DPC-600PKG Cutting System
Installation and Operation Manual

Rev. 231215

DECLARATION OF COMFORMITY

PrintFinishing Co. Ltd., located at 625 Sec. II, Wende Road, Hsin-Pu 30544, Taiwan declares that the product compliances with the provision defined in the regulations as below.

Product Name	Model	Regulation			
		Machinery Directive 2006/42/EC	Low Voltage Directive 2006/95/EC	Electromagnetic Compatibility Directive 2004/108/EC	UL/CUL
		Standard			File No
Feeder Stacker	SF-300i ST-200	Annex I of Machinery Directive EN60204-1:2006+A1: 2009 EN-1010-1: 2004 EN-1010-2: 2006	EN60204-1: 2006+A1: 2009	EN61000-3-2 EN61000-3-3 EN61000-6-2 EN61000-6-4 CISPR16-3-2 CISPR16-2-1 CISPR16-1-2 IEC61000-4-2 IEC61000-4-3 IEC61000-4-5 IEC61000-4-6 IEC61000-4-8 IEC61000-4-11	E305160
Cutter	DPC-600	Graphic Aarts Equipment (UL775:1998 ED.3+R: 19 Nov, 2013			ETL/ETL 5017600

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Part I SF-300i Suction Feeder

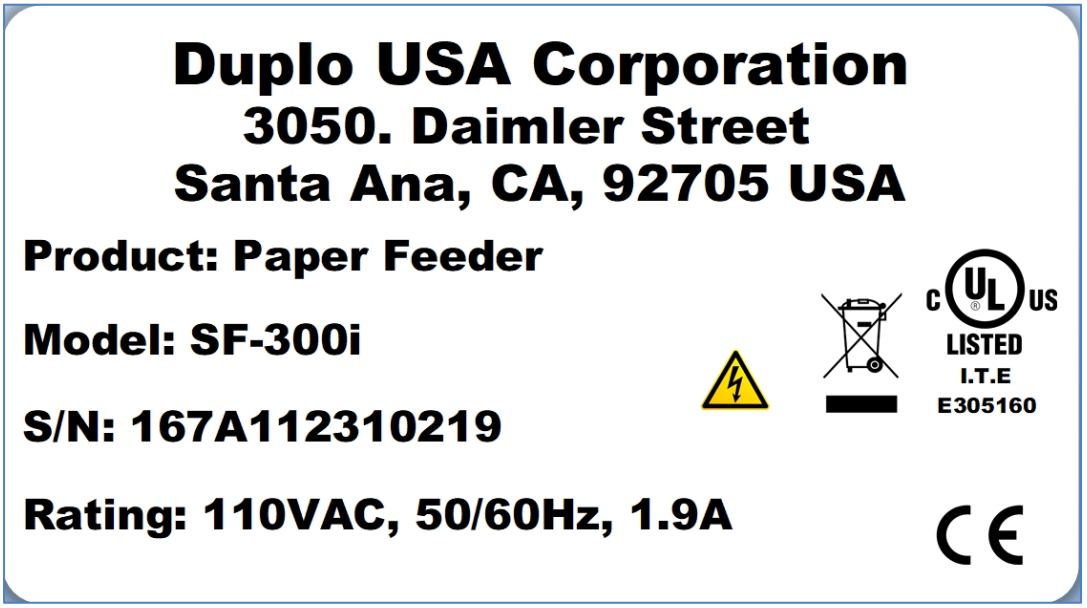
1. Introduction

The SF-300i feeder is an automatic air suction, top-feed feeder that offers cost effective and increase thruput of the DPC-600PKG flat bed cutter for **Box-on-Demand.**

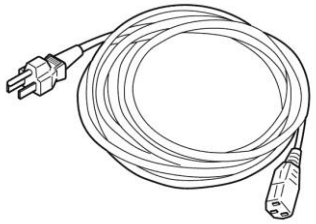
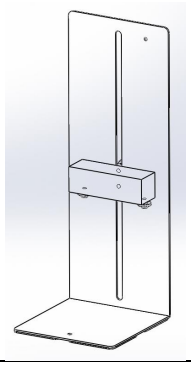
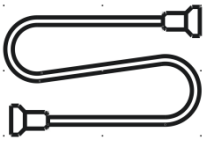
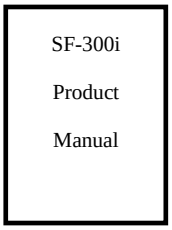
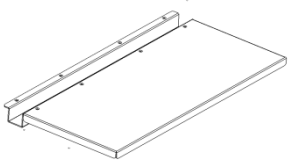
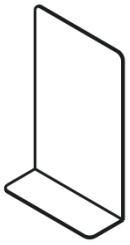
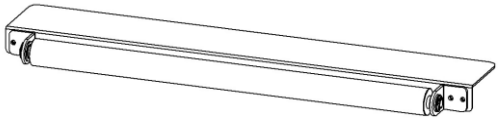
2. Specification

Specifications	SF-300i Suction Feeder
Max. Paper Width	23”
Max. Paper Length	29.5”
Min. Paper Width	12”
Max. Thickness	0.14” (3.6mm)
Paper Weight	200gsm
Min Paper Size	17 x 11” (Long edge feed)
Power Requirement	110VAC, 50/60HZ 1.9A
Dimension	77.3” x 35.4” x 39.8” (1964 x 900 x 1012.6mm)
Weight	342 lbs (155Kgs)

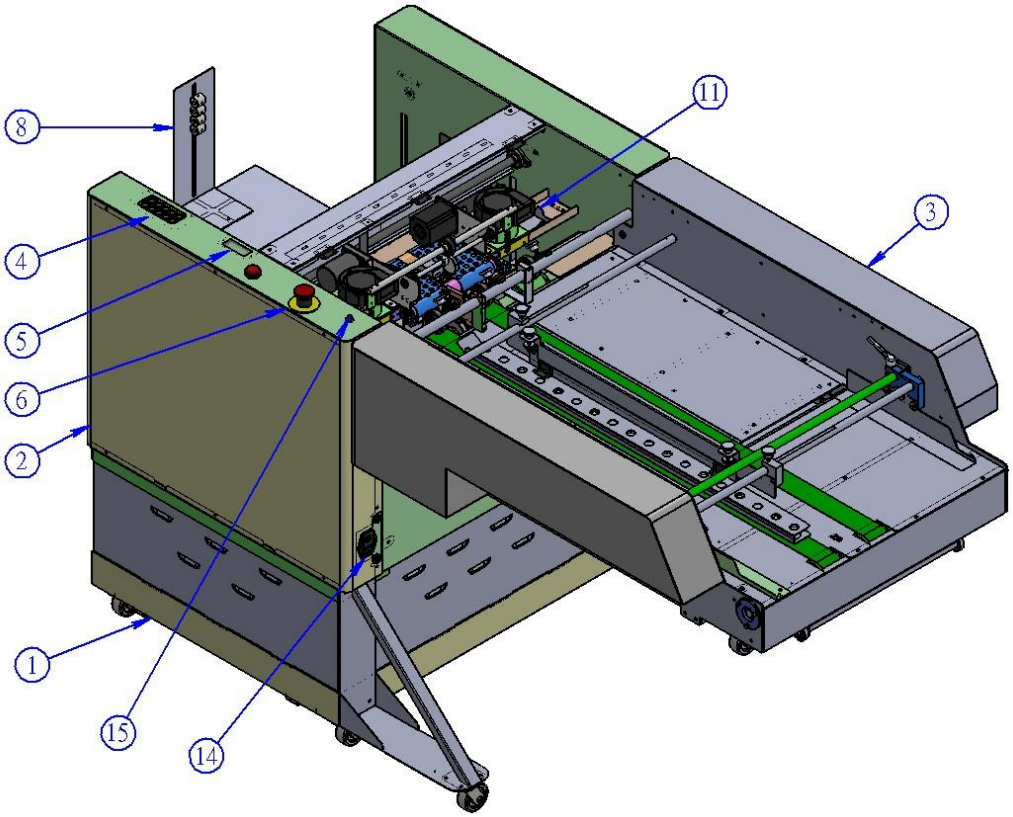
3. Name Plate

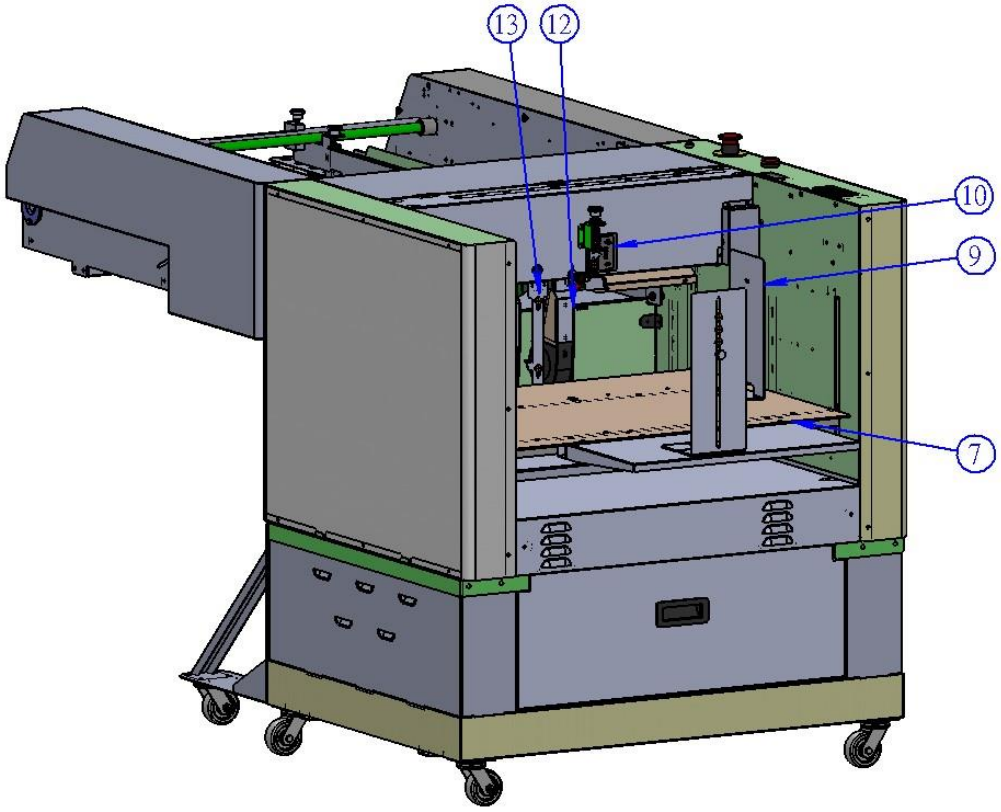


4. **Accessories List**

	
Power Cord 00P-000-3007 USA	Back Stop Asm P/N
	
Interface Cable 50cm	Product Manual (Download from Website)
	
Extension Plate	Side Guide x 2
	
DPC-600PKG Cutter – Ejection Roller Asm	

5. Key Components



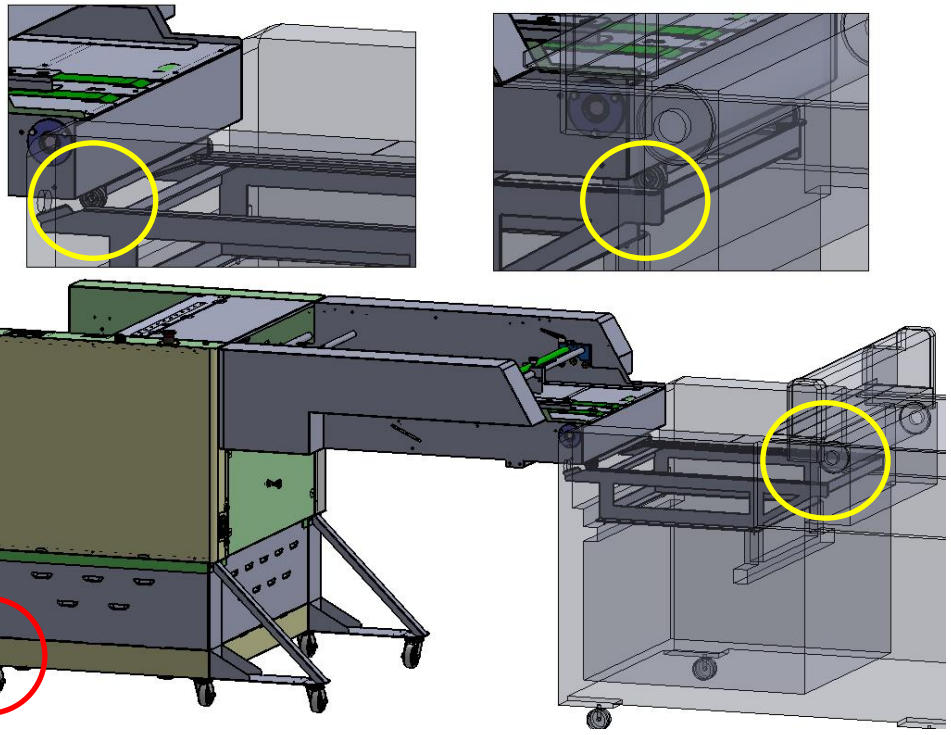


Item	Key Components
1	Base Stand
2	Feeder Body
3	Conveyor Asm
4	Conrol Panel
5	LED Display LED
6	Emergency Stop
7	Feed Tray
8	Back Stop
9	Side Guide
10	Leading Edge Index Sensor
11	Suction Feed Components
12	Blower Fan
13	Double Feed Separator
14	Upper 6-pin Interfaces with Cutter Lower 8-pin interfaces with Stacker
15	Restart Brushless Motor Switch

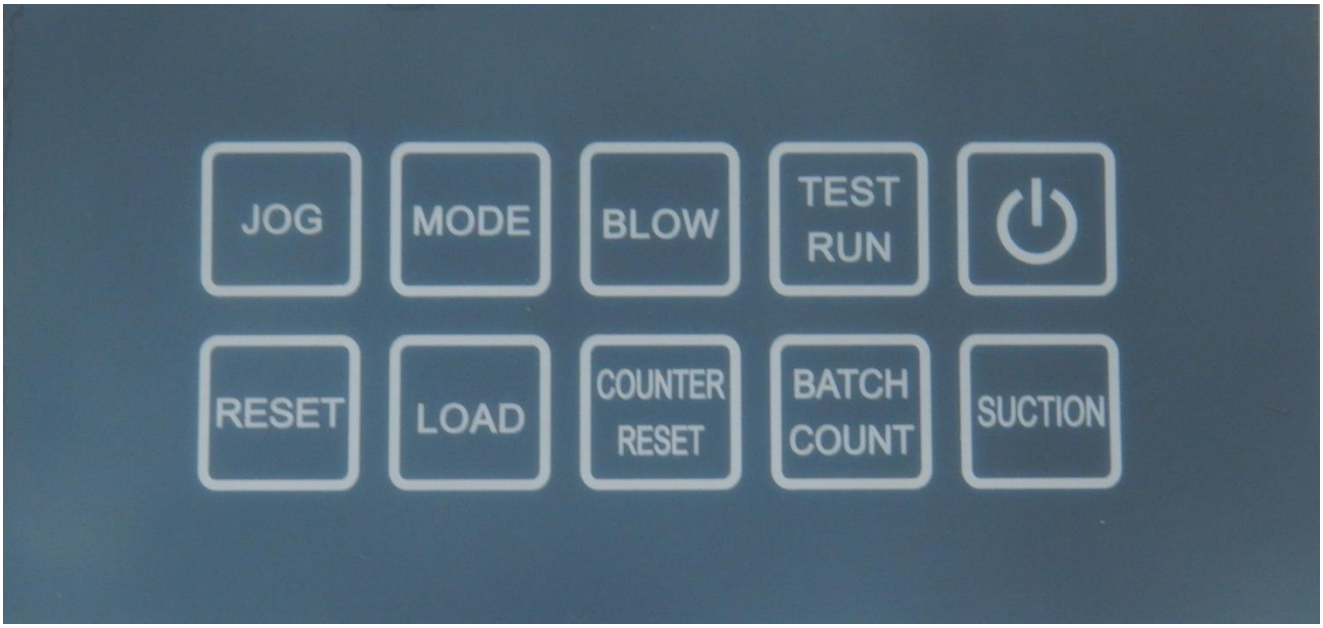
6. Installation Procedure

Integrate the feeder into cutter as shown below:

a. The front bottom of feeder conveyor has 2 ball bearings. Align the bearing with the guides on the feeder supporting chassis.
b. Push the feeder all the way into position, the bearing will contact the limit both sides.
c. Lock the caster brake.
d. Connect the interface cable with the cutter.
e. Connect the grounding wire between feeder and cutter.



7. Control Panel and Function Key

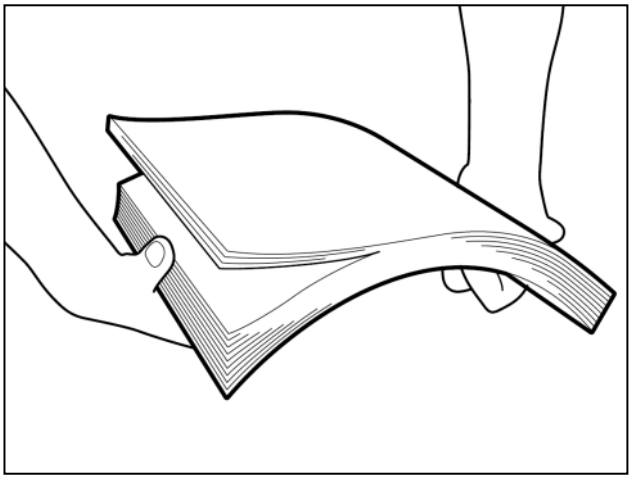


Function Keys	Function
JOG	Clear paper path and as composition key
RESET	Reset error message on the display
LOAD	Tray down to reload the media
BLOW	The blower has 4 speed to select; the higher speed has stronger air flow. SP-1~SP-4 The thicker media needs higher speed.
TEST RUN	Send one piece of the sheet to be fed to see parking position in the beginning of the job to adjust the sheet parking position to minimize gap between sheet
⏻	Start or Pause the feeder

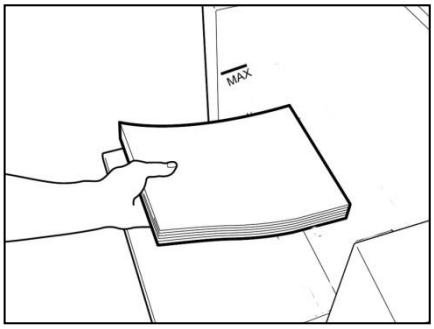
BATCH COUNT	No Function
MODE	Composition Key
COUNTER RESET	Reset counter
SUCTION	Default without adjustment

8. Loading Paper

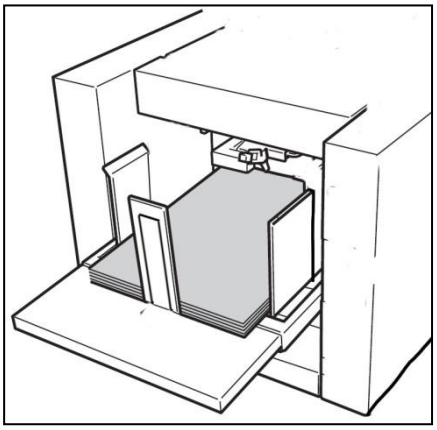
8.1 Fan the paper and make in order to separate the sheets if feeding the thin stock



8.2 Load the Paper



8.3 Setting the Guides and Back Stop.

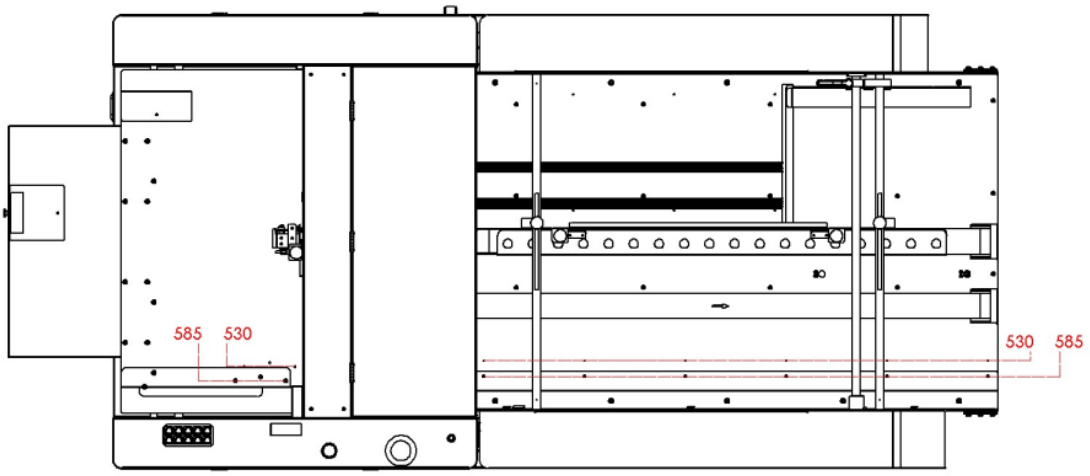


The feeder is right-hand side justify, please use the side guide and back stop to box the feed pile.

*** Back stop always set in the center of the feed tray prevents skew feed.***

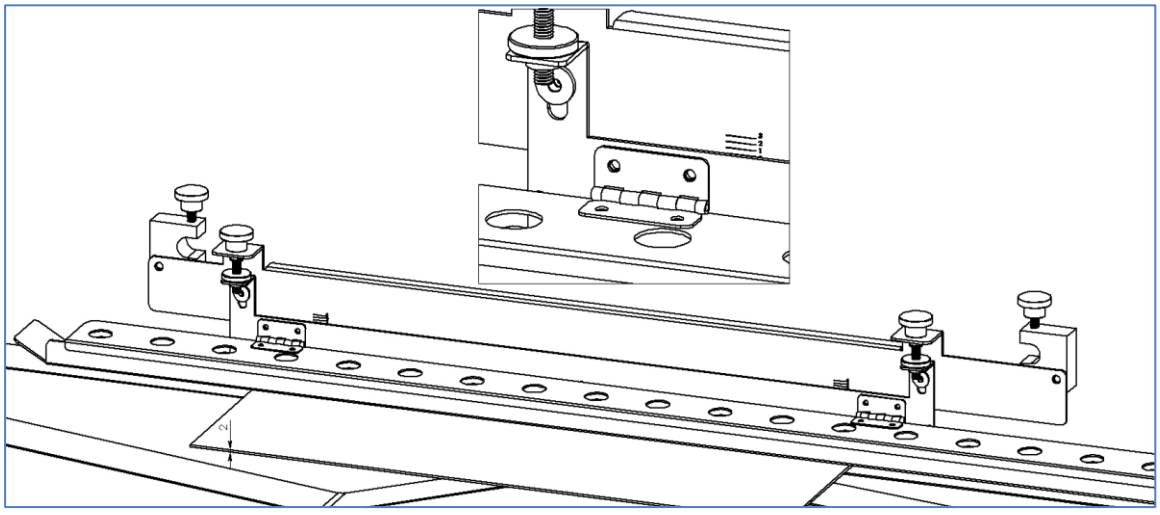
9. Operation Procedure

9.1 585mm (23”) Sheet width Setting.



1. Default Registration from factory is 530mm (B2+). It is good to run 2x18”, 13x19”, 20x14” long edge feed and short edge feed.
2. For 23” sheet width, please set it to 585mm which is 23”. Loosen the feed side guide screws (5x) and transport registration guide (6x) and re fastening it onto to 585mm position.

9.7 Transport Pressure Asm Setting



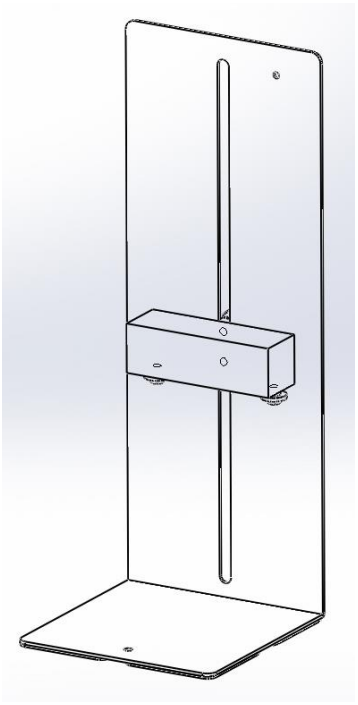
Paper Weight	Index
200~400gsm	1.0
2mm Thick Stock	1.5
3mm	2.0

9.2 Level Sensor Adjustment

Substrates				
Range	Abnormal			Normal
	Cured Up 5mm	Cured Up 10mm	Cured Down 10mm	
200~400gsm	-1.0	-2	3.0	1.0
2mm Thick Stock	N/G	N/G	N/G	1.5
3mm	N/G	N/G	N/G	2.0

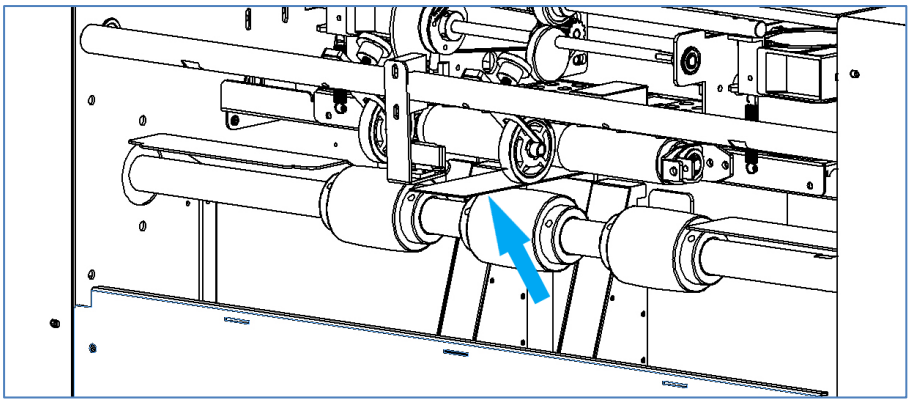
Note: The curled /curled down substrates are after Spot UV and laminated sheet.

