

# D P C INNECT

# Installation and user manual

# 1. Set machine IP address

Enter the settings at the cutter control panel and navigate to the *Advance\_c tab*, then hit *Extended Setup*.



If connecting to the local network enter a valid, free and static IP address in your local network.

Extended Setup		
IP: 192 - 168	• 255 • 20	
Material Type : board	Rolling Repeat;	SEP ON
Vacuum sucker1:	Weak Suction :	OFP ON
Vacuum sucker2:	Page Distance: 30	
		Back

## 2. Tool setup

Enter the machine tool setup and assign the tools according to the following screenshot.

DPC-600



Creasing Wheel



wheel

=

DPC-600

SP3

=

wheel



SP3	=	wheel	Creasing Wheel
SP4	=	КЗ	Drag knife/drawing pen
SP6	=	knife	Kiss cut/ thru cut knife
SP7	=	EOT	Oscillating knife



Enable "AutoFeed" on the control panel of the machine (Setup - Advanced menu).

The default tools selection is set up for DPC-400 machine: drag kiss / thru cut knife and creasing wheel.

To activate tools for DPC-600 machine: multitool K3, kiss / thru cutting knife and oscillating knife follow the procedure:

Open the DPC Connect – click on the working area - Press Ctrl+Shift+P on the keyboard to open adriver editor – a new window will be displayed.

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For better view select Maximize.

Go to tool settings to disable / enable the required tools.

😑 🔁 Tool settings	
庄 🔁 Creasing wheel No output tool	
🕀 🔁 Pointer No layer tool No output tool	
🕀 🔁 Ausgabe mit Layerzuordnung Tandem No	b layer tool Ni
🕀 🍾 Output with layer assignment. No layer too	bl
표 🚡 Kiss cutting knife No layer tool No output	tool
🗄 🗄 Thru cutting knife Nolayer tool Nooutput	t tool
🛨 🔁 Perforation No output tool	
🕀 👍 Thru cutting knife (Tangential) No layer to	ol No output
😟 🔁 Kiss cutting knife (Tangential) No layer to	ol No output
🕀 🗄 Oscillating knife Nooutput tool	
표 🔁 Kiss / Thru cutting knife (Tangential) No (	output tool
庄 🚡 Multitool K3 No output tool	
🗄 🖓 🔁 JoyStickSettings	
	~
<	>

Select a tool – right click – deselect 'No layer tool'. 'No output tool' must be selected.



The correct tool settings are:

÷.	👍 Multitool K3	Νοιου	itput tool
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E [E	JoyStickSetting		Сору
			Delete
			No layer tool
		$\checkmark$	No output tool
			Tool can have inserts

Repeat the steps for kiss / thru cutting knife (tangential) and oscillating knife.

For kiss cutting knife and thru cutting knife make sure that both options are selected 'No layer tool', 'No output tool'.

Go to File – Save As to save the settings. Close the Driver editor.



New tools will be available.



# 3. Camera setup

Install Basler pylon suite.



Run the installer in *custom* mode and disable USB Camera Support, Camera Emulation Support and enable the

DirectShow support option

Open Pylon Viewer – select Basler – right click – pylon IP configurator

Dasier	Open Device		
	Open Device •		
	Single Shot		
	Continuous Shot		
	Firmware Updater		
	Bandwidth Manager		
	pylon IP Contribution		
	Get Help		
	1 Submit Feedback		
Show Came	eras Only	Auto-Scan	C
eatures		~	¢ X

The Status OK and static IP address will show that the camera is connected properly.

ne	Device User ID	Serial Number	MAC Address	Status	IP Configuration	IP Address	Subnet Mask		
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alA640		23272619	00:30:53:31:EF AB	ок	Static IP	10.250.0.94	255.255.254.0		
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If the status is 'Not reachable' add the Static IP address based on the machine IP address. Check if the subnet mask is correct.

To check if the camera is connected properly turn on the camera and select continuous shot.

pylon Viewer 64-Bit				
File View Camera Tools Window Help				
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If the image is too dark, type in the search box 'exposure' to find the Exposure time setting. The default setting is set to 5000. Depend on the light above the machine this value might need to be changed. Change the value until the image is not dark.

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File View Camera loois Window Help		
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To Save the settings type in the search window 'user'. To save the setting Stop live image by using the stop button. Change the Configuration Set to User Set 1, Default Startup Set to User Set 1 and Select Execute in User Set Save.



## 4. Install PrintDriver application

- Run the *Jingwei Driver English Setup.exe* installer and follow the instructions
- Start JWEIDriver from the Windows start menu and enter the IP address set at the machine control panel.

		<u> </u>	主利	玙
V		JINGW	EI CAD/	CAM
	Connect Typ	be: 🔹 M3		
		C IC		
		○ Modbus		
	Machine	IP:	32.168.255.20	
Server	Client	Control	Demo	Close
				s <del>t</del>

Hit the *Control* button in the centre to connect to the machine. The machine has to idle! The IP address has to match the Machine IP address on the control panel. If the connect is successful, you will get the following screen.

tem Op	otion Help				
	Reset		×+		SW:
		Y+	Origin	Y-	
	Pump		×-		
C:\PFiE	BladeConnect				
Prog	ress:				

The Green indication behind Mac shows that the panel is connected to the machine. The red indicator shows that DPC Connect is currently not connected to the panel. This panel acts as a bridge between the machine and DPC Connect. It has to be active before sending anyjob to the machine.

