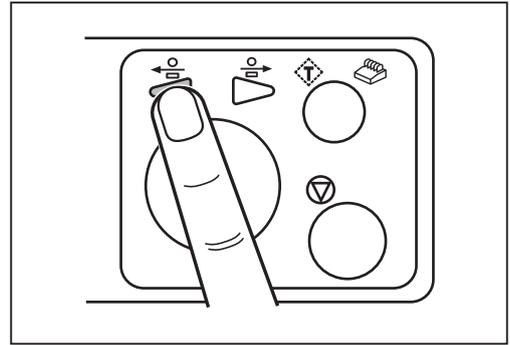
J7-*

Remove document
from cut/crease
area  to clear

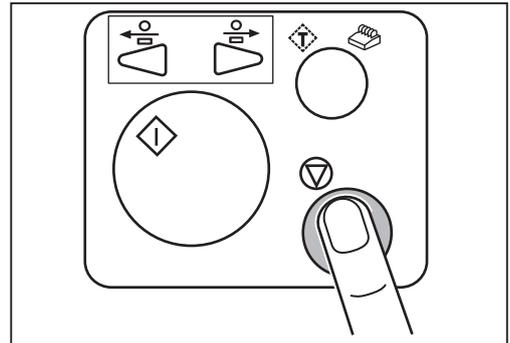
- 1 Press the JOG (Forth) key to eject the document.

IMPORTANT

The JOG (Back) key is inactive if a document remains inside of the machine.

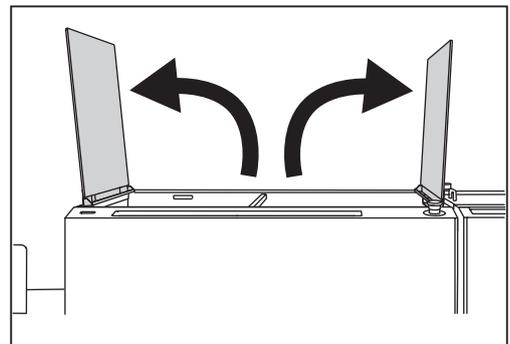


- 2 Press the STOP key to clear the error. The machine is reset and the error message is cleared.



If the jammed document cannot be removed by the procedure above, attempt to remove the document according to the following procedure.

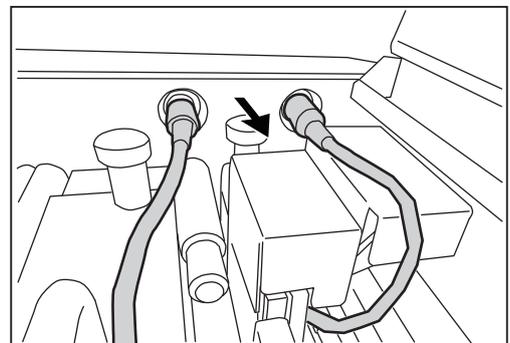
- 1 Open the **top cover 2** and the **top cover 3**.



- 2 Disconnect the connectors of the **creaser module** or the **cutter module**.

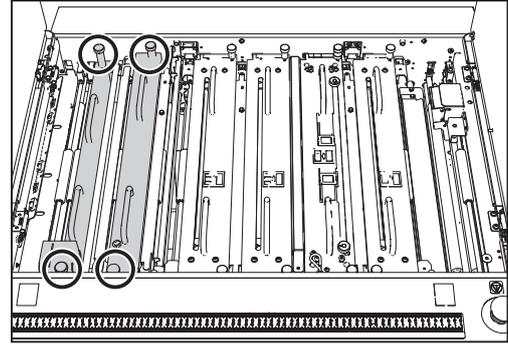
(The figure on the right shows a view from the non-operator's side;

- Left side connector: **Creaser module**
- Right side connector: **Cutter module**)

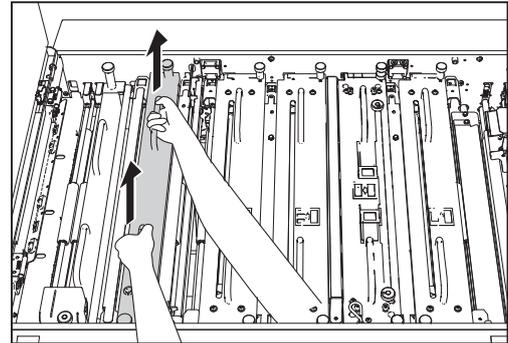


If a Document Jam Has Occurred

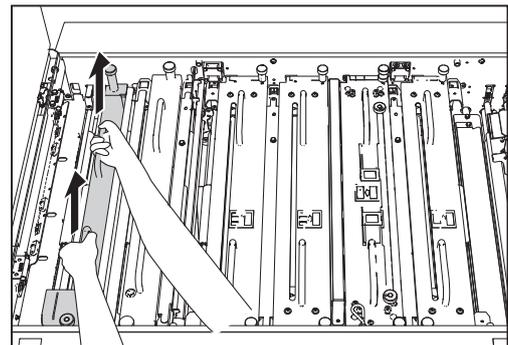
- 3** **Creaser module:** Loosen the two fixing screws.
Cutter module: Remove the two fixing screws.



- 4** Grasp the **handle** to take out the **creaser module** by lifting it up.

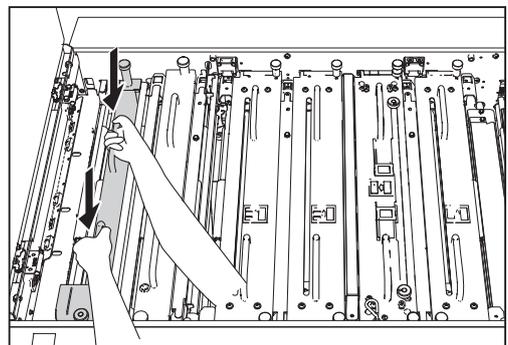


- 5** Grasp the **handle** to take out the **cutter module** by lifting it up.

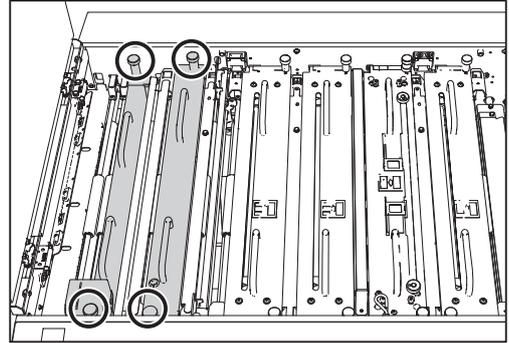


- 6** Remove the jammed document by using the supplied pliers.

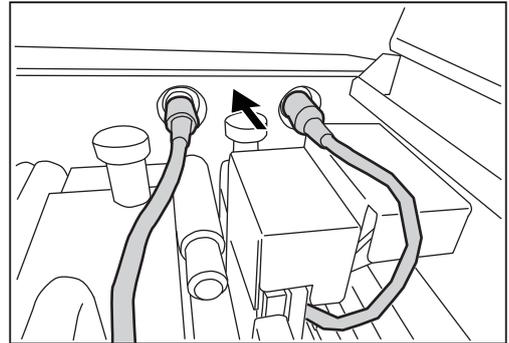
- 7** Slowly lower the **cutter module** or the **creaser module**. Check to see that the pins on both sides are securely fitted in the modules.



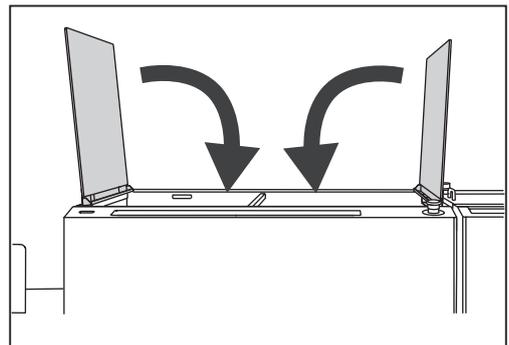
- 8 Tighten the fixing screws (two each) of the **creaser module** and the **cutter module**.



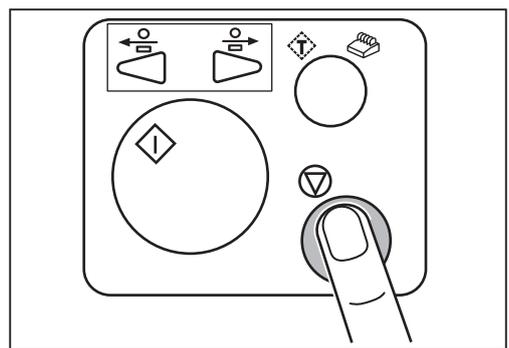
- 9 Connect the connectors of the **creaser module** or the **cutter module**.
 (The figure on the right shows a view from the non-operator's side;
 • Left side connector: **Creaser module**
 • Right side connector: **Cutter module**)



- 10 Close the **top cover 2** and the **top cover 3**.



- 11 Press the STOP key to clear the error.
 The machine is reset and the error message is cleared.



J8 EXIT TRAY

A document jam has occurred in the **exit tray**.
 Follow the procedure below to remove the jammed document.

J8-*

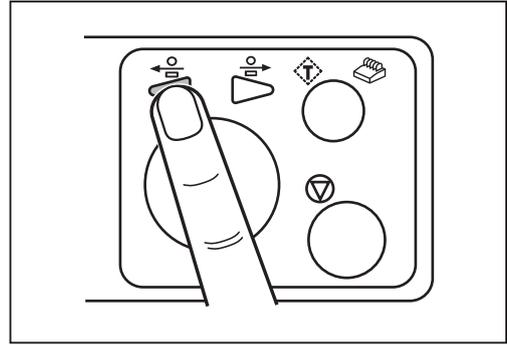
Remove document from exit tray
 ⏏ to clear

If a Document Jam Has Occurred

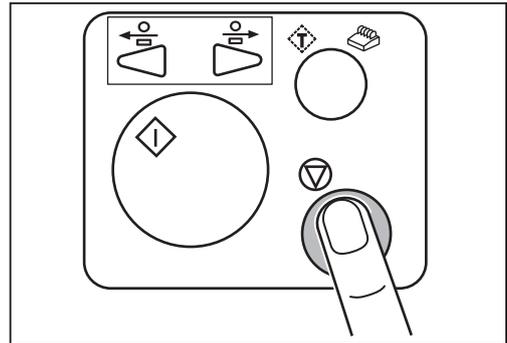
- 1 Press the JOG (Forth) key to eject the document.