9.3 Weight



The paper is always in position to hold the paper pile doesn't matter it is thick or thin which will be preventing the double feed especially 200gsm ~400gsm paper.

9.4 Pinch Roller Pressure Setting



Thickness	Piece of 200gsm Paper Strip to Adjust
1mm	1 x 200gsm Strip
2mm	2 x 200gsm Strip
3mm	3 x 200gsm Strip

**********To set pinch roller little bit tight**********

9.5 Separator Setting

While using the Weight to hold the feed pile, the Separator is not necessary to use,

If the weight still experiences double feed, please set the separator as below:

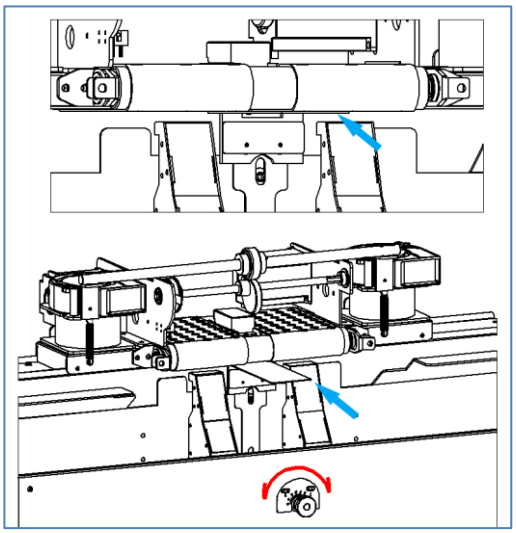
9.5.1 Think stock 200gsm~ 400gs

a. Rotate the knob clockwise to lower the separator down allow the paper strip in

b. Place a piece of 200gsm paper strip between suction belt and double feed stopper.

c. Rotate the knob counterclockwise to hold the sheet against the suction belt.

d. Pull the sheet to feel, it has a little bit drag and tight.



9.5.2 For 2 or 3mm thick stock, using the substrate to be fed as a gauge to set it loose.

9.6 Setting the Clapper

9.6.1 Loosen the clapper holding Screw and push it aside.

9.6.2 Press to bring one sheet in to standby position

9.6.3 Move the clapper in and against the edge of the sheet. Be sure to eepk 0.5~1mm spacing.

9.7 Change Blower Speed

The blower force is adjustable, thin stock say 200gsm set it to SP-2~3, thicker substrates set it to SP-4 by holding the

then tip on

to change the speed from SP1>>SP2>>SP3>SP4>>SP1>>SP2>>SP3>>SP4 cycle.

9.8 Optimum the gap between sheets

There is 0~9 can be adjusted, each no represents 15mm increment.

Press the sheet will be fed and parked at standby sensor, hold

+ tip on

, every tip has 1 increment, total 0~9 can be adjusted, each number represents 15mm increment. 6 for B2+ or B2 sheet, 9 for 19x13” sheet.

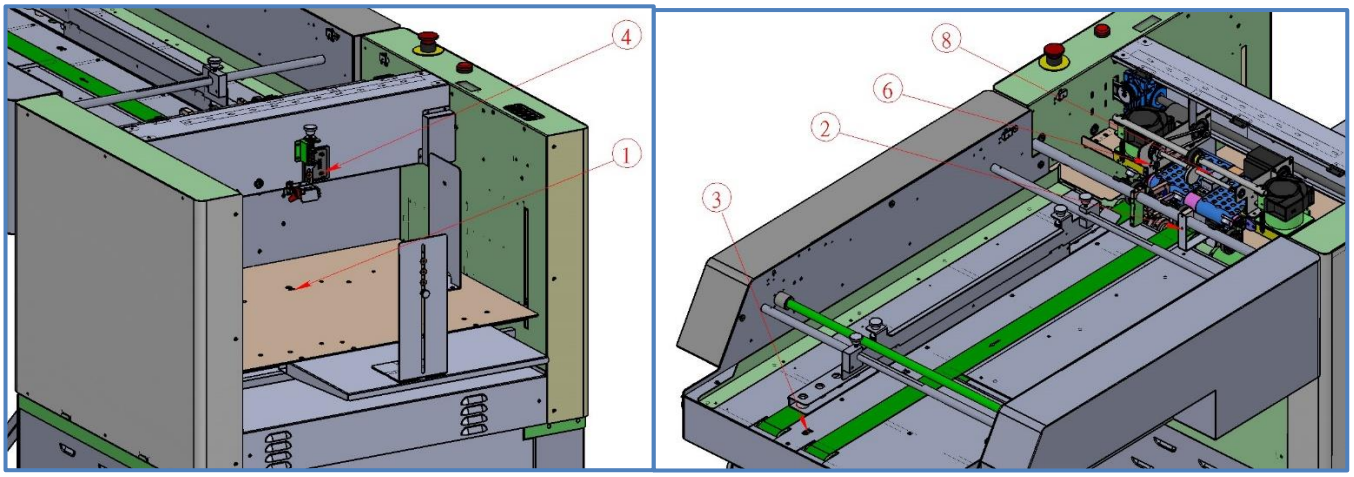
9.9 Reset Counter

Hold the

for 1 second, it will be rest to 0

10. Sensor Location

Sensor No	Description	Function
S2	Feeding Sensor	Make sure feeding is success
S3	Exit Sensor	Standby Sensor is detected by cutter feeding signal
S4	Level Sensor	Detect feed tray height
S6	Suction Fan On/Off	Accurate feeding control



11. Error Message

Error Code	Symptom	Action
E001	Paper does not reach S3	1.1 Readjust side the guide 1.2 Check the media quality 1.3 Clean Sensor 3 if needed 1.4 Adjust the Level Sensor height
E002	1 Paper does not reach to S2 2 Undesired paper under S2 when pressing the “START” key	1.1 Correct skew, readjust side guide 1.2 Check media not flat or curled 1.3 Sensor #2 dirty 1.4 Adjust the Level Sensor height 2. Remove the paper
E003	1. Undesired paper under S3 2. Sensor 3 detect InfraRed	1. Clear the paper out 2. Block the Infra Red source
E004	Feed Tray keeps going down	Level Sensor failed
E005	S3 seeing paper too long	Remove jamed paper in Standby Sensor
E006	Suction Fan no On/Off function	Suction Fan On/Off Index Sensor failed
E008	Sensor 8 keeps seeing Actuator/	1. Sure Feed Sensor Trigger malfunction
E009	Feed tray reach to upper or bottom margin	Hold the Red button and press “Load” or “Start” key to release the lock signal
E010	Stacker not Ready	
Ld Er	Cover not closed or in place	Close the cover
db Er	Double feed.	1. Adjust the level sensor lower 2. Raise separator
tP Er	Feed tray up to suction head then down without feeding	Sensor 4 Level Sensor too High
“- -“	Feed tray stop at bottom limit	Feed tray empty and reach to bottom mrgin switch
“----“	Feed tray stop at the upper limit	Feeder tray reaches top margin switch
Error can not reset	1. Standby sensor sensed the Infra Red 2. Paper path has paper	1.Try to cover the sensor to block the Infra Red 2. Remove the sheet in paper path
No Power	E-stop is ON	Reset E-stop

Recommended Spare Parts

Index	P/N	Name
5.1.01.04	DBM-24V-BL60	Brushless Motor, BL60M80-A, DC24V, 5.2A
5.1.01.06	00B-0XL-105A	Belt, 0.2P, 106XL
5.1.01.07	DBD-0BL-1250	DC Brushless Motor Driver, BL-1250V, 24 / 48V, 6A
5.1.01.11	B/B-000-2280	Ball Bearings, 608ZZ
5.1.01.14	CHN-000-0035	Chain, 35 Segment, 00C-000-0504
5.1.01.15	CHN-000-0019	Chain, 19 Segment, 00C-000-0503
5.1.01.21	00A-000-1001	Asm, Logic Board
5.1.01.22	00A-000-1901	Asm, Sensor Adaptor Board
5.1.01.23	00A-000-1211	Asm, Power Board
5.1.01.24	00A-000-1111	Asm, Interface Board
5.1.01.25	00A-000-1311	Asm, Relay Board
5.1.01.26.2	I/S-000-VM05	Interlock Switch, 00S-000-6105
5.1.01.26.3	00A-000-0177	Asm, Paper Sensor, Black
5.1.01.30	00A-000-1501	Asm, Keyboard
5.1.01.31	00A-000-1601	Asm, Display Board
5.1.01.34	E/S-000-0USA	E-Stop, USA
5.1.01.37	R/S-000-0001	Rest Switch, Brushless Motor
5.1.02.04	S/M-075-B055	Motor, 3A, 2.58V, 55x55x75
5.1.02.06	00B-0XL-130B	Belt, 0.2P, 130XL
5.1.02.10	B/B-000-2280	Ball Bearings, 608ZZ
5.1.02.13	CHN-000-0035	Chain, 35 Segment
5.1.02.14	CHN-000-0019	Chain, 19 Segment
5.1.03.02	FAN-12V-0080	FAN, DC, 12V, 80MM, 00F-000-0003
5.1.03.06	P/S-24V-350W	Power Supply NES - 350 - 24
5.1.05.07	B/B-00R-1960	Ball Bearings, R-1960ZZ, 626ZZ
5.1.05.08	00A-00B-0177	Sensor, Paper, White
5.1.06.19	S/B-090-0346	Belt, Suction, 90 x 346
5.1.06.23	00B-0XL-072A	Belt, 0.2P, 72XL
5.1.06.30	00B-0XL-148A	Belt, 0.2P, 148XL
5.1.06.33	00S-000-1513	Index Sensor
5.1.06.39	166-106-390A	Sensor, Sure Feed
5.1.07.09	G/B-NRV-3060	Gear Box NRV30-60-L
5.1.08.12	166-108-030A	Separator
5.1.09.06	FAN-24V-9BMB	Fan, Blower, 9BMB24P2K01, 162-109-070A

5.1.10.07	H/B-000-1612	Hard Bushing, OD16, ID12
5.1.10.08	O/W-000-FC16	One Way Clutch, FC-16, 162-109-080A
5.1.11.02	162-110020A	Asm, Pinch Roller, SF-200
5.1.11.09	00A-000-0177	Asm, Paper Sensor, Black
5.1.12.07	00A-00B-0021	Level Sensor Asm
5.2.06	F/B-050-2320	Flat Belt, 50 x 2320 mm
5.2.09.04	CUS-0GM-2015	Shock pad GM-2015
5.2.09.05	CUS-0GM-2518	Shock pad GM-2518
5.2.09.11-2	S/M-110-0055	Motor, SQ, 3A, 2.58V, 110x55x55mm
5.2.09.11-5	00S-000-1509	Sure-Feed Sensor ASm

Part II DPC-600PKG Digital Die Cutter

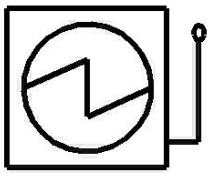
1. Introduction

1.1 What is the DPC-600PKG Does.

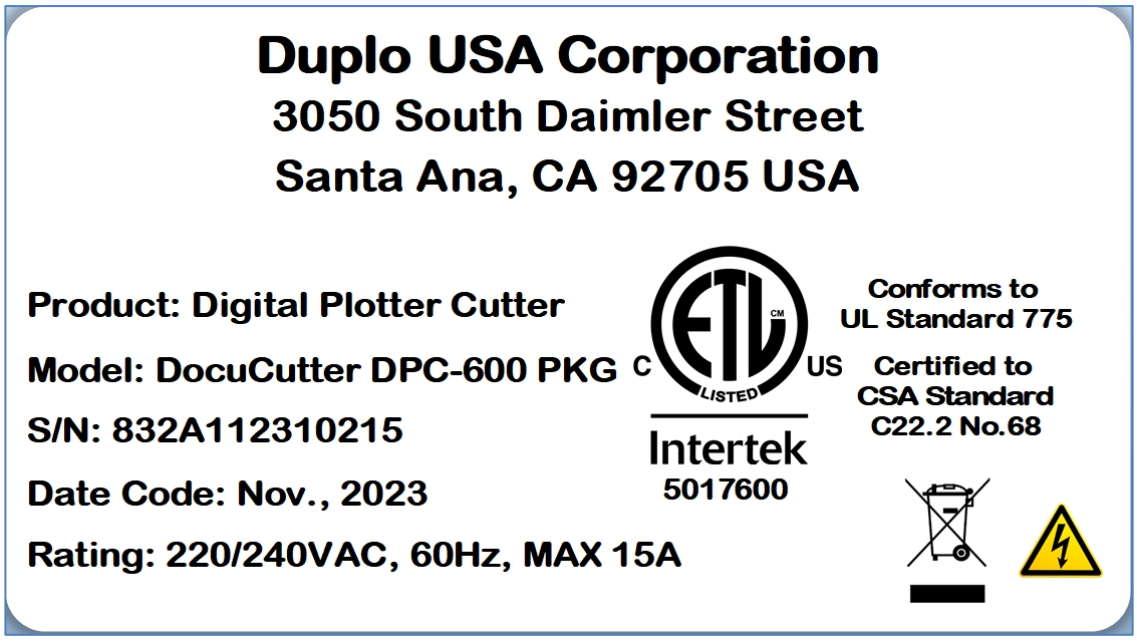
DocuCutter DPC-600PKG is design for cutting and creasing to the digital printed material, such as labels, cardstock, synthetic (may varies) and corrugated board for die cutting especially for packaging, Box-on-Demand.

1.2 Symbol Description

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

	Be careful of high voltage or the rigsk of electric shock.
	Power Switch
	Be careful of rollers and keep your hands away.
	Be careful of touching the blades. The blades are extremely sharp which could result in a serious injury when coming into play with hands or other parts of the body
	Warning **signs: kn**ife change reminder Please reset the tool depth after changing the tool. Prevent the Blade/knife damage the conveyor belt

1.3 Name Plate



1.4 USAGE PRECAUTIONS

1.4.1 Before Operation

a. Understand emergency stop button and main power location.

b. Tools and sundries should not be put on the machine.

c. No obstacles should surround or be placed on top of the machine.

1.4.2 During Operation

a. Do not open any doors or guards.

b. No personnel in risk areas.

c. No maintenance and repair.

1.4.3 Maintenance

a. Power must be turned off before leaving the machine.

b. The location of each limited switch is identified.

c. Check all buttons and switches are in the normal position.

d. Switches must be turned off before opening any door/guards.

1.4.4 Others

a. Damaging all external and internal panels and controls is forbidden.

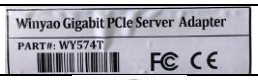
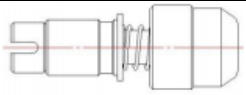
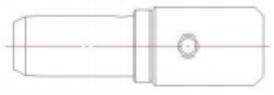
b. Do not cover each button and switch.

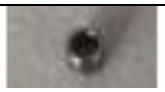
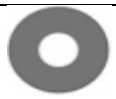
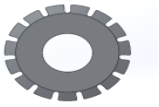
c. The machine should be kept clean at all time. Warning signs and tags on the machine should not be removed or destroyed.

2. Specification

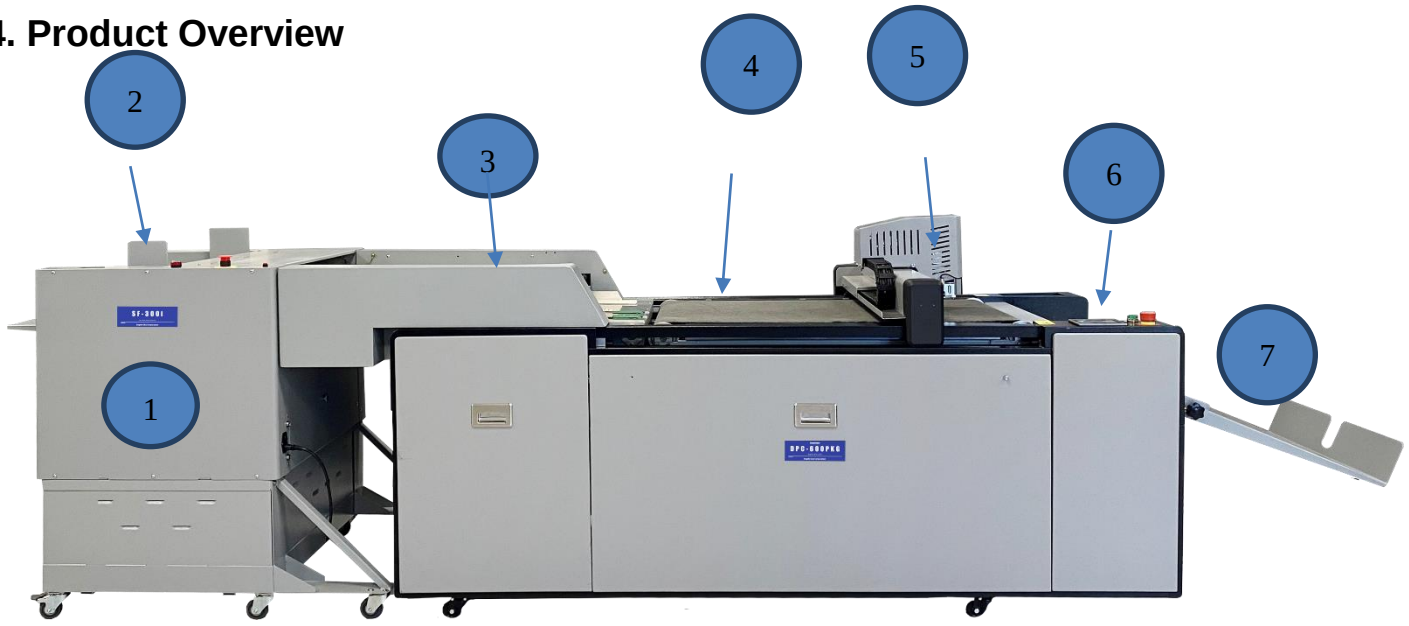
Max Sheet Size w/o CCD	L31.5” x W23.6”
Max sheet size with CCD	L31.5” x W23.6”
Min Sheet Size	L17” × W11” (Long edge feed)
Min Sheet Width	12”
Maximum Paper Weight	400gsm or 3.6mm Thickness from feeder, > 3.6mm manual feed
Minimum Paper Weight	200gsm
Productivity	15-45 secs per 12x18” depends on layout complexity
Repeat accuracy	±0.1mm
File format	PLT、DXF、XML
Data Interface	Ethernet
Registration System	CCD
Registration mark	Circle or dot with 5-10mm
Bar Code for File Retrieving	QR Code
Power Rating	220V±10%, 60HZ, 15A
Air Pump	1.5kW
Computer	Processor I5 7500 Series Dual Core or higher, Ram 4GB or more, Hard Drive 5GB {SSD drives recommended for optimal performance), Ethernet Port: 10/100Mb x1, PCI-E 1Gb Ethernet card x1, Display: 19” LCD or bigger
Safety	CE/ETL
Roll to Sheet	Option
Machine Dimension - Net	L75.6” {2700mm} x W31.1” {1100mm} x H41.7” {1100mm}
Machine Dimension - Packing	L86.6” {3300mm} x W39.4” {1220mm} x H60.2” {1530mm}
Machine Weight - Net	926 lbs {420Kgs}
Machine Weight - Packing	1433 lbs {650Kgs}

3. Accessories

P/N	Name	Photo	U/M	Qty	Remarks	Check
PCB-831-PCIE	PCIe Server Adaptor		Pcs	1	For CCD	
00C-831-0001	Cable, Ethernet, 01.53.0066		Pcs	1		
00W-831-0001	Wire, Grounding		Pcs	1		
00P-831-0001	Power Cord		Pcs	1		
Key-831-0001	Key, Electric Cabinet		Pcs	1		
Kit-831-0002	Kit, Screw		Pcs	1		
Kit-831-0003	Kit, Tool		Set	1		
00T-832-0000	Hand Tool, 03.06.0161		Pcs	1	Clip the blade while installation it onto tool holder	
00T-831-J206	Tool Holder, J206, 01.49.2009		Pcs	1	J206	
00K-831-J206	Knife–J206, 01.49.0005		Pack	1	5 pieces in a pack	
00T-831-J208	Tool Holder, J208, 01.49.2008		Pcs	1		
00K-831-J208	Knife -J208, 01.49.0006		Pack	1	5 pieces in a pack	
00T-832-J301	Tool Holder, J301, 03.06.0133		Pcs	1		
00K-832-J301	Knife-J301, 01.49.0016		Pcs	2		
00T-832-J384	Tool Holder, J384, 03.06.0134		Pcs	1		
00K-832-J385	Knife-J385, 01.49.0221		Pack	1	5 pieces in a pack	
00K-832-J383	Knife-J383, 01.49.0208		Pack	1	5 pieces in a pack	

00T-832-J385	Tool, Press Cut, 03.06.0178		Pcs	1		
00T-832-J603	Tool, V-Cut, 03.06.0179		Pcs	1		
00K-832-603A	Knife, V-Cut, 01.49.0230		Set	1	2 pieces as a set	
00K-832-603B	Knife, V-Cut, 01.49.0231		Set	1	2 pieces as a set	
0CM-832-0250	Creasing Module, with 2.5mm Creasing Wheel		Pcs	1		
0CM-832-J380	Creasing Module, J380		Pcs	1	Install on the machine	
CWR-831-J380	Spacer Ring, Creasing Wheel, J380, {T3.73mm} 02.27. 01320		Pcs	1	Install on the machine	
CWR-831-J372	Spacer Ring, Creasing Wheel, J372, {T4.1mm} 02.27.01310		Pcs	1		
CWR-831-J382	Spacer Ring, Creasing Wheel, J382, {T3.3mm} 02.27.01300		Pcs	1		
0CW-831-J380	Creasing Wheel, 0.63mm, 01.49.0090		Pcs	2	One installed on the machine	
0CW-831-J382	Creasing Wheel, 1mm, 01.49.0094		Pcs	2		
0PW-831-J381	Perforation Wheel, 0.63mm, 01.49.0093		Pcs	1		
00S-832-0001	Box, Ethernet		Pcs	1		
00F-831-0001 00F-831-0002	Fitting, Air Hose, Male/Femal		Pcs	1		

4. Product Overview



1	Feeder	5	Cutting Head
2	Feed Side Guide	6	Control Panel
3	Feed Conveyor	7	Stacker
4	Cutting Conveyor		

5. Unload and Unpack

5.1 Unload Requirement

a. Crane loading greater 2,200 lbs (1000kg)

b. Forklift loading greater 2,200lbs (1000kg)

c. Car or tractor loading dimension match with the wooden crate.

5.2 Unpack Requirement

Use 13/14mm Open-end Wrench, Box Wrench, and Power Box Wrench, Ladder, Scissors..etc.

6. Installation Requirement

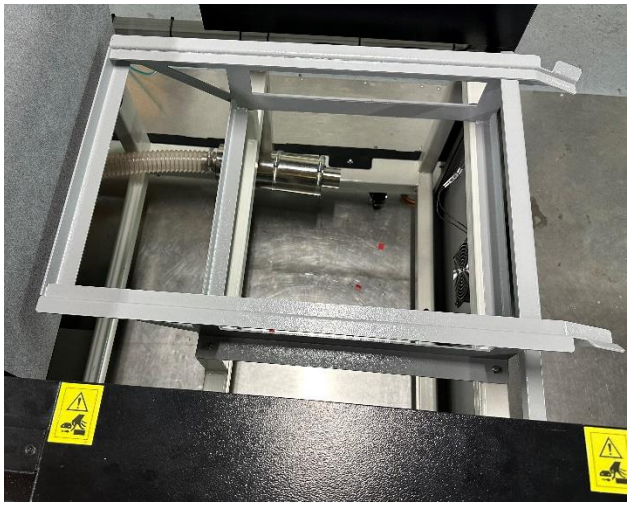
6.1 Cautions for Installation

a. The machine should have good level and ventilation.

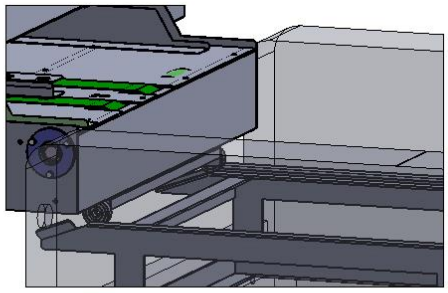
b. Machine should not be allocated in damp or wet place.

