XEROX®

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DocuColor 5000 Administrator Guide

Table of contents

Conventions v

Symbols v

Safety notices vii

Electrical safety vii
Disconnect device ix
Laser safety x
North America x
Europe (EU) xi
Safety standards xii
North America xii
Europe (EU) xii
Maintenance safety xii
Operational safety xiii
Ozone safety xiv

Notices xv

Radio frequency emissions xv
FCC in the USA xv
In Canada (ICES-003) xvi
Regulatory information for RFID xvi
Safety extra low voltage approval xvi
Certifications in Europe xvii
It's illegal in the USA xviii
It's illegal in Canada xx
Environmental notices for Canada xxii
Product recycling and disposal xxiii

North America xxiii
European union xxiv
Other countries xxiv

1. Administrator overview 1-1

Overview 1-1
Logging on as Administrator 1-1
Finishing System Profiles overview 1-3

2. System Settings 2-1

Overview 2-1
User Interface 2-2
Fault Details window 2-3
Change Password 2-5
Setting the Date & Time 2-8
System 2-9
Productivity Setting 2-10
Productivity charts 2-11
Single Paper Weight 2-11
Mixed Paper Weight 2-12
Power Saver 2-13
Exit Power Saver 2-14
Auto Resume After 2-14
Fault Clearance 2-15
Pause 2-16
Job Spacing 2-17
Auto Logoff 2-18
NVM Read/Write 2-19
Tray Options 2-23
Auto Tray Switching, Auto Paper Selection, and Do Not Include 2-23
Paper Tray Assist 2-25
Tray Priority 2-28

3. Profiles 3-1

Overview 3-1
Alignment 3-2
Alignment Adjustment Profile procedure 3-4
Creating an Alignment profile 3-6
Selecting the Registration options 3-7
Selecting the Perpendicularity options 3-8
Selecting the Skew options 3-9
Selecting the Magnification options 3-10
Running test prints 3-11
Editing an existing Alignment profile 3-13
Custom Paper 3-14
Custom Paper procedure 3-15
Creating an Custom Paper profile 3-16
Selecting the desired paper type 3-17
Selecting the desired paper weight 3-18
Selecting other options for your Custom Paper profile 3-19
Running test prints 3-24
Editing a Custom Paper profile 3-25
Second Bias Transfer Belt 3-26
Aligner Roll Pressure 3-30
Paper Tray Air Assist 3-31
Decurler 3-32
Decurler specifications 3-33
Decurler settings A-D 3-33
Evaluate your print output for paper curl 3-35
Decurler Profile options 3-37
Name 3-38
Downward/Upward Values 3-39
Decurler Profile procedure 3-40
Selecting the Decurler tab 3-40
Creating a Decurler profile 3-41
Entering your curl calculations 3-42
Running test prints 3-43

Conventions

Standardized conventions have been used in this manual to assist you in visually locating and identifying information quickly.

Symbols

CAUTION: This symbol alerts you to an action that may cause damage to hardware, software, or result in the loss of data.

WARNING: Warnings mark alert users to areas of the machine where there is a possibility of personal injury.

WARNING: This symbol identifies an area on the machine that is HOT and should not be touched.

WARNING: This symbol indicates a laser is being used in the machine and alerts you to refer to the appropriate safety information.

TIP: This symbol identifies information that is being emphasized and is important for you to remember.

The 1 2 3... symbol indicates the beginning of a task or work process you should use to complete a procedure and is followed by the first step of a numbered procedure, task, or work process.

NOTE: *This symbol calls your attention to information that is helpful, but not essential to complete a procedure or task.*

This symbol indicates that there is additional information from another source, such as a web site or manual.

Safety notices

This Xerox digital press and the recommended supplies are designed and tested to meet strict safety requirements. These include safety agency approval and compliance to established environmental standards. Please read the following instructions carefully before operating the product, and refer to them as needed to ensure the continued safe operation of your digital press.

TIP: The safety testing and performance of this product have been verified using Xerox materials only.

WARNING: Any unauthorized alteration, which may include the addition of new functions or connection of external devices, may impact the product certification. Please contact your authorized local dealer for more information.

Electrical safety

- Use only the power cord supplied with this equipment.
- Plug the power cord directly into a correctly grounded electrical outlet. Do not use an extension cord. If you do not know whether or not an outlet is grounded, consult a qualified electrician.
- Do not use a ground adapter plug to connect this equipment to an electrical outlet that lacks a ground connection terminal.

WARNING: You may incur a severe electrical shock if the outlet is not grounded correctly.

- Do not place the press where people may step or trip on the power cord. Do not place objects on the power cord.
- Do not override or disable electrical or mechanical interlocks.
- Do not obstruct the ventilation openings. These openings prevent overheating of the machine.

WARNING: Never push objects of any kind into slots or openings on this equipment. Making a contact with a voltage point or shorting out a part may result in fire or electrical shock.

If any of the following conditions occur, immediately switch off the power to the machine and disconnect the power cord from the electrical outlet. Call an authorized Xerox service representative to correct the problem.

- The machine emits unusual noises or odors.
- The power cord is damaged or frayed.
- A wall panel circuit breaker, fuse, or other safety device is tripped.
- Liquid is spilled into the press.
- The machine is exposed to water.
- Any part of the machine is damaged.

Disconnect device

The power cable is the disconnect device for this equipment and is attached to the back of the machine as a plug-in device. To remove all electrical power from the machine, disconnect the power cable from the electrical outlet.

WARNING: This product must be connected to a protective earth current.

Laser safety

North America

This product complies with safety standards and is certified as a Class 1 Laser product under the Center for Devices and Radiological Health (CDRH) of the United States Food and Drug Administration (FDA) implemented regulations for laser products. This product complies with FDA 21 CFR 1940.10 and 1040.11 except for deviations pursuant to Laser Notice No. 50, dated July 26, 2001. These regulations apply to laser products marketed in the United States. The label on the machine indicates compliance with CDRH regulations and must be attached to laser products marketed in the United States. This product does not emit hazardous laser radiation.

CAUTION: Use of controls or adjustments or performance of procedures other than those specified herein may result in hazardous exposure of laser light.

Since radiation emitted inside this product is completely confined within the protective housing and external covers, the laser beam cannot escape from the machine during any phase of the user operation.

This product contains laser warning labels. These labels are intended for use by the Xerox Service Representative and are placed on or near panels or shields that require special tools for removal. Do not remove any of the panels. There are no operator serviceable areas in these covers.

Europe (EU)

This product complies with IEC's safety standard 60825-1 (Edition 1.2) issued August 2001.

The equipment complies with laser product performance standards set by governmental, national, and international agencies as a Class 1 Laser Product. It does not emit hazardous radiation as the beam is totally enclosed during all phases of customer operation and maintenance.

CAUTION: Use of controls or adjustments or performance of procedures other than those specified herein may result in hazardous radiation exposure.

This product contains laser warning labels. These labels are intended for use by the Xerox Service Representative and are placed on or near panels or shields that require special tools for removal. Do not remove any of the panels. There are no operator serviceable areas inside these covers.

If you need additional safety information concerning the product or Xerox supplied materials, you may call the following number:

+44 (0) 1707 353434

Safety standards

North America

This Xerox product is safety certified by Underwriters Laboratories Incorporated to Standards UL60950, third edition (2000), and CSA International CAN/CSA C22.2 No. 60950-00 third edition.

Europe (EU)

This Xerox product is Safety Certified by NEMKO to publication IEC60950-1 (2001) First Edition.

Maintenance safety

- Do not attempt any maintenance procedure that is not specifically described in the documentation supplied with your digital press.
- Do not use aerosol cleaners. The use of supplies that are not approved may cause poor performance of the press and could create a dangerous condition.
- Use the supplies and cleaning materials only as directed in this manual. Keep all materials out of the reach of children.
- Do not remove the covers or guards that are fastened with screws. There are no parts behind these covers that you can maintain or service.

Do not perform any maintenance procedures unless you have been trained to do them by a Xerox representative, or unless a procedure is specifically described in one of the manuals included with your press.

Operational safety

Your Xerox equipment and supplies were designed and tested to meet strict safety requirements. These include safety agency examination, approval, and compliance with established environmental standards.

Your attention to the following safety guidelines will help ensure the continued safe operation of your digital press:

- Use the materials and supplies specifically designed for your digital press. The use of unsuitable materials may result in poor performance of the machine and possibly a hazardous situation.
- Follow all warnings and instructions that are marked on or supplied with the machine.
- Place the machine in a room that provides adequate space for ventilation and servicing.
- Place the machine on a level, solid surface (not on a thick pile carpet) that has adequate strength to support the weight of the machine.
- Do not attempt to move the machine. A leveling device that was lowered when your machine was installed may damage the carpet or floor.
- Do not set up the machine near a heat source.
- Do not set up the machine in direct sunlight.