IMPORTANT

The JOG (Back) key is inactive if a document remains inside of the machine.

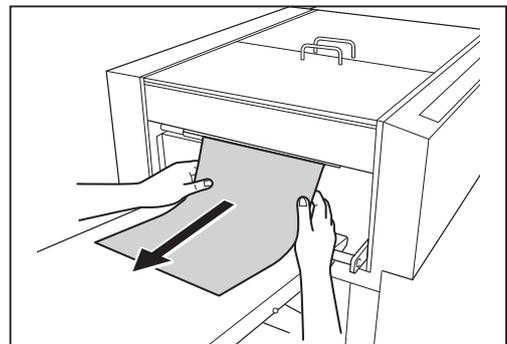


- 2 Press the STOP key to clear the error. The machine is reset and the error message is cleared.

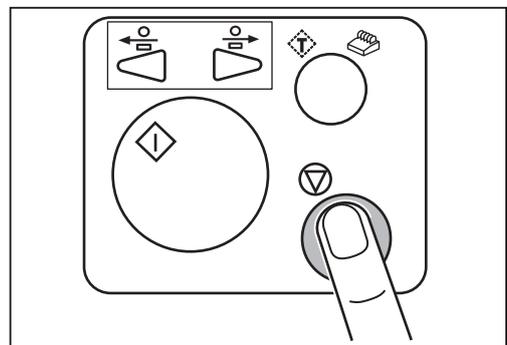


If the jammed document cannot be removed by the procedure above, attempt to remove the document according to the following procedure.

- 1 Remove the jammed document with hands.



- 2 Press the STOP key to clear the error. The machine is reset and the error message is cleared.



J9 WASTE BOX

The waste box has become full of waste during operation. Accumulation of waste may cause a document jam.

J9-*

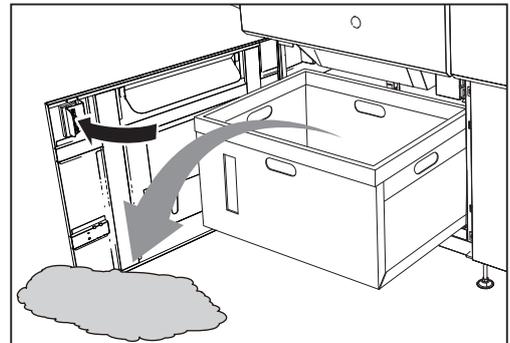
Remove document from waste box
 to clear

WARNING

Make sure that the machine is fully stopped before removing the waste. Otherwise, your hands or fingers may get caught and injured.

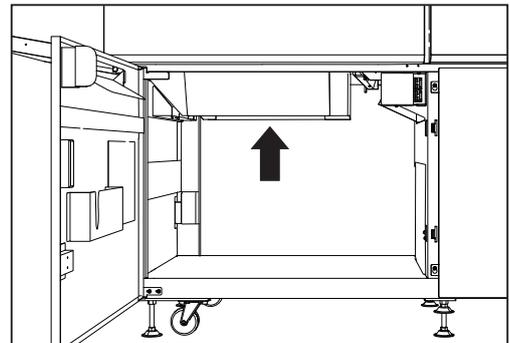
- 1 Open the **front cover**, then take out the waste box. Dispose of the waste.

If waste remains inside of the machine, remove it.



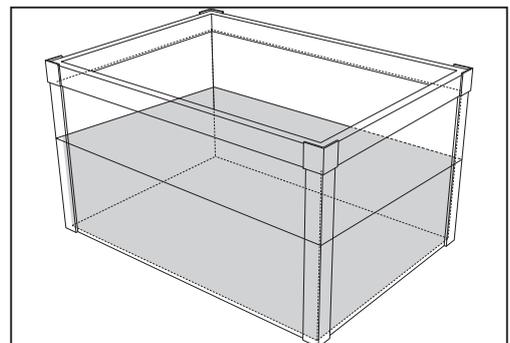
IMPORTANT

Make sure that there is no waste around the area indicated with the arrow.



REFERENCE

When the waste comes to approximately half of the waste box, the machine detects **waste box full**. If you select **MAX** on the **Waste detection** screen in **Settings2**, waste can accumulate until it comes to approximately 70% of the waste box. (Light weight documents and shorter documents only)
 (→P.63 Function Setting 2, →P.127 SETTING 2)

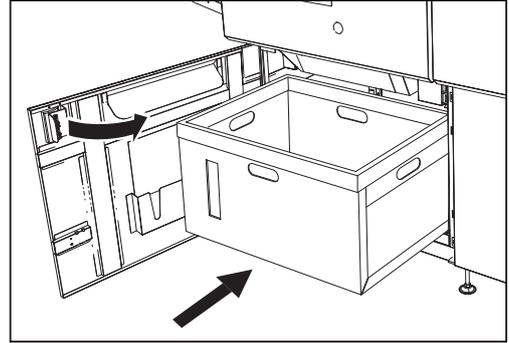


If a Document Jam Has Occurred

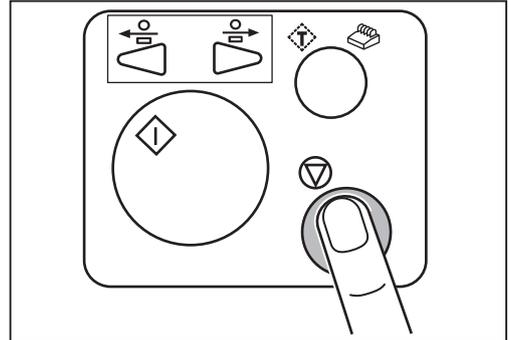
- Put the waste box back in its place and close the front cover.

IMPORTANT

Make sure to set the waste box properly pushing it all the way in.



- Press the STOP key to clear the error. The machine is reset and the error message is cleared.



J10 REJECT AREA

A document jam has occurred in the reject area. Follow the procedure below to remove the jammed document.

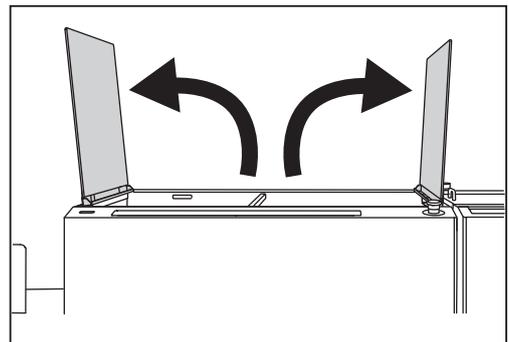
REFERENCE

Follow the procedure below as well if a **REJECT LOCK** error appears.

J10-*

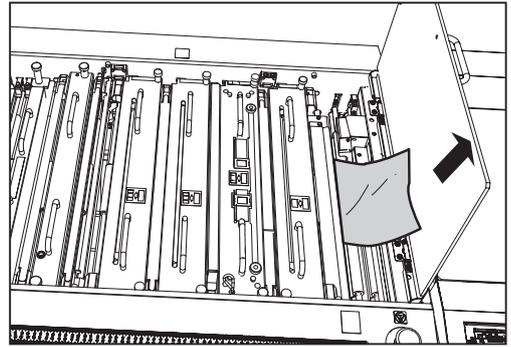
Remove document from reject area
⏏ to clear

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

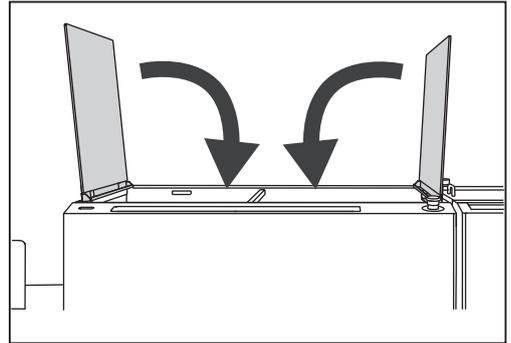


If a Document Jam Has Occurred

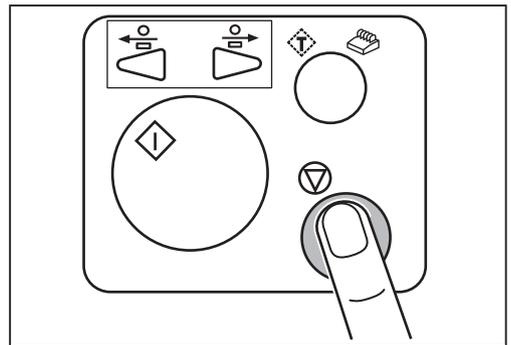
- 2 Remove the jammed document from the reject area.



- 3 Close the **top cover 2** and the **top cover 3**.



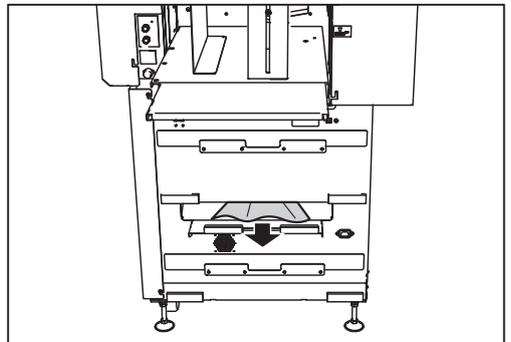
- 4 Press the STOP key to clear the error. The machine is reset and the error message is cleared.



If the jammed document cannot be removed by the procedure above, attempt to remove the document according to the following procedure.

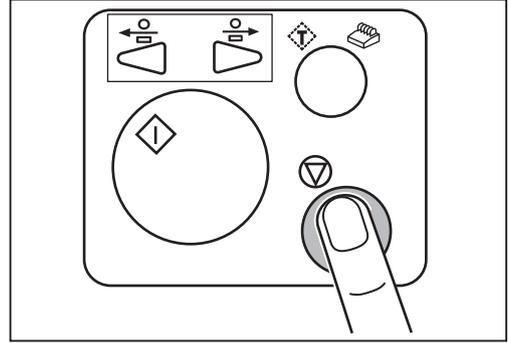
- **When removing the document from the exit tray**

- 1 Remove the document from the **exit tray**.