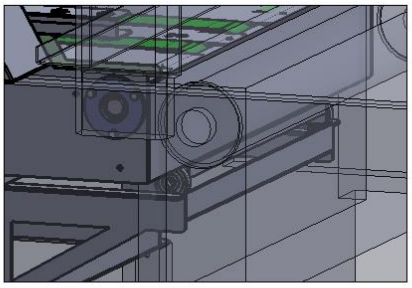
c. Machine should not be exposed in combustible or wet corrosive gases.

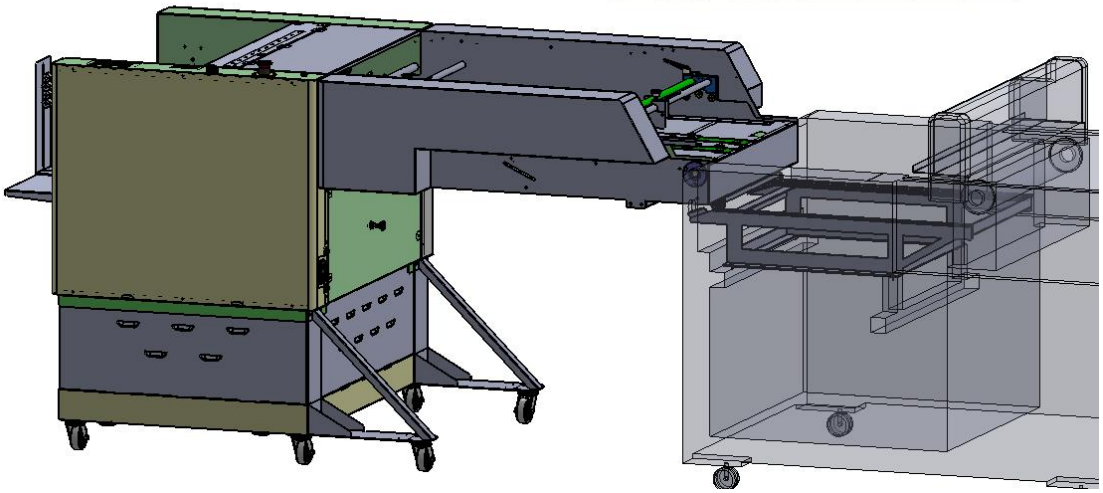
d. Install the feed support chassis.



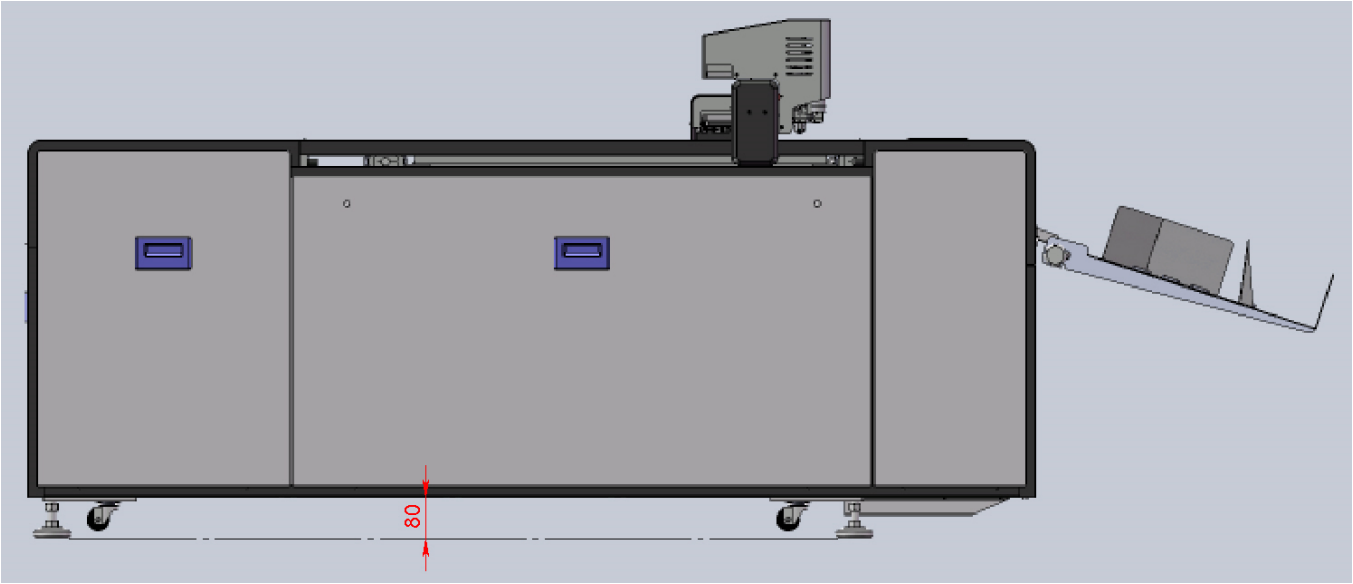
e. Engage the feeder with cutter.







f. Set the cutter foot height to 80mm.



g.

6.2 Optimum Environment

a. Operational ambient temperature of this machine is 40°F (10°C) ~ 96.8°F (36°C)
The machine should be kept away from the wall at least 30” (76cm) facilitate operation of the control panel and servicing purpose.
b. Machine should have at least 30” (76cm) space with any other equipment.

6.3 After Installation and before Activating the Cutter

a. Note the Serial No for future service use.
b. Avoiding accident the machine must be grounded according to electrical rule NO.3
c. Do not connect ground with the other machine which has leakage circuit breaker.

6.4 Power Requirement

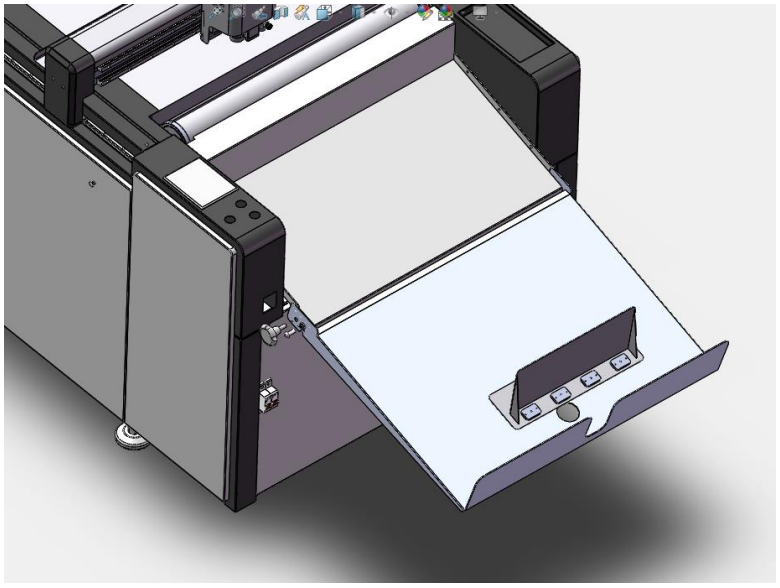
DPC-600PKG Cutter: 220V±10%, 60HZ, 15A

6.5 Clearance Requirements

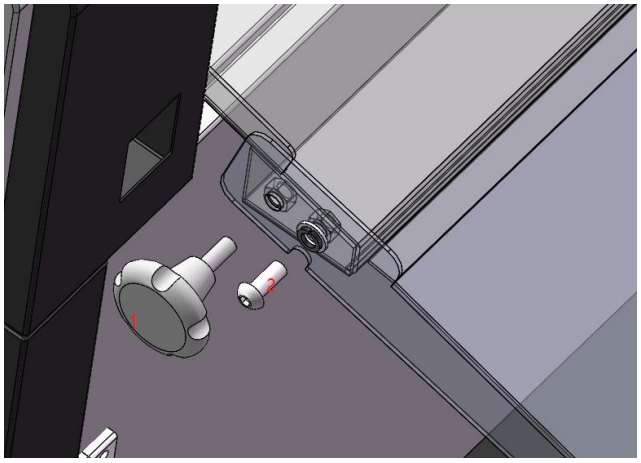
a. The machine should have at least 30” (76cm) space against any wall.
b. Machine should have at least 30” (76cm) space with any other equipment.

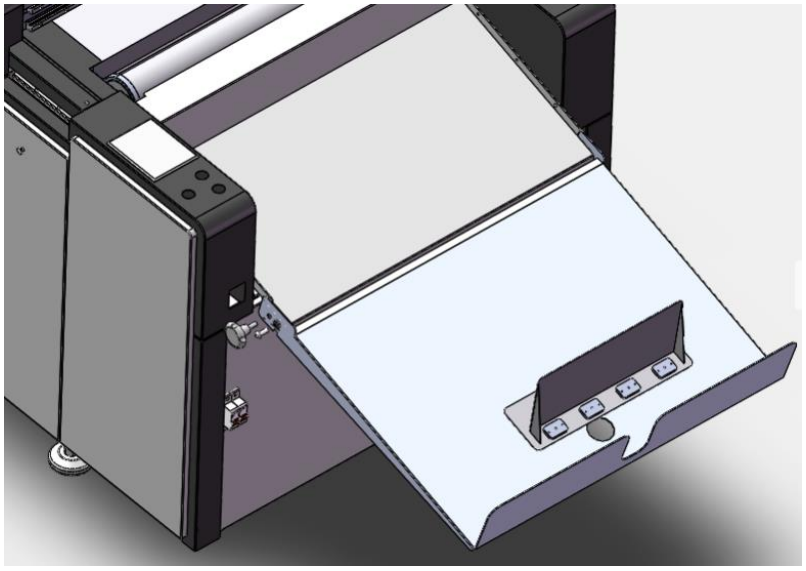
7. Installation of Catcher

Step 1:



Step 2

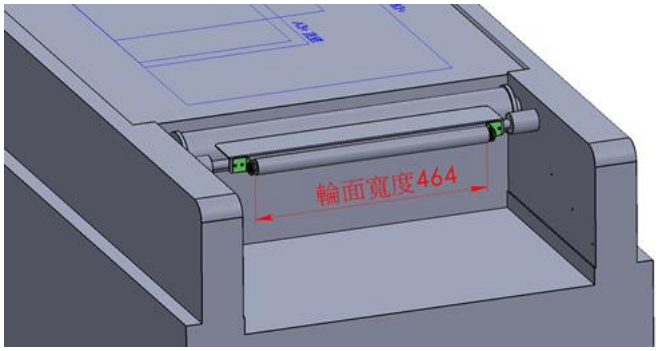


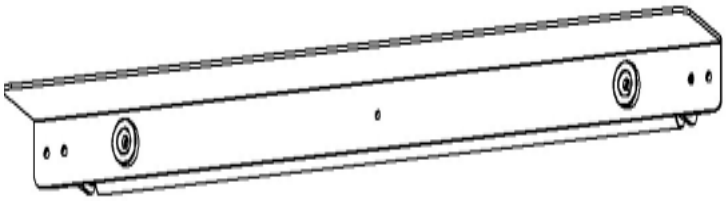


Screw 1 use for fix catch tray position so that collect tray cannot fold down.

Screw 2 use for making these two trays connect.

Step 3 Installation of Ejection Roller Assembly

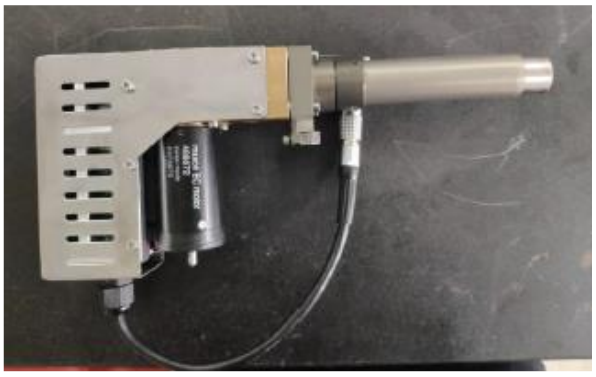




8. Installation of Tools

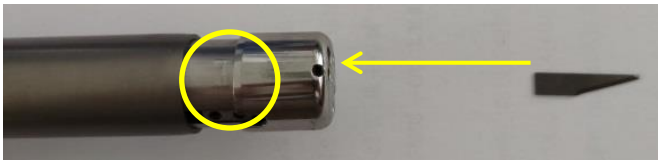
8.1 Installation of Oscillating Tool

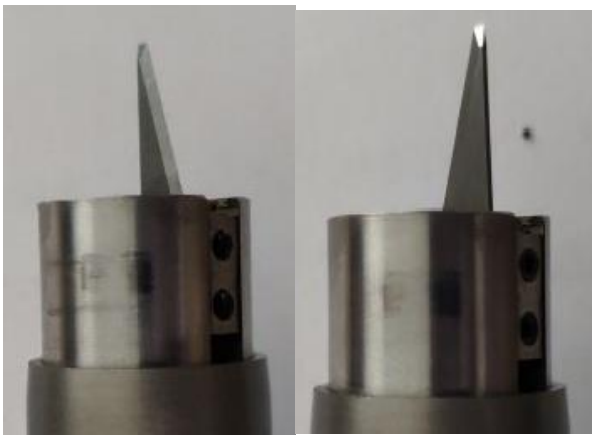
The oscillating too mainly used for foam board/pad, grey board, cardboard, KT board, PVC board, corrugate board, and other thicker/harder materials.



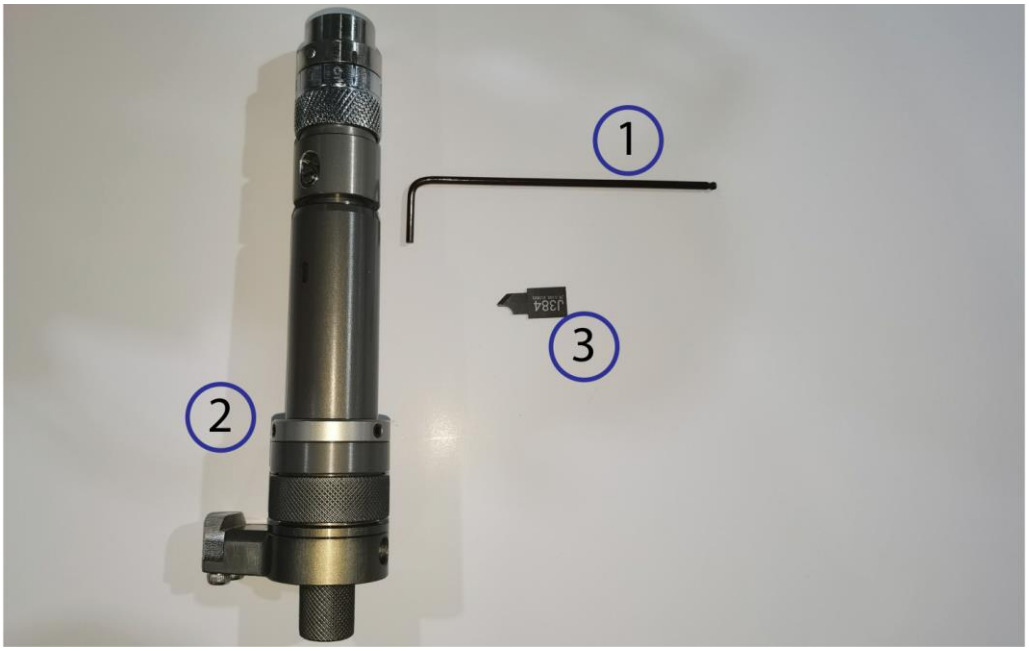
Step 1 Loosen these two set screws with Allen key allows to press the cover down.

Step 2 Make the blade direction face to the set screw. Install the blade to holder. Make sure it against the tool holder base. Then fastening the two set screws.





8.2 Press cut tool Installation Guide

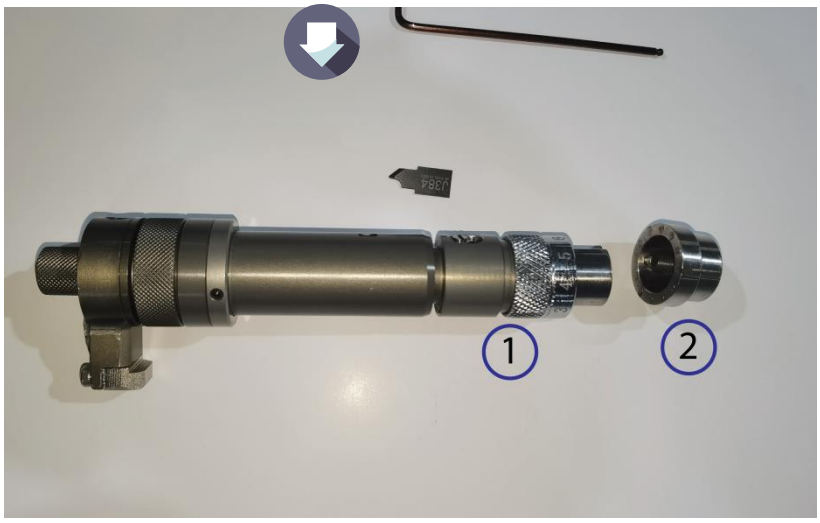


Step 1 : Prepare the knife and the tools

①: 2 mm Allen key

②: Knife J383, J384 and 385

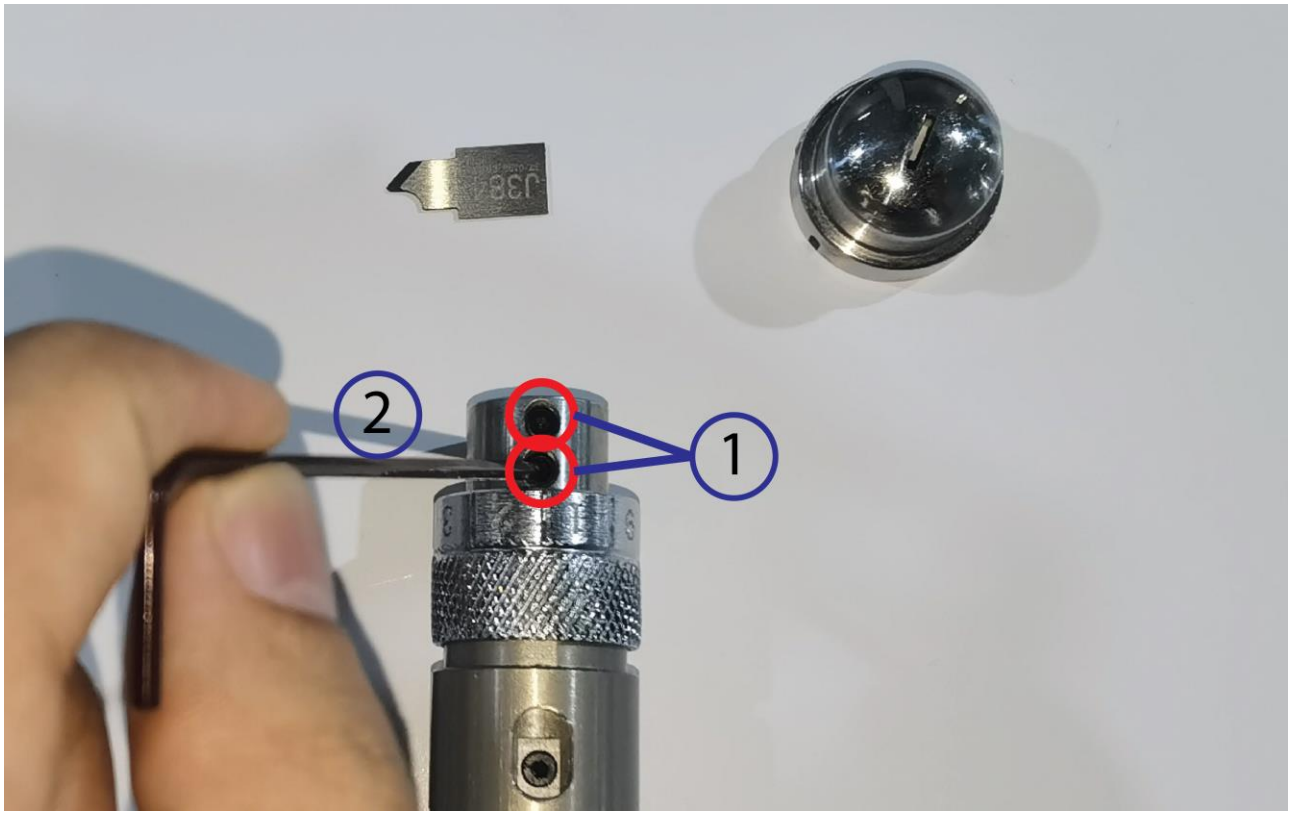
③: Press cut tool: JWT-096-00-00



Step 2: Use hand to pull the tool cap to remove the cap from the tool body

①: Tool body

②: Tool cap



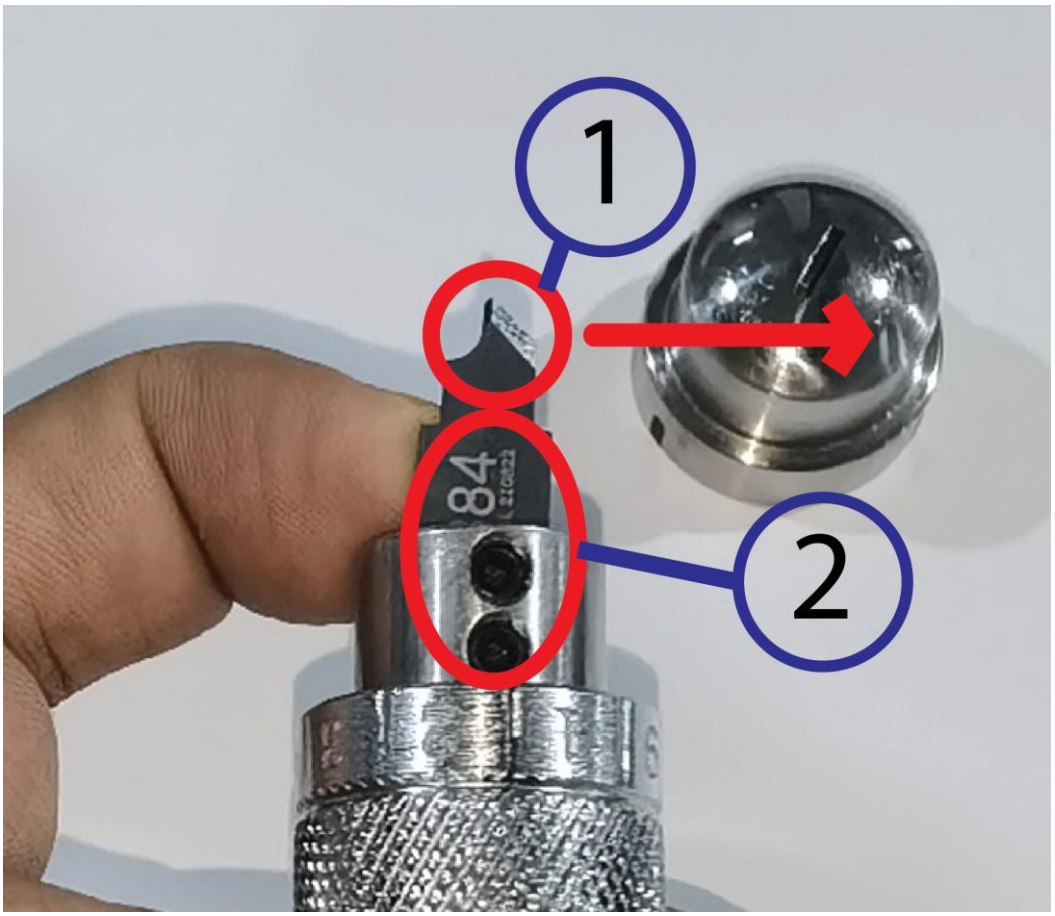
Step 3: Use 2mm Allen key to lose the 2-knife lock screws

①: Knife lock screw

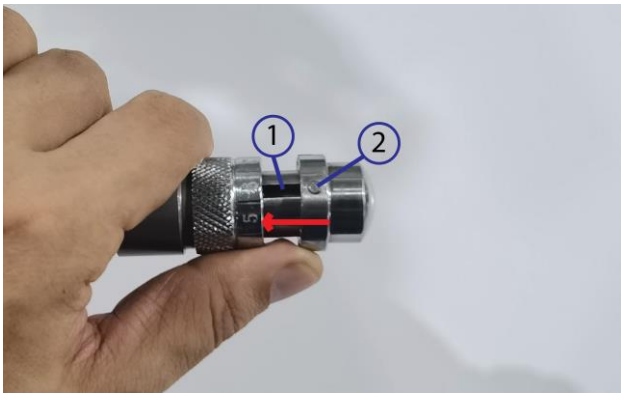
②: 2mm Allen key

Step 4 Insert the knife into the tool body, the knife edge should face the right side. The knife model and the knife lock screws should face the front.