- Do not set up the machine in line with the cold air flow from an air conditioning system.
- Do not place containers of coffee or other liquid on the machine.
- Do not block or cover the slots and openings on the machine.
- Do not attempt to override any electrical or mechanical interlock devices.

WARNING: Be careful when working in areas identified with this warning symbol. These areas may be very hot and should not be touched.

If you need any additional safety information concerning the machine or materials, contact your Xerox representative.

Ozone safety

This product produces ozone during normal operation. The ozone is heavier than air, and the quantity is dependent on print volume. Providing the correct environmental parameters, as specified in the Xerox installation procedures, ensures that concentration levels meet safe limits.

If you need additional information about ozone, request the Xerox publication, *OZONE*, 600P83222, by calling 1-800-828-6571 in the USA. For a French language version, call 1-800-828-6571 in the USA, then press 2.

Notices

Radio frequency emissions

FCC in the USA

This equipment has been tested and found to comply with the limits for a Class A digital device, pursuant to Part 15 of the Federal Communications Commission (FCC) Rules. These limits are designed to provide reasonable protection against harmful interference when the equipment is operated in a commercial environment. This equipment generates, uses, and can radiate radio frequency energy and, if not installed and used in accordance with the instruction manual, may cause harmful interference to radio communications. Operation of this equipment in a residential area is likely to cause harmful interference in which case the user will be required to correct the interference at his/her own expense.

Changes or modifications to this equipment not specifically approved by the Xerox Corporation may void the user's authority to operate this equipment.

Shielded cables must be used with this equipment to maintain compliance with FCC regulations.

In Canada (ICES-003)

This Class “A” digital apparatus complies with Canadian ICES-003.

Cet appareil numérique de la classe “A” est conforme á la norme NMB-003 du Canada.

Regulatory information for RFID

This product generates 13.56 MHz using an Inductive Loop System as a Radio Frequency IDentification system device (RFID). This system is certified in compliance with European Council Directive 99/5/EC and applicable local laws or regulations as applicable.

Safety extra low voltage approval

This Xerox digital press is in compliance with various governmental agencies and national safety regulations. All system ports meet the Safety Extra Low Voltage (SELV) circuits for connection to customer-owned devices and networks. Additions of customer-owned or third-party accessories that are attached to the press must meet or exceed the requirements previously listed. All modules that require external connection must be installed per the installation procedure.

Certifications in Europe

The CE marking that is applied to this product symbolizes Xerox Declaration of Conformity with the following applicable Directives of the European Union as of the dates indicated:

January 1, 1995: Council Directive 73/23/EEC amended by Council Directive 93/68/EEC, approximation of the laws of the member states related to low voltage equipment.

January 1, 1996: Council Directive 89/336/EEC, approximation of the laws of the member states related to electromagnetic compatibility.

March 9, 1999 Council Directive 99/5/EC on radio equipment and telecommunications terminal equipment and the mutual recognition of their conformity.

A full declaration, defining the relevant directives and referenced standards, can be obtained from your Xerox Limited representative or by contacting:

Environment, Health and Safety
The Document Company Xerox
Bessemer Road
Welwyn Garden City
Herts
AL7 1HE
England
Tel Number +44 (0) 1707 353434

WARNING: This system is certified manufactured and tested in compliance with strict safety and radio frequency interference regulations. Any unauthorized alteration which includes the addition of new functions or the connection of external devices may impact this certification. Please contact your local Xerox Limited representative for a list of approved accessories.

WARNING: In order to allow this equipment to operate in proximity to Industrial, Scientific, and Medical (ISM) equipment, the external radiation from the ISM equipment may have limited or special mitigation measures taken.

WARNING: This is a Class A product in a domestic environment. This product may cause radio frequency interference in which case the user may be required to take adequate measures.

Shielded cables must be used with this equipment to maintain compliance with Council Directive 89/336/EEC.

It's illegal in the USA

Congress, by statute, has forbidden the reproduction of the following subjects under certain circumstances. Penalties of fine or imprisonment may be imposed on those guilty of making such reproductions.

1. Obligations or Securities of the United States Government, such as:

Certificates of Indebtedness	National Bank Currency
Coupons from Bonds	Federal Reserve Bank Notes
Silver Certificates	Gold Certificates
United States Bonds	Treasury Notes
Federal Reserve Notes	Fractional Notes
Certificates of Deposit	Paper Money

Bonds and Obligations of certain agencies of the government, such as FHA, etc.

Bonds. (U.S. Savings Bonds may be photographed only for publicity purposes in connection with the campaign for the sale of such bonds.)

Internal Revenue Stamps. (If it is necessary to reproduce a legal document on which there is a canceled revenue stamp, this may be done provided the reproduction of the document is performed for lawful purposes.)

Postage Stamps, canceled or uncanceled. (For philatelic purposes, Postage Stamps may be photographed, provided the reproduction is in black and white and is less than 75% or more than 150% of the linear dimensions of the original.)

Postal Money Orders.

Bills, Checks, or Drafts of money drawn by or upon authorized officers of the United States.

Stamps and other representatives of value, of whatever denomination, which have been or may be issued under any Act of Congress.

2. Adjusted Compensation Certificates for Veterans of the World Wars.
3. Obligations or Securities of any Foreign Government, Bank, or Corporation.
4. Copyrighted material, unless permission of the copyright owner has been obtained or the reproduction falls within the “fair use” or library reproduction rights provisions of the copyright law. Further information of these provisions may be obtained from the Copyright Office, Library of Congress, Washington, D.C. 20559. Ask for Circular R21.
5. Certificates of Citizenship or Naturalization. (Foreign Naturalization Certificates may be photographed.)
6. Passports. (Foreign Passports may be photographed.)
7. Immigration Papers.
8. Draft Registration Cards.
9. Selective Service Induction Papers that bear any of the following Registrant’s information:

   Earnings or Income — Dependency Status

   Court Record — Previous military service

   Physical or mental condition

   Exception: United States military discharge certificates may be photographed.
10. Badges, Identification Cards, Passes, or Insignia carried by military personnel, or by members of the various Federal Departments, such as FBI, Treasury, etc. (unless photograph is ordered by the head of such department or bureau.)

    Reproducing the following is also prohibited in certain states: Automobile Licenses - Drivers’ Licenses - Automobile Certificates of Title.

The above list is not all inclusive, and no liability is assumed for its completeness or accuracy. In case of doubt, consult your attorney.

It’s illegal in Canada

Parliament, by statute, has forbidden the reproduction of the following subjects under certain circumstances. Penalties of fines or imprisonment may be imposed on those guilty of making such copies.

1. Current bank notes or current paper money.
2. Obligations or securities of a government or bank.
3. Exchequer bill paper or revenue paper.
4. The public seal of Canada or of a province, or the seal of a public body or authority in Canada, or of a court of law.
5. Proclamations, orders, regulations or appointments, or notices thereof (with intent to falsely cause same to purport to have been printed by the Queen’s Printer for Canada, or the equivalent printer for a province).
6. Marks, brands, seals, wrappers or designs used by or on behalf of the Government of Canada or of a province, the government of a state other than Canada or a department, board, Commission or agency established by the Government of Canada or of a province or of a government of a state other than Canada.
7. Impressed or adhesive stamps used for the purpose of revenue by the Government of Canada or of a province or by the government of a state other than Canada.
8. Documents, registers or records kept by public officials charged with the duty of making or issuing certified copies thereof, where the reproduction falsely purports to be a certified copy thereof.
9. Copyrighted material or trademarks of any manner or kind without the consent of the copyright or trademark owner.

The above list is provided for your convenience and assistance, but it is not all inclusive, and no liability is assumed for its completeness or accuracy. In case of doubt, consult your solicitor.

Environmental notices for Canada

Terra Choice Environmental Services, Inc. of Canada has verified that this Xerox product conforms to all applicable Environmental Choice EcoLogo requirements for minimized impact to the environment.

As a participant in the Environmental Choice program, Xerox Corporation has determined that this digital press model meets the Environmental Choice guidelines for energy efficiency.

Environment Canada established the Environmental Choice program in 1988 to help consumers identify environmentally responsible products and services. Copier, printer, digital press, and fax products must meet energy efficiency and emissions criteria, and exhibit compatibility with recycled supplies. Currently, Environmental Choice has more than 1600 approved products and 140 licensees. Xerox has been a leader in offering EcoLogo approved products. In 1996, Xerox became the first company licensed to use the Environmental Choice EcoLogo for its copiers, printers, and fax machines.

Product recycling and disposal

If you are managing the disposal of your Xerox product, please note that the product contains lead and other materials whose disposal may be regulated due to environmental considerations. The presence of lead is fully consistent with global regulations applicable at the time that the product was placed on the market.