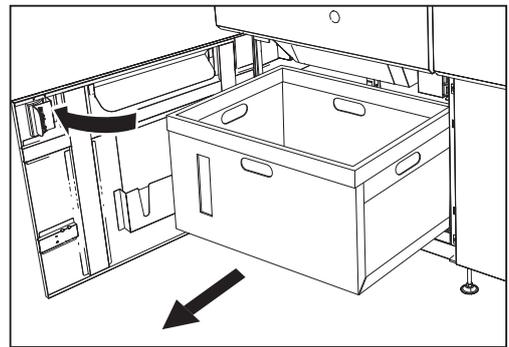
If a Document Jam Has Occurred

- 2 Press the STOP key to clear the error. The machine is reset and the error message is cleared.

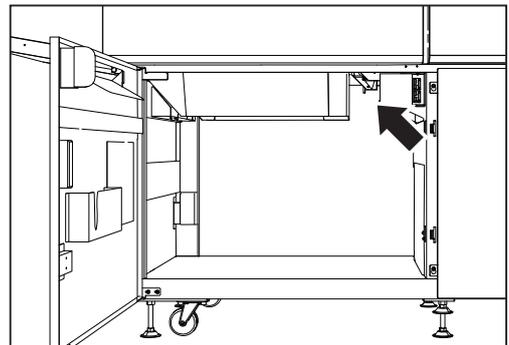


• When removing the document from the waste box area

- 1 Open the **front cover**, then take out the waste box.



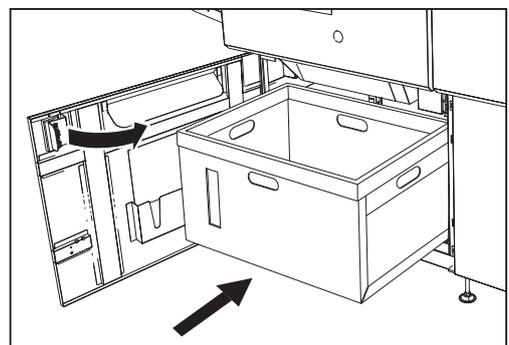
- 2 Remove the document from the arrow area.



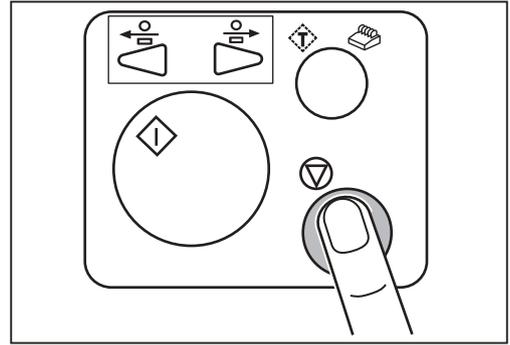
- 3 Put the waste box back in its place and close the **front cover**.

IMPORTANT

Make sure to set the waste box properly pushing it all the way in.



- 4 Press the STOP key to clear the error. The machine is reset and the error message is cleared.



J11 WASTE BOX

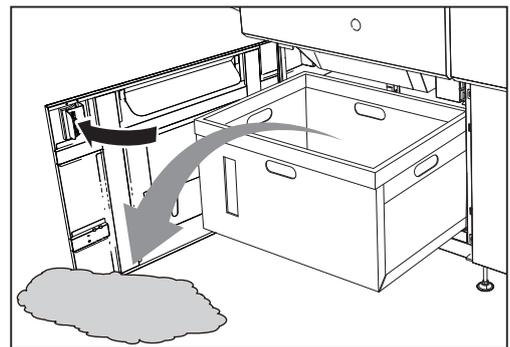
Slit waste is jammed in the chute area because it cannot drop in the waste box smoothly. Follow the procedure below to remove the waste.

J11-*

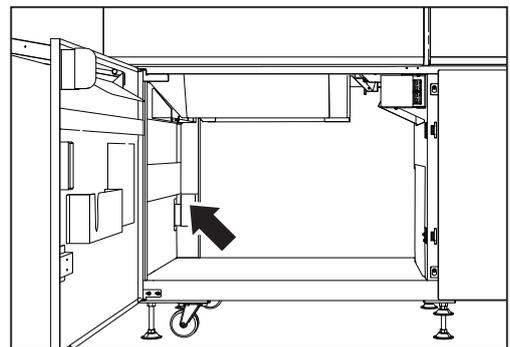
Remove document from waste box
 to clear

- 1 Open the **front cover**, then take out the waste box. Dispose of the waste.

If waste remains inside of the machine, remove it.



IMPORTANT
 Make sure that there is no waste around the arrow area.



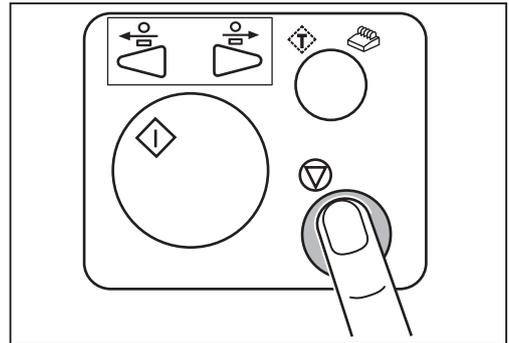
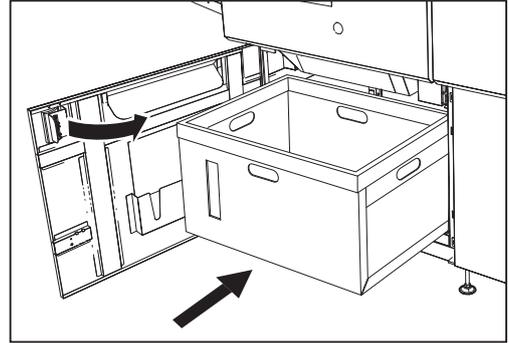
If a Document Jam Has Occurred

- Put the waste box back in its place and close the front cover.

IMPORTANT

Make sure to set the waste box properly pushing it all the way in.

- Press the STOP key to clear the error. The machine is reset and the error message is cleared.



J12 DOCUMENT LENGTH

If the document is longer than the length that was saved at JOB entry, processing stops halfway and the document is ejected.

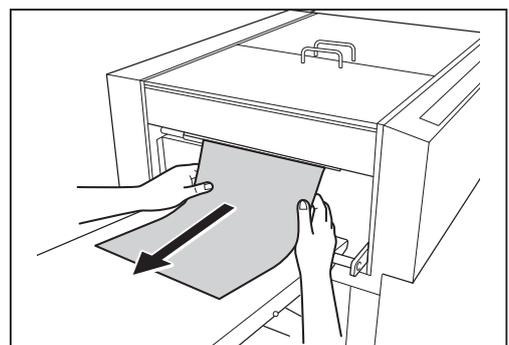
J12-*

Machine stopped
Document is too long

J12-*

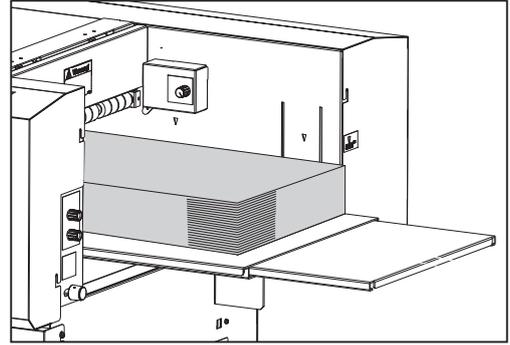
Remove document from exit
▽ to clear

- Check if the finished product ejected is correctly processed. If there are any finished products that are not correctly processed, remove them.

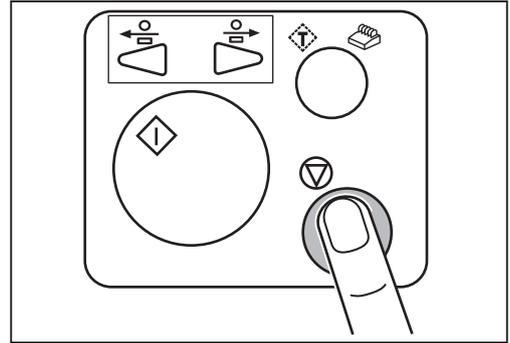


If a Document Jam Has Occurred

- 2 Confirm that the document length on the **feed tray** is the one that was saved at JOB entry.



- 3 Press the STOP key to clear the error. The machine is reset and the error message is cleared.



Chapter 6

Daily Maintenance

This chapter describes daily maintenance for the machine.

.....

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.....

Daily Maintenance

Clean the machine periodically to maintain its performance.

WARNING

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

Clean the exterior in the following procedure.

1. Tightly wring a soft cloth that has been moistened with water or mild detergent.
2. Wipe the exterior.
3. Wipe off the excess moisture on the exterior with a dry soft cloth.

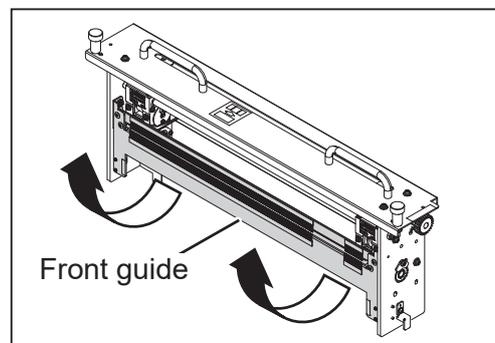
WARNING

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

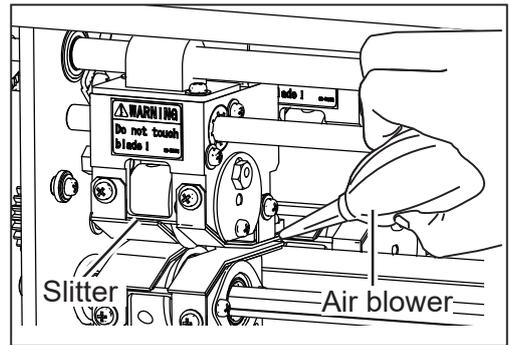
Dust accumulation may cause the machine to malfunction. Clean it periodically. Contact our service person as for cleaning of inside of the machine.

Cleaning the Slitter Tool

- 1 Remove the **front guide** on the **slitter module**.



- 2 If a document is slit by the **slitter** after a long period of use of the machine, finished products may get dirty.
Before starting operation, clean the **slitter tool** with an air blower, then perform test runs several times and check the finished products for any blot.