①: Knife edge
②: Knife mark and knife lock screw


1
2
84

Step 5 Push the knife to the bottom, use Allen key to lock the 2 knife lock screws to lock the knife to the tool body

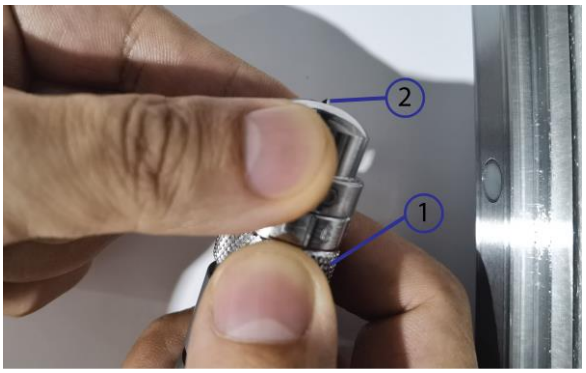


Step 6 Put back the tool cap and match the pin on the tool cap to the slot on the tool body and push the cap to fit into the tool body

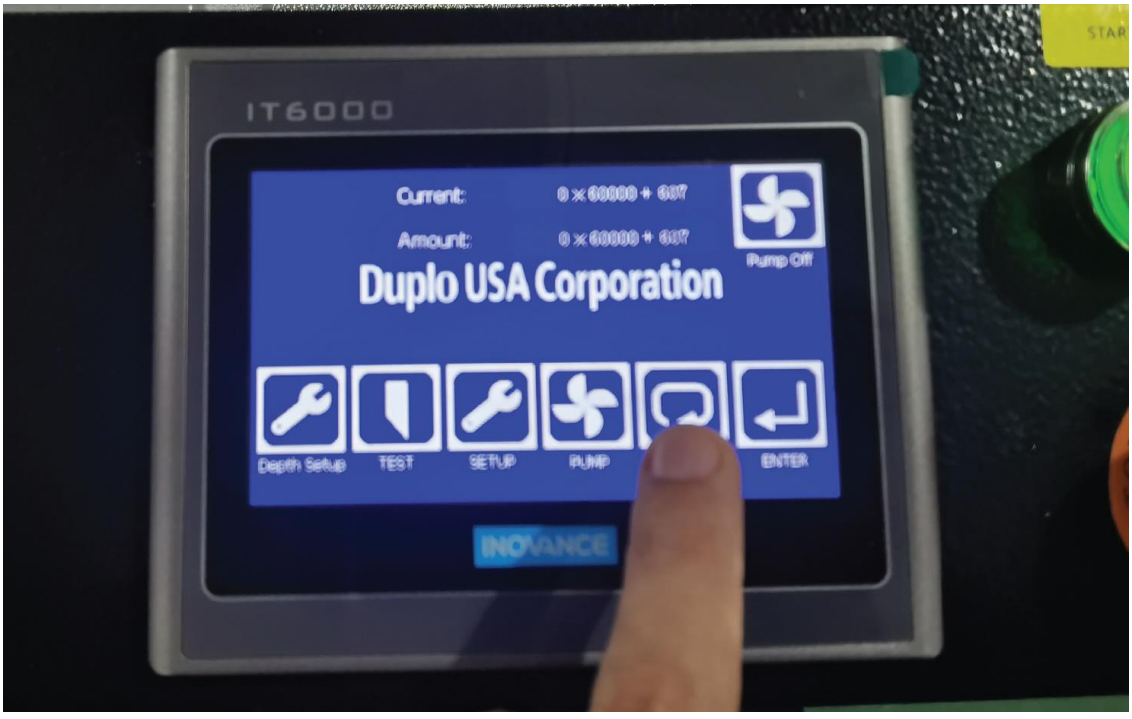
Step 7 Rotate the knife adjust the ring to adjust the knife point to come out of the tool cap 1-2mm

①: Knife adjust ring

②: Knife point



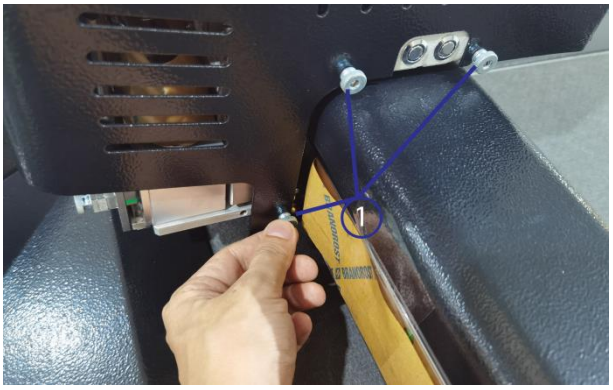
Step 8: Press the reset button to reset the cutter

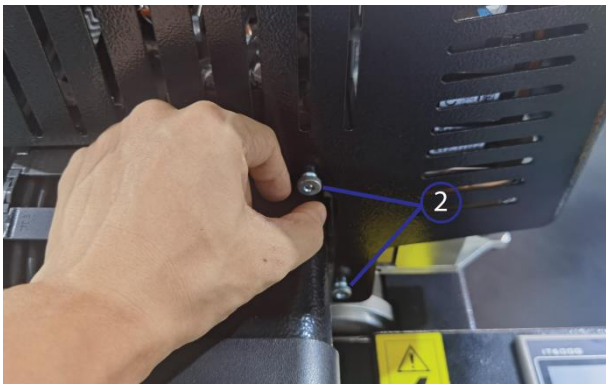


Step 9 Loose the head cover lock screws on both side of the machine head

①: Right side head lock screws

②: Left side head lock screws

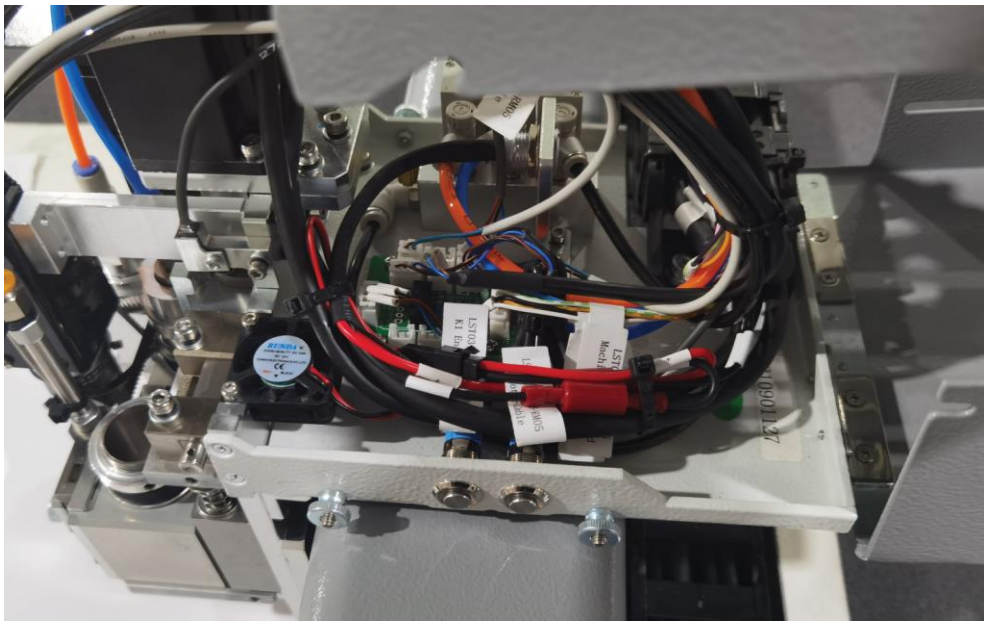


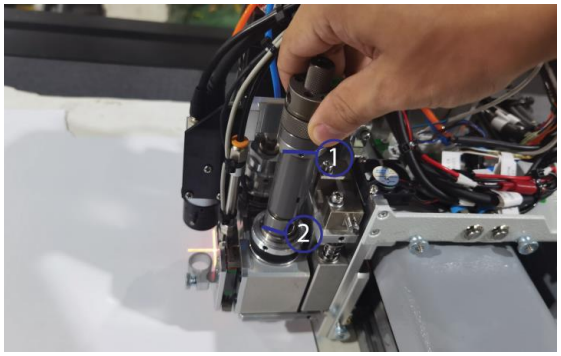


Step 10 Open the head cover, Insert the tool to the machine head oscillating tool holder, matching the notch on the tool with the notch on the tool holder

①: Notch on the tool

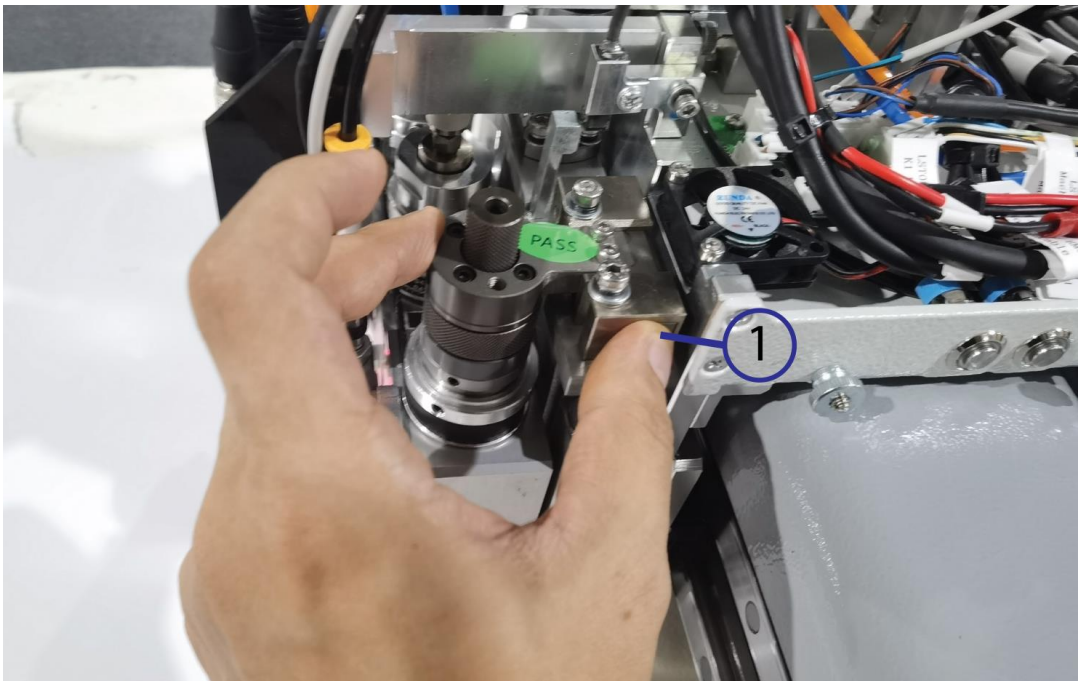
②: Notch on the tool holder

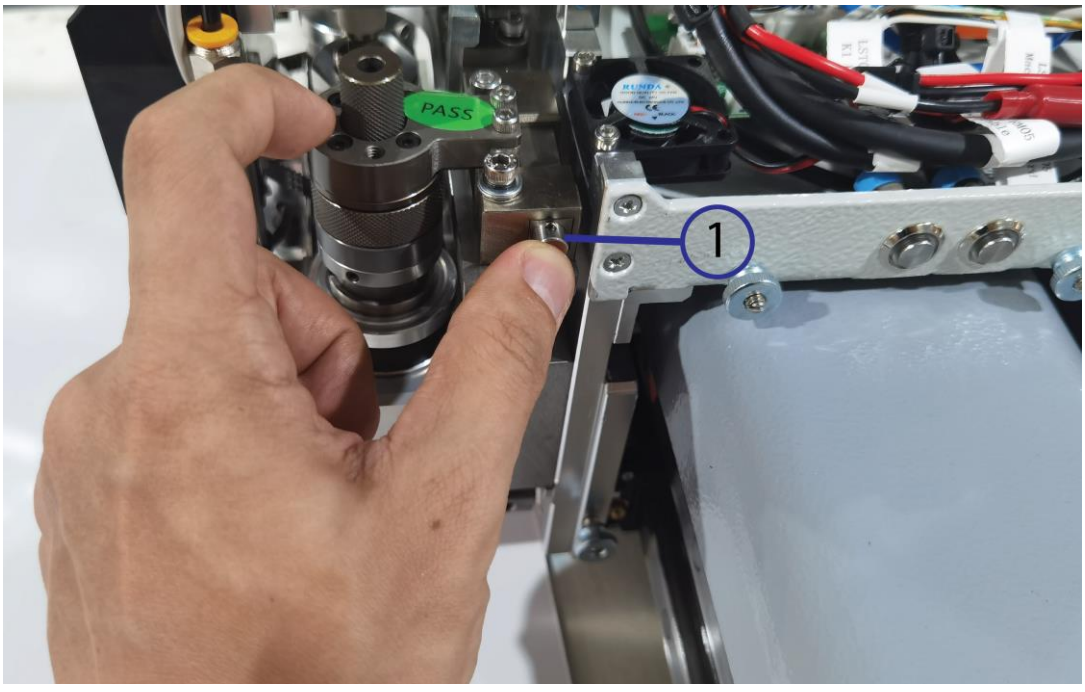




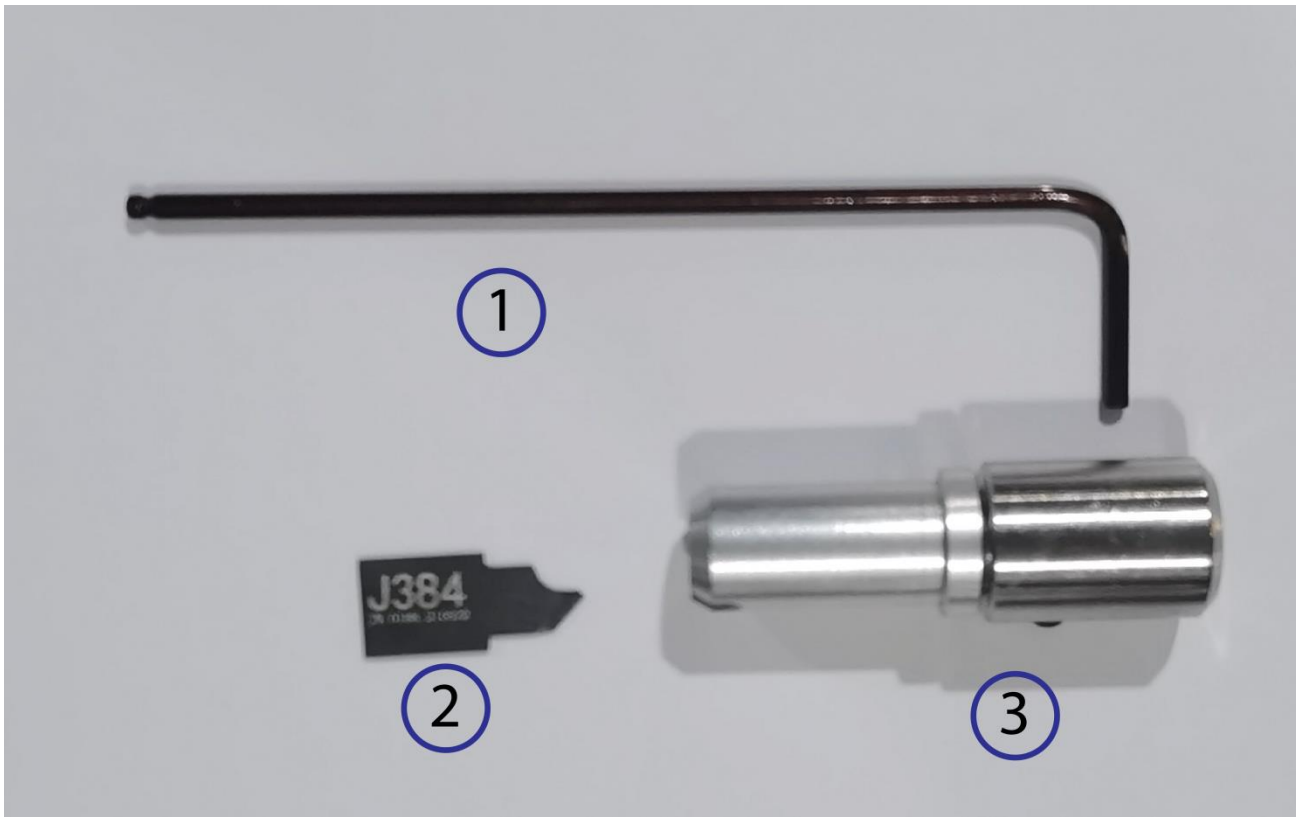
Step 11 Press down the lock button on the tool holder to release the tool holder.

①: Lock button slide down the tool to the bottom and release the lock button to lock the tool in the holder





8.3 Installation of Full Cut Tool

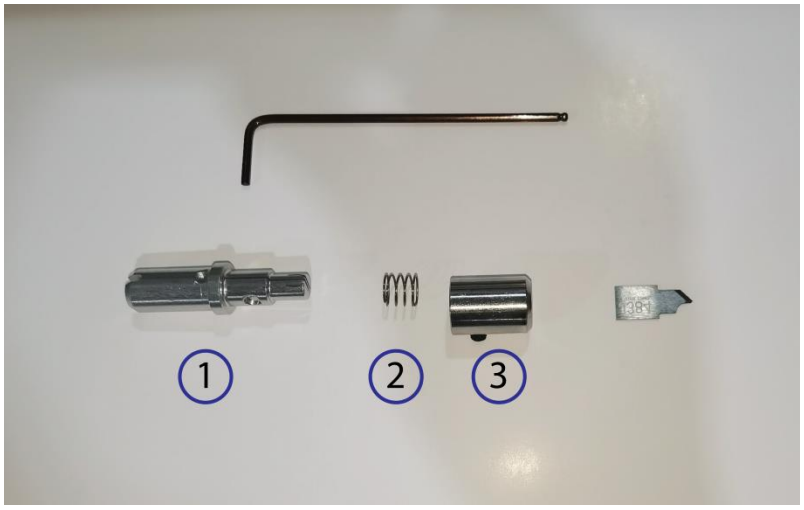


Step 1 : Prepare the knife and the tools

①: 2 mm Allen key

②: Knife J383, J384, J385

③: Full cut tool:

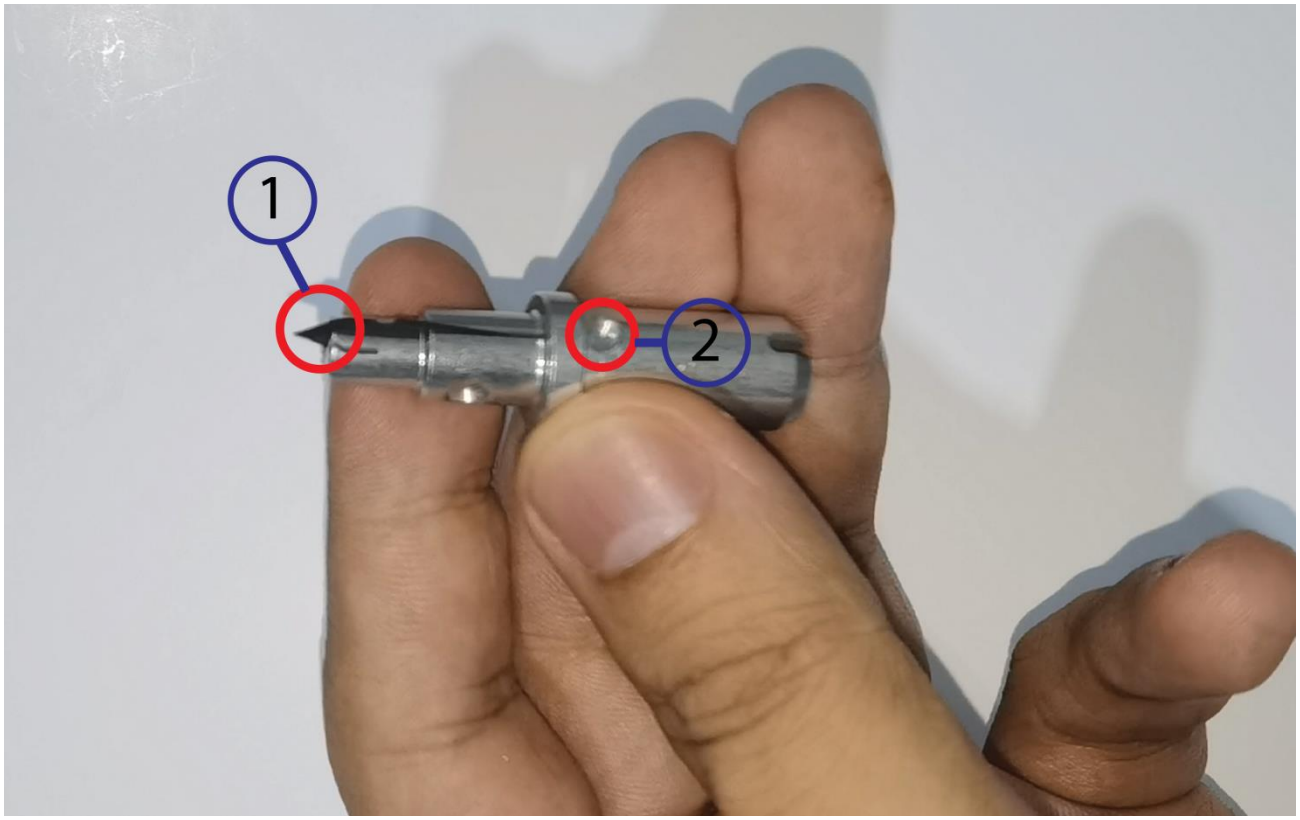


Step 2: Use the Allen key lose the tool lock screw on the tool and disassemble the tool

①: Tool body

②: Spring

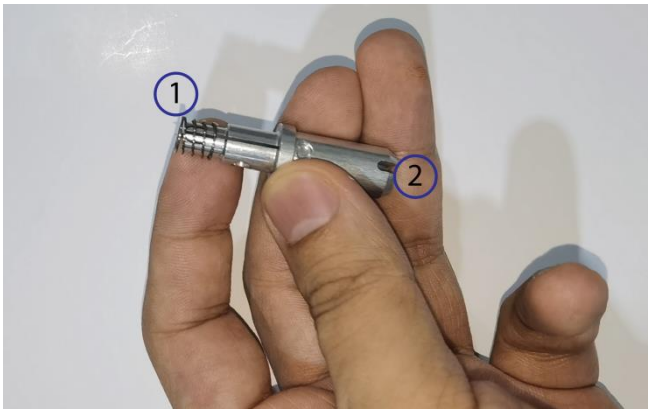
③: Tool cap



Step 3: Insert the knife into the tool body and match the knife edge to the lock notch in the tool body to be in the same direction