North America

Xerox operates a worldwide equipment take-back and reuse/recycle program. Contact your Xerox sales representative (1-800-ASK-XEROX) to determine whether this Xerox product is part of the program. For more information about Xerox environmental programs, visit www.xerox.com/environment.

For recycling and disposal information, contact your local authorities. In the United States, you may also refer to the Electronic Industries Alliance web site: www.eiae.org.

Perchlorate Material

This product may contain one or more Perchlorate-containing devices, such as batteries. Special handling may apply, please see www.dtsc.ca.gov/hazardouswaste/perchlorate.

If your product is not part of the Xerox program and you are managing its disposal, please follow the instructions provided in the above paragraph.

European union

Application of this symbol on your equipment is confirmation that you must dispose of this equipment in compliance with agreed national procedures.

In accordance with European legislation end-of-life electrical and electronic equipment subject to disposal must be managed within agreed procedures.

Prior to disposal, contact your local dealer or Xerox representative for end-of-life take-back information.

Other countries

Please contact your local waste authorities and request disposal guidance.

1. Administrator overview

Overview

The Administrator mode allows you to set the default settings for your digital press in order to fit your individual requirements. You can change the settings for a variety of features, such as the language to display on the UI, timers, changing the Administrator password, creating custom paper and alignment profiles, and more.

Logging on as Administrator

Use the following procedure to enter and exit the Administrator mode:

1. Select the **Logon** button from the main UI window. The **Logon** screen appears.

2. Use the keyboard to enter the Administrator password.

   The default password is five ones (**11111**).

   For security reasons, only asterisks are displayed on the screen.

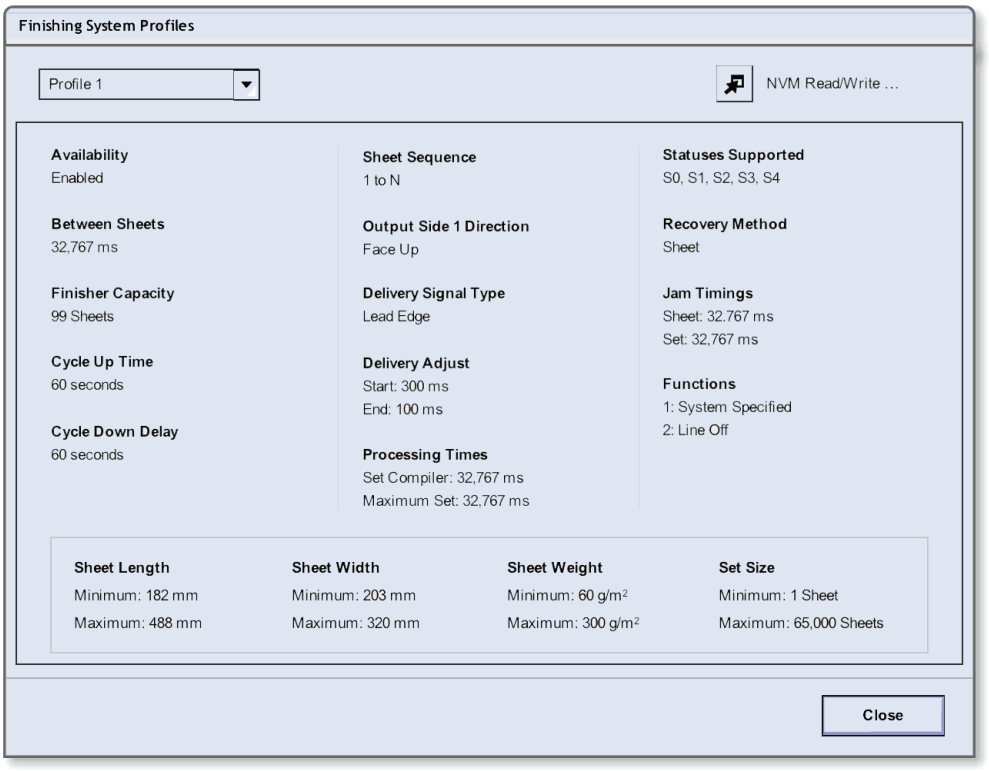
3. Select the **OK** button.

The main UI screen now displays additional options and indicates in the upper right that you are in the Administrator mode.

NOTE: *It is recommended that you change the Administrator password as soon as possible after installing the digital press in order to prevent unauthorized access to the Administrator mode. The procedure for changing the password is on page 2-5 of this book.*

4. To exit the Administrator mode, select the **Logoff** button.

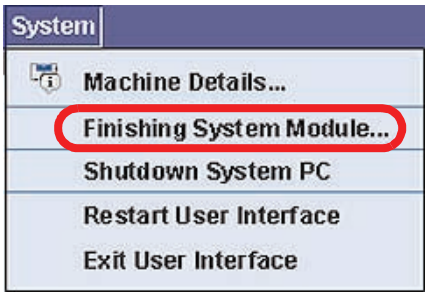
Finishing System Profiles overview



If your digital press has an optional, third-party, Digital Finishing Architecture (DFA) device finishing, then the **Finishing System Profiles** option is available to you.

TIP: This feature is available *only* if you are logged on as the Administrator.

Once your system is configured for the optional finishing accessory, the Finishing System Profiles option is accessed from the System pull-down menu on the main UI screen.



TIP: This window is ready-only; you cannot change the information shown on this screen. If you have more than one finishing device connected to your digital press, you can select the desired profile from the pull-down menu at the upper-left portion of the Finishing System Profiles window.

2. System Settings

Overview

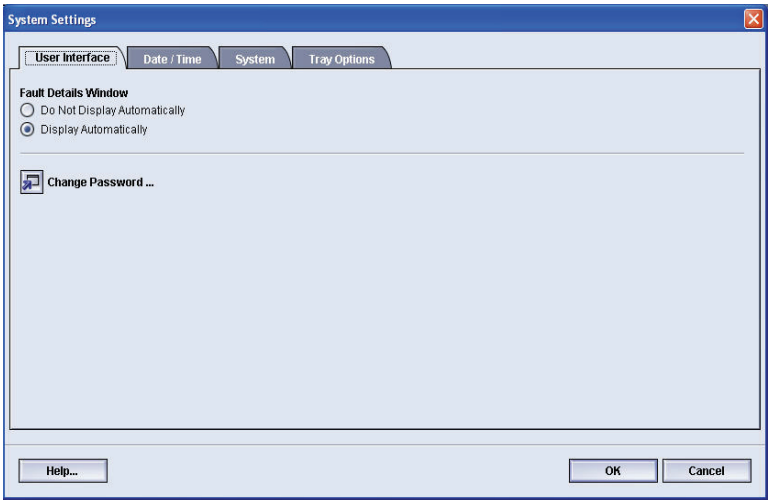
The System Settings feature allows you to make changes to the following features:

- User Interface
- Date and Time
- System
- Tray Options

User Interface

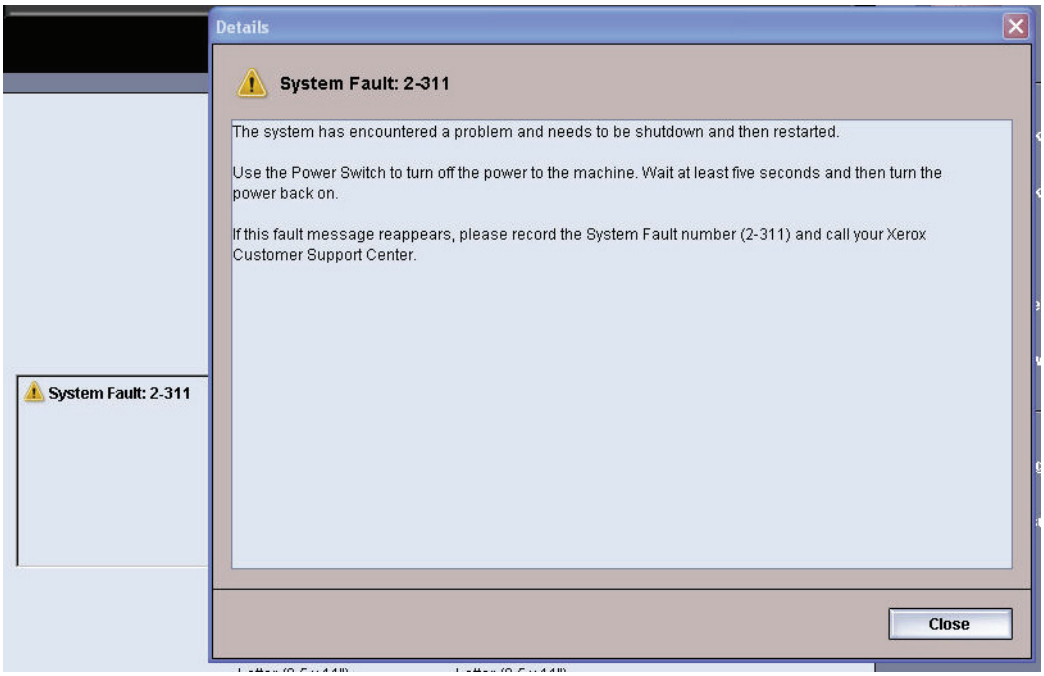
The **User Interface** feature allows you to make changes to the following:

- Fault Detail Window
- Changing the Administrator password

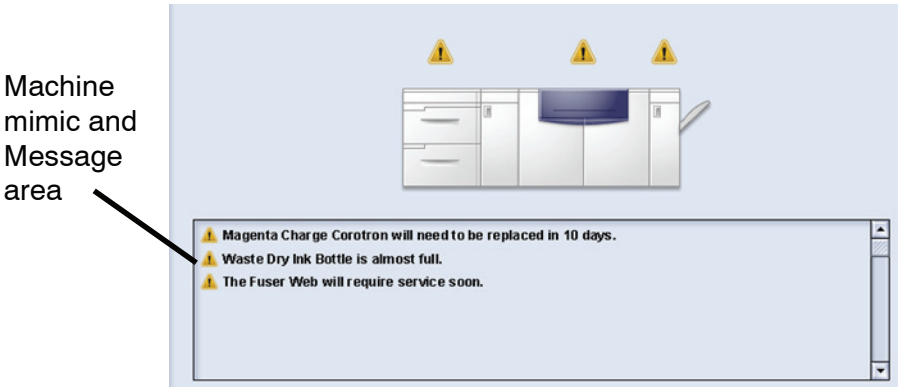


Fault Details window

By default, the UI automatically opens a Details window which provides additional information about the alert, warning, or fault (as shown in the following illustration).

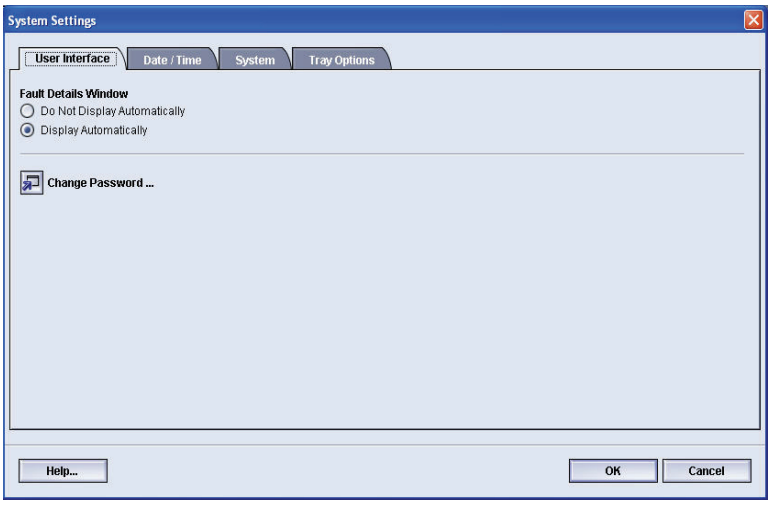


However, you can select whether or not you want this window open automatically or to open only when the user clicks on the alert, warning, or fault message in the machine mimic and message area of the UI.



Use the following procedure to choose the default setting for this feature.

1. Select the Logon button from the UI and logon as the Administrator.
2. Select the System Settings button; the System Settings window opens.



3. Select whether or not you want any machine faults to automatically display on the UI when they occur.
   - Do Not Display Automatically: Select this option if you do ***not*** want the fault Details window to open automatically when an alert, warning, or fault occurs.
   - Display Automatically: Select this option if you ***do*** want the fault Details window to open automatically when an alert, warning, or fault occurs.
4. Select **OK** to save the change and close the System Settings window.

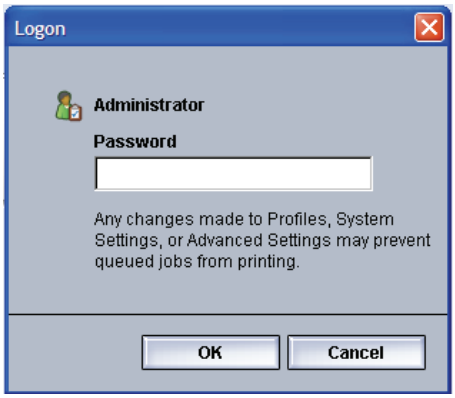
Change Password

Select the **Change Password** button if you want to change the Administrator password.

Use the following procedure to change the Administrator password.

1. Select the Logon button from the main UI window.

2. From the Logon window, enter the Administrator password and select **OK**.



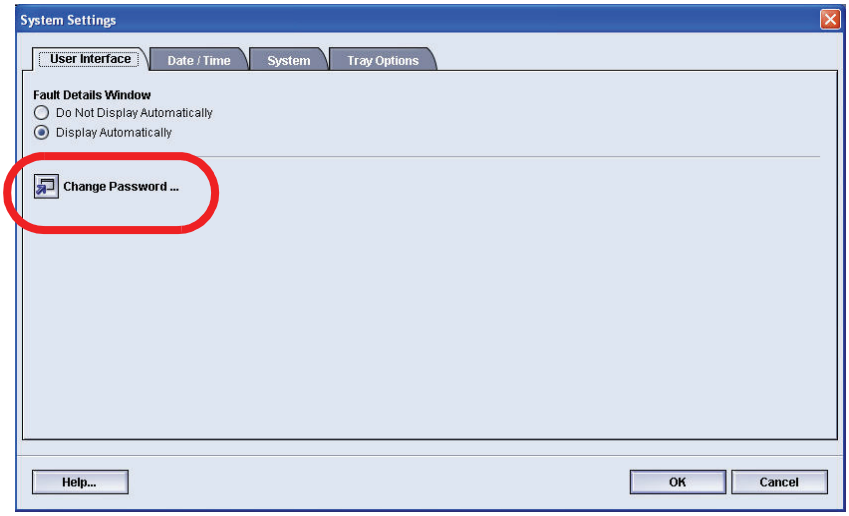
For security reasons, only asterisks are displayed on the screen.

NOTE: *The digital press arrives from the factory with a default Administrator password of five ones (11111). Use this default password to logon.*

TIP: For security reasons, you should change the Administrator password from its default password to a new one.

3. Select the System Settings button.

4. From the System Settings window, select the Change Password button from the User Interface tab.



The Change Password window opens.

TIP: Use numbers ***only*** for creating your new password. Alpha characters (letters and other characters, such as !*& are not allowed). A maximum of twelve numbers can be entered for your password.

5. From the Change Password window, enter:

a. The old (current) password

b. The new password

c. Reenter the new password in the Confirm New Password area

d. Select **OK**

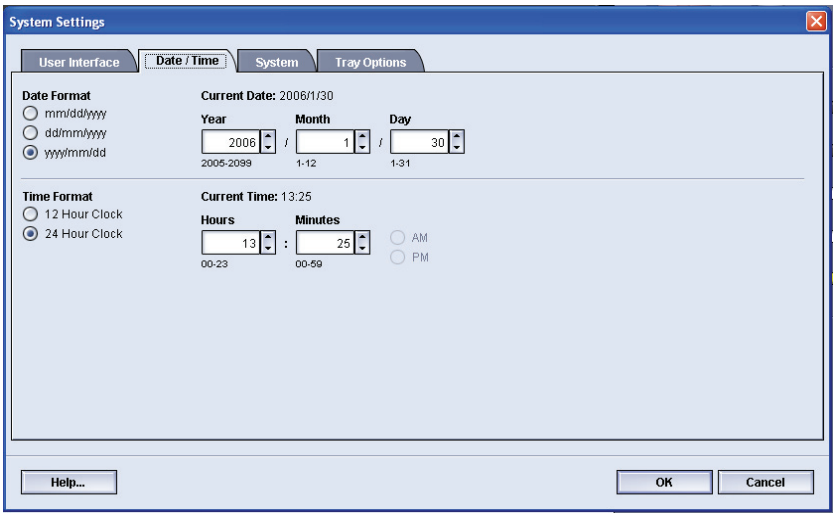
NOTE: *For security reasons, only asterisks are displayed on the screen.*

6. Select **OK** from the System Settings window to return to the main UI window.

Setting the Date & Time

Use this feature to set the date and time for the system. The date and time is displayed on the *Machine Details* screen on both the *Installed Software* and *Error Log* screens.