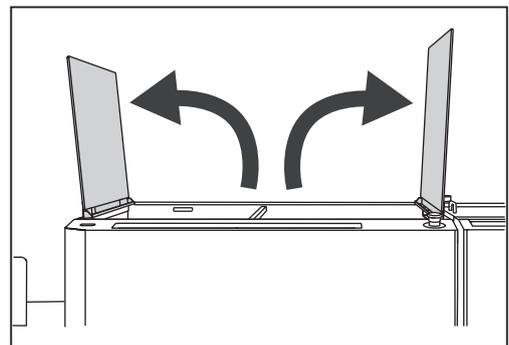


- 3 Reattach the **front guide** removed in step 1.

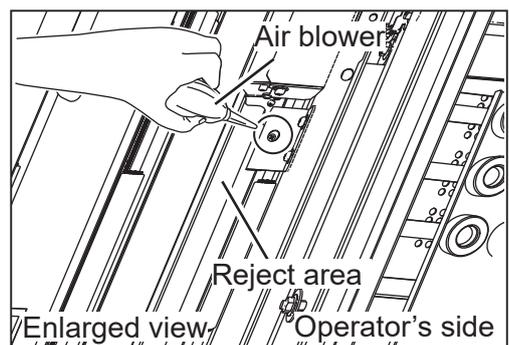
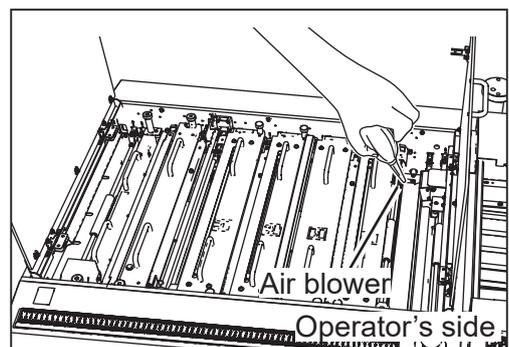
Cleaning the Sensors

- Sensor on the right side of the reject area

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

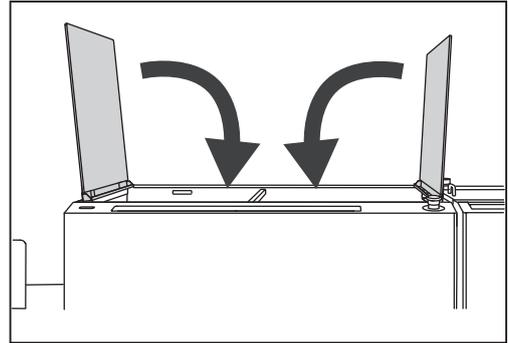


- 2 Clean the sensor on the right side of the **reject area** with an air blower.



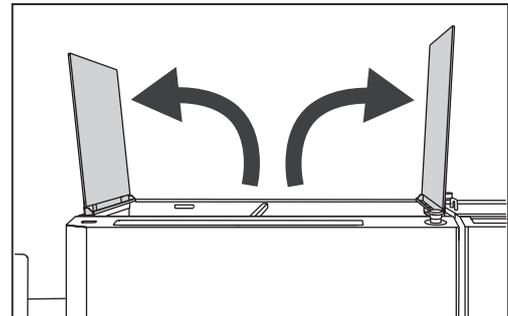
Daily Maintenance

- 3 Close the **top cover 2** and the **top cover 3**.

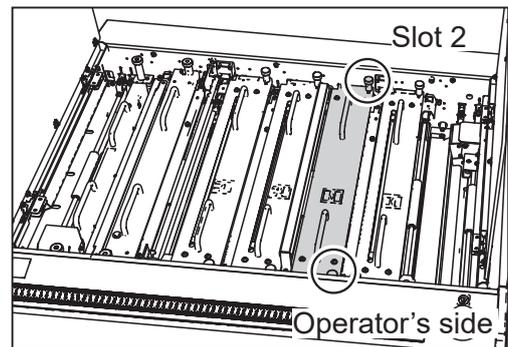


• Sensor on the right side of slot 2

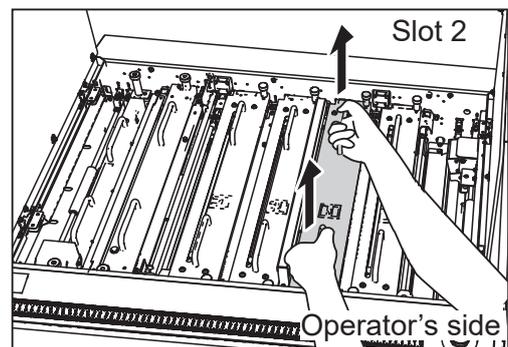
- 1 Open the **top cover 2** and the **top cover 3**.



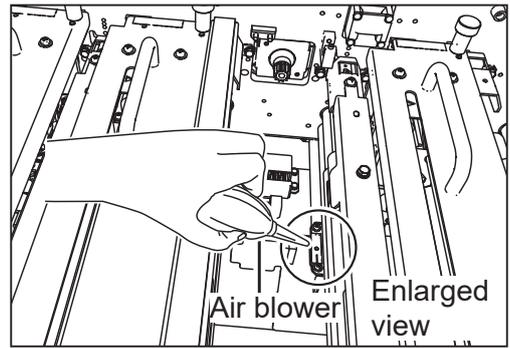
- 2 Loosen the two fixing screws of the module in slot 2.



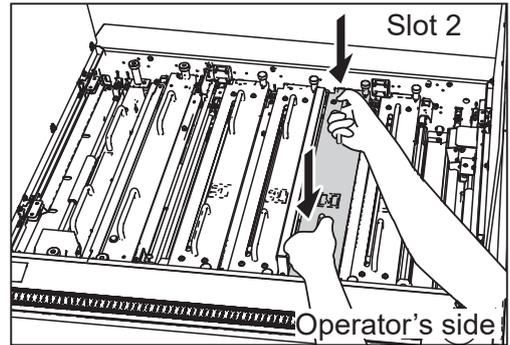
- 3 Grasp the handles to take out the module from slot 2 by lifting it up.



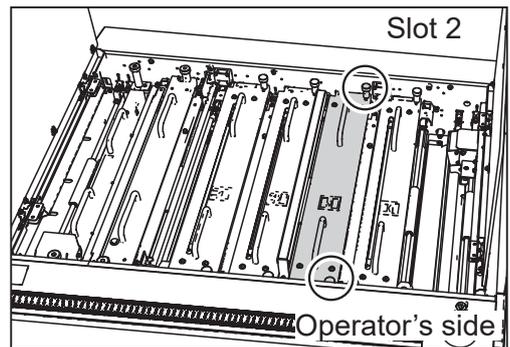
- 4 Clean the sensor on the right side of slot 2 with an air blower.



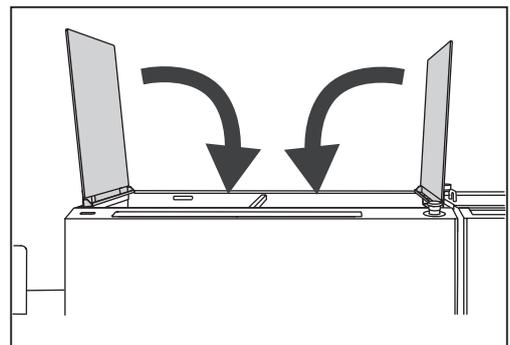
- 5 Slowly lower the module in slot 2. Check to see that the pins on both sides are securely fitted in the module.



- 6 Tighten the two fixing screws of the module in slot 2.



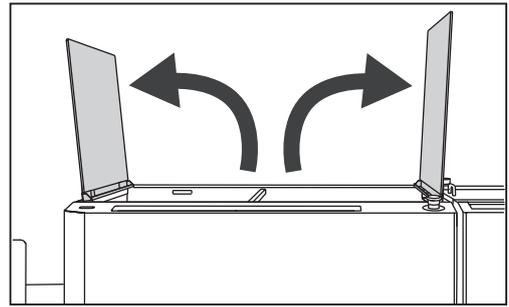
- 7 Close the top cover 2 and the top cover 3.



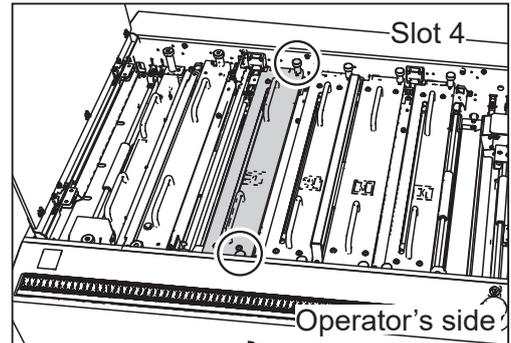
Daily Maintenance

- Sensor on the right side of slot 4

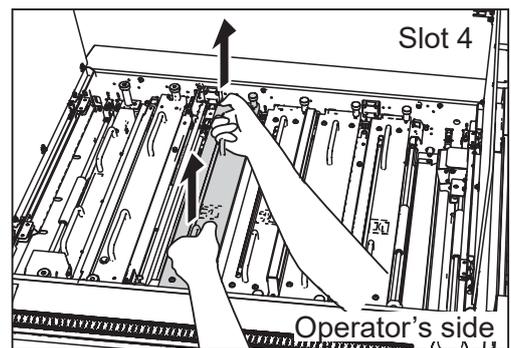
1 Open the **top cover 2** and the **top cover 3**.



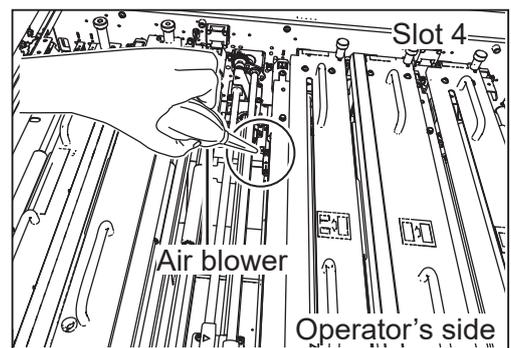
2 Loosen the two fixing screws of the module in slot 4.