①: Knife edge

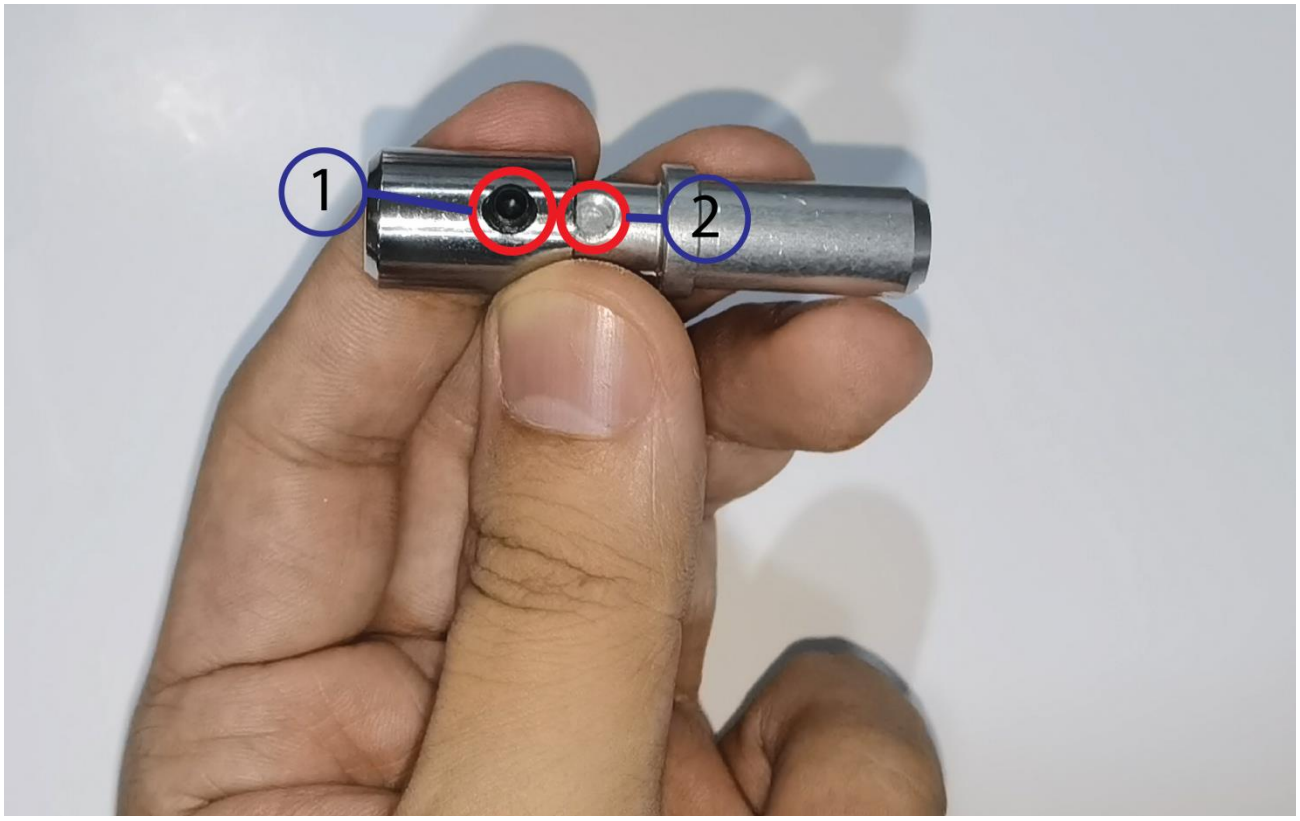
②: Lock notch



Step 4 Put the spring into the tool body

①: Spring

②: Tool body



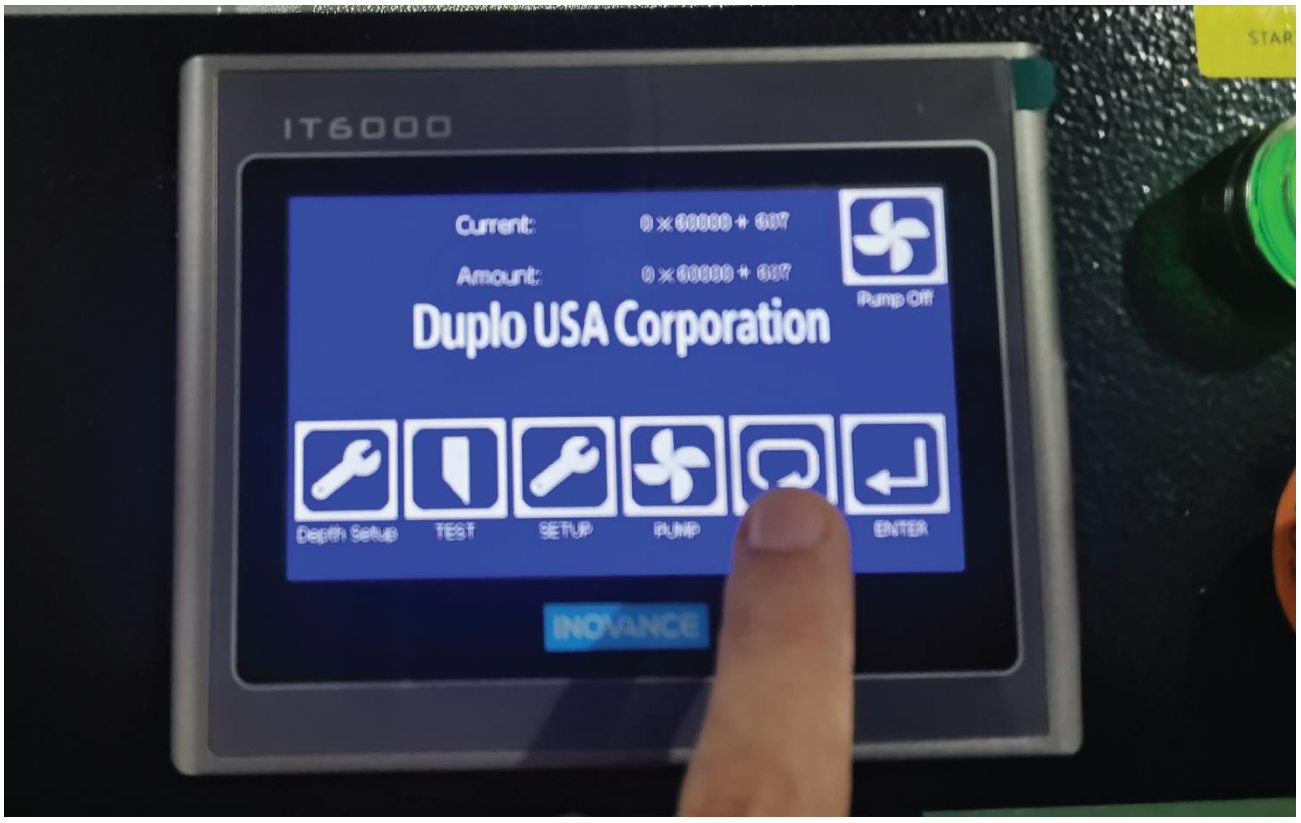
Step 5: Put the tool cap onto the tool and match the tool lock screw with the lock notch to be in the same position

①: Tool lock screw

②: Lock notch

Tight the tool lock screw to lock the tool cap to the lock notch
The tool tail end can Use 2mm Allen key to adjust the knife sharp point to come out the tool cap ,
Base on material thickness that you can control the blade sharp point out length. please note do not fix cap screw when you adjust blade sharp point out.

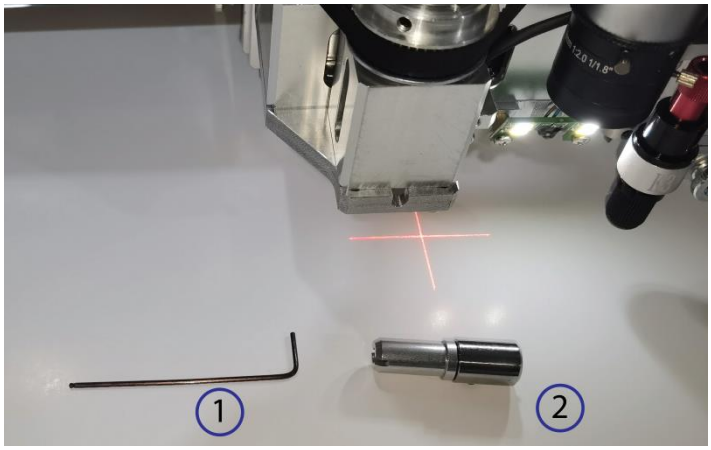
Step 6: Press reset button on the touch screen to reset the machine



Step 7 Prepare the tools

①: 1.5 mm Allen key

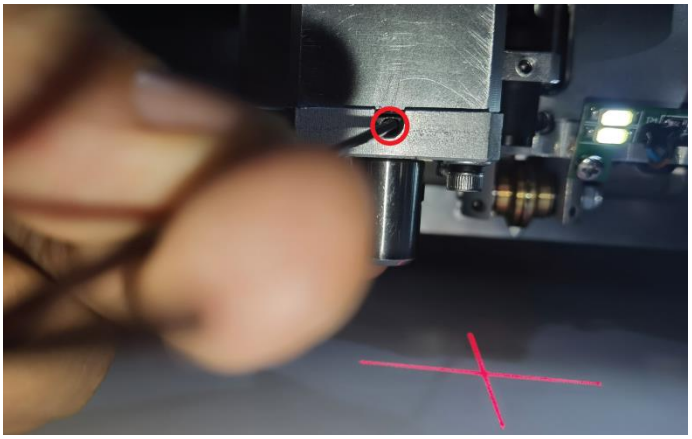
②: Full cutting tool



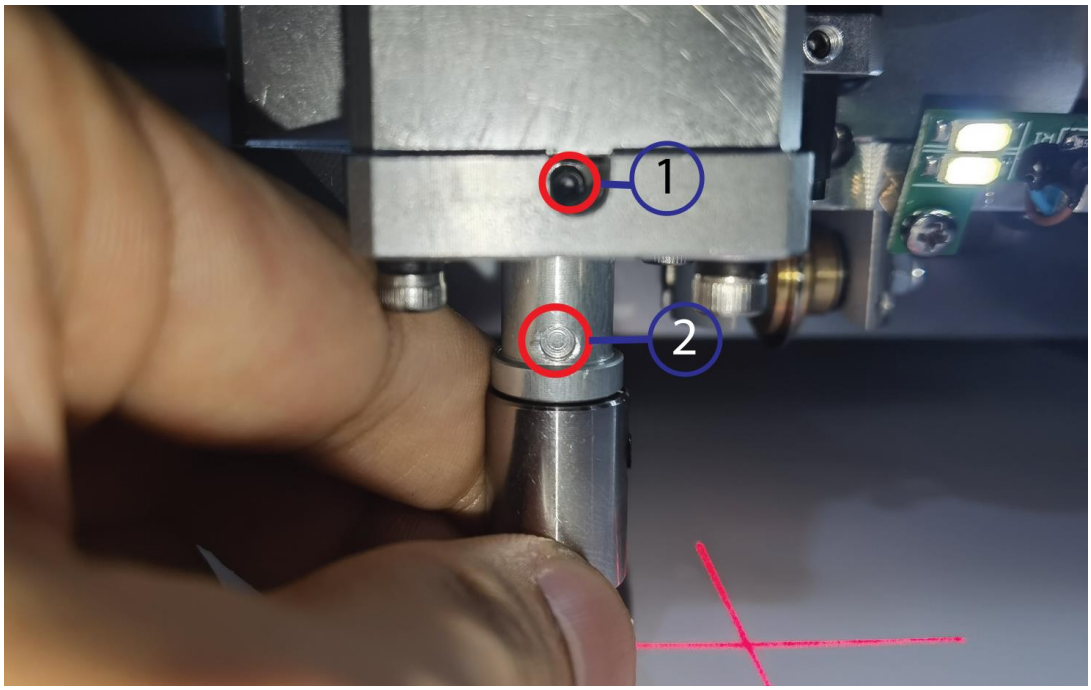
Step 8: Insert the tool into the full cutting tool holder in the machine head, match the holder lock screw with the tool lock notch to be in the same position

①: Holder lock screw

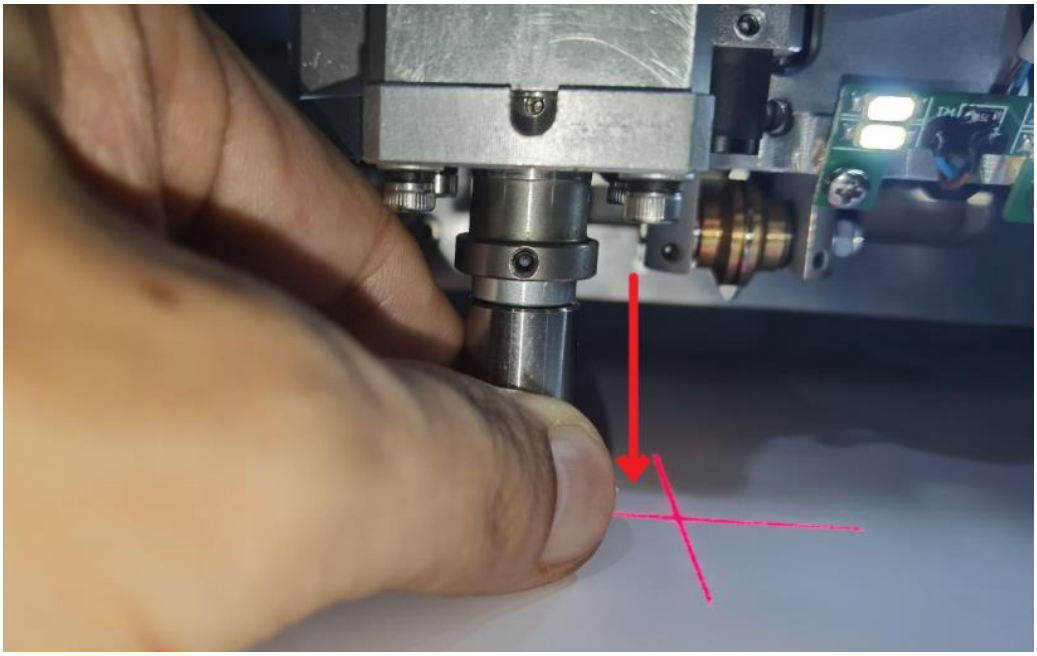
②: Tool lock notch



Step 9 Push up the tool deeply inside the holder and tight the holder lock screw on the tool lock notch.



Step 10 Drag down the tool several times to test if the



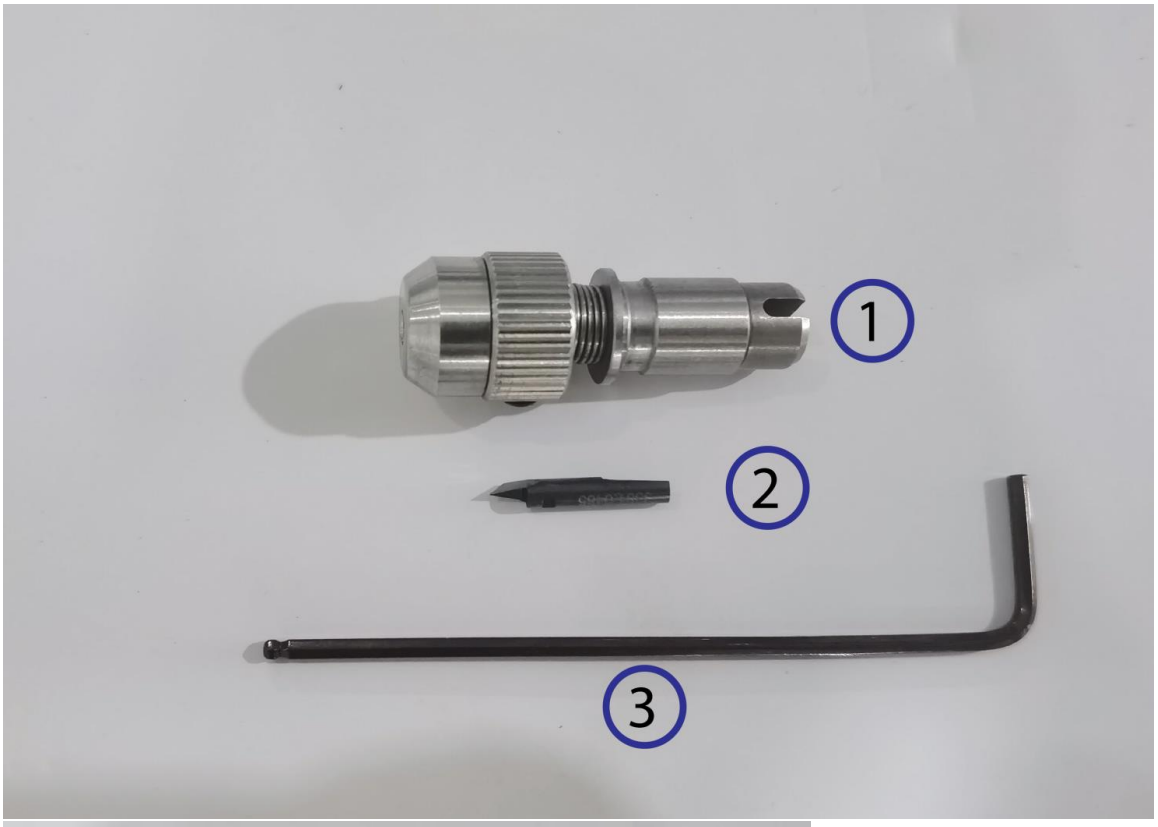
8.4 Installation of Kiss Cut Tool

Step 1: Prepare the knife and the tools

①: 2 mm Allen key

②: Knife J301

③: Kiss cut tool: JWT-066-00-00

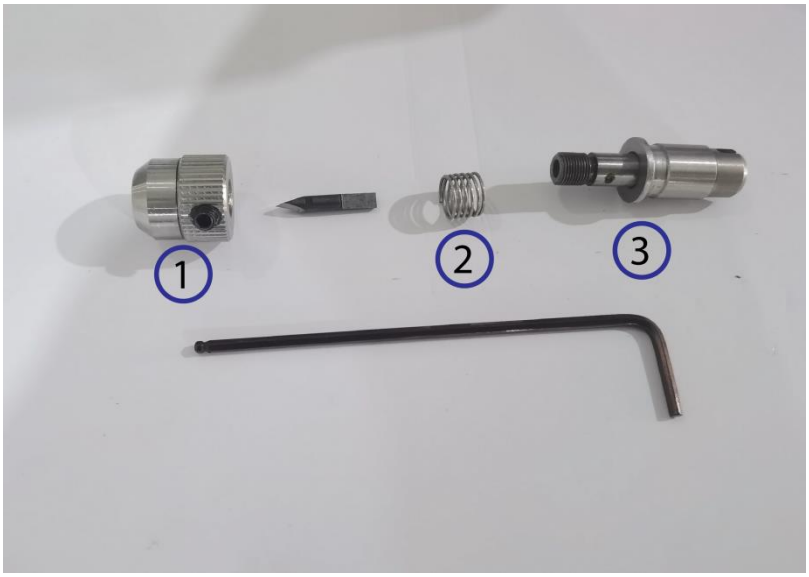


Step 2: Loose the tool lock screw with the Allen key to remove the tool cap from the tool body

①: Tool cap

②: Spring

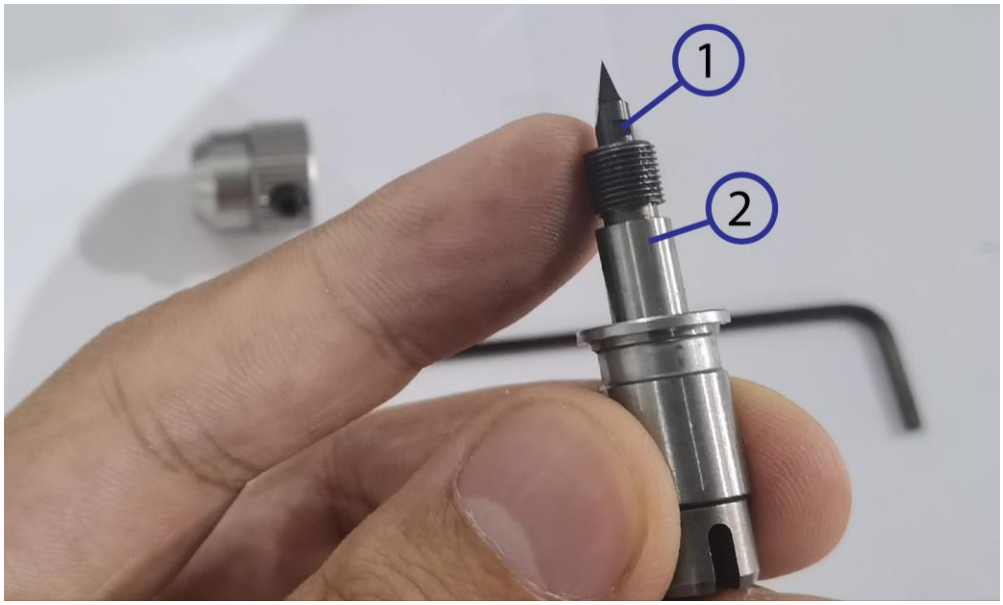
③: Tool body



Step 3: Insert the knife to the tool body until the knife notch matches with the tool body top

①: Knife notch

②: Tool body



Step 4 Put the spring onto the knife body

①: Spring

②: Knife body

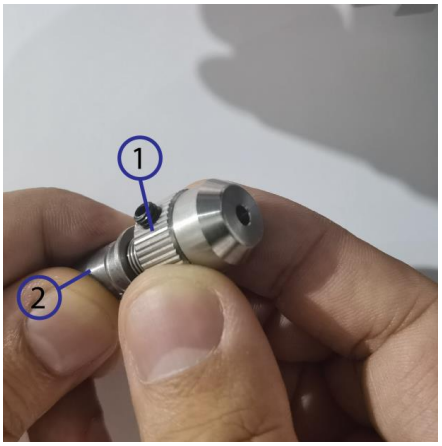
Step 5 Put on the tool cap and tight it to the tool body.

Step 6 Use the Allen key to tight the screw to lock the tool cap to the tool body

Step 7 Hold the tool tail and rotate the tool cap to adjust the Knife point expose distance from the tool cap

①: Tool cap

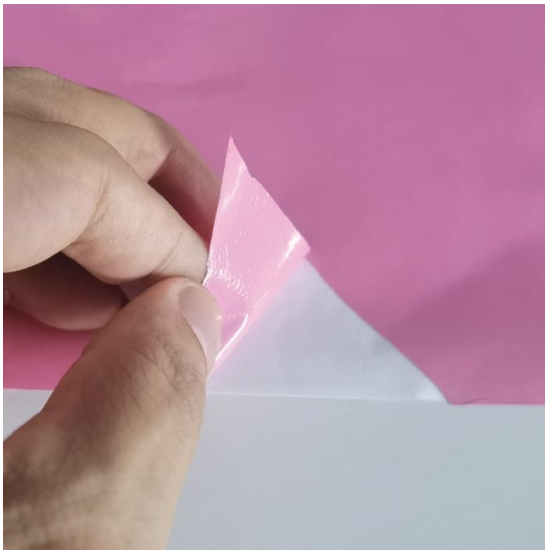
②: Tool tail



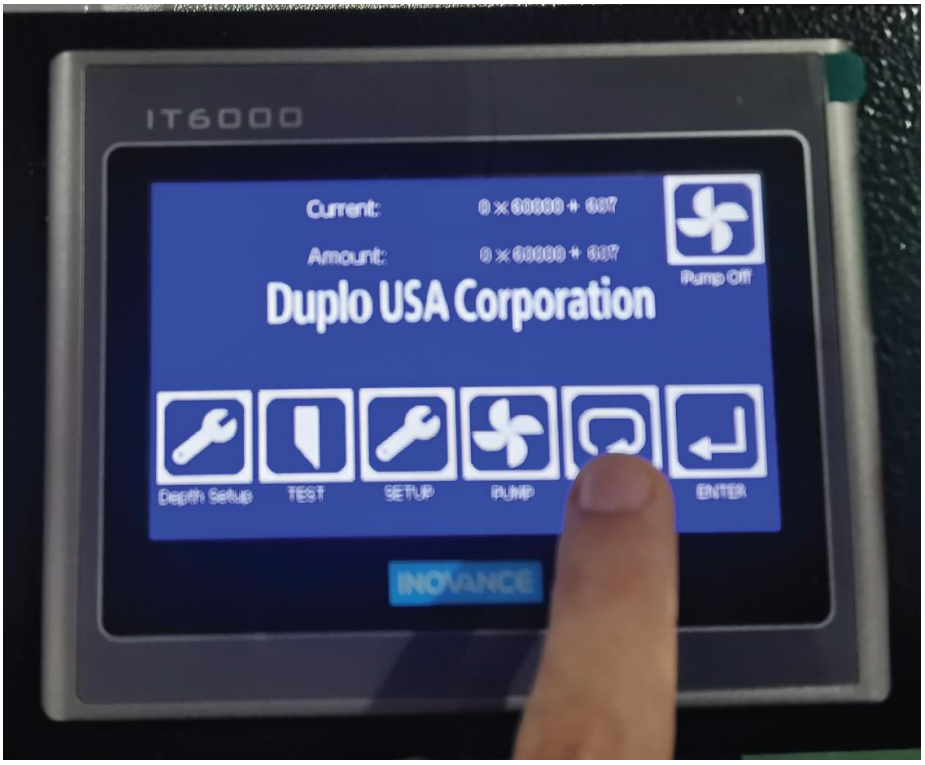
Step 8 Press down the tool on the surface of the sticker material with a certain force. Then drag it along the flat step in the tool tail direction.

①: Flat step in the tool tail

Step 9 Check if you can only peel off the top layer of the sticker material and the knife will not hurt the bottom layer too much. If not adjust the knife point expose distance.



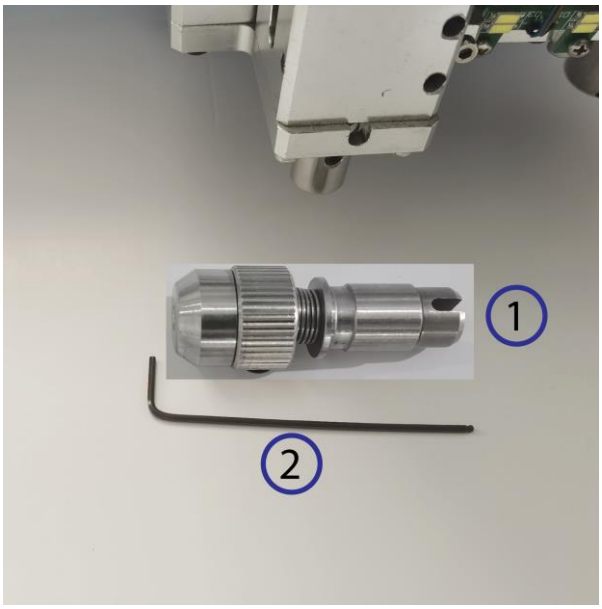
Step 10: Press the reset button to reset the machine



Step 11 Prepare the tools.