C Modbus		C Parallel C Delta C FTP	
Net		Serial	
Link Type	: Ethernet 👻	Comport COM1	*
ID Adds	192 168 0 250	Paudrates 38400	*
IP Addr	102.100.0.200	Daudraie. 130-100	
Net Port	: 23	Parity: None	
PCI No	5	DataBits: 8	
	Fast Mode	StopBits: 1	~
Comport	1	Handshaking: None	*
	Channel Protocol	Parallel	
Channel	⊡ I Time-Out		
Time	3	Parallel No:  1	*
Delta			
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Please change the below settings in Options - Settings.

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Print Delay(:	s): 5	File Code Conversion	
		✓ Software Mutex	
Languag	e: English	🗖 Auto Min-Display	
Server Net Po	rt 70	Lock Current Software	
	Print Preview	🔽 Old Program Mode	
	☐ File don't exist. <delete item=""></delete>		
	☐ JW-MES		
Watcher Function     File Filter	s:  *,plt*.HPG;	□ Sub-	Dir
Only-Save Disposed File,	it's not print files!		
Save Printed Files	🗆 Loop ;	print file	
C:\Program Files (x86)\Jingw	ei\Jingwei Driver\BackupFile_Folder		

Create "Hotfolder" c:\DPC Connect for cut files and select the folder in the JingWei driver.

stem Option Help				
Reset		×+		SW: Mac:
	Y+	Origin	Y-	
Pump		×-		
C:\PFiBladeConnect				
Progress:				

#### 6. Update cutter Firmware

Open your browser and enter the IP address of the machine.

Enter the user name "admin" and the password "sys" Click

File upload and select the program.bin file.



Embedded Development Tools	<b>N</b>	JWEI	6
WEB Server File Uplo	ad		
You can select files from your local PC and upload them to a machine. Files will be stored to the <b>root folder</b> on SD Card.	n SD Card con	nected to th	e
Select a File to upload to SD Card:			
Durchsuchen Keine Datei ausgewählt.			

Hit send and reboot the cutter Run *Hyperterminal*. Type a name e.g 123 and select ok.

Connection Des	cription			?	×
Enter a name an Name:	nnection d choose ar	n icon for	the conne	ection:	
Icon:		MC	<b>8</b>	ß	<b>%</b>
			ОК	Can	cel

Change the 'Connect using' from COM3 to TCP/IP. Type the machine IP address on port 23.

Connect To			? ×			
Enter details for	the host th	at you want to ca	all:			
Host address:	192.168.3	255.20				
Port number:	23					
Connect using:	TCP/IP (	Winsock)	~			
		OK	Cancel			

If you are connected, enter \_program\_ . Wait until the reboot machine message appears.

# 5. Install DPC Connect

Run the *dpcconnect.exe* installer and follow the instructions on the screen. Setup will automatically add the device driver and set the communication IP address for the local computer to 127.0.0.1. This device driver will communicate with the JingWei Print driver.



6. DPC Connect Setup



#### 6.1. Check if the device is DPC-600.

6.2. If the device is not correct – select settings – standard settings – Output device.



6.3. Select 3 dots next to the device name - change

Devices	? ×	
out Device		
	v	Add local device
DPC-600 127.0.0.1		Connect to Plot Manager Change Check for newer version
Output with layer assignment	~	Delete
Standard	~	
	Devices DPC-600 127.0.0.1 Output with layer assignment Standard	2 Devices ? × but Device DPC-600 127.0.0.1 Output with layer assignment ✓ Standard ✓

6.4. Select arrow down next to the driver name and select DPC Connect and change the device name – then OK.

	?	×
Common:		
Device name	Driver:	_
DPC-600	DPC-600	$\sim$
n 🕞 🔲 Run as Plot Server (	19 << Please select >>	
Plot to file only	DPC-400	_
	DPC-600	
Device Types:		
Local Ports:		
COM/ O << Please	select >> V Settings	•
USB / FireWire Devices:		
USB/ FireWire		~
TCP / IP:		
TCP / IP (0) 127 .	0 . 0 . 1 Port 50000	~
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Spooler O Adobe Pt	2F	
Spooler O Adobe PI	ок с	Cancel

6.5. Once the device is selected check if the working area is  $800 \times 600$ .

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6.6. If not correct – right click on the working area – select working area – select DPC-600.



Working Area		1.000000000000000000000000000000000000								?	×
+ New	🗙 Delete	🛐 Change	Default*								
											-
N	lame	Width [Inch]	Height [Inch]	Format							7
DIN A5		5.827	8.2								
DIN A4		8.268	11.6	Na	ame [		Rei	ad from connected device			
DIN A3		11.693	16.5				_				
DIN A2		16.535	23.3	1	6dth	21.490 A Inch		Change orientation			
DIN A1		23.386	33.0		iuui	51,450 -	<b>A</b>	Change one haton			
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DIN B2		19.685	27.8	Margins							
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Legal		8.500	14.0		Left	0.000 - Inch		Гор	0.000 🖕	Inch	
Plate 1*		39.370	39.3								
Plate 2		59.055	59.0		Right	0.000 <sup>1</sup> Inch		Bottom	0.000	Inch	
DPC-600		31.496	23.6		rugnu	0.000 - 11101		Bollom	0.000	incir	
Dummu		23 622	15.7								
•				Show margi	ns 🗍						
Preview											
T T											
				□ Color							
				Foreg	round	255; 255; 255					
				Baaka	round	255: 255: 255					
				Backgi	round	200, 200, 200					
				Select in	nage						
L L				Scale objects too			<ul> <li>Accept wor</li> </ul>	king area dynamically from cu	rrent device		
				OK		Cancel					
						Cancer					

6.7. Check if the production profiles have the correct device selected and material width/length set up. Edit – edit profile.