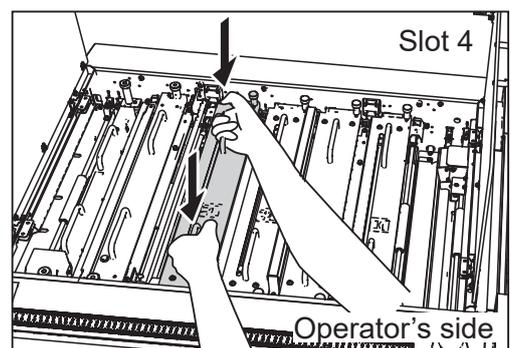
3 Grasp the handles to take out the module from slot 4 by lifting it up.



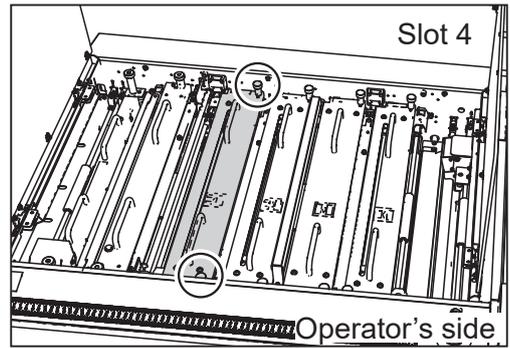
4 Clean the sensor on the right side of slot 4 with an air blower.



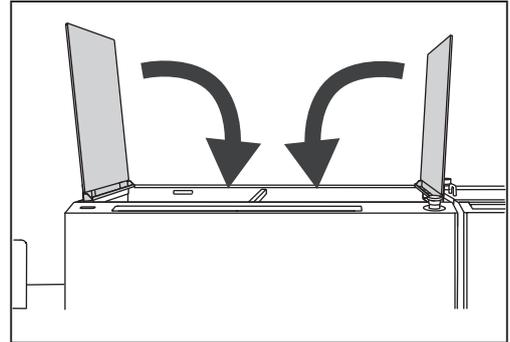
5 Slowly lower the module in slot 4. Check to see that the pins on both sides are securely fitted in the module.



- 6 Tighten the two fixing screws of the module in slot 4.

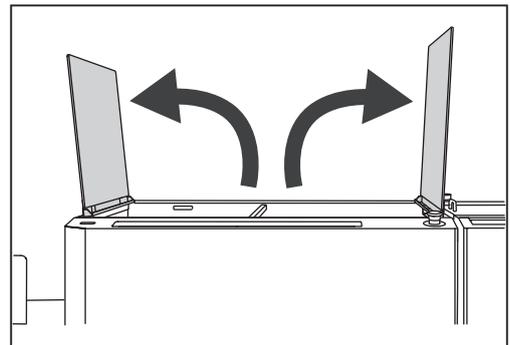


- 7 Close the top cover 2 and the top cover 3.



- Sensor on the right side of the creaser module

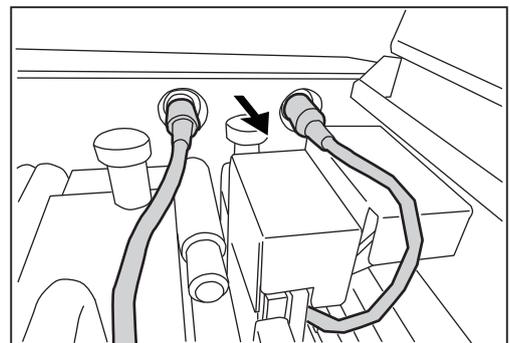
- 1 Open the top cover 2 and the top cover 3.



REFERENCE

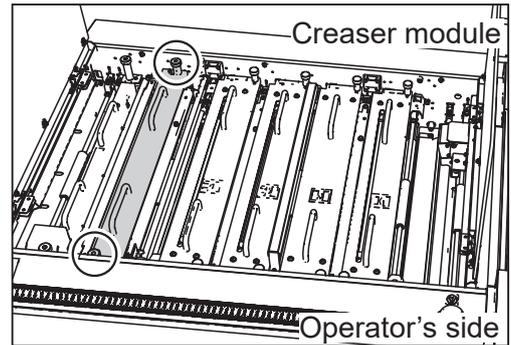
Disconnect the connector of the **creaser module**.
 (The figure on the right shows a view from the non-operator's side;

- Left side connector: **Creaser module**)

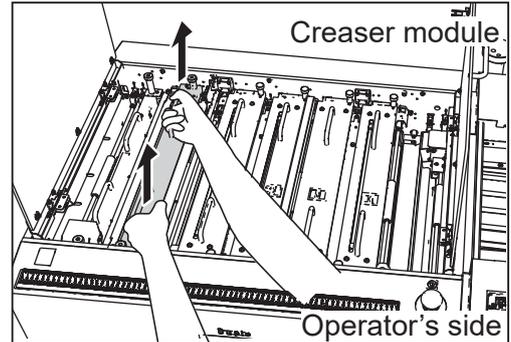


Daily Maintenance

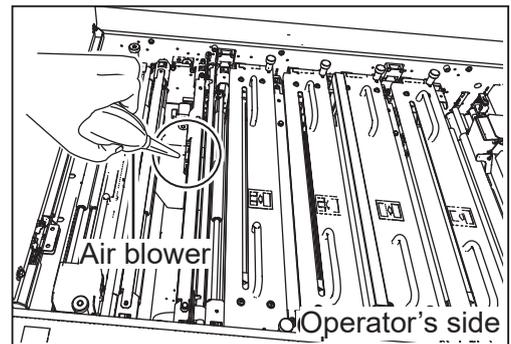
- 2 Loosen the two fixing screws of the **creaser module**.



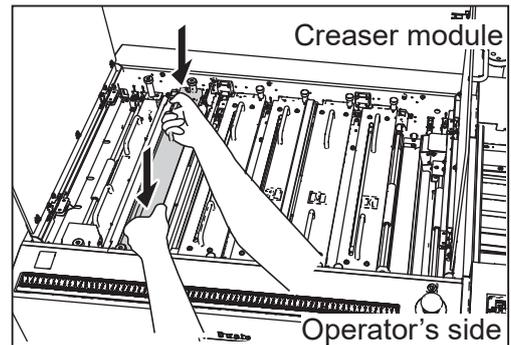
- 3 Grasp the handles to take out the **creaser module** by lifting it up.



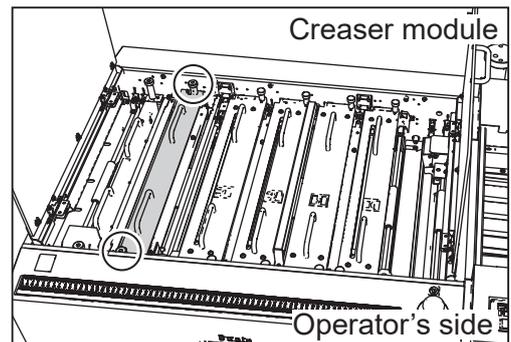
- 4 Clean the sensor on the right side of the **creaser module** with an air blower.



- 5 Slowly lower the **creaser module** in its position. Check to see that the pins on both sides are securely fitted in the module.



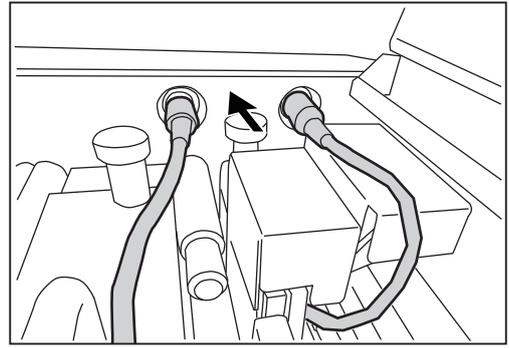
- 6 Tighten the two fixing screws of the **creaser module**.



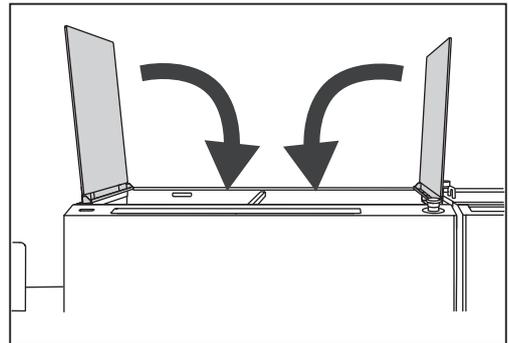
REFERENCE

Connect the connector of the **creaser module**.
 (The figure on the right shows a view from the non-operator's side;

- Left side connector: **Creaser module**)

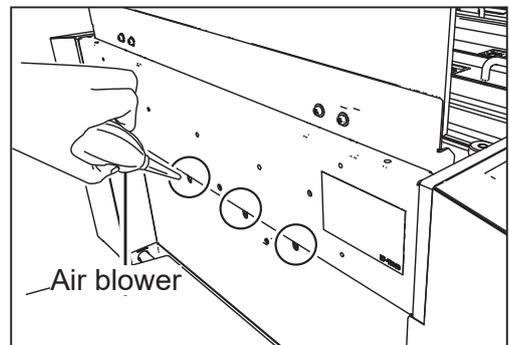


- 7 Close the **top cover 2** and the **top cover 3**.



- **Sensors at the exit area**

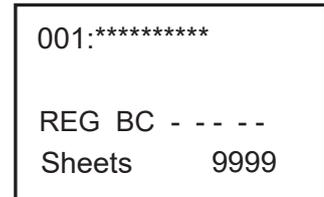
- 1 Clean the sensors at the exit area with an air blower.



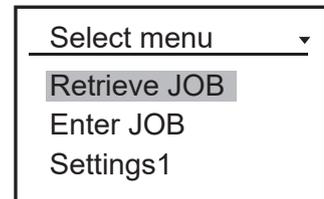
Cleaning the Conveyance Rollers

As the DC-646 processes digital color outputs, toner etc. on the documents may adhere to the surface of the **conveyance rollers** of the DC-646. Accumulation of toner may affect the performance of the DC-646. Clean the rollers according to the following procedure.

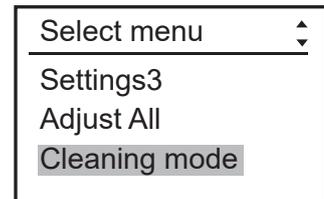
- 1 Turn the power **ON**.
- 2 Make sure that the standby screen is displayed on the LCD panel.



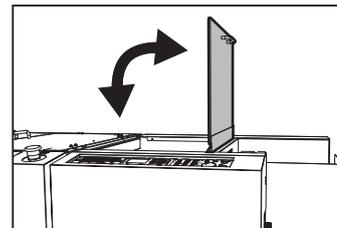
- 3 Press the F key to display the **Select menu** screen.