1. From the System Settings window, select the Date/Time tab.

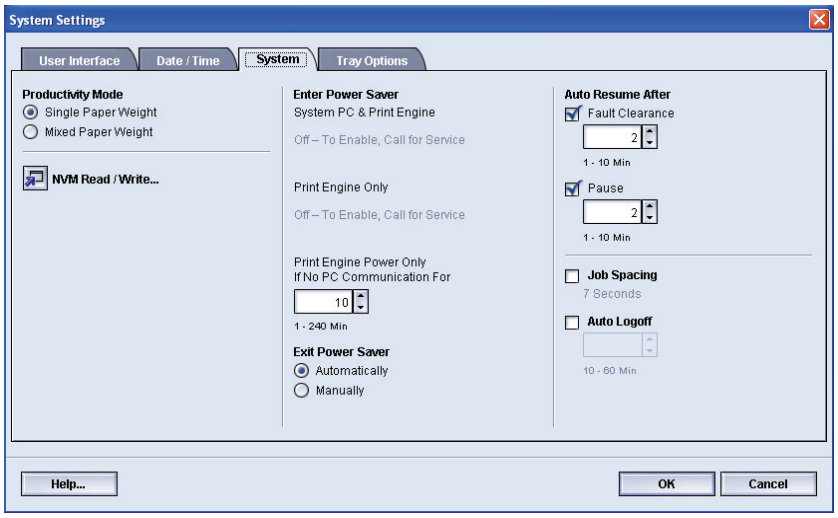


2. Select the Date Format you wish to use.
3. Use the up or down arrow buttons to enter the correct year, month, and day.
4. Select the Time Format you wish to use.
5. Use the up or down arrow buttons to set the correct hour and minutes.

NOTE: *If you selected the 12 Hour Clock, touch the* ***AM*** *or* ***PM*** *button.*

6. Select **OK** to save your changes and close the System Settings window.

System

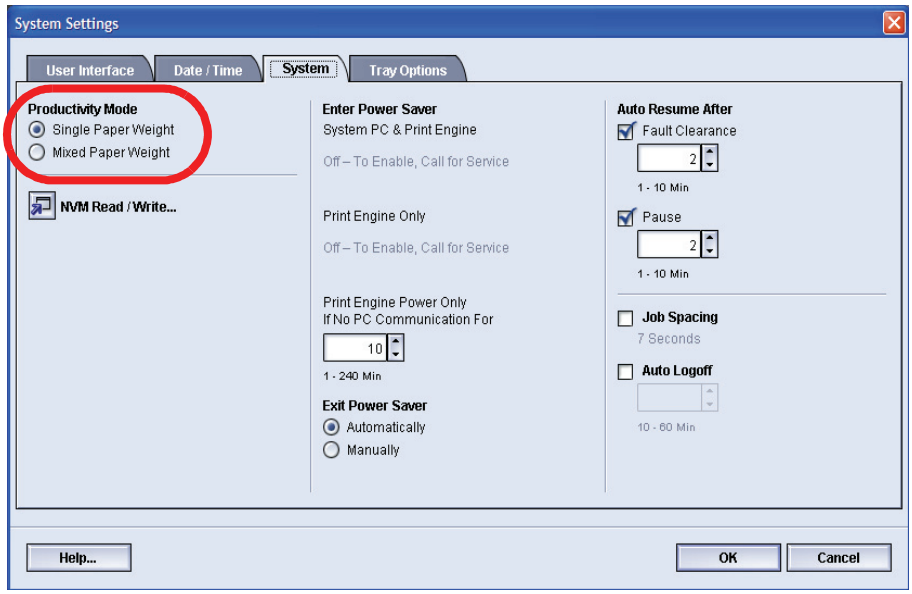


Use this feature to change the factory default settings for the following:

- Productivity Mode
- Power Saver (Enter and Exit options)
- Auto Resume
- Job Spacing
- Auto Logoff

The System feature also allows you to enter NVM Read/Write values when using specialized media. This is discussed in more detail on page 2-19.

Productivity Setting



The productivity of the digital press relates to the continuous speed of the media output as measured in prints per minute (ppm). The continuous speed is dependent on paper size, paper weight, and fuser temperature.

Use this setting to optimize the throughput speed for the type of paper you run most frequently. Productivity Setting options include:

- **Single Paper Weight:** This setting optimizes the throughput speed for single (light or heavy) weight papers, according to the weight range that is set in the paper tray.
- **Mixed Paper Weight:** This setting optimizes the throughput speed of print jobs that contain mixed media weights from different paper trays.

Select the setting that best fits your printing environment and that you use most frequently.

Productivity charts

The following productivity charts lists the various paper weights and sizes and their related print speeds for 1 Sided and 2 Sided output. Each chart outlines the print speed parameters for both productivity settings.

Single Paper Weight

Single Paper Weight Mode				
Paper Weight	**Paper Size (Feed direction length) [mm]**		**Print Speed (prints per minute - ppm)**	
	Min.	**Max**	**1 Sided**	**2 Sided**
60 - 220 g/m^2	182.0	216.0	50	25
	216.1	297.0	33.3	16.7
	297.1	458.0	25	12.5
	458.1	488.0	20	10
221 - 300 g/m^2	182.0	216.0	33.3	--
	216.1	280.0	25	--
	280.1	458.0	16.7	--
	458.1	488.0	12.5	--
Transparency	210.0	216.0	25	--

NOTE 1: *2-Sided printing is not available for transparency and paper that is 221 g/m^2 or greater.*

NOTE 2: *There is no decrease in productivity (ppm) from the second feeder module to the first feeder module.*

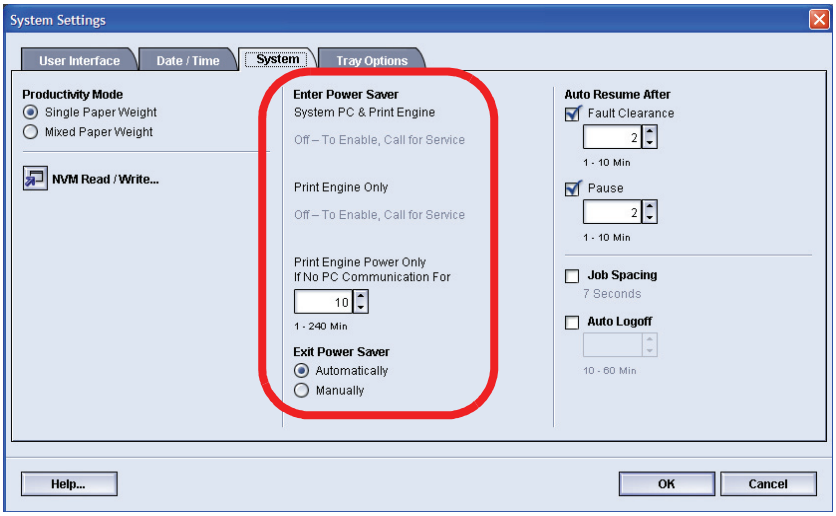
NOTE 3: *Transparency is only available for 1 Sided, A4 or 8.5" x 11" LEF.*

Mixed Paper Weight

Mixed Paper Weight Mode				
Paper Weight	Paper Size (Feed direction length) [mm]		Print Speed	
	Min.	Max	1 Sided	2 Sided
60 - 135 g/m^2	182.0	216.0	50	25
	216.1	297.0	33.3	16.7
	297.1	458.0	25	12.5
	458.1	488.0	20	10
136 - 186 g/m^2	182.0	216.0	33.3	16.7
	216.1	297.0	25	12.5
	297.1	458.0	16.7	8.3
	458.1	488.0	12.5	6.3
187 - 220 g/m^2	182.0	216.0	33.3	16.7
	216.1	280.0	20	10
	280.1	432.0	16.7	8.3
	432.1	488.0	12.5	6.3
221 - 300 g/m^2	182.0	216.0	25*	--
	216.1	280.0	16.7*	--
	280.1	458.0	12.5*	--
	458.1	488.0	10*	--
Transparency	210.0	216.0	25	--

NOTE: **Print speeds may decrease due to printer setup operations, which are based on environmental conditions and specific interval volume of continuous printing.*

Power Saver



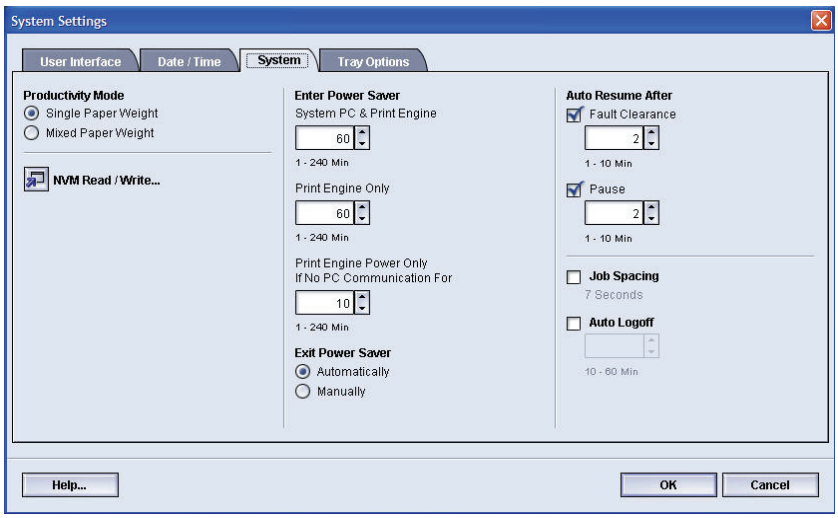
Use this feature to set the time that elapses until the digital press and System PC enter a reduced power consumption mode. The timers are activated when all print jobs have been completed and there are no jobs in the job queue.