Profile:							
Profile name:	Reg Marks Bo	ard/Sheet (No QR)					
Profile description:							
🗳 Device		🖊 Output 🛛 🏃	Miscellane	ous	Bar code	💿 Camera	
🔿 🗌 Default	settings						
Material:	嵴 Curren	t settings					
Device:	👘 DPC-6	00					
Tool:	/ Output	with layer assignment					
	🗐 Oranda						
Output Profile:	Standa	ra					
Material wic	Jth	600	0.00 📜 mm	Uisible	Auto Reset		
Material len	gth	800	).00 📜 mm	Visible	Auto Reset		
Preload first	t sheet	⊻		Visible	Auto Reset		
Production	mode	Production	~	Visible	Auto Reset		
Compensat	tion method	Best fit (Smart Compensatio	on) 🗸	Visible	Auto Reset		
Reference p	point (Fit to Job)	Lower right corner (LR)	~	Visible	Auto Reset		
Material		Feeder	~	Visible	Auto Reset		
s							

6.8. If the settings are not correct change it for each production profile.

#### 7. Measure camera offset

Open "0260702017000\_calibration.job" from the DPC Connect Job folder. Print the sheet ona desktop printer. If no printer is connected, export the file (File – Export) to PDF in order to print the file from another computer. When printing select 'Actual size' on the printer settings. Use 150-170gsm stock.

🚱 <u>File</u> Edit	Design View	Tools	Settings	Window	<u>H</u> elp				
	<b></b> }		1 🌙	2 1					(0)
X	🚯 Open Job								×
mm	Look in:	iol 📙	b			~	0 0 0	<del>.</del>	
	Quick access	Name	607020170	^ 00_calibrati	on.job		Date modifi 7/29/2019 3	ed :36 PM	Type JOB F
400 1 500 500	Desktop Libraries This PC								
1-1	in the second se	۲							>
30		File nam	ne:	00000		-	~		Open
100		Files of	type: Jot Jot La:	DPC Conne Contour pr b size: b st change:	ect-JOB JOB;JT eview Text Text Text Text	P	~		cancel

Assign the tools for Kiss-cut and Thru-cut layer. Adjust the knife depth for Kiss and Thru cutting on the machine.



Put a non-printed sheet onto the conveyor mat, turn the machine in online mode and run the JWDriver application.

Place a blank 150-170gsm paper on the mat. Change to the **Production** tab and select Camera settings by the Edit profiles button.

	<u> </u>	v Ö
🔇 Edit profile		
Cott copy		
🔆 Create new profil	e	
orofile from temp	olate	
Camera settings		
X Delete profile		

#### Select 5mm mark size



In the Camera Offset tab select Kiss cutting knife. Please make sure that the kiss cutting knife can cut through the paper. Move the knife over the paper and select Output Object.

Settings Scale and Scalir g Camera Off	set mage Processir	g Profile Camera Settings				- 8
Generat Marking:						
Calibration Object: O Circle	✓ X:	244.64 <del>-</del> mm	/ Output Object	👘 🖉 🖊 No	QR	· 0
Tool: 4 Kis	s cutting knife 🖌 Y:	123.23 <sup>•</sup> mm	Use Marking			-
Determine Camera Off	set:					110000
c	urrent	Measured			4	
Offset X:	48.25 🗘	0.00 ÷ mm	Measure Offset			
Offset Y:	-1.55 🗘	0.00 <u>*</u> mm	🥏 Save Offset			
				Ψ	Ý	
		📢 Reset				
				Outputs:	10	X: 244.64 mm
				Done: 0	13	Y: 123.23 mm
				Job: kite.jo	b	
				Adjus	t mark detection	
				-		
				Satur		
Save		Cancel			Close	

Remove the inner part of the circle and move the camera above the circle.

If the software recognizes 5mm cut the circle will be green.

In the Scale and Scaling tab, select adjust - the software will calculate pixels for 5mm mark. Click 'Move to mark' to move the circle to the middle of the cross. Keep pressing until the circle is in the middle. Select 'Adjust' again to finish pixel adjustment.

Settings		×		-
Scale and Scaling Gamera Offset Image Pro	cessing Profile Camera Settings			
Set up detection scale:				
Make sure, that one video mark of the currently camera. Click "Customize" to adjust.	active detection profile, is located in the field of vie	w of the	🖍 🕢 No QR	· 0
Mark size: 5.00 🗧 mm				
Corr. factor X: 1.00000 👻 Mark size i	n pixel X: 97.000 Current X: 97.000			
Corr. factor Y: 1,00000 👗 Mark size i	n pixel Y: 98.000 Current Y: 98.000	Adjust		
Test detection:				
To check the mark detection, a correction drive c The closer to the mark then located in the center	an be done manually. • of the camera, the better the recognition system is	i set.		
Set up centering distance:				
The measurement is most accurate in the center The tolerable distance between the recognized n exceeded, inside the measurement process a cor The value refers to the mark size.	of the camera image. nark and the camera center can be set here. If this c rection run is done. It brings the mark into the cam	listance is era center.		
Centering distance: 1.00 🛱			Outputs: 1:	X: 384.08 mm
			Time: 00:00:12 Job: kite.job Adjust mark detection	TEIGES IIII
			setup	
Course	Canal .			

If the 5mm circle is not recognized, the mark will not be green. In the Image Processing Profile select other Circle Threshold profiles to see if the reg mark is changed to green. If it's still not recognized using the profiles already saved adjust the filter values.