- 4 Select **Cleaning mode** using the CURSOR (Down) key, and press the SET key.



- 5 Every time the **top cover 1** is opened/closed, the **conveyance rollers** turn 60 degrees. Wipe off the toner and debris on the rollers with a tightly wrung cloth.



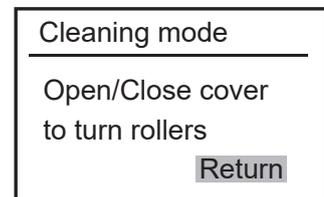
IMPORTANT

Do not wipe the rollers with anything other than that specified above. Use of anything else may result in mechanical malfunction.

! WARNING

Do not put your hands or fingers in the feeding part when cleaning it. Your hands or fingers may be caught and injured.

- 6 After cleaning the rollers, press the RETURN key to return to the **Select menu** screen.



Cleaning the Skew Correction Belt

Long hours of machine use result in accumulation of paper dust.

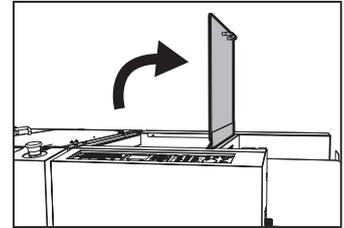
Wipe off the paper dust with a cloth while turning the **skew correction belt** with your hand.

- 1 Open the **top cover 1**.



WARNING

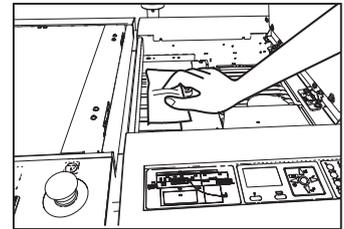
Do not put your hands or fingers in the feeding part when cleaning it. Your hands or fingers may be caught and injured.



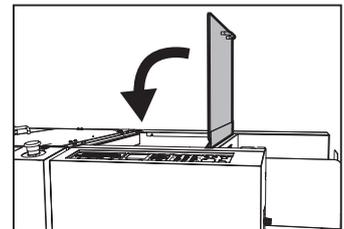
- 2 Wipe off the paper dust with a cloth while turning the **skew correction belt** with your hand.

IMPORTANT

Do not wipe the **skew correction belt** with anything other than that specified above. Use of anything else may result in mechanical malfunction.



- 3 Close the **top cover 1**.



About Slitter Tool Intersection Correction

If a heavy weight document is jammed in the slitter area and the document is pulled out by force, the slitter upper tool and the lower tool may intersect each other.

Also, If the document cannot be slit or conveyed, the tools may have intersected.

In this case, follow the procedure below to correct the upper tool or lower tool position.

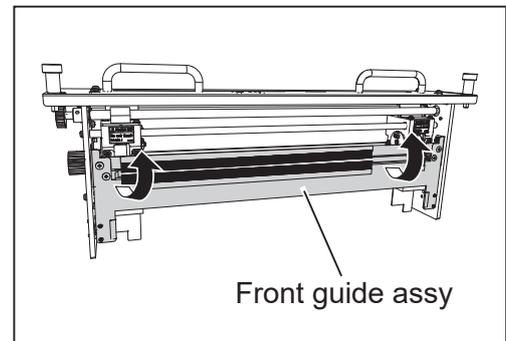
REFERENCE

Slitters differ in shape depending on modules.

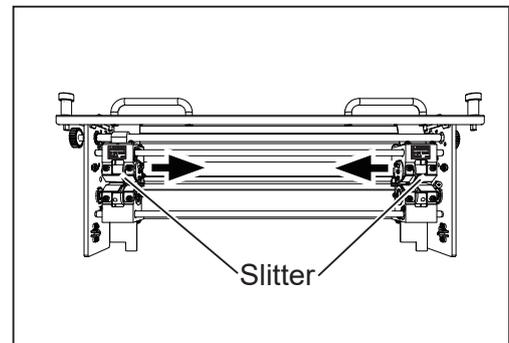
The slitter 3 and the slitter 4 are the same in shape. (→ P.18 Before Preparing a Document)

The slitter 5 and the slitter 6 are the same in shape. (→ P.18 Before Preparing a Document)

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



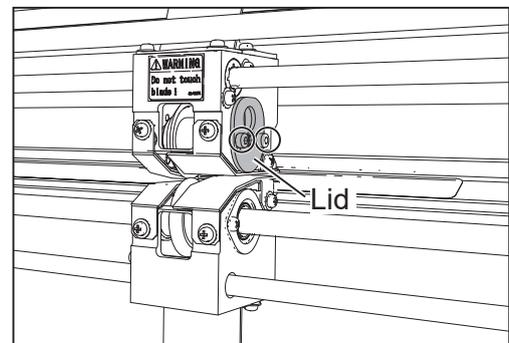
- 2 Move the slitters to the center of the module.



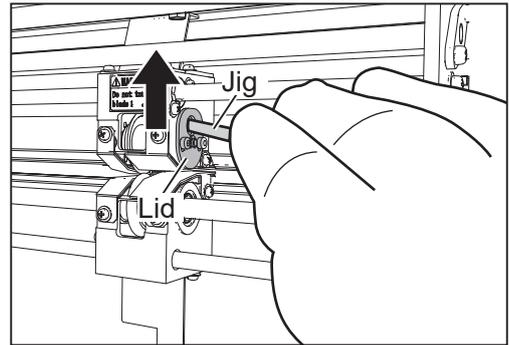
- 3
 - In the case of slitter 3 and slitter 4
 - 1. Loosen the two hexagon socket head cap screws securing the lid of the slitter with the intersecting tools. (The figure on the right shows the slitter 3.)

REFERENCE

You can lay the **slitter module** on its side if it is easier for you to carry out the work.



2. Insert the jig into the hole of the lid while sliding the lid upward.



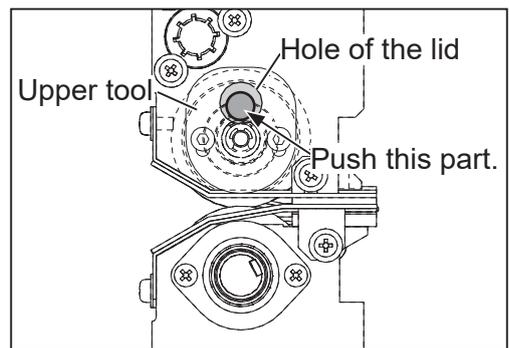
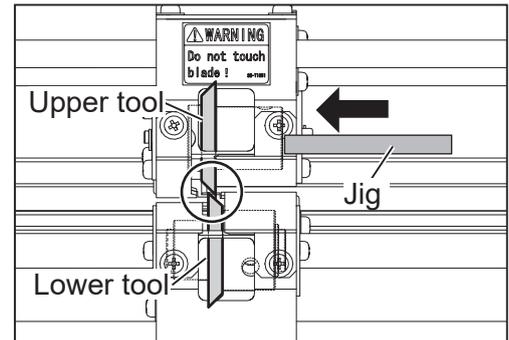
3. Push the jig in the direction of the arrow to correct the intersecting upper tool.
The figure on the right shows that the upper tool and the lower tool intersect.

REFERENCE

Pushing the jig in without sliding the lid may damage the upper tool and the lower tool.

REFERENCE

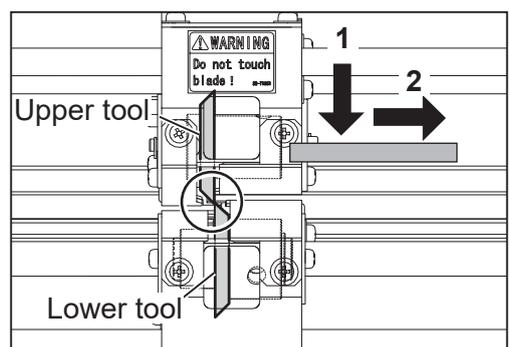
Push the indicated part in the figure on the right with the jig.



4. Pull out the jig while pushing the lid downward.
Make sure that the tool intersection is corrected.

REFERENCE

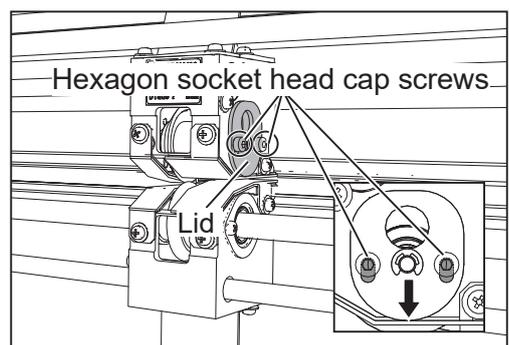
The figure on the right shows that the tool intersection is corrected and the tools are in the normal position.



5. Tighten the two hexagon socket head cap screws to secure the lid.

REFERENCE

Lower the lid and tighten the hexagon socket head cap screws.



Daily Maintenance

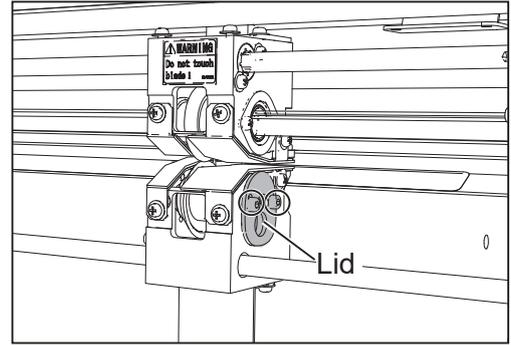
- In the case of slitter 5 and slitter 6

1. Loosen the two hexagon socket head cap screws securing the lid of the slitter with the intersecting tools. (The figure on the right shows the slitter 5.)

REFERENCE

You can lay the **slitter module** on its side if it is easier for you to carry out the work.