The digital press and/or System PC exits the Power Saver mode when a job is sent to be printed or the UI on the System PC is activated.

TIP: The **System PC & Print Engine** and **Print Engine Only** features must be enabled by your Xerox representative before you can use them. If these features are not enabled, call your Xerox representative for more information.

To change the time for each power saver feature, use the following procedure.

1. From the System Settings window, select the System tab.



2. Use the up or down arrow buttons to change the time for each of the power saver features:
   - System PC & Print Engine
   - Print Engine Only
   - Print Engine Power Only If No PC Communication For

   The range available is 1-240 minutes.

NOTE: *The system default time is sixty minutes.*

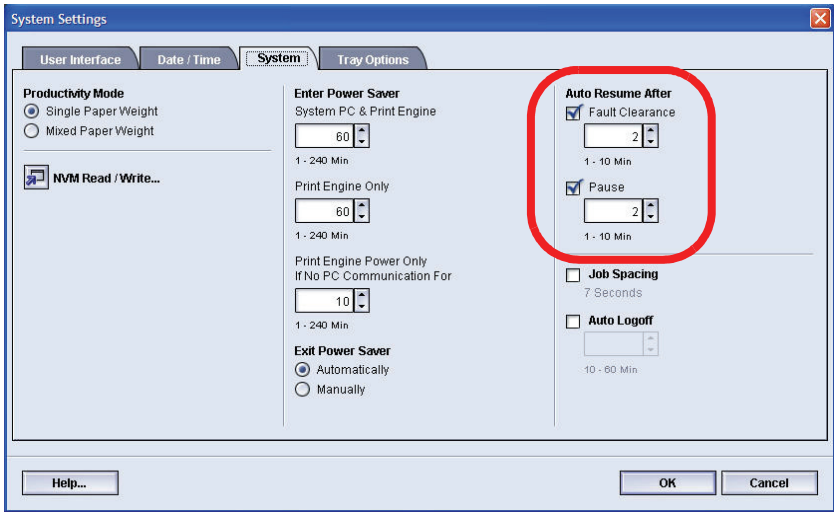
3. Select **OK** to save your changes and close the System Settings window.

Exit Power Saver

Select one of two options:

- Automatically: Select this option if you want the system to automatically exit from power saver mode whenever the mouse, keyboard, or PC Power Switch is activated.
- Manually: Select this option if you want to manually exit the system from power saver mode when the Power Saver button on the main UI screen is selected.

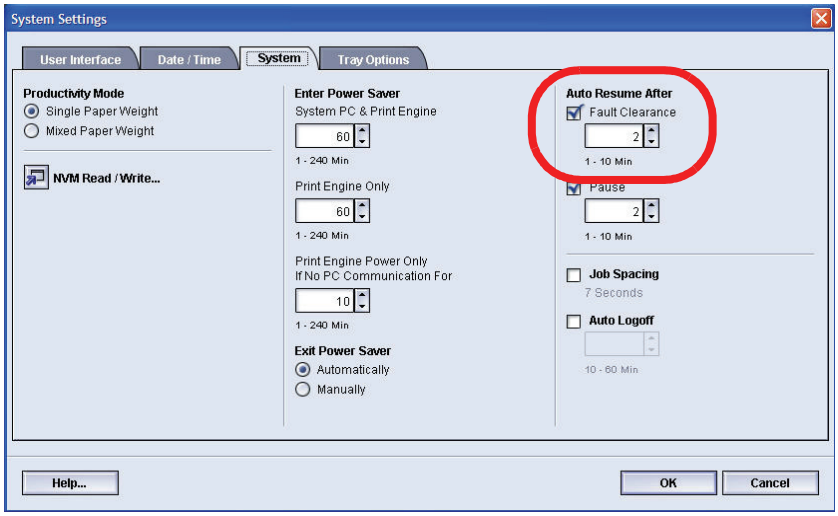
Auto Resume After



Fault Clearance

Use the Auto Resume After Fault Clearance feature to restart a job automatically after a fault is cleared and a job received over the network is waiting for user instruction.

1. From the System tab of the System Settings window, select the checkbox to the left of Fault Clearance.



2. Use the up or down arrow buttons to change the time. The range available is 1-10 minutes.

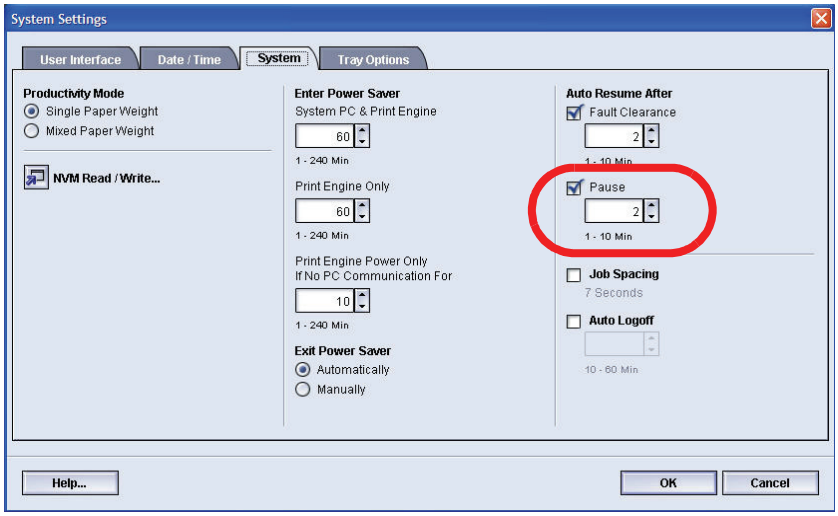
NOTE: *The system default time is two minutes.*

3. Select **OK** to save your changes and close the System Settings window.

Pause

Use the Auto Resume After Pause feature to restart a job automatically after the Pause button is selected on the UI and the job is waiting for user instruction.