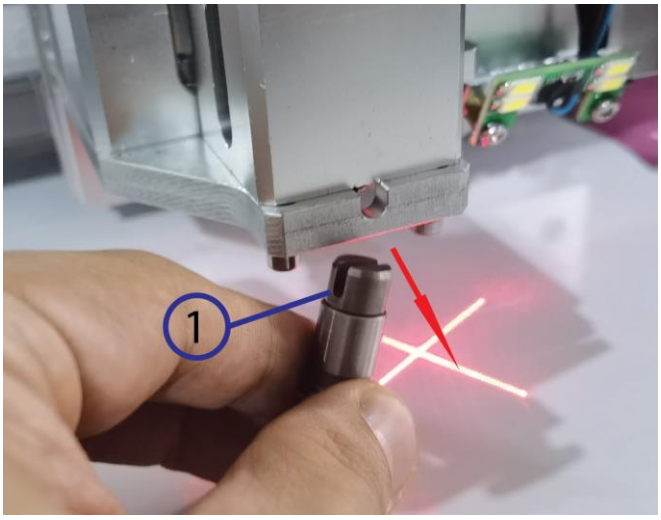
①: Kiss cut tool with knife installed

②: 1.5mm Allen key

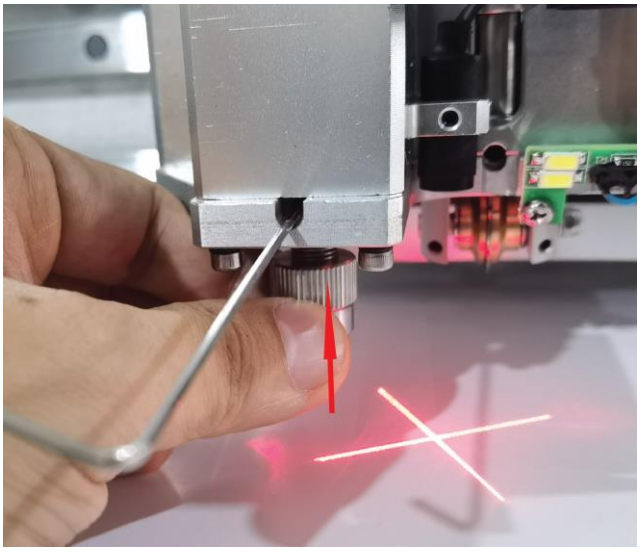


Step 12 Insert the kiss cut tool to the machine head tool holder,the flat step in the tool tail should facing the front direction

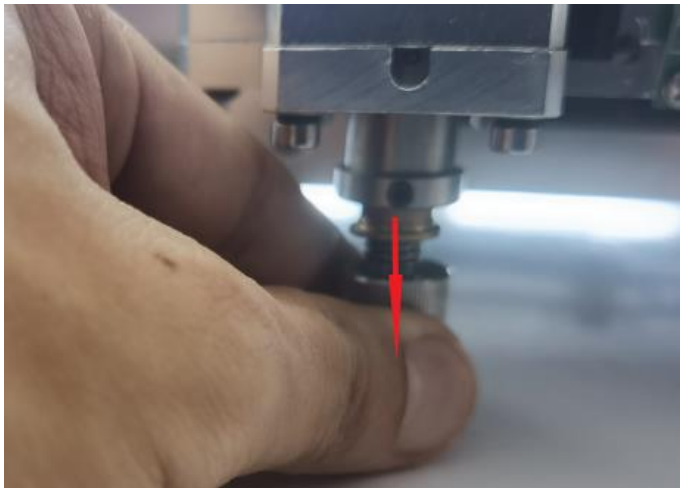
①: Flat step in the tool tail



Step 13 Push the tool up and lock the lock screw with 1.5mm Allen key on the tool holder



Step 14 Drag down the tool several times to test if it is locked tightly or not



9. Tools Installation Video Download

https://www.duplousa.com/support/

10. Cutting File Format

10.1 Common format

The default file format for the machine is HPGL, the other adaptable file formats are HPG. PLT. DXF.PDF and EPS

10.2 Special format

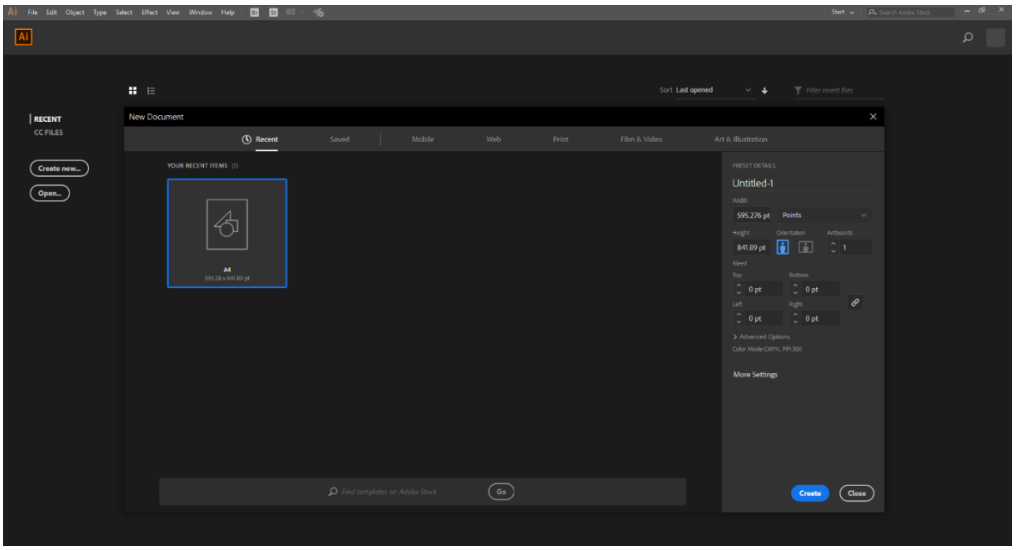
Machine can also import files exported the XML format file from the RIP software such as Onyx/Caldera PhotoPrint / PrintFactory.

11. How to Export DXF Files in the Adobe Illustrator

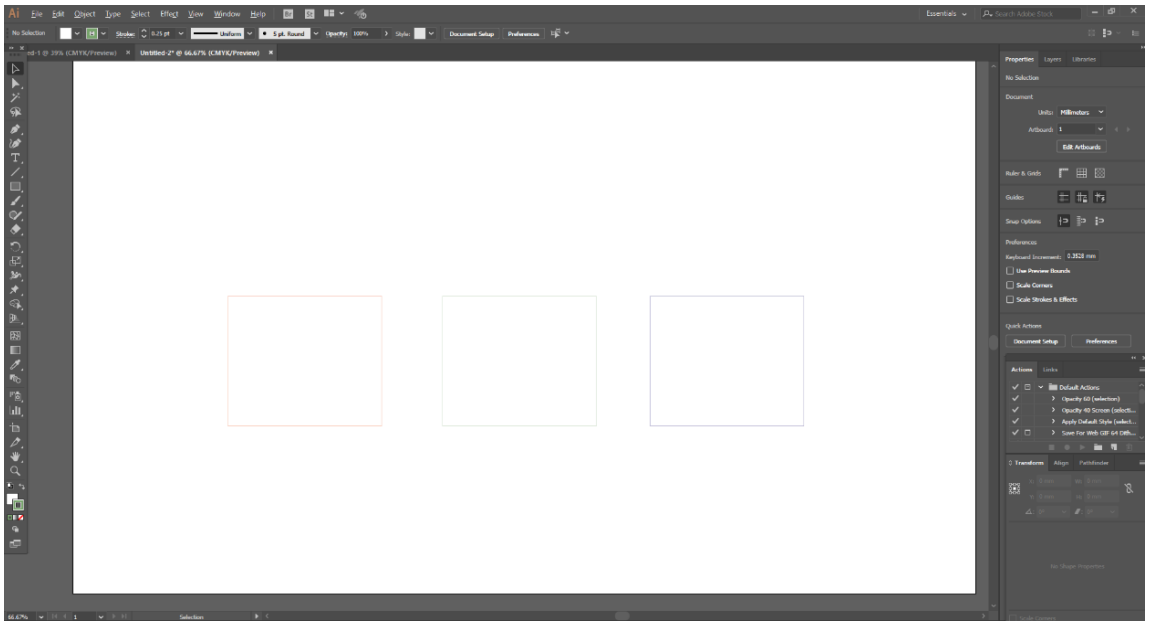
Step 1: create a new art board, set width (X direction) and height (Y direction) according to machine cutting area size)

① Width (W): Machine X Direction Dimension ②Height (H): Machine Y Direction ③

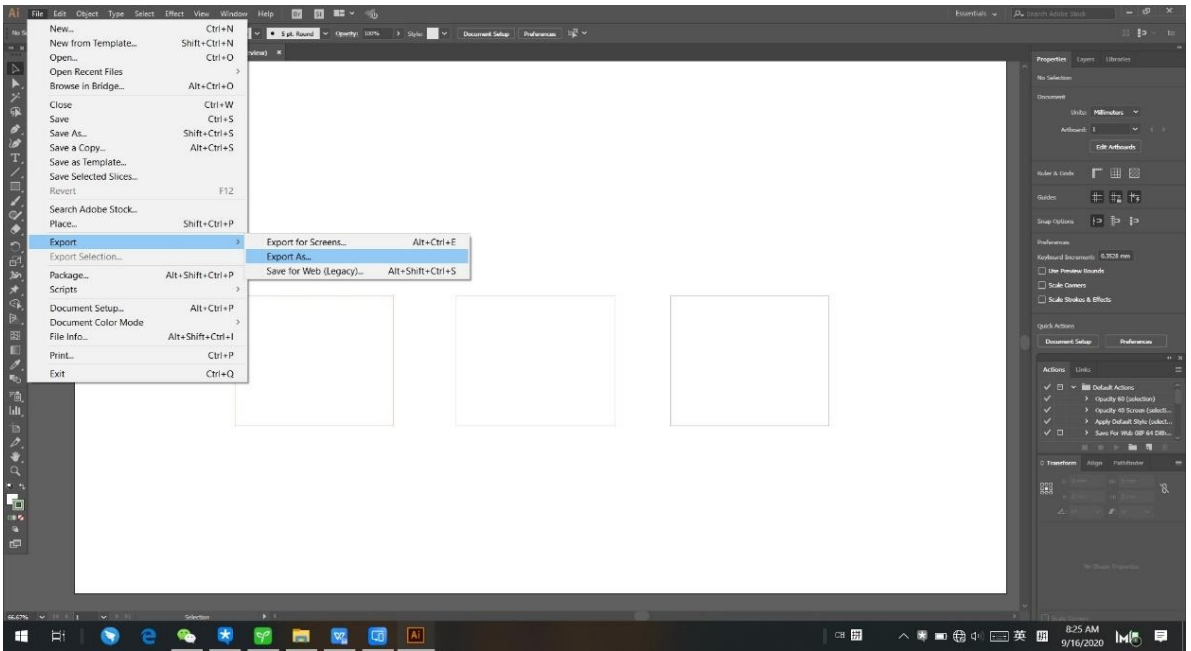
Dimension Unit: Recommended mm (mm)



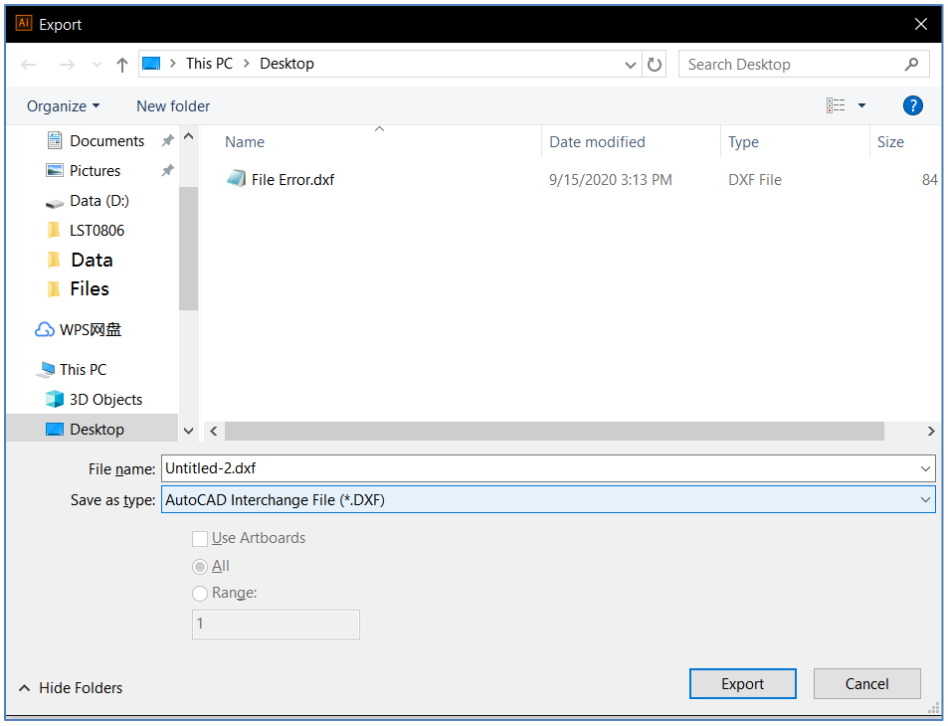
Step 2: Import the graphics in the art board, set different color to the related vector lines.



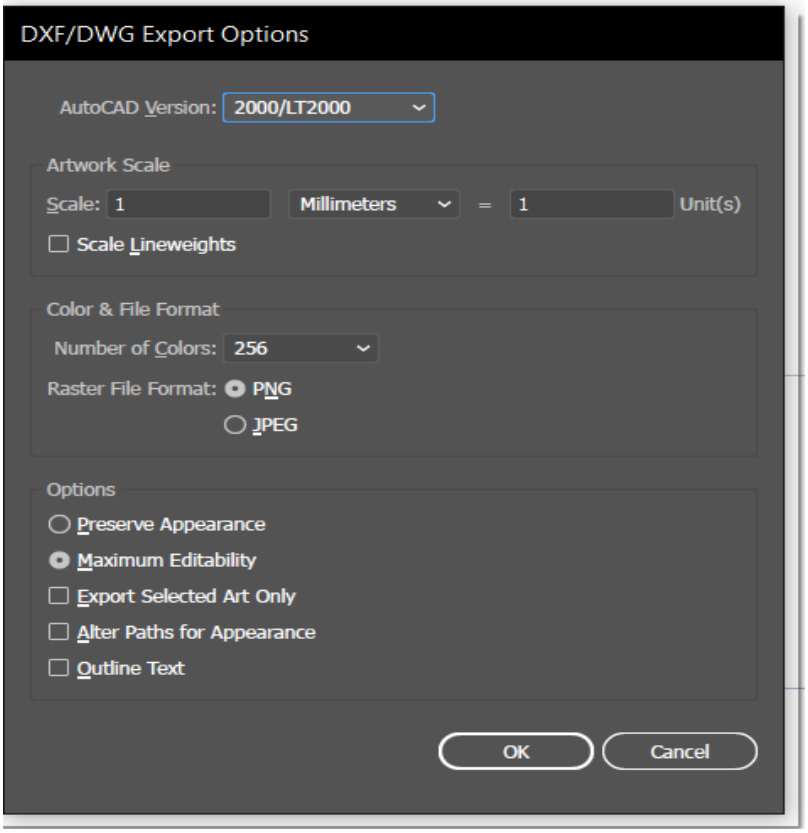
Step 3: File menu --> export --> export to



Step 4: Select the save type as DXF format and enter the file name



Step 5: DXF the unit in the export menu should be millimeter for the file, then select OK



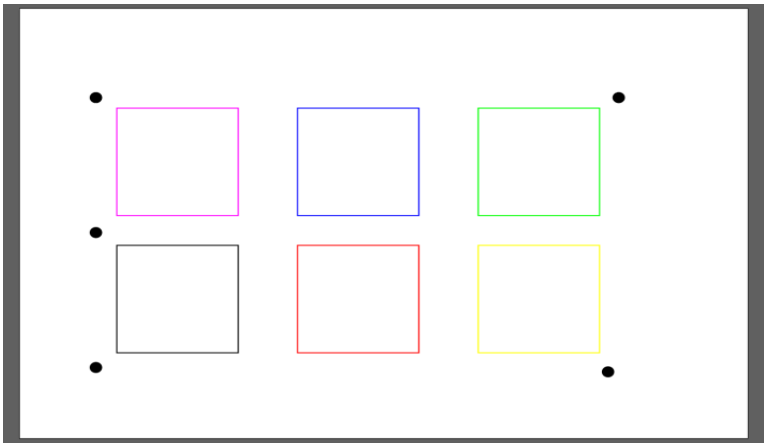
12. How to Export of Camera Locating Files

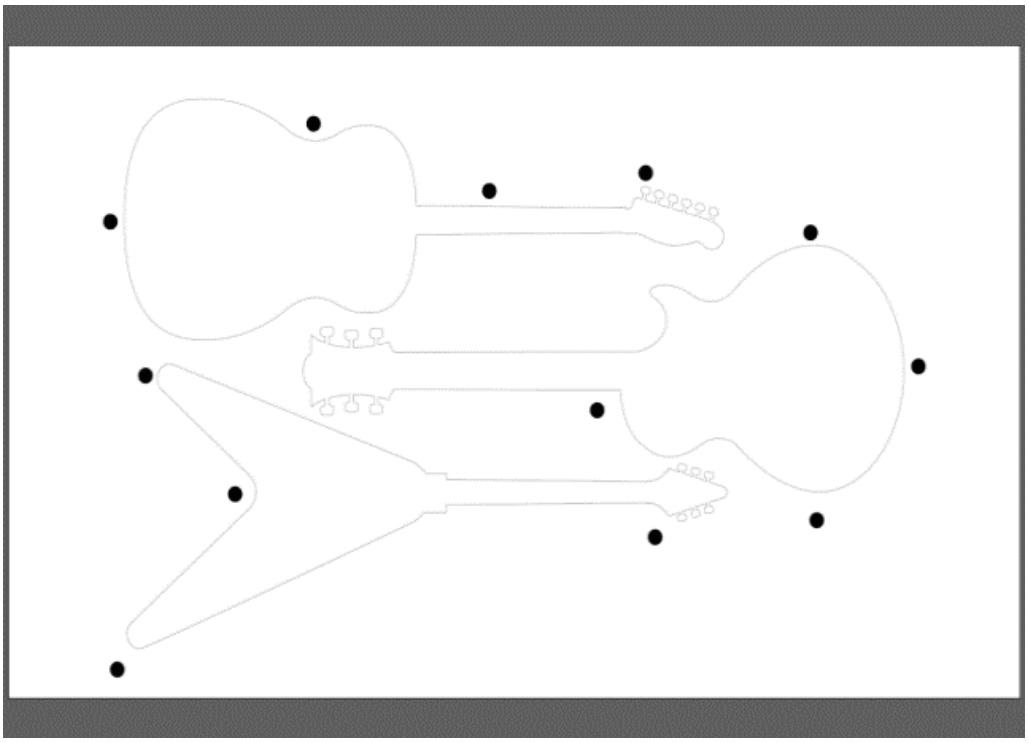
There are two main register marks supported by our locator function: black circle (●) and black cross (┼) respectively.

The register marks size can be from 3 mm to 20 mm and the recommended register marks are 6 mm circles and 10 mm circles.

Number of the register marks: generally, the distance between the register marks should be at least 4.30 to 40 CM each section.

The register marks position: the register marks positions are recommended outside the objects, or around the object. The register marks position can be not symmetrical.

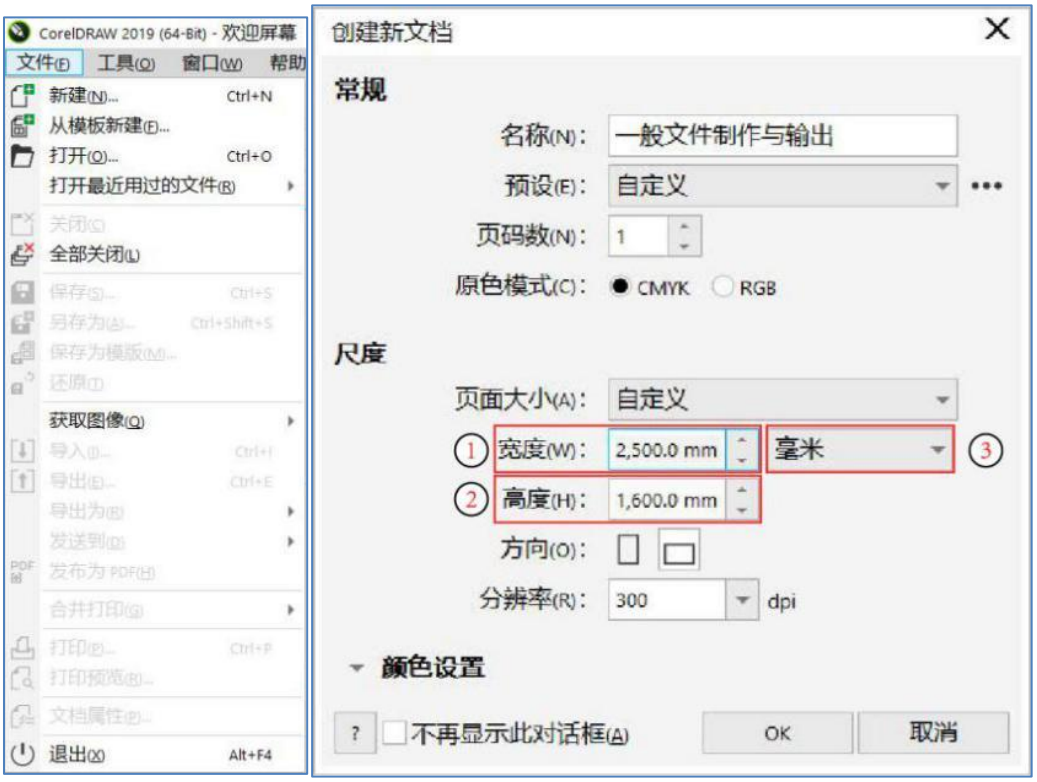




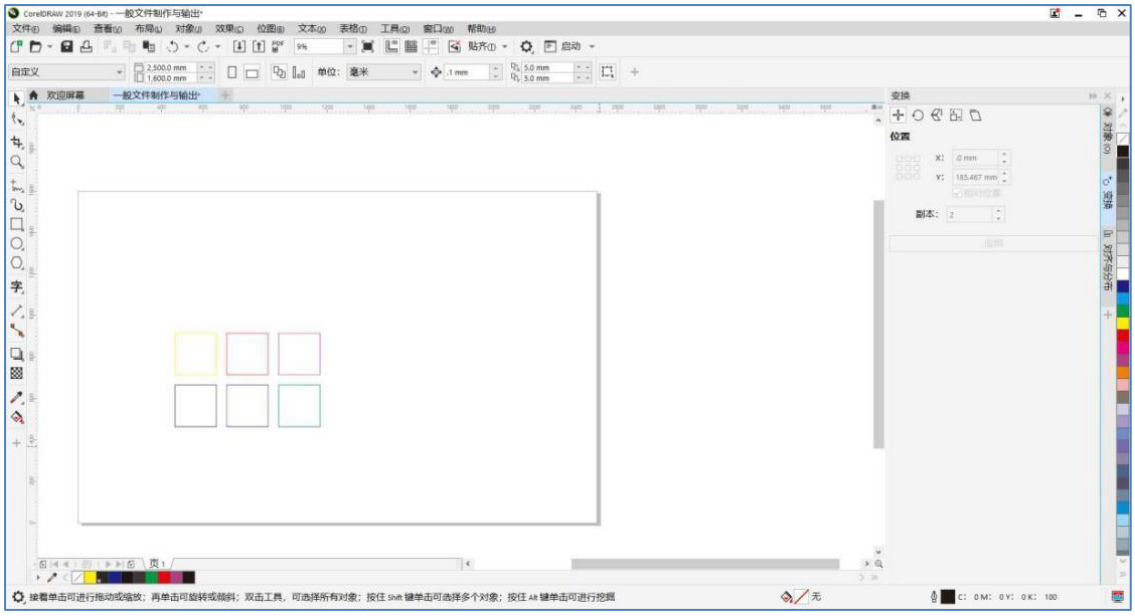
13. How to Export PLT Files in CorelDRAW

Step 1: create a new art board, set width (X) and height (Y) according to machine size.

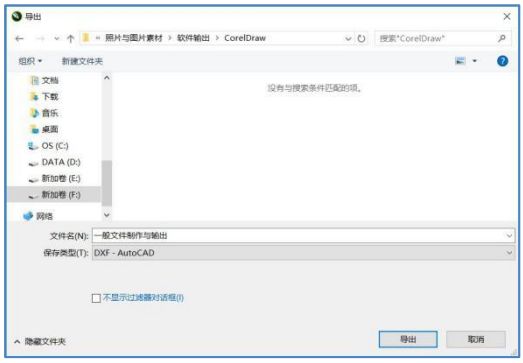
① Width (W): Machine X Direction Dimension ②Height (H): Machine Y Direction ③Dimension Unit: Recommended mm (mm)

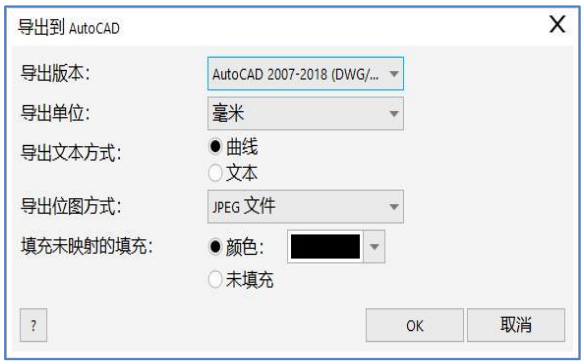


Step 2: Import the graphics in the art board, set different color to the related vector lines.