Settings	The second second	and the Barrisson of the				
Scale and Scaling Camera	a Offset Image Process	ng Profile Camera Settings				
Edit Image Processi	ing Profile:				🤍 🖌 No QR	× 0
Circle Threshold Silve	r 🖌 🌏 Save	🍼 Create copy	Restore	X Delete		
Circle Threshold gold	ł					
Circle Threshold Silve	er foil			19.35 ms		
Circle Threshold Silve	er type:	2 🗧		2.716 ms		
Circle Threshold	old1: 144	.00 🗘				
Circle	u(Val: 83	3.00 ÷				)
Default	eps:	1		2.933 ms	$\downarrow$	
QRCode		2.4		20.027		
QRCode Threshold	ure:	3		30.837 ms		
	Threshold2: 22	2.00 0				
Dilatefilter	Steps:	3 🗘		1.174 ms	Outputs: 1	X: 480.20 mr
CircleDetector					Done: 0	Y: 228.77 mr
	Size: 63.	500 🗧			Time: 00:00:19	
	Form tolerance:	85 🗘		5 212 mc	Adjust mark detection	
	Size tolerance: 1	.20 🗧		5.515 ms		
	Axis tolerance:	.20 😴			💉 <	
					Setup Close	
🌏 Save		Cane	cel			
			· · · · · · · · · · · · · · · · · · ·			

In the Camera Offset tab select Measure Offset. The value will change. Then select Save Offset, then Save.

Settings	
Scale and Scaling Camera Offset Image Processing Profile Camera Settings	
Generat Marking:	
Calibration Object: Circle V X: 244.64 mm	/ Output Object
Tool: 4 Kiss cutting knife Y Y: 123.23 🛱 mm	Use Marking
Determine Camera Offset:	
Current Measured Offset X: 48.25 - 0.00 - mr	Measure Offset
Offset Y: -1.55 – 0.00 – mr	Save Offset
Reset	

Exit the camera settings, put the printed sheet "0260702017000\_calibration.job" – sheet onto the conveyor mat (make sure the rotation is correct) and cut the file in order to verify the measured camera offset.

In Macros tab select Output to device - check if the Material is changed to Manually. Select Output

	C	utput to device DPC-600	? ×
1     Register       Default		Dutput Device: DPC-600 Number of jobs: 1 Copies per job: 1 Copy spacing y-direction: 0.00 mm Copy spacing y-direction: 0.00 mm Weed border distance: 0.00 mm	Only output tool-assigned layers Send design relative to origin Plot to file Enable toottips Pause after feeding a segment Save settings
Eile import		Parameter Value	Sort Options
- The import		Table width in Y [mm] 623.00	
File import Barcode		Table length in X [mm] 820.00	Sort before output
		Number of copies 1	
📔 File open		Production mode Manually->Production	Actual Setting:
		Material Manually	Always prefer job order
File save		Edae detector Edit	Search for heat Sort Method
	N 1	Copy options Edit	Search for best Soft Method
Rotate 90°		Optiongroup park position Edit	Sort Options
• =====	N	No feed after last segment Off	L
• Edit hodes		Compensation method Best fit	
- Sort with Simulation	<b>N</b>	Reference point (Fit to Job) Center (C)	_
		Preload first sheet Off	
Object properties			
Output to device	۲		
Direct output to device	Execute mad		Feed: No feed
			Objects: All objects ~
		Preview Output Read material size	Cancel



Move the head over the first registration mark using the keyboard arrows. Right click on the camera screen and select Mark Recognition.

Select Move to mark to move the reg mark to the center. Select Measure, and then Save.



Select the bullet button - the camera will move each registration mark. Once it is finished select **Run**. The machine will cut the job.



# 8. File information

1. Job design.

A separate layer has to be created for registration marks (e.g. reg marks), for thru cutting (e.g. cut), for creasing (e.g. crease) and kiss cutting (kiss cut).

2. Open a pdf file in Adobe Reader to check if the layers are created.



3. We recommend using 3mm black dots as a registration mark. For better workflow position of first reg marks should be in the same location on all jobs.

4. The QR code should be between 7-10mm. The QR code must match the file name. E.g QR – monkey; file name 'monkey'.

We recommend placing the QR code in the same position for all jobs.

# 9. Settings for 3mm reg mark



•				
Look in	PDF Input		- 🛛 🗊 📂 🛄 •	
4	Name	^	Date modified	ђ
X	🖲 01cut laye	rs	01/09/2020 14:27	A
Quick access	A 100x150		15/05/2020 13:04	A
	A 11125 cut	ter	13/03/2020 15:41	A
1.11	🛃 215571-L		15/10/2020 12:59	A
Desktop	A4 WINDO	OW BOOK	27/05/2020 19:24	A
-	A5 POCKE	T FOLDER CUTTER	05/05/2020 14:20	A
111	A5 POCKE	TFOLDER	05/05/2020 10:27	A
Libraries	Amber Bo	x	07/08/2020 10:35	A
	appleprint	cutter1	18/03/2020 12:15	A
5	BUS CARE	HOLDER	05/05/2020 13:18	A
This PC	CD COVE	2	11/05/2020 14:03	A
	Colouring	book CUTTER	16/04/2020 17:00	A
<b>1</b>	COLOURI	NG BOOK	16/04/2020 17:00	A
Network	🛃 covid2 sta	nd cutter	05/05/2020 23:04	A
	DISNEY ST	ICKERS	27/08/2020 08:32	A
	lemboss		04/06/2020 13:23	A
	🛃 EMOJI		08/06/2020 14:01	A
	GIN I ARFI	\$	22/01/2020 11:32	A >
	File name:	covid2 stand cutter	~	Open
	Files of type:	All Files (*.*)	~	Cancel
_	péra	Preview Create new Job Insert at position X: 0.0	00 Y: 0.00 mm	
		Rotate by angle     Scaling by factor     Mirror at	00 ° 0 contal axis ~	