1. From the System tab of the System Settings window, select the checkbox to the left of Pause.

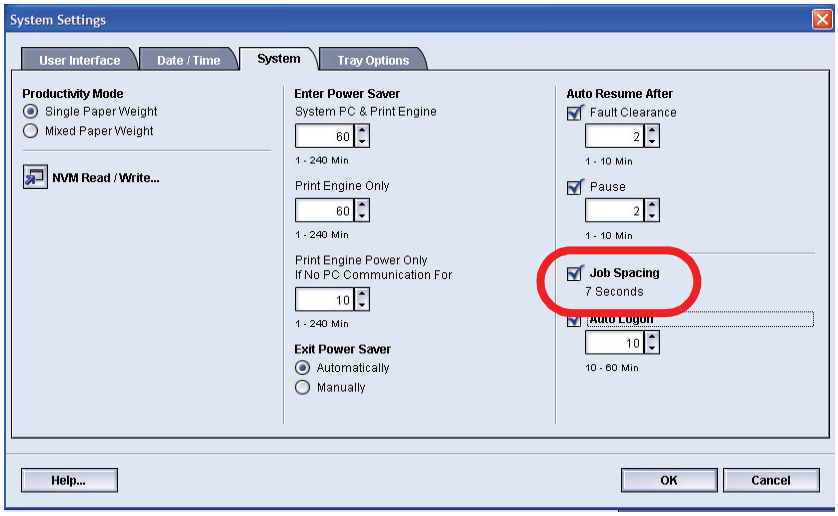


2. Use the up or down arrow buttons to change the time. The range available is 1-10 minutes.

NOTE: *The system default time is two minutes.*

3. Select **OK** to save your changes and close the System Settings window.

Job Spacing



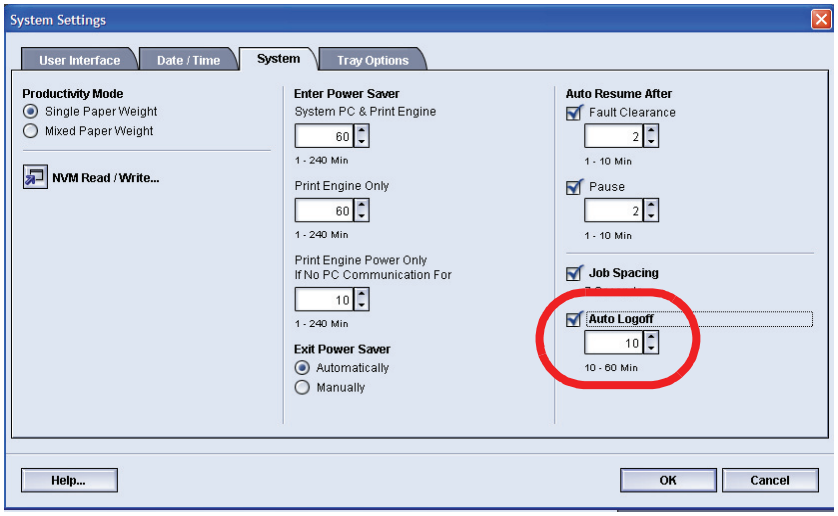
Use the Job Spacing feature when there are multiple jobs queued and you would like to allow seven seconds to unload prints from a finishing device before the next job starts printing.

1. From the System tab of the System Settings window, select the checkbox to the left of Job Spacing.

   Seven seconds is the standard and only time for this option.

2. Select **OK** to save your changes and close the System Settings window.

Auto Logoff



Use the Auto Logoff feature to have the digital press automatically return to the printing mode when no action is taken from any of the Administrator functions after the set amount of time.

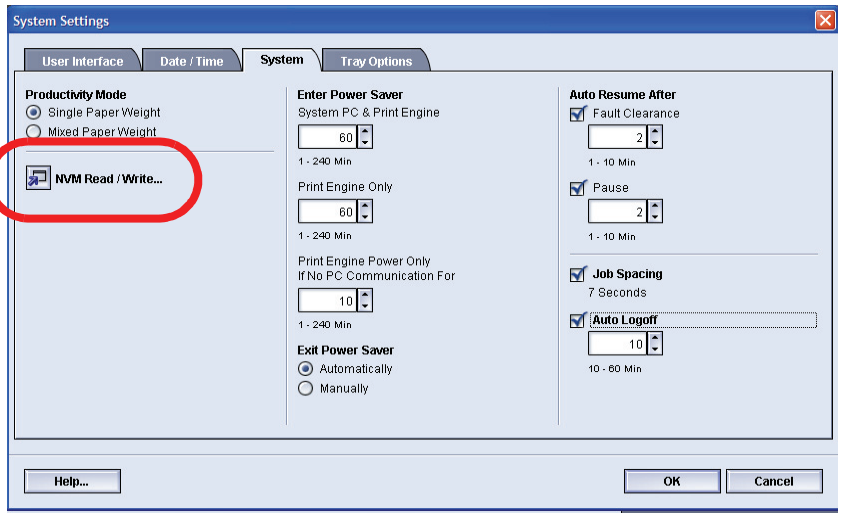
1. From the System tab of the System Settings window, select the checkbox to the left of Auto Logoff.
2. Use the up or down arrow buttons to change the time. The range available is 10-60 minutes.

NOTE: *The system default time is ten minutes.*

3. Select **OK** to save your changes and close the System Settings window.

NVM Read/Write

Your Xerox service representative uses this feature to change certain system settings. It also may occasionally be used by system administrators.



Under most conditions, this feature is not used by system administrators; however, there are limited circumstances under which this feature is used. These circumstances include:

Special Media Setting for Drilled Papers

If you use 3-hole, predrilled paper on a regular basis and continually encounter an inordinate amount of paper jams, and/or

Special Media Setting for LEF Tab Stock

If you regularly run tab stock and continually encounter paper jams.

Carbonless Media Enablement

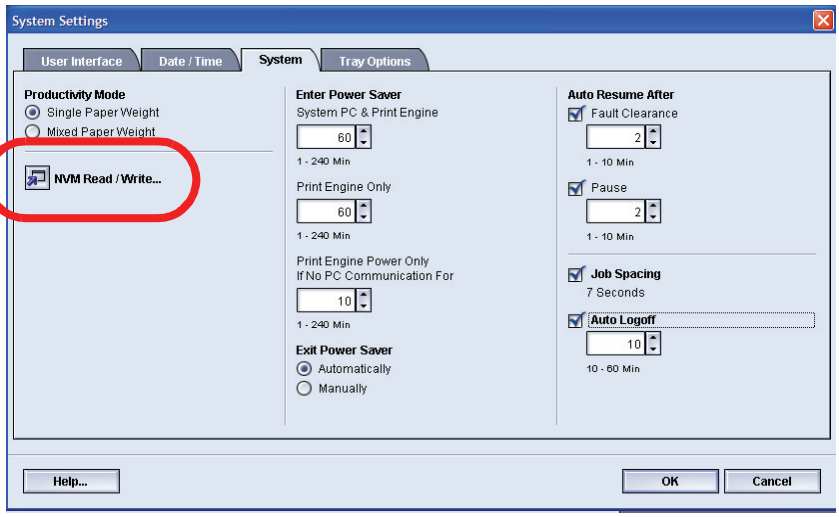
- Carbonless papers are coated with several functional coatings which promote the image transfer through the form set and enable the form sets to separate appropriately after padding with a special adhesive. Each supplier of xerographic carbonless paper has developed their own unique chemistry, which is why the following procedure enabling this application, works best with Xerox Premium Digital Carbonless Paper.
- In order to avoid problems when running carbonless media, you may use the NVM Read/Write feature to switch on the carbonless media feature.

If any of the above conditions exist in your environment, you may use the NVM Read/Write feature to switch on a feature.

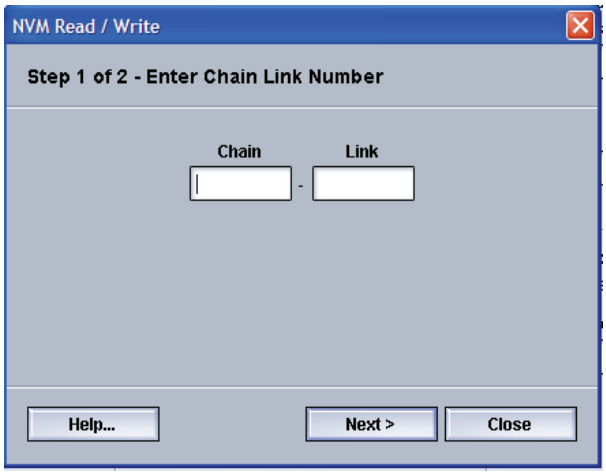
CAUTION: Do not enter any numbers on this screen other than the ones described in this procedure. Entering and saving numbers, other than the ones described, changes the system settings which may result in a service call to restore the system to the correct settings.

To switch **on** a feature, perform the following:

1. From the System tab on the System Setting window, select the NVM Read/Write button.



The NVM Read/Write window opens.

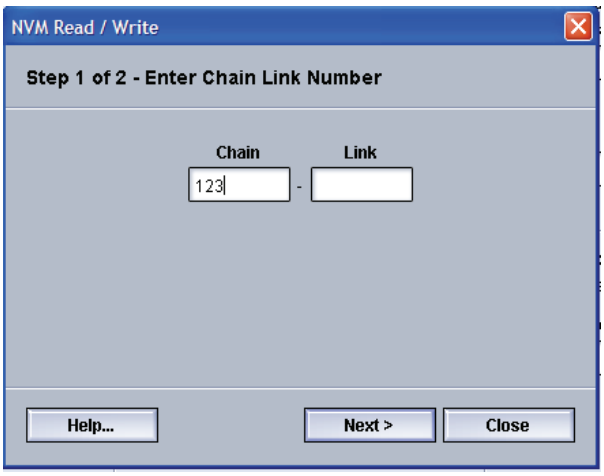


2. Enter the desired **Chain Link Number**:

   - The Chain Link Number for Special Media Setting for Drilled Papers is **700 545**.
   - The Chain Link Number for Special Media Setting for LEF Tab Stock is **700 546**.
   - The Chain Link Number for Carbonless Media Enablement is **700-920**.