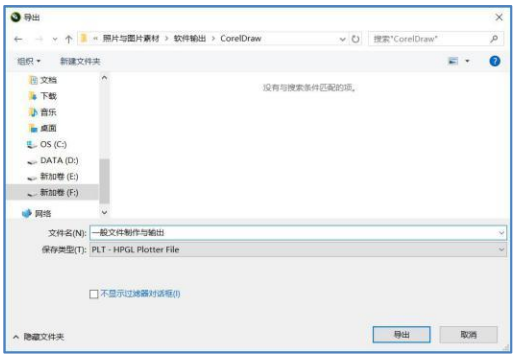


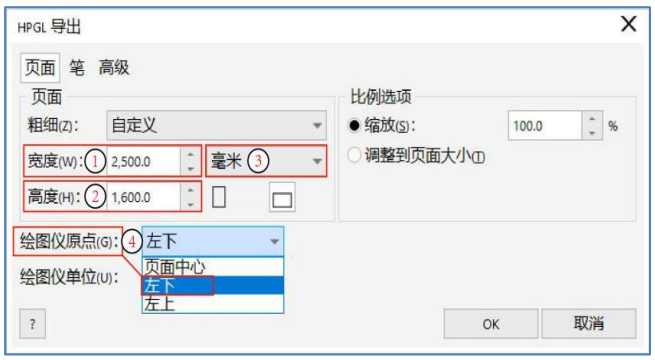
Step 3: File menu --> export --> Export to the DXF Format

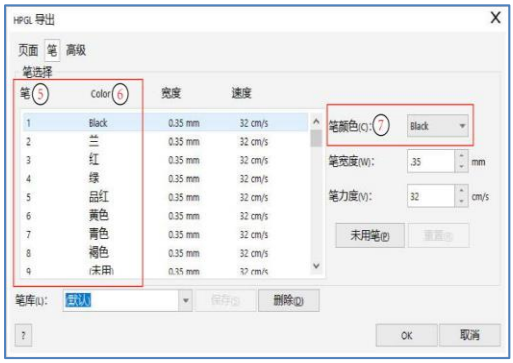


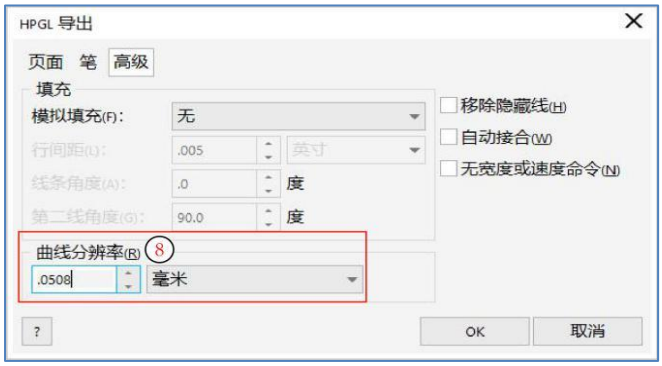


2) Export to the PLT Format









1 Width (W): machine X direction dimensions

② Height (H): Machine Y Direction Dimensions

③ Unit: mm

④ plotter origin: lower left (machine origin)

⑤ Pen: SP property (current device support SP1 to SP8)

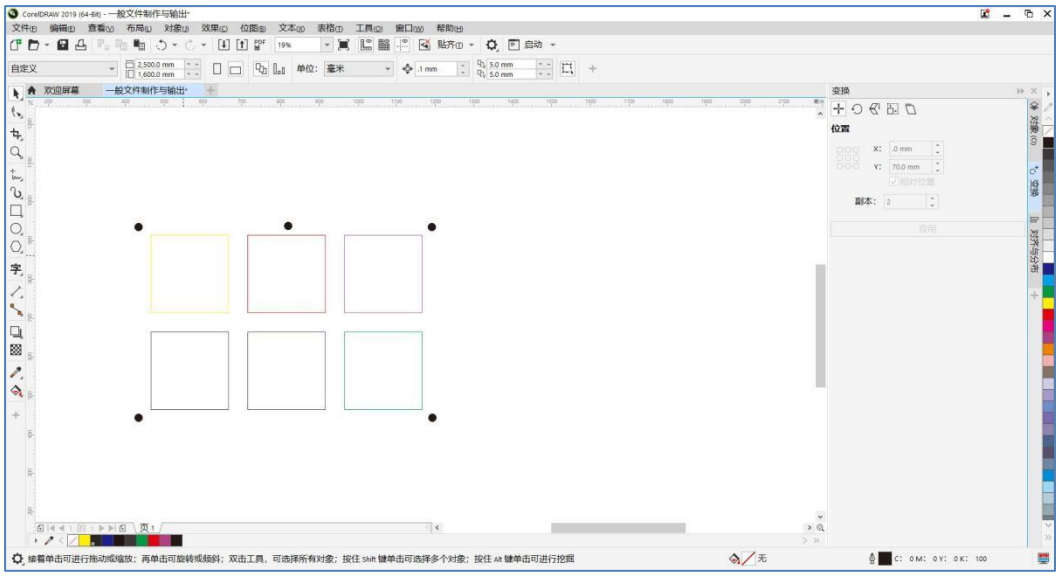
⑥ Color：CorelDRAW software contour color

⑦ Pencil Color: The corresponding contour color can be adjusted after selecting the pen number

⑧ Curve resolution (R): the unit is set to "mm ", the smaller the curve resolution value, the more arc points.

14. How to Generate and Export the Camera Locating Files

The registration marks position for the CorelDraw is as same as the illustrator, and only the contour lines are retained.



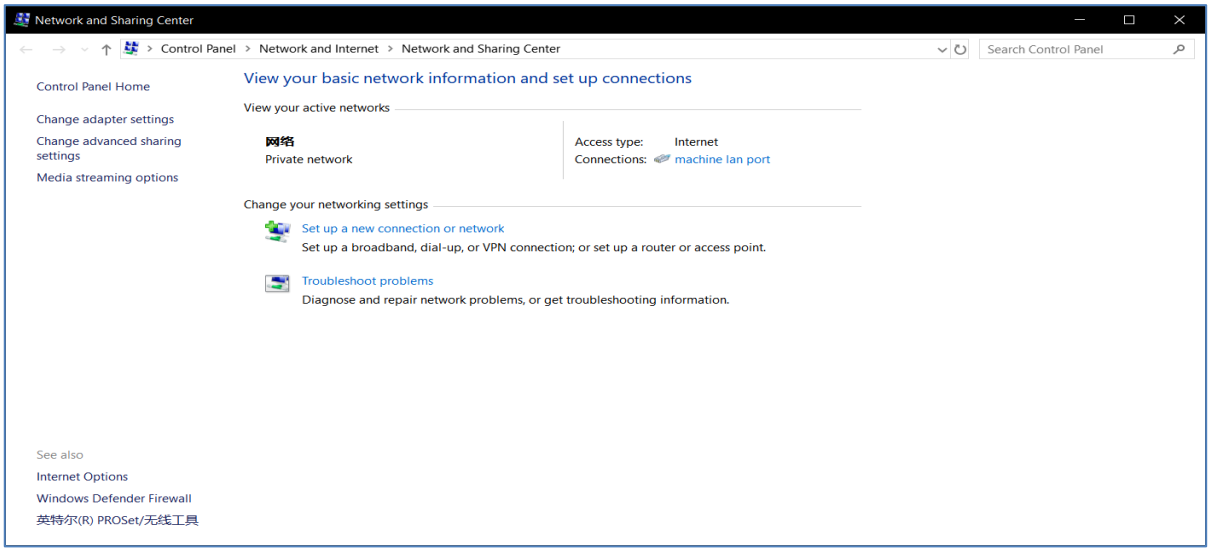
15. DPC Connects Installation and Operation Download Link

https://www.duplousa.com/support/

16. Data Transfer Settings

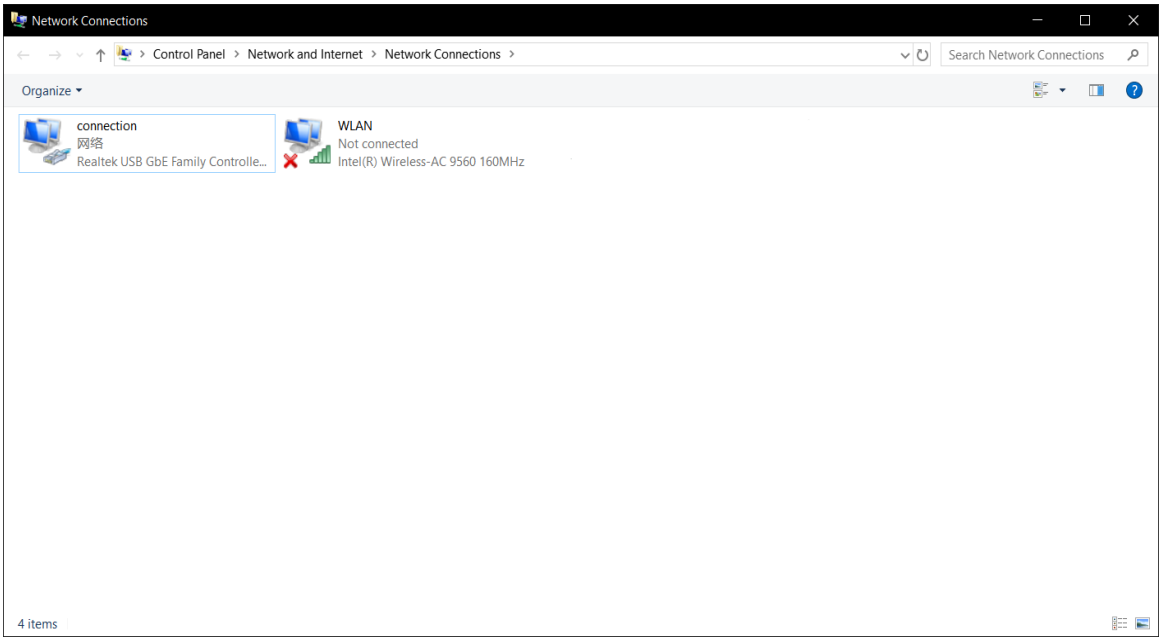
16.1 Computer Setup

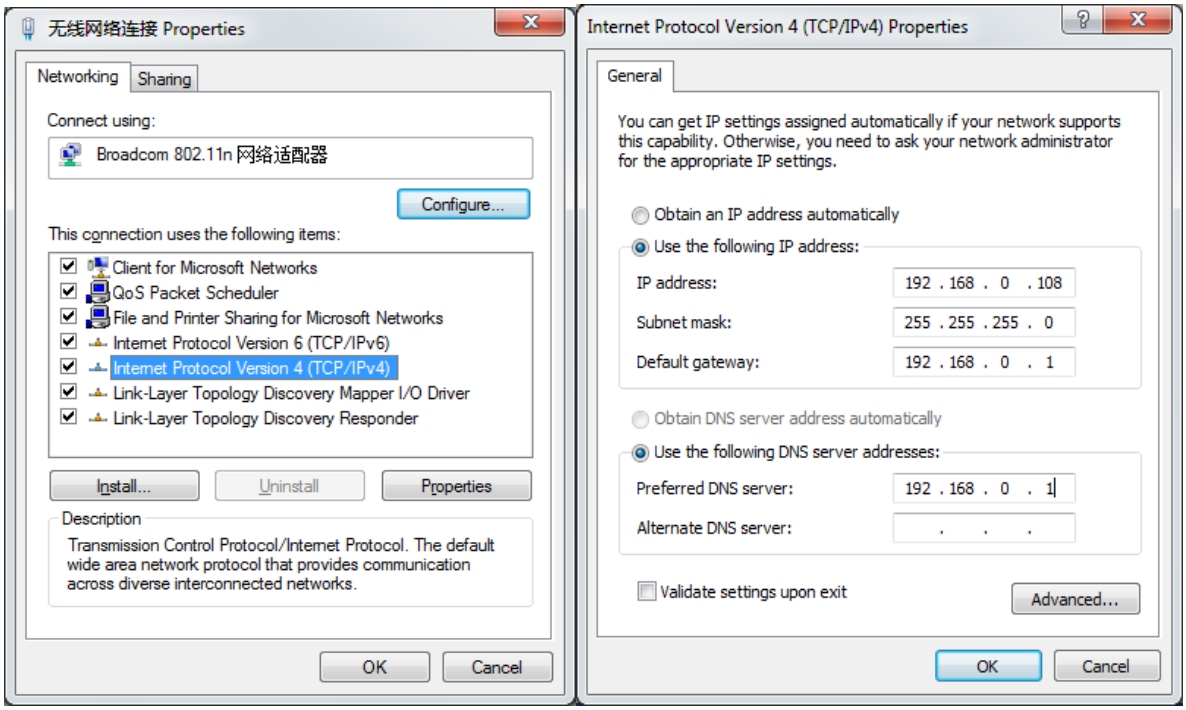
While Computer started and ready, find the "network" icon on the desktop, right-click the network icon and Select Properties, Enter into the network and share center window, click "change adapter settings".



After Click “Change Adapter Settings” to enter the local connection Window, Right - click on the Relevant local connection, Click "properties ", Double click \Protocol version 4 to enter IP settings, Select “use following IP Address”, then you can define the ip what you need.

For example:192.168.0. XXX. Click OK to save and close the local connection control panel after completion.





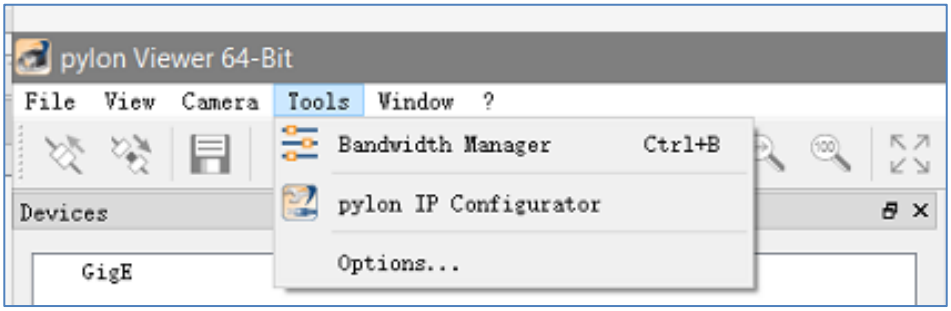
16.2 Connection DPC-600 and Computer, and the Software IP Setup

Power on the cutting machine, after the machine reset finish, click the "Setup" button, enter the "Advanced " page, enter the" extended Settings "page. You will see machine IP address option, Set the IP to 192.168.0.250, click return after setting, IP address will be saved automatically (Note: make sure the computer and machine are in the same network segment, otherwise the machine cannot be connected). Software IP is same as machine.

16.3 Camera Software Parameter Settings

Double click the camera driver (Pylon viewer) on the computer desktop

, then click the tools and IP configurator, the software will automatically search the device, the device list will be displayed below the connection item, need to modify the IP before connecting. Click on the device and do the following settings:

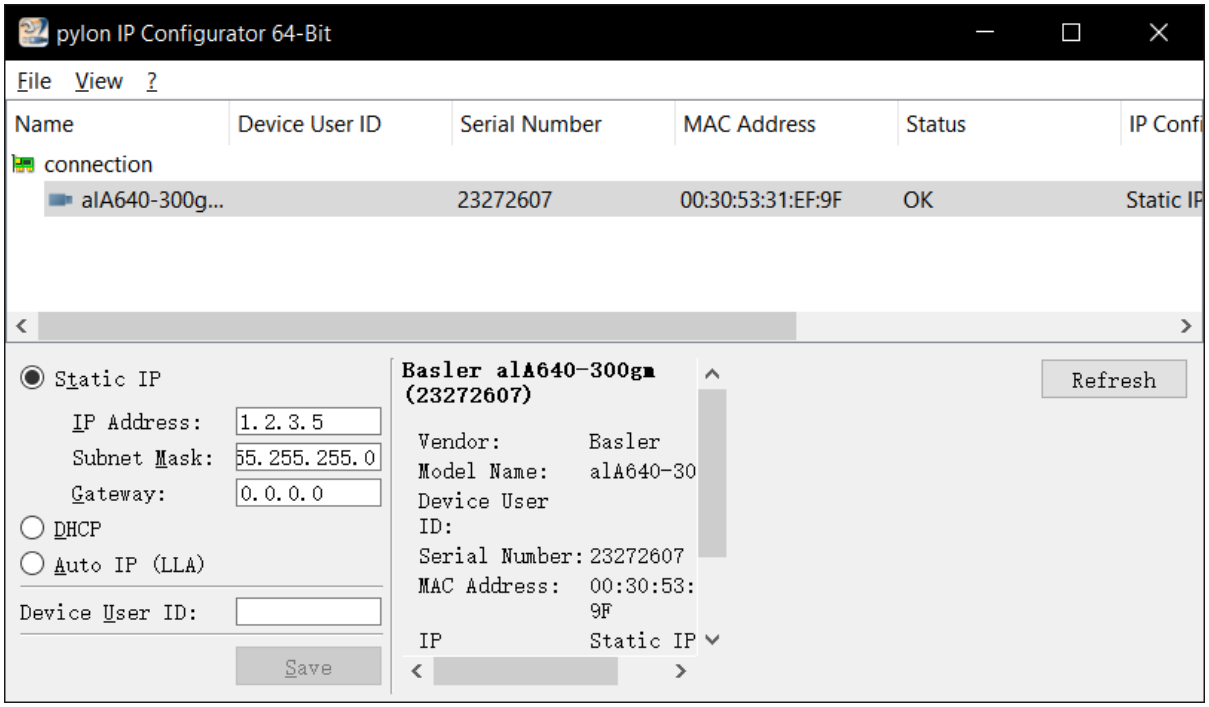


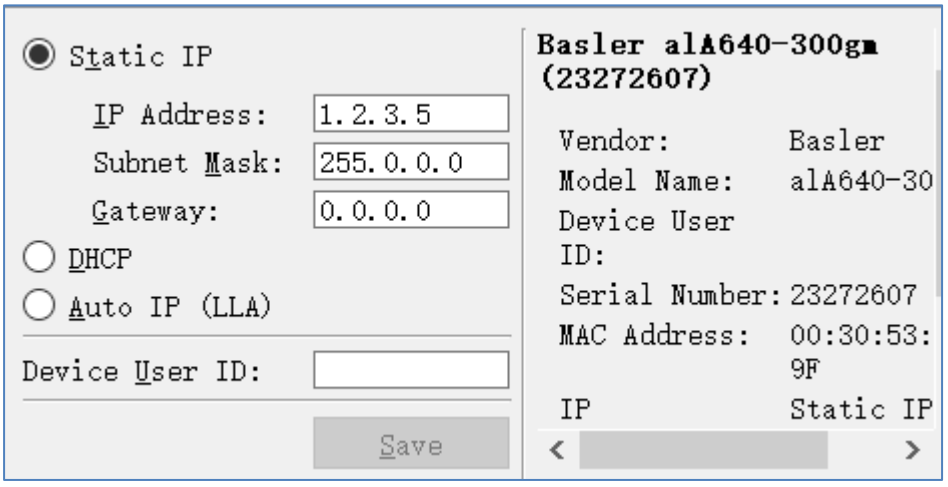
For example: Set camera IP address as 1.2.3.5,

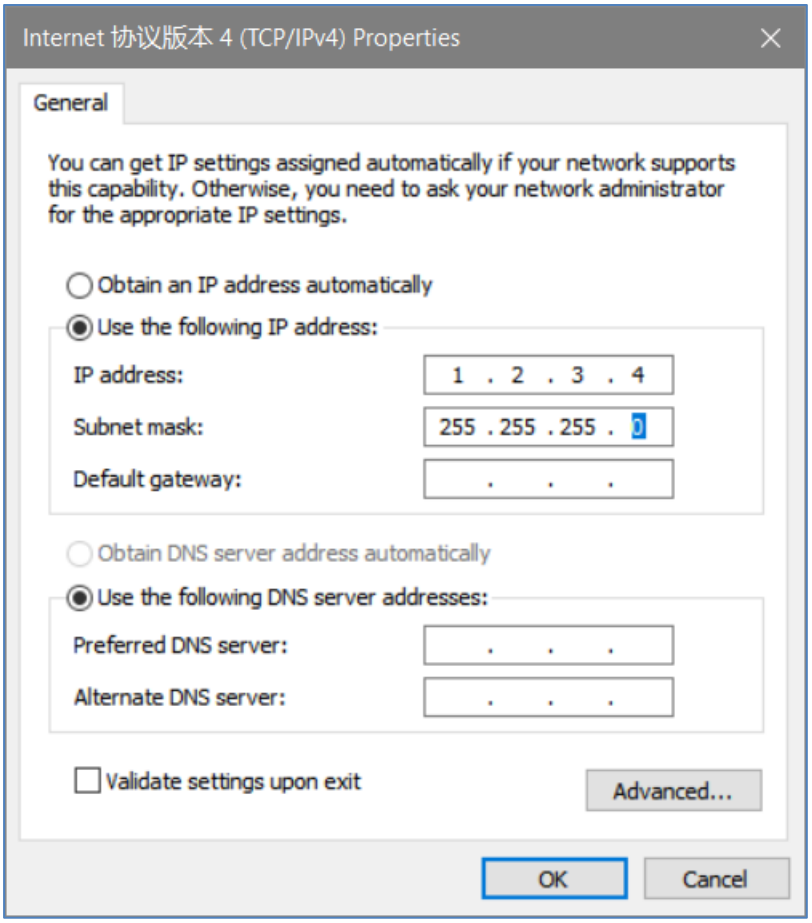
Camera local connection Ip need set to same segment, such as 1.2.3.*(cannot same with camera software setup).

Computer IP address setting method as below:

Right click on the camera PCI Card local connection and click Properties,select internet protocol version 4(TCP/IPv4) and double click it.Select the “Use the following IP address”and set IP address:1.2.3.4,Subnet mask as 255.0.0.0,default gateway as 0.0.0.0) then click OK to save the setting.



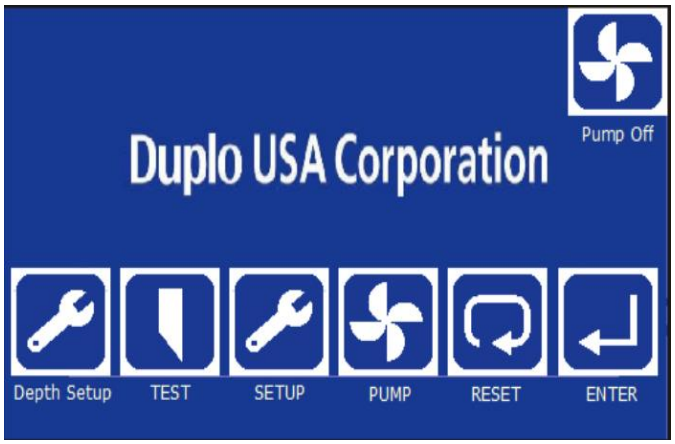




The machine IP address, the net router (if use) and computer address must be set to the same network segment, otherwise they may not be connected.

17. Operation Procedure

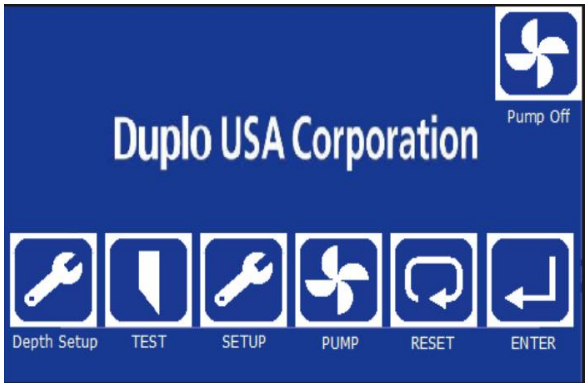
17.1 Function Key



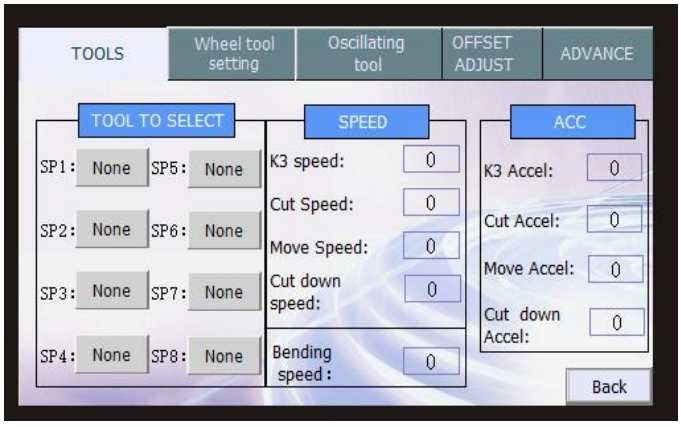
Key	Function	Function
	Suction	Turn on/off the suction Manually
	Reset	Reset to Home (X0, Y0)
	Enter	Repeat the previous file
	Test	Common Tool Testing
SETUP	Tool Set Up	Common Tool Set Up
Depth Setup	Tool Depth Set Up	Tool Depth Set Up

17.2 Tool Selection and Set-Up

Click “press to start”:



Click

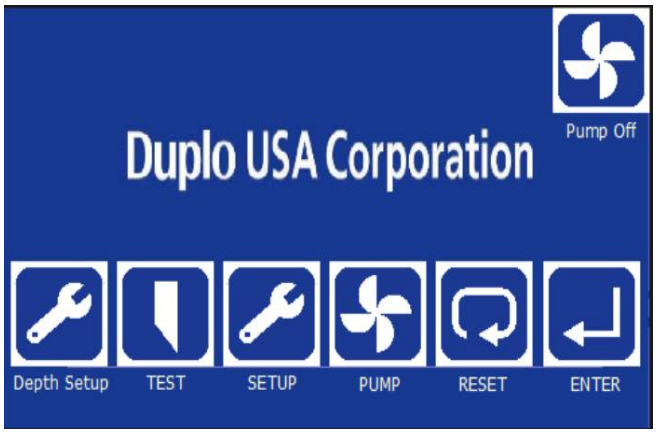


Press “TOOL TO SELECT”

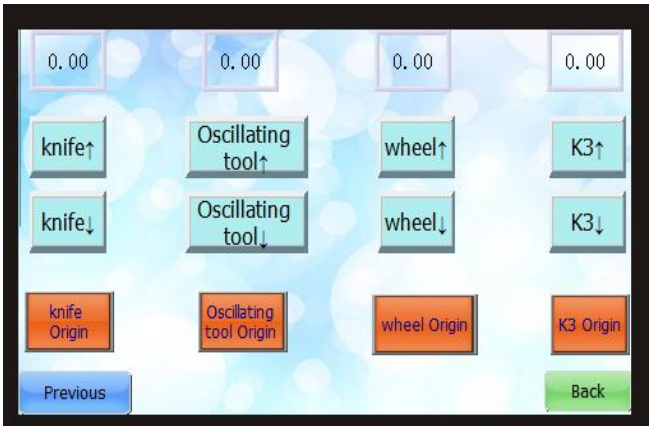
There are SP1~SP8 for select the tool Name. You can name the Number for different tools as your needs.