#### 2. Select the file

3. Check if the software recognizes reg marks (ref to page 39).



4. In production tab select NO QR profile, then Edit - Camera Calibration.



5. Move the camera over the reg mark using the arrows.



6. Click on 'Move to mark' to move the reg mark to the center. Continue until the reg mark is in the middle.

Settings	10		
Scale and Scaling Camera Offset Image Processing Profile Camera Settings		× >>	
Set up detection scale:	uluuluu	💿 🖊 No QR	× 0
Make sure, that one video mark of the currently active detection profile, is located in the field of view of the camera. Click "Customize" to adjust.			
Mark size: 3.00 🗘 mm			
Corr. factor X: 1.00000 📮 Mark size in pixel X: 103.000 Current X: 62.000			
Corr. factor Y: 1.00000 🗘 Mark size in pixel Y: 104.000 Current Y: 62.000			
Test detection:			
To check the mark detection, a correction drive can be done manually. The closer to the mark then located in the center of the camera, the better the recognition system is set.			
Set up centering distance:			
The measurement is most accurate in the center of the camera image. The tolerable distance between the recognized mark and the camera center can be set here. If this distance is exceeded, inside the measurement process a correction run is done. It brings the mark into the camera center. The value refers to the mark size. Centering distance:		Outputs: 1 Done: 0 Time: 00:01:00 Job: covid2 stand Adjust mark	X: 170.09 mm Y: 64.47 mm cutter.job detection
		Setup	Close

7. The software calculates the number of pixels for the reg mark. The camera calibration was done with 5mm reg mark. The pixels for 5mm reg marks is about 103. The current reg mark is 3mmso the number of pixels is 62.

Settings	
Scale and Scaling Camera Offset Image Processing Profile Camera Settings	A 32
Set up detection scale:	🧰 🖉 No QR 🛛 🔍 🔕
Make sure, that one video mark of the currently active detection profile, is located in the field of view of the camera. Click "Customize" to adjust. Mark size: 3.00 mm	
Corr. factor Y: 1.00000 Corr. factor Y: 1.00000 Mark size in pixel Y: 104.000 current Y: 62.000	
Test detection:	
To check the mark detection, a correction drive can be done manually. The closer to the mark then located in the center of the camera, the better the recognition system is set.	

8. Click on 'Adjust' to replace the values from 5mm with the new values and the green circle will be aligned with the reg mark.

Settings	
Scale and Scaling Camera Offset Image Processing Profile Camera Settings	A >====================================
Set up detection scale:	🧰 🖉 No QR 🛛 🗸 🗘
Make sure, that one video mark of the currently active detection profile, is located in the field of view of the camera. Click "Customize" to adjust.	
Mark size: 3.00 🗧 mm	
Corr. factor X: 1.00000 Mark size in pixel X: 62.000 Current X: 62.000	
Corr. factor Y: 1.00000 Corr. factor Y: 1.00000 Adjust	
Test detection:	
To check the mark detection, a correction drive can be done manually.	

9. In the 'Image Processing Profile' select 'Circle' profile. This profile is used for good quality print and good contrast between reg mark and substrate.

and the second s						
Scale and Scaling Camera Offset	mage Processing Profile	Camera Settings				
Edit Image Processing Profile:						
Circle 🗸	🌍 Save	🍠 Create copy	Restore	X Delete		
RemoveNoisefilter				20.635 ms		
Closefilter	Steps: 3 🔹			8.476 ms		
Аре	erture: 3			35.261 ms		
Cannyfilter Threst	hold1: 66.00 🗘					
Thres	hold2: 54.00 ÷					
Dilatefilter	Steps: 2 🗘			1.265 ms		
CircleDetector	······································					
	Size: 62.000 🕻					
Form tole	rance: 85 🗧			4 925 mc		
Size tole	rance: 1.10 🗘			4.555 ms		
Axis tole	rance: 1.10 🗘					
Number of r	nodes: 23 🗘					

10. The lower the value in the Closefilter and Dilatefiler the more accurate the reg mark reading and the more accurate the reg mark print needs to be. After the adjustment is done press 'Save'.

Settings						121		
Scale and Scaling Can	mera Offset Image Pr	ocessing Profile	e Camera Settings				*	
Edit Image Proce	essing Profile:						💿 🦯 No QR	~ <b>Q</b>
Circle	🗸 💽 Sav	e	🍼 Create copy	nestore	Delete			
RemoveNoisefilter	r				20.366 ms		- 4	
Closefilter	Steps:	1 🗘			5.087 ms			
Cannyfilter	Aperture: Threshold1: Threshold2:	3 ÷ 66.00 ÷ 54.00 ÷			41.757 ms			-
Dilatefilter	Steps:	1 🗘			0.919 ms	. 1		
CircleDetector	Size: Form tolerance: Size tolerance: Axis tolerance: Number of nodes:	62.000 85 1.10 1.10 23 •			4.883 ms		Outputs: 1 Cone: 0 Done: 0 Time: 00:03:07 Job: covid2 stand cut Adjust mark det	X: 170.09 mm Y: 64.47 mm ter.job ection
							Setup	Close

11. The pixels value now has been changed from 62 to 60. Select Adjust to replace the value.

Settings			
Scale and Scaling Camera Offset Image Processing Profile Camera Settings	^ >		
Set up detection scale:	and the state of t	🖻 🖉 No QR	× 0
Make sure, that one video mark of the currently active detection profile, is located in the field of view of the camera. Click "Customize" to adjust.			maxing
Mark size: 3.00 🛱 mm			104004
Corr. factor X: 1.00000 😴 Mark size in pixel X: 60.000 Current X: 60.000			
Corr. factor Y: 1.00000 Current Y: 60.000 Current Y: 60.000			
Test detection:			- 1
To check the mark detection, a correction drive can be done manually. The closer to the mark then located in the center of the camera, the better the recognition system is set.			