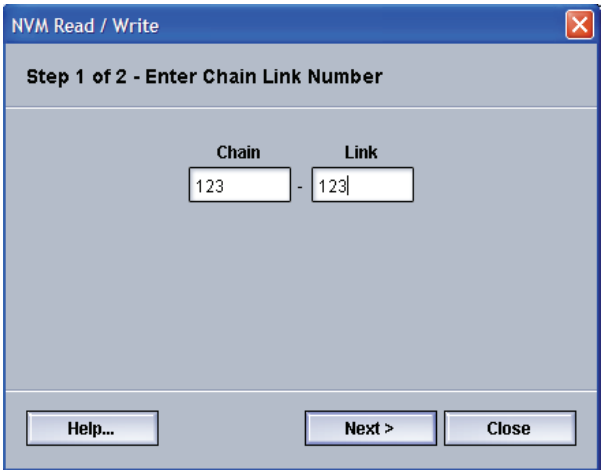
NOTE: *For the purpose of this procedure, the following screens show an example of a Chain Link Number, Current Value, and New Value; this example does not represent an actual Chain Link Number. The Current Value and New Value numbers will vary depending on the Chain Link Number entered.*

a. Using the numbers on the keyboard, enter the Chain Number (the following example uses 123 as the Chain number).



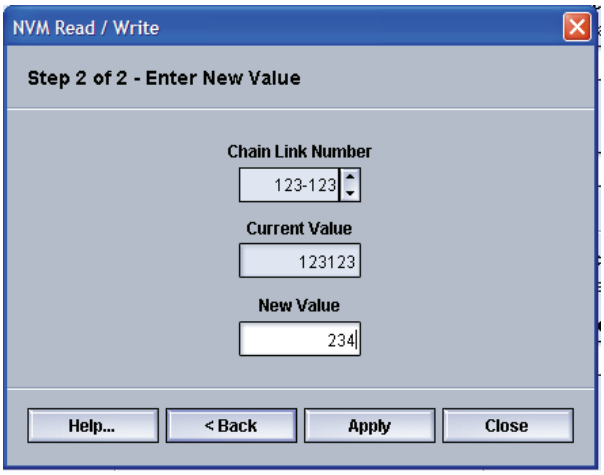
b. Press the Tab button on the keyboard to advance to the Link field.

c. Enter the Link number (the following example uses 123 as the Link number).



d. Select the Next button.

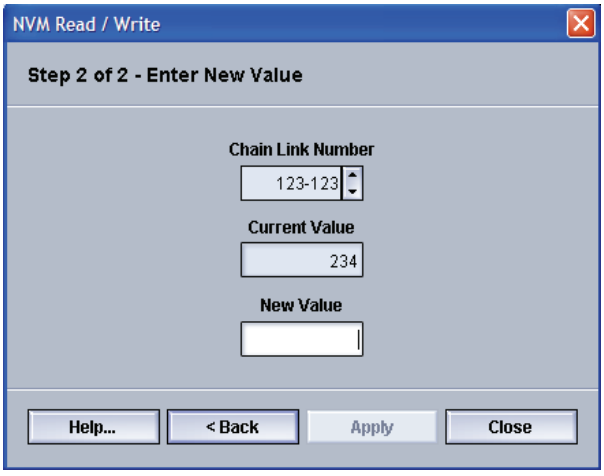
3. Using the keyboard, enter the New Value (the following example uses 234 as the New Value number).



TIP: To switch on a feature, enter the appropriate value from the keyboard:

- For Special Media Setting for Drilled Papers, enter **0** for the New Value.
- For Special Media Setting for LEF Tab Stock, enter **1** for the New Value.
- For Carbonless Media, enter **1** for the New Value.

4. Select the Apply button. The NVM Read/Write window displays the entered value as the Current Value.



5. Select **Close** to save and close your new setting.

6. Select **OK** to close the System Settings window.

TIP: After running your print job, reenter Administrator mode, System Settings, NVM Read/Write, and switch off the feature that is currently on. Follow the steps outlined in this procedure and use these settings for the New Value number:

- To switch off the Special Media Setting for Drilled Papers, enter **1000**.
- To switch off the Special Media Setting for LEF Tab Stock, enter **0**.
- To switch off the Carbonless Media, enter **0**.

TIP: To prevent paper jams from occurring with stock types other than the ones mentioned in this procedure, you **must switch off** the NVM Read/Write feature **before** running other print jobs.

Tray Options

Use this feature to change the factory default settings for the following:

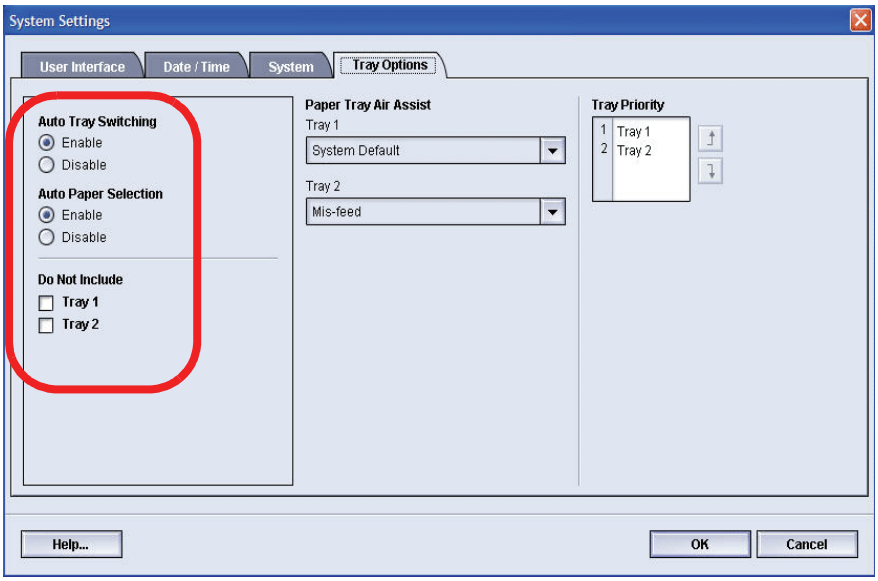
- Auto Tray Switching
- Auto Paper Selection
- Do Not Include
- Paper Tray Air Assist
- Tray Priority

Auto Tray Switching, Auto Paper Selection, and Do Not Include

Choose the default settings for the following options:

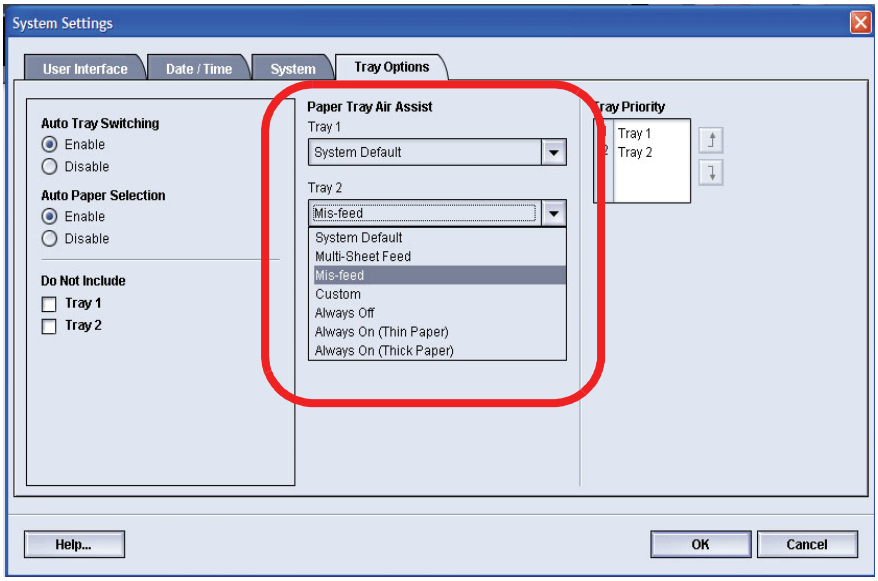
Default Setting	What the Default Does
Auto Tray Switching (ATS)	Allows the digital press to automatically select another paper tray, containing the appropriate paper, if the selected paper tray becomes unusable.
Auto Paper Selection (APS)	Allows the digital press to automatically select the appropriate paper size for the job being processed, without a specific paper tray being selected. When Single Paper Weight is selected as the default setting, Auto Paper selects only 81-105 g/m^2 paper in the correct size. When the Mixed Paper Weight Productivity Setting is enabled, Auto Paper selects only 106-135 g/m^2 paper in the correct size.
Do Not Include	Selecting a tray or trays in this option tells the machine to ignore any selections that were made in the Auto Tray Switching or the Auto Paper Selection options.

1. From the System Setting window, select the Tray Options tab.



2. Select either the **Enable** or **Disable** button for the Auto Tray Switching option.
3. Select either the **Enable** or **Disable** button for the Auto Paper Selection option.
4. To instruct the digital press to bypass (ignore) one or more of the paper trays, select the checkbox to the left of the desired paper pray in the Do Not Include area.
5. Select **OK** to close the System Settings window.

Paper Tray