For Example: SP1: knife SP2: Wheel

17.3 Tool Depth Set-Up



Press

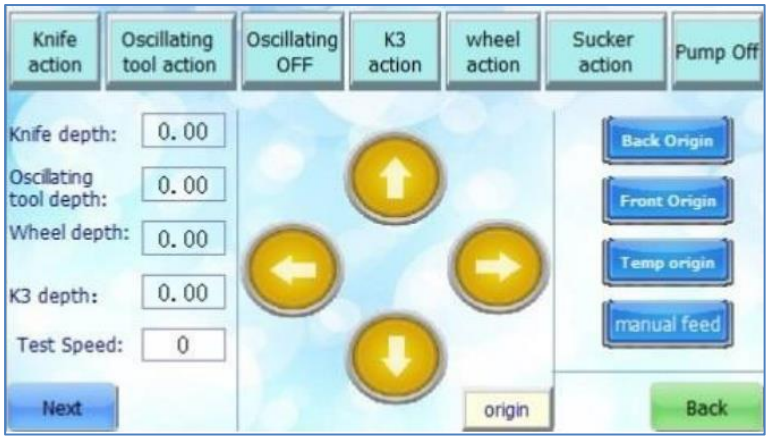


a. You can find Knife/Oscillating tool/wheel/K3 tools name with up/down button.

b. Select one tool then Press down button until the blade sharp point touch to the mat.

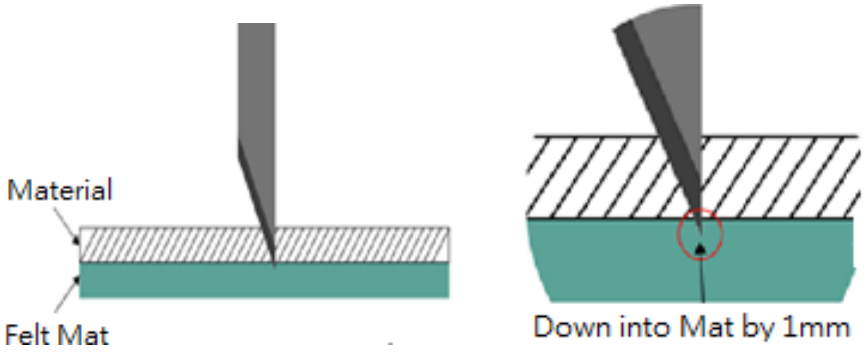
c. Click the “Origin” button to save the depth while you make the blade touch to the mat.

d. After depth saved, you can find the value as shown below:



e. While you do test if the tool cannot cut the material thru, you can modify the depth value directly.
*Please note that value cannot be over 0.5mm. For example, the depth value is 5. You can modify it less than f. If you need more depth, you need into Depth Setup and do it again.

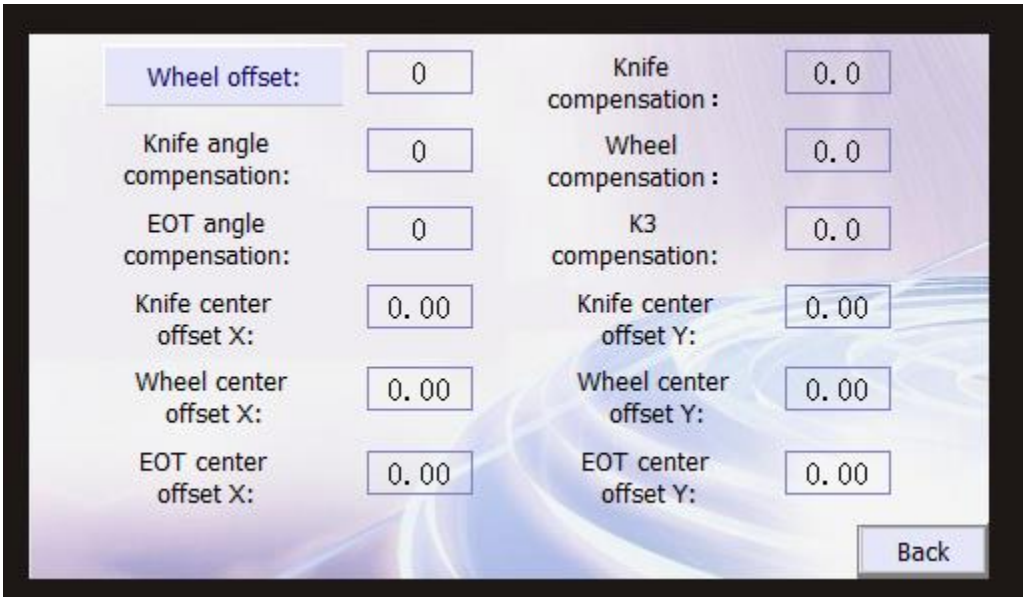
When setup the Oscillating tool depth, the cutter head cover needs to be lifted-up, then rotate the tool motor end to make the blade at down position. Then you can setup the depth as below.



17.4 Tool Compensation Settings

If the knife, creasing wheel, or oscillating knife is not parallel to the X direction. please can enter into the Tool Calibrate page and adjust the blade angle .

You can find below page thru Click “Compensation” option which in the ADVANCE page.

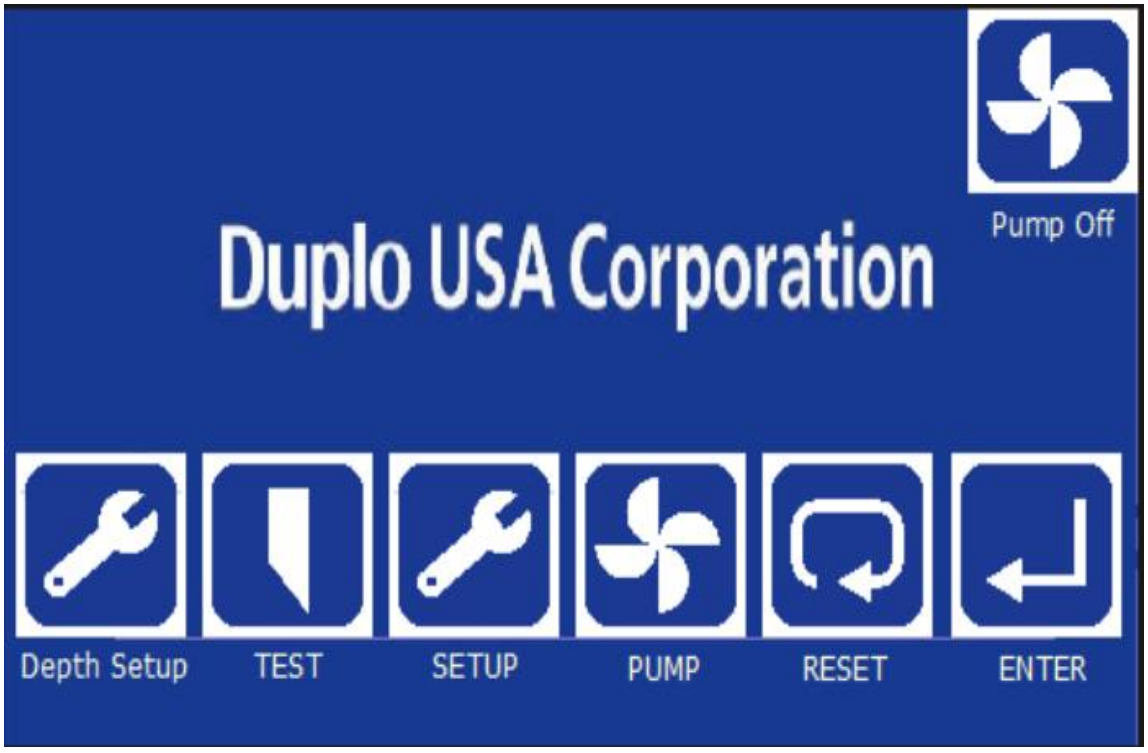


Caution

When creasing Arc/curve with creasing wheel that file diameter should bigger than 6mm. Otherwise that will damage the substrate.

17.5 Start

After power on the cutter, the touch screen will take around 10s to initializing and show above page. Then Click the center of screen and the cutter head will move to home position.



17.6 Test

Menu	Items	Functions
Test	Knife action	Control the Tangential tool up/down.
	Oscillating tool action	Control the Oscillating tool up/down.
	Wheel action	Control the wheel tool up/down.
	Test speed	Moving the speed when you press the direction key
	Temp origin	Temporary original position setting. Please refer to the red cursor to move the machine head to any position of the cutting area, then click Button down and the cutter will start from the position work.
	Manual feed	Click it and the cutter will take the material from the feeder table

Menu	Items	Functions
Tool selection Speed & Acceleration	SP1-SP8	To set the tools name
	K3 Speed	K3 tool cutting speed
	Cut Speed	Tangential tool cutting speed
	Moving Speed	Machine moving speed after tools lifting up.
	Cut Down Speed	The tools move down speed
	Bending Speed	Machine processing curve/circle speed
	K3 Acceleration	The cutter acceleration when it is working with the K3 tool
	Cut acceleration	The machine move acceleration when it is working with the knife tool
	Move acceleration	The machine move acceleration when it is travelling without tools working
	Cutdown Acceleration	The tools move down acceleration speed
Advanced Settings	K3 down delay	The machine delays in N millisecond before the K3 tool drops down
	K3 up delay	The machine delays in N millisecond before the K3 tool lifts
	Cut down delay	The machine delays in N millisecond before the knife tool drops down
	Cut up delay	The machine delays in N millisecond before the knife tool lifts
	Wheel down delay	The machine delays in N millisecond before the wheel tool drops down
	Wheel up delay	The machine delays in N millisecond before the wheel tool lifts up
	Automatic repeat	Repeat the previous job automatically after activated
	Automatic return to origin	After finished the job, the machine automatically back to the origin position
	Gradient	Gradient correction of the gantry
	Restoration of factory settings	Restore all machine parameters to pre-factory settings
	Return	Return to the upper layer

17.7 Tool Parameter Set Up:

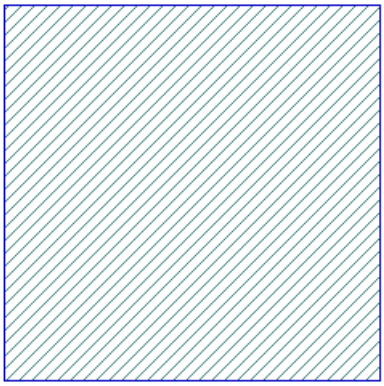
Menu	Items	Functions
Tools	Current Tools	Set SP1-SP8 number to the related tools
	Tool Depth	Set the depth value of the tool
	Knife Action	Click to test the knife tool depth, the knife tool will drop down as much as per the tool depth value
	Oscillating Tool Action	Click to test the oscillating tool depth, the oscillating tool will drop down as much as per the tool depth value
	Wheel Action	Click to test the wheel tool depth, the wheel tool will drop down as much as per the tool depth value
	Test Speed	To set the machine speed when you click the ↑↓←→ buttons
	Temp Origin	Temporary set the original position after moving the cutter head with the ↑↓←→ buttons to a certain position of the table.
	Manual Feed	Click to feed a sheet or a certain distance of the roll sheet
	Angle K3 Action	Adjusting the deceleration of the K3 slash
	K3 Stop Angle	Adjust the stop speed of K3 slash
	Cut-off Angle	Adjusting the cutting speed of the cutter
	Cut-off Angle	Adjust the stop speed of cutting slash
	Corner	Lift the knife when set to how much angles tangent
	Knife Established Set Vibration knife speed	The speed at which the cutter performs the vibration cutter instruction
	Vibration knife acceleration	Acceleration of the cutter in the execution of the vibration cutter cutting order
	Lower Shock Tool Speed	The speed of the cutter when executing the command of the vibration cutting
	Acceleration of the under shock knife	Acceleration of the lower cutter when the cutter executes the instruction of the lower vibration cutting
	Oscillating knife angle	Angle of the cutter when executing the arc instruction of the vibration cutting

17.8 Offset

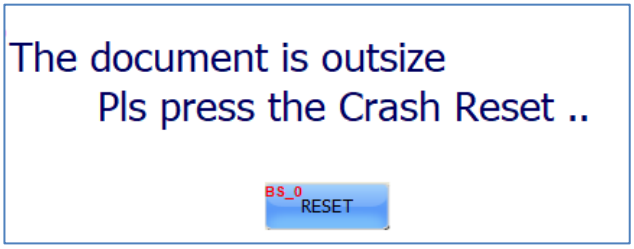
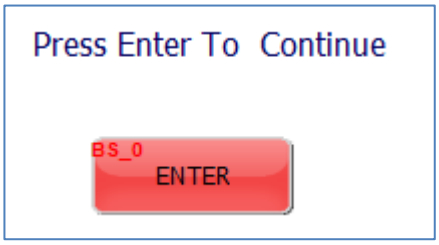
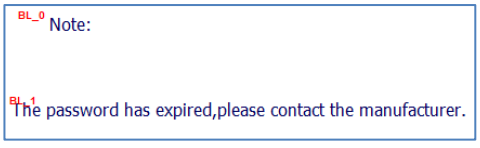
Items		Functions
X Offset	Calibration Ratio	Change this when the actual output size in the X direction is more or less than designed. Parameters. One unit is 0.01 time. The positive value is enlarged, the negative value is reduced
	Tool K3 Offset	X direction cutter K3 coincidence error correction
	X-cursor Offset	X Direction Cursor Overlap Error Correction
	Wheel K3 offset	X direction wheel K3 coincidence error correction
	Deviation K3 Shaker	X direction shaker K3 coincidence error correction
Y Offset	Calibration Ratio	Change this when the actual output size in the Y direction is more or less than designed. Parameters. One unit is 0.01 times. The positive value is enlarged, the negative value is reduced
	Tool K3 Offset	Y direction cutter K3 coincidence error correction
	Y- Cursor Offset	Y Direction Cursor Overlap Error Correction
	Wheel K3 Offset	Y direction wheel K3 coincidence error correction
	Deviation K3 Shaker	Y direction shaker K3 coincidence error correction

17.9 Calibration Option

If Design size is 400*400mm; Real cutting size is 401*399mm: adjust calibration X & Y value.



18. Touch Screen Common Alarm Information

Alarm Information	Solutions
	1.If the sample exceeds the effective format of the cutter, please set up the size in DocuCutter software. 2.Sample beyond the DocuCutter effective typesetting position, please move the sample to the DocuCutter effective typesetting area.
	This information is a security protection item while cutting job finish and it will pop up, after click ENTER then cutter will continue next page or turn to standby. If you do not need it and you can turn off by PG Enter option.
	This information is a cutter self-check item, while screen shows it, you need to check servo drivers whether display alarm code.
	After this prompt, please contact the Duplo dealer directly.

19. Maintenance

The DPC-600 is a precision electromechanical product, the whole machine includes two parts: circuit board and precision machinery, so it must be carefully maintained to prevent all kinds of faults. For prolong the service life of the equipment. Please strictly follow the instructions below for maintenance.

Item	**Maintenance Cycle**			
	A day	**A month**	**A Quarter**	**A Year**
Tools	Cleaning	Lublication	Maintenance	Maintenance
Vibration Tools	Cleaning	Lublication	Maintenance	Maintenance
Conveyor Belt	Cleaning	Cleaning	Cleaning	Replacement
Boxes	/	Cleaning	Dust removal	Maintenance
Air Compressor	Water release	Cleaning	/	/
Pressure Regulating Valve	Water release	Cleaning	/	/
Guide Rail	/	Dust removal	/	/
Transmission Parts	/	/	Fastening	Maintenance
Cutter	Cleaning	/	Maintenance	Apply for Professional Maintenance
Computer	Cleaning up	Anti-virus	/	/

Part III Stacker ST-200i (Option)

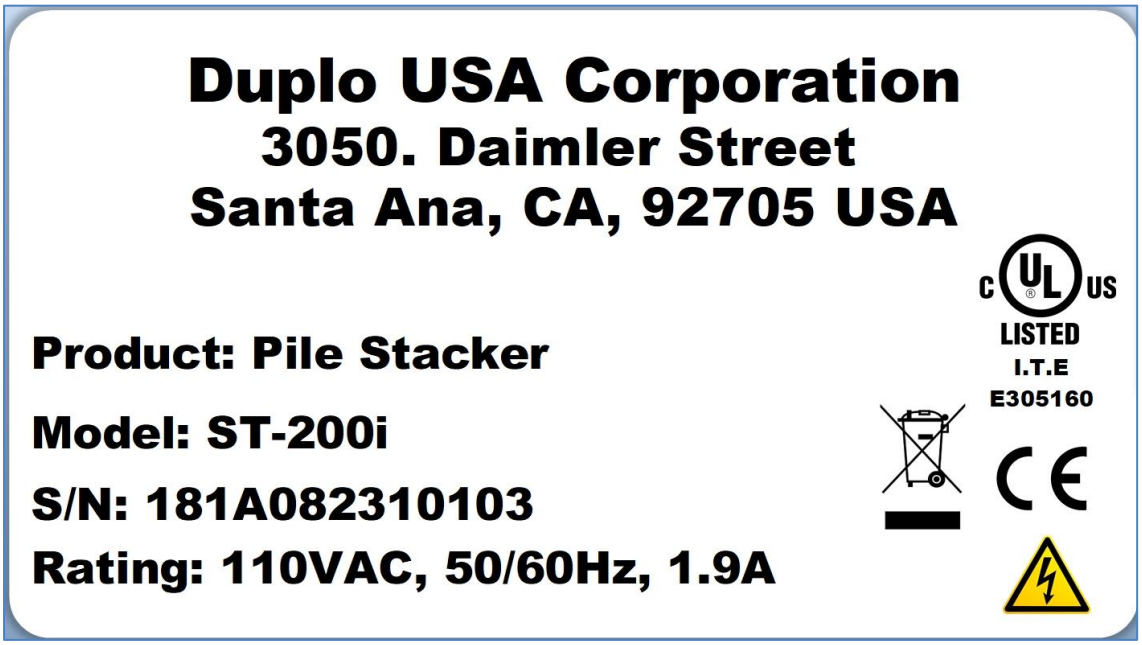
1. Introduction

The ST-200i is an automatic stacker provides smooth and neat stacking.

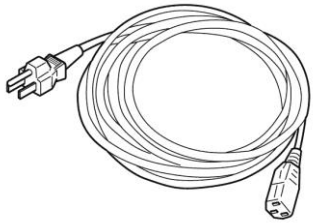
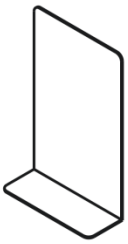
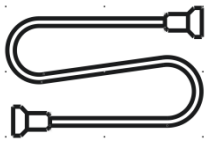
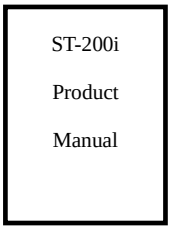
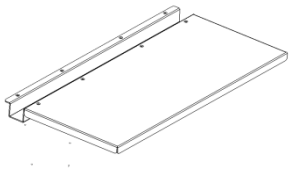
2. Specification

Specifications	SF-300i Suction Feeder
Max. Paper Width	23”
Max. Paper Length	29.5”
Min. Paper Width	12”
Max. Thickness	0.14” (3.6mm)
Paper Weight	200gsm
Min Paper Size	17 x 11” (Long edge feed)
Power Requirement	110VAC, 50/60HZ 1.9A
Dimension	77.3” x 35.4” x 39.8” (1964 x 900 x 1012.6mm)
Weight	342 lbs (155Kgs)

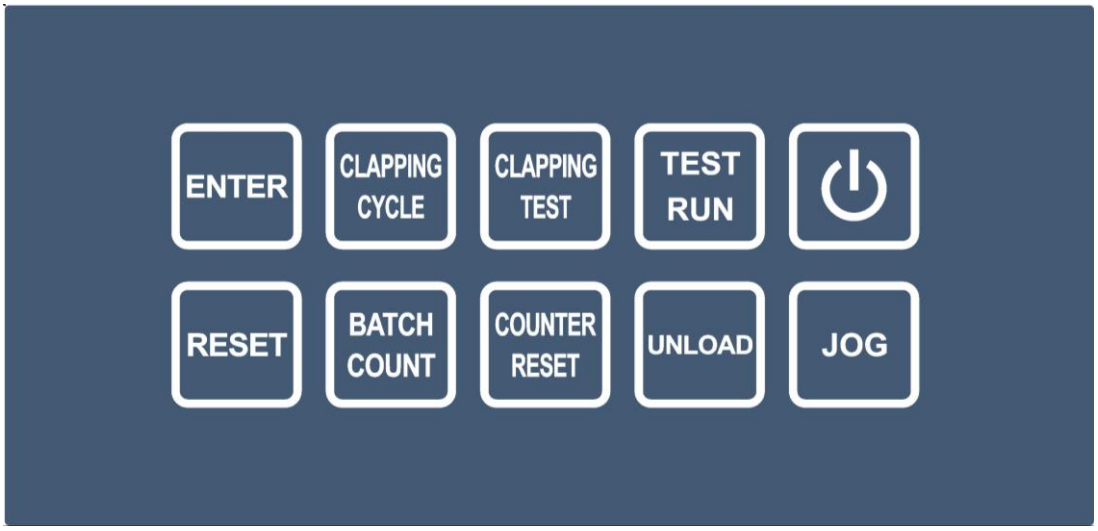
3. Name Plate



4. Accessories List

	
Power Cord 00P-000-3007 USA	Back Stop P/N
	
Interface Cable-8pin 150cm	Product Manual (Download from Website)
	
Extension Plate	

5. Control Panel and Function Key



Function Keys	Function
	Change system to On(Ready) or Off (Not Ready)for inline, Off mode can do jogger plate position adjustment
JOG	Clear paper path and as composition key
TEST RUN	Under “OFF” Mode, Enable Intake Conveyor Turning
UNLOAD	Tray down to unload the media
CLAPPING TEST	Test clapper position
COUNTER RESET	Reset Counter
CLAPPING CYCLE	Jogger Clapping Cycle
BATCH COUNT	No Function

	Confirm the setting
	Reset error message on the display,

6. Operation Procedure

6.1 Load the Paper

6.1.1 Press

, the feed tray will be lowering down to home position

6.1.2 After the paper is loaded, press to bring the stacker up to ready position

6.2 Adjust the Jogger Clapping Plate Home Position

6.2.1 Loosen the clapper locking thumb knob and put aside the clapper to the side.

6.2.2 Feed one piece of paper throught coater and into stacker

6.2.3 Set the clapping plate against the sheet and keep 0.5~1mm spacing.

6.2.4 Press again to change to “OFF” mode

6.2.5 Press to set stacker to “Ready” mode

6.3 Setting the Clapping Cycle

6.3.1 Press to change mode from “READY” to “OFF”

6.3.2 Hold

gently then

press to set every 1, 2, 3, 4, 5 or 6 pieces the clapper will activate one time to organize the stacking pile.

6.4 Setting the Back Stop

.

7. Reset Counter

7.1 Press to change to “OFF” mode.

7.2 Press

and tip on

8. Error Code

Error Code	Sensor No	Symptom and Possible Cause	Action
E001	S1	Jogger sensor error	Call for service
E002	S2	Paper jam at S2	1 Correct skew, readjust side guide 2 Check media not flat or curled 3 Sensor #2 dirty 4 Remove the paper
E003	S2	Input sensor see no paper.	Input sensor failed
E004	S4	Level sensor keep seeing paper	1 Readjust side guide 2 Check media quality 3 Check side guide and clapping plate alignment 4 Check and adjust end stop setting
E005	S4	Level Sensor Error	1 Check stacking tray position 2 Check end stop position 3 Level sensor failed
E009	S4	Stacking Upper Limit Switch Error	Level sensor failed, call for service
E009	S7	Top margin Limit Error	Top margin sensor fail, call for service
E010	S8	Bottom Limit Error	Bottom margin sensor fail, call for service
- - - -	S9	Top Margin	Feed Tray up to top margin
- -	S10	Bottom Margin	Feed tray down to bottom margin
Blinking “□□□□”		Press doesn’t feed	1. Coater not ready
Error can not be reset		1. Exit sensor sensed the Infra Red 2. Paper path has paper	1.Try to cover the sensor to block the Infra Red 2. Remove the sheet in paper path
No Power		E-stop is ON	Reset E-stop