#### 12. Press Save to save the settings.

13. In NO QR - edit profile - select Camera tab and check if the 'Circle' profile is selected.

Prome	
Profile name: No QR	
Profile description:	
🚔 Device 🖌 Output 🏸 Miscellaneous 🞇 Ba	r code 💿 Camera
✓ Activate mark detection: Circle	
Save	Cancel

- 14. Repeat the steps for QR profile.
- 15. If new profile is created then this procedure needs to be followed again.
- 16. The lower quality print then the filter value may need to be adjusted or different image processing profile need to be selected.

#### 8. How to run a job with reg mark (no QR)

- 1. Import the pdf file. There are 4 ways how to import a file
- a. File Import
- b. Right click on the working area Import
- c. Macros File import
- d. Import icon



2. Assign the tool to each layer in Macros tab. If the tools where not assigned before click on Default to select correct tool.





- 3. Save the layers in layer library.
  - a. Layer tab
  - b. Pallet menu
  - c. Save Palette



4. Check if the software recognizes reg marks. The reg mark circle will have a cross.



5. If the reg marks are not recognized (the reg mark circle will not have a cross) add the reg mark layer name to Settings – Standard settings – Import.

🔅 <u>F</u> ile	<u>E</u> dit <u>D</u> esign <u>V</u> iew <u>T</u> ools	<u>S</u> ettings <u>V</u>	<u>/</u> indow <u>H</u> e	lp	
1		St <u>a</u> nda	rd Settings		Miscellaneous Ctrl+J
		Color P	alette	•	Job
X:	↔ mm	S Workin	a Area		Mouse
Y:	‡ mm	Pulare	gracun	Chiffe I	Bridge length
	mm 200 210 22	The Rulers.		Shirt+i	Register / Crop Marks 310
R		Unit of	Measuremer	nt 🕨	Wood Porder
4		<u>G</u> rid		Ctrl+R	weed Border
7¥ 200	330	Origin		•	Cut Off Line
<b>*</b>		Vindo /	Redo	Shift+F7	Material <u>D</u> atabase
	340	Create I		Chil. E	Output Devices
		+ Cross-I	air	Ctri+F	Output Parameters
, A 📑		Guideli	nes	Н	Import
	- X-1	✓ Snap M	lode	P	Universal Placing Tool
		Lock G	uidelines	Ctrl+H	Drofile
100	320	🖌 Guideli	nes Visible	Shift+H	Prome
<b>1</b>					
1	310	Choose	Language		]
-					
1.2					
Setup Import			<b>V</b> 1.		<u>^</u> ?
General			✓ 2. ✓ 3.	Barcode Draw	
AI / EPS	✓ Create new job and close Load following palette:	active job	₹4.	Creasing wheel	CREASE
CDR / CMX	Load following job template:		♥ 5. ▼ 6.	Perforation	
DXF	Run the following macro before importing:		<ul> <li>✓ 7.</li> <li>✓ 8.</li> </ul>	Thru cutting kni None	ife Thru-cut
ACM Gerber	Conversions		9.	Thru cutting kn	fe CUTTER
GTP	<ul> <li>✓ Separate layers by name</li> <li>✓ Insert objects at position</li> </ul>		<ul> <li>✓ 10.</li> <li>✓ 11.</li> </ul>	REG MARKS	G
HPGL JOB	Combine objects in the same layers		✓ 12. ✓ 13.	Thru cutting kni cutting marks	fe Cut
oxx	Break combinations     Group all objects		✓ 14.	Kiss cutting kni	fe KISS CUT
ONYX OXF	Ungroup		<ul> <li>✓ 15.</li> <li>✓ 16.</li> </ul>	Creasing wheel	Fold
PDF*	Rotate objects by the following angle:		17.	Thru cutting kn	ife Tru-Cut
DMPL	<ul> <li>Drag n Drop objects rotate at the following angle</li> </ul>	-	A	II layers	No layers
zcc	Scale objects by the following factor:				
ZCC	Scale objects by the following factor: Mirror objects as follows:				
ZCC	Scale objects by the following factor: Mirror objects as follows: Search / replace alignment marks in the followin	g layers:	Number of selected	layers: All layers	
zcc	Scale objects by the following factor: Mirror objects as follows: Search / replace alignment marks in the following Resume video marks from the following layers: Insert separation cut	g layers:	Number of selected cutter marks;Marks;f	layers: All layers Reg	
zcc	Scale objects by the following factor: Mirror objects as follows: Search / replace alignment marks in the followin Resume video marks from the following layers: insert separation cut Insert weeding frame	g layers:	Number of selected cutter marks;Marks;f	layers: All layers Reg	
zcc	Scale objects by the following factor: Mirror objects as follows: Search / replace alignment marks in the following Resume video marks from the following layers: Insert separation cut Insert weeding frame Object properties Autor Stard object size	g layers:	Number of selected cutter marks;Marks;f	layers: All layers Reg	
zcc	Scale objects by the following factor: Mirror objects as follows: Search / replace alignment marks in the following Resume video marks from the following layers: Insert separation cut Insert weeding frame Object properties Assign "Fixed object size"	g layers:	Number of selected cutter marks;Marks;H	layers: All layers	

6. In Production tab select a NON QR profile and press start.



7. The machine will feed a paper and the camera will move to the location of the reg mark on the job run before. If the reg mark are in new position please use the arrows on the screen to move the head over the reg mark.



- 8. Once the reg mark is within camera screen (the dot will be green or red) double click on the reg mark to bring it closer to the middle.
- 9. Select how many copies you require, and press start. If the number of copies is not visible extend the window.
- 10. The last copy always stays on the matt.