2. Insert the jig into the hole of the lid while sliding the lid downward.



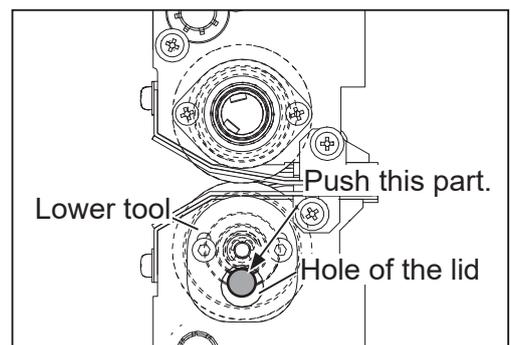
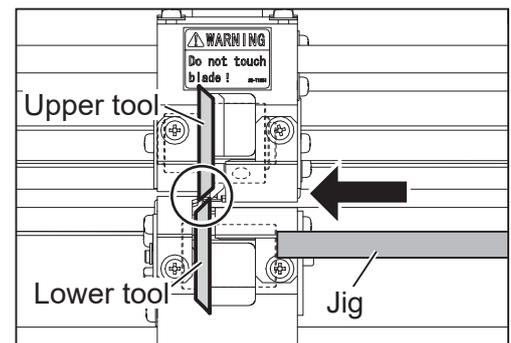
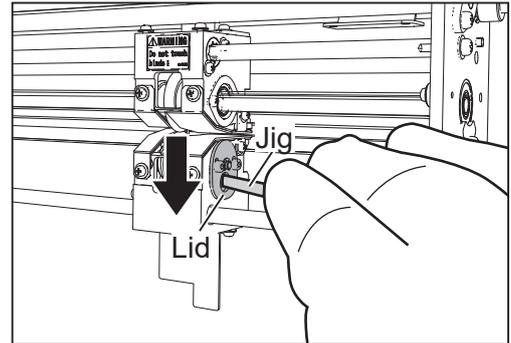
3. Push the jig in the direction of the arrow to correct the intersecting lower tool. The figure on the right shows that the upper tool and the lower tool intersect.

REFERENCE

Pushing the jig in without sliding the lid may damage the upper tool and the lower tool.

REFERENCE

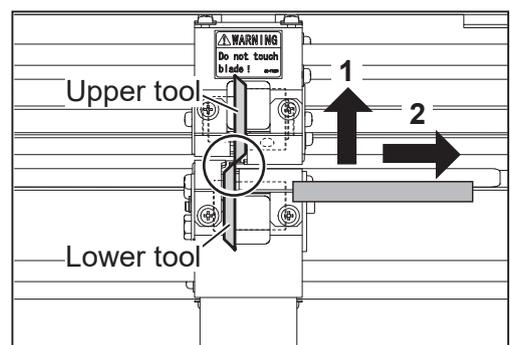
Push the indicated part in the figure on the right with the jig.



4. Pull out the jig while pushing the lid upward. Make sure that the tool intersection is corrected.

REFERENCE

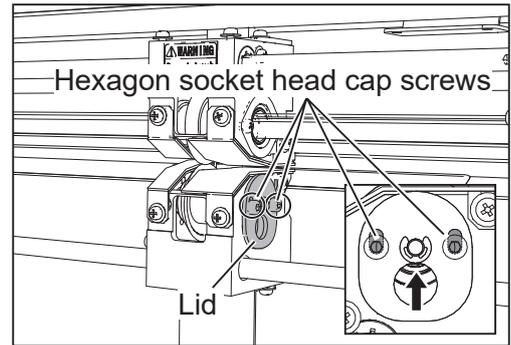
The figure on the right shows that the tool intersection is corrected and the tools are in the normal position.



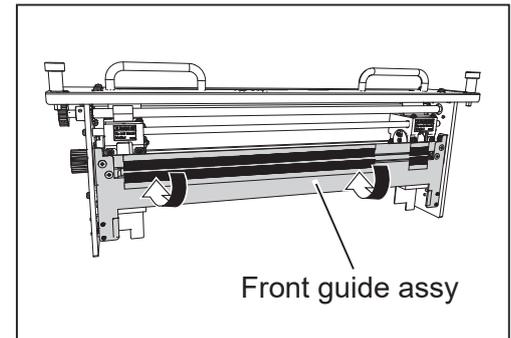
- Tighten the two hexagon socket head cap screws to secure the lid.

REFERENCE

Raise the lid and tighten the hexagon socket head cap screws.



- Attach the **front guide assy** in the direction of the arrows.



Waste Box

Slit waste accumulates in the waste box. Open the **front cover** and remove them periodically. Accumulation of waste may cause a document jam. Follow the instructions below for removing the waste.

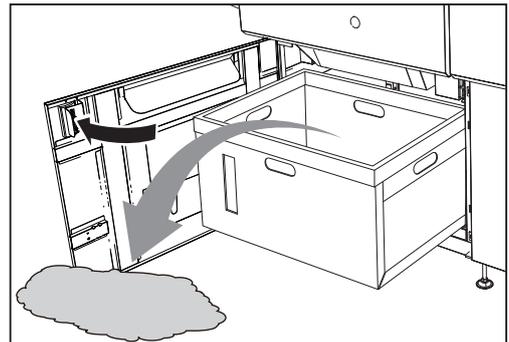
REFERENCE

When processing a document of more than 670 mm, remove the waste frequently.

WARNING

Be sure to confirm that the machine is fully stopped before removing the accumulated waste to prevent your hands or fingers from being caught.

- 1** Confirm that the machine is fully stopped.
- 2** Open the **front cover** and take out the waste box. Then remove the waste in the waste box.



- 3** If waste remains inside the machine when taking out the waste box, remove it.
- 4** Put the waste box back in its place and close the **front cover**.

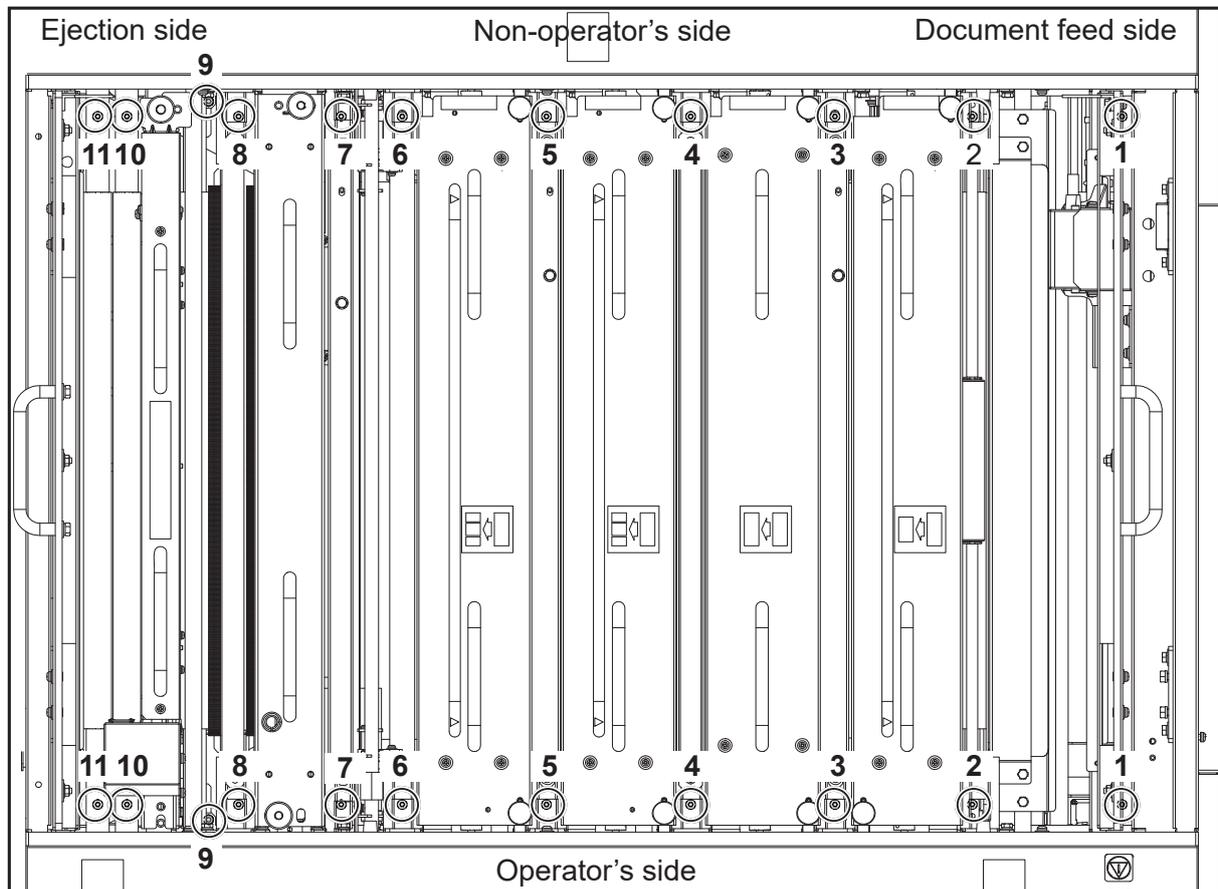
About Protection of Press Rollers

If the **press rollers** stay at the same position for a long time, they may be deformed by the pressure from the **back-up rollers**. To prevent them from being deformed, if the machine does not operate for one hour with the power on, the rollers automatically rotate at low speed. When you do not operate the machine for a long period of time (approx. two weeks), release the contact of the **back-up rollers** and the **press rollers** according to the following procedure.

The hexagon socket head cap screws releasing the contact of the **back-up rollers** and the **press rollers** are located at 11 places on the operator's side and the non-operator's side shown in the figure below.

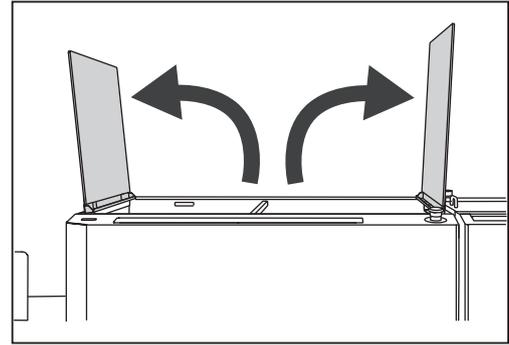
Loosen them by using the supplied hexagon wrench.

The screws **1** to **8**, and **10** to **11** are located at the upper side and can be loosened directly. The screw **9** is located at the lower side.



About Protection of Press Rollers

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

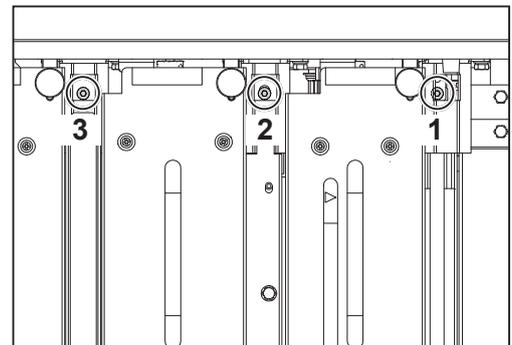


- 2 Releasing the **back-up roller** pressure of **1 to 8**, and **10 to 11**

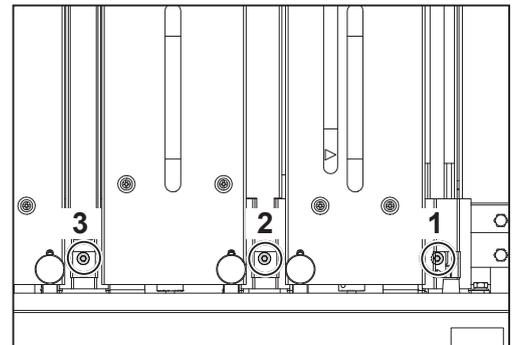
Turn the hexagon socket head cap screws (of **1 to 8**, and **10 to 11**) adjusting the **back-up roller** pressure counterclockwise by using the supplied hexagon wrench.

The figures on the right show **1 to 3**. Carry out the work for **4 to 8**, and **10 to 11** in a similar way.

Non-operator's side **1 to 3**

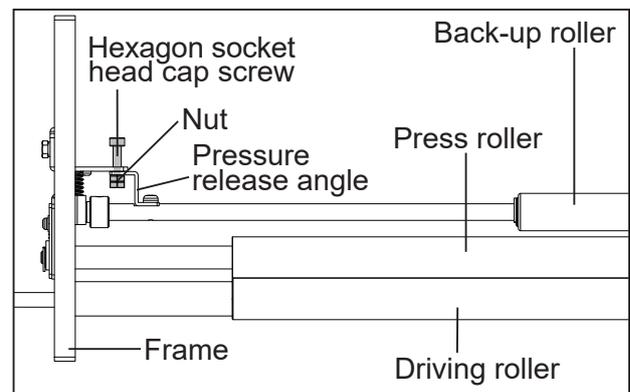


Operator's side **1 to 3**



REFERENCE

Turn the hexagon socket head cap screws counterclockwise until they stop to loosen them.



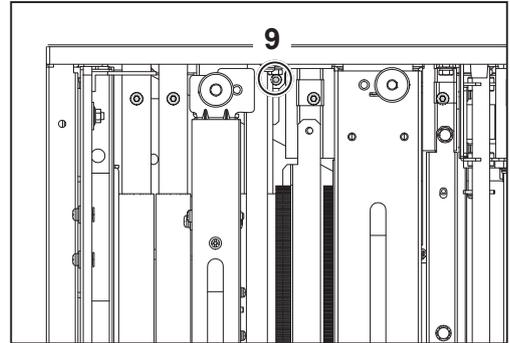
3 Releasing the **back-up roller** pressure of 9

Turn the hexagon socket head cap screw (of 9) adjusting the **back-up roller** pressure clockwise by using the supplied hexagon wrench.

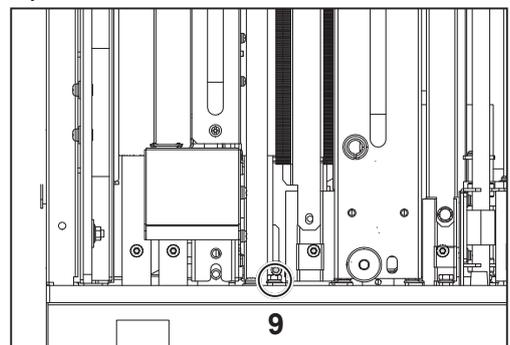
REFERENCE

You can turn the hexagon socket head cap screws without removing the **cover**.

Non-operator's side 9

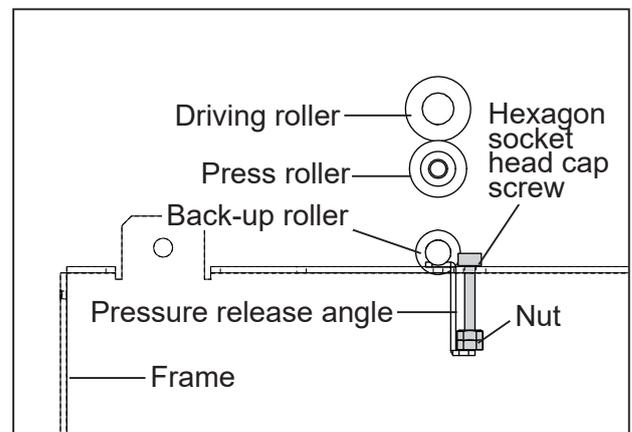


Operator's side 9



REFERENCE

Turn the hexagon socket head cap screws clockwise until they stop to loosen them.



4 When using the machine again, be sure to bring the **back-up rollers** into contact with the **press rollers** by tightening the loosened hexagon socket head gap screws.

Chapter 7

Specifications

This chapter lists the machine specifications.

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.....

Specifications

Model name	DC-646
Product type	Slitter/Cutter/Creaser Floor model
Feeding method	Belt suction
Feed tray	Elevator
Infeed document size	Width: 210.0–370.0 mm (8.27–14.56 in) Length: 210.0–999.9 mm (8.27–39.36 in) *Max length of the feed tray: 710 mm
Minimum finishing size	Width: 48 mm (1.89 in) Length: 50 mm
Document weight	Slit/Cut: 110-400 gsm Crease: 110-350 gsm • Laminated or UV coated stock: within the above range including lamination/coating layer.
Document type	Coat, non-coat, laminated
Paper curl	No curl (within 5 mm) *With documents over 350 gsm: within 3 mm
Feeder capacity	100 mm * There is the load limitation for a document of over 670 mm.
Speed	30 sheets/min (A4 SEF, 2 cuts and 1 crease) With REG ON (Every sheet): 22 sheets/min
Tolerance	+/- 0.2 mm on finished size (Business card: +/- 0.3 mm) *With documents over 350 gsm: +/-0.3 mm (Business cards: +/- 0.4 mm) *With documents over 670 mm: +/-0.6 mm *The crease tolerance depends on the number of creases on the documents and their depths.
Side margin slits positions	3.2–55 mm from the side edges
Number of slits	Max 6 slits on 1 document (Side margin slit × 2, Center slits × 4)
Gutter slit widths	5.0–15.0 mm (Gutter slit wider than 15 mm are output on the exit tray.)
Gutter slit deflector	Max 2, automatic control
Number of cuts	Max 30 cuts on 1 document
Cut positions	Lead cut trim: min 3 mm Gutter cut: min 3 mm Last cut trim: min 5 mm
Number of creases	Max 20 creases on 1 document
Crease depth adjustment	3 steps (from the control panel or from the PC Controller)
Exit tray	Drop down tray
Exit tray capacity	140 mm * Exit tray length: 670 mm
Card stacker capacity	60 mm
Control panel	64 dots×128 dots LCD, OK monitor
Panel languages	English, French, German, Italian, Spanish, Polish, Russian, Japanese
Job program	From the control panel and/or from the PC Controller

Model name	DC-646				
Standard functions	<ul style="list-style-type: none"> • 250 jobs can be stored in the machine. (Job files can also be stored in the via PC Controller.) • Test feed • PDF template generator • Feed skew adjustment • Air knife • Ultrasonic double feed detection • Emergency stop • Automatic job setup by reading Barcode • Image drift compensation by reading REG mark • End mark detection • Reject (Document length: 670.0 mm or shorter) • Pause feeding • Job lock • Batch separation (Not available when IFS connected.) • PC Controller (USB connection: B-type connector) Compatible OS: Windows 8.1 (32bit/64bit) Windows 10 (32bit/64bit)				
Optional devices	RTM-02 Rotary Tool Module CPM-02 Cross Tool Module OSM-02 Optional Slitter Module PCM-03 PC Arm AIR-05 Side Air CRM-12 Light Weight Paper Creaser module				
Power supply	100 VAC±10%, 50/60 Hz 115 VAC, 60 Hz 230 VAC, 50/60 Hz				
Power consumption		Consumption		Standby	
		Current	Power	Current	Power
	100 V	4.7 A	430 W	0.7 A	66 W
	115 V	4.0 A	420 W	0.74 A	70 W
	230 V	1.9 A	400 W	0.54 A	73 W
Dimensions	<ul style="list-style-type: none"> •DC-646 115V, DC-646 230V In use (standard): 2310(W)×1005(D)×1110(H) mm In use (max paper): 2510(W)×1005(D)×1110(H) mm When stored: 1650(W)×1005(D)×1110(H) mm When packed: 1760(W)×880(D)×1335(H) mm •DC-646 100V, DC-646 230V (ASIA), DC-646 115V (TAIWAN) In use (standard): 2310(W)×765(D)×1110(H) mm In use (max paper): 2510(W)×765(D)×1110(H) mm When stored: 1650(W)×765(D)×1110(H) mm When packed: 1760(W)×880(D)×1335(H) mm 				
Weight		Net weight	Gross weight		
	DC-646 230V	280 kg	345 kg		
	DC-646 115V	280 kg	345 kg		
	DC-646 100V DC-646 230V (ASIA) DC-646 115V (TAIWAN)	275 kg	340 kg		

Specifications

Model name	DC-646
Operating temperature	10°C–30°C (50°F–86°F)
Operating humidity	40%RH–70%RH (No condensation)
Storing temperature	0°C–50°C (32°F–122°F)
Storing humidity	10%RH–80%RH (No condensation)
Noise level	During operation: 80 dB or less
Operating altitude	Max 1000 m ALT
Overvoltage category	Category II according to IEC60664-1
Pollution degree	Degree 3 according to IEC6064-1
Safety standard	UL CE (Low Voltage Directive, Machinery Directive) VCCI FCC

The specifications are subject to change without prior notice.

Document Curl

Due to the automated slitter function design, the document path of the DC-646 is sensitive to document curl.

If document curl is causing document jams, the following are suggestions for remedying the problem:

1. Adjust the printing devices de-curler (if available).
2. Manually de-curl the stock before loading in the feed tray.
3. Turn the document over (reprogramming the job may be necessary).
4. Use different document stock.

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