# 10. How to run a job with reg marks and QR

1. In the Production tab - QR profile select edit profile (this step only on machine set up)



2. Specify the location of the files. All QR files must be saved in one folder (this step only on machine set up.

Profile:						×
Profile name: Reg M	larks Board/Sheet (No C	R)				
Profile description:						
🗳 Device	/ Output	🏄 Miscellaneous	Bar code	💿 Camera		
✓ Activ: Directory	ate barcode: QRCoo	e OXF			×	_
Assume bar co	ode rotation:					
neud burcode only on a	Import file:					
Execute after load	ding the job: 🛛 🍇 No	action				~

- 3. All files must have layers already saved in layer library and the reg mark layer added to import settings.
- 4. Press start.



5. The machine feeds the paper and the camera moves to the location of the job run previously. If the QR position is in different location move the head to the QR code. Select Save (to save this location). The software will import the correct file.



- 6. The camera will move to the reg mark location on the job run previously. If the reg marks are in different position use arrows on the screen to move to the first registration mark.
- 7. Once the reg mark is within camera screen (the dot will be green or red) double click on the reg mark to move it close to the center.



- 8. Press start.
- 9. The QR code will run until the profile is stopped. If you want to stop the profile press 'Break' to pause the profile. The machine will cut the current job and pause to wait for further instruction.
- 10. Select 'Stop' to stop the profile or 'Continue' to run more jobs.

#### 11. How to run a job with no reg mark

1. Import the pdf file

Ele Lde Resign Xew Jook S	Renge Worke Help	No QR Board/Sheet -
	y	

 Check if the tools are assigned to the layers. If not assign tools to the layers and save it in the layer tab. To run a job without reg mark the pdf cannot have reg mark layer.
 If layer is on the pdf – delete the reg marks or hide the layer using an eye icon on the layer.

Device: 🎮 DPC-600	v 🕸 Layer	Device: T DPC-600 V
Layer: Crease	V 🧇 Macro	Layer: Crease V
1 Reg-Marks/DPC	Produc	4 Crease
4 Crease Creasing wheel Default		Default
12 Thru-Cut		Creasing wheel Kiss / Thru cutting knife (Tangential)
💶 File import		Multitool K3 MOscillating knife

- 3. Move the design to 0,0 position
  - a. Select the shape



b. Drag it to 0,0 position



# c. Or change the x, y location in the menu



4. Select Output to device.



- 5. **For single copy** place the paper on the matt.
  - a. On the control panel move the head to the top corner of the paper to select the temp origin.(Gold K holder screw is estimated 0,0 position for the temp origin)





- b. Check if the preload the first sheet is OFF.
- c. Select output.

put to device DP	C-600		?
utput			
Device:	DPC-600 ~	Number of jobs: 1	Only output tool-assigned layers
Mode:	Output with layer assignment $\qquad \lor$	Copies per job: 1 Copy spacing y-direction: 0.00 m	Plot to file  Enable toottios
Output Profile:	Standard V	Copy spacing x-direction: 0.00 m Weed border distance: 0.00 m	m Pause after feeding a segment
	Manage Profiles		Save settings
Parameter		Value	Sort Options
Table width in Y [r	nm]	623.00	
Table length in X [r	nm]	820.00	Sort before output
Number of copies		1	0.*
Production mode		Manually->Production	Actual Setting:
Material		Manually	ŤŪ
Mark settings		Edit	Always prefer job order
Edge detector		Edit	Search for best Sort Method
Copy options		Edit	
Optiongroup park	position	Edit	Sort Options
No feed after last	segment	Off	
Compensation met	hod	Best fit	
Reference point (F	Fit to Job)	Center (C)	
Preload first sheel	t.	Off	
			Feed: No feed
			Objects: All objects
Prev	iew Output	Read material size	Cancel

d. If the machine does not start, check the print queue if there is no other job blocking the print queue. The icon plot manger is in the hidden icons.



Double click on the icon to open plot manager.

Plot Manager	- 🗆 X
Jutput Status:	<b>1</b>
	Preview:
	no plot job selected
	ОК

Open the DPC-600 tree. If there is an active job it means that there was an error when printing the job. Delete the job to clear the print queue.



To delete the job - right click on the job name - pause



6. For multiple copies – place the paper in the feeder

a. On the control panel manually feed the paper and move the head to select the temp origin.

action	tion action	Sucker	Pump Off
Knife depth: 3.00	6	Constant of the	Back Origin
Knife1 depth: 3,53	U		Front Origin
Wheel depth: 16.00	A	B.	Temp origin
Test Speed: 200	2		manual feed
Next	9	origin	Back
		26	

b. In the output to device select feeder, preload the first sheet OFF (as the paper is already on the matt)

utput				
Device:	DPC-600 ~	Number of jobs:	1 Only output tool-assigned lay	ers
			<ol> <li>Send design relative to origin</li> </ol>	
Mode:	Output with layer assignment	Copies per Jop:	Plot to file	
		Copy spacing y-direction: 0.0	00 mm	
Output Profile:	Standard	Copy spacing x-direction: 0.0	00 mm	
		Weed border distance: 0.0	00 mm Pause after feeding a segme	nt
	Manage Profiles			
			Save setti	ngs
arameter		Value	Sort Options	
able width in Y [i	nm]	623.00		
able length in X [	mm]	820.00	Sort before output	
lumber of copies		1	Actual Setting:	
roduction mode		Manually->Production	Select material handling	
laterial		Manualy	Always prefer job order	
dae detector		Feeder		
ony ontions		Roll	Search for best Sort Method	
Optiongroup park	position	Edit	Sort Optio	ons
lo feed after last	segment	Off		
Compensation me	thod	Best fit		
teference point (	Fit to Job)	Center (C)		
Preload first shee	t	Off		
			Feed: No feed	
			Feed: No feed	

- c. Select number of outputs to run multiple copies.
- d. Select output

# 11. DPC Connect additional features.

# a. Draw function



Select Draw – Universal Placing Tool.

The last selected object will appear



Right click – Universal Placing Tool window will be displayed.

Universal placing too	1					×
Width	130.00	mm				
Height	130.00 📜	mm				
C Ellipse						
<ul> <li>Rectangle</li> </ul>						
Triangle						
🔿 Regmark						
Clipboard						
O From file			Keep	o original s	ize	
Add						
Delete						
		🧭 ок	(Ca	ancel		

Ellipse, rectangle and triangle object is possible to place on the working area.

Add the shape dimension and select Ok.

Click on the working area to place the object.

To move the object – refer to section 11.3.

#### b. <u>Changing the cut direction</u>

In View select 'Show Object Orientation' to see the starting position. The arrow indicates where the cut will start and the cut direction.

<u>V</u> iev	v <u>T</u> ools <u>S</u> ettings <u>W</u> in	dow <u>H</u> elp
<b>_</b>	Zoom <u>I</u> n	+
۶	Zoom <u>O</u> ut	-
$\mathbf{\rho}$	Full <u>P</u> age	В
A	Show <u>A</u> ll	F4
9	Sho <u>w</u> Selected Objects	Shift+F4
및	To <u>F</u> ront	Ctrl+O
92	To <u>B</u> ack	Ctrl+U
맞	Forward One	PgUp
	Ba <u>c</u> k One	PgDn
	<u>R</u> everse Order	U
	Change Order	Shift+R
	Show Order	Shift+F8
	Fit Page to Objects	
٩ı	Contour <u>V</u> iew	F9
<b>~</b>	Show Object Orientation	Ctrl+F9
	Enhanced View	Shift+F9
	A <u>l</u> ways on Top	Shift+Ctrl+Y
۲	Refresh <u>S</u> creen	Ctrl+W

Click on the arrow to change the cut direction.



#### c. Changing starting point

Select the shape – select node editing – new points will be displayed on the corners.



Select the required corner – right click – New Starting Point



To add new point – click on the line where new point should be added – right click – 'Insert'.



#### d. Breaking joined lines

To break 2 lines joint together – select shape – Node editing – the joint point of 2 lines – right click 'Break' – the starting point will be automatically moved to the new position.



Repeat the process on another corner to break in another point.

e. Moving the object to different layer

Select object – In Macros tab open arrow to see other layers – select a new layer e.g. Thru-cut – and select tick icon.

	»·····				
	Device:	DPC-600	~	*	Layer
	Layer:	Crease	~		INIGCIO
	1 Reg-	Reg-Marks/DDC			
	Defai	Barcode			1000
	4 Creat	Crease			CHOIL
	Creat	V-Cut			h
	Defai	Perf			I
	12 Thru-	Active Kiss-Cut			I
	Defa	Drag Kiss-Cut			I
	🐚 File ir	Active Thur-Cut			1
$\langle \cdot \cdot \rangle$	_	Press Thur-Cut			I
	File ir	EOT Thru-Cut			
	📔 File o				
	100 March 100 Ma				

The selected object will be moved to a new layer and new layer name will be displayed.



#### f. Insert bridges/nicks

Go to Settings – Standard settings – Bridge length to set up bright/nicks length



#### Change the value and select ok.

Default Settings				
Miscellaneous	Manual bridge			
Job	Bridge length: 0.00 🗧 mm			
Mouse	Adding a bridge via right mouse menu will disjoin the selected object with ab feature is only available in the Node Edit Mode.			
Bridges				
Register / Crop marks				
Weed border				

#### Select all shapes – left mouse click – insert bridge



The bridge position will be displayed. Multiple number of bridges can be added to a shape.



#### g. Layers/tools settings

Select Edit next to the layer name



Output parameters will be displayed.

Depends on the selected tool the parameters might change.

Speed, acceleration, overcut on contour and number of repetition can be set separately for creasing tool/kiss cut/thru cut tool

de analise	Output Parameters		
	Parameter		Value
•	Speed [mm/s]		800
ut	Acceleration [mm/s2]		5000
ation	Overcut length on contour [mm]		0.00
aut 📃	Number of repetitions		1
arks			
ER			
CUT			
ER MARKS			
	Information:		
	Thru-cut	×	
	Mode / Tool:		
	Creasing wheel	~	

#### Settings for tangential knife:

Output Parameters		
Parameter	Value	
Speed [mm/s]	400	
Acceleration [mm/s2]	3000	
Number of repetitions	1	
Overcut length on contour [mm]	0.00	
Overcut Compensation Mode	Off	
Overcut lenght at corner [mm]	0.00	



#### Settings for oscillating knife

Parameter	Value
Speed [mm/s]	400
Acceleration [mm/s2]	3000
Number of repetitions	1
Overcut length on contour [mm]	0.00
Overcut Compensation Mode	Off
Break point overlap [%]	1
Overcut lenght at corner [mm]	0.00
Lift up angle °	35

The break point overlap - With the tangential, oscillating knife - the tool is lifted out of the material in good time according to the driver values, then rotated by 180 ° and the cutting path is followed in the opposite direction.

This compensation method prevents object material from being damaged.

Different parameters can be set up for different layer names even if using the same tool.

#### h. Sort with simulation

4 File import File import Barcode File open File save Rotate 90° Edit nodes 미문 Object properties ۰. Output to device Direct output to device

Import a file and select Sort with Simulation from the Macro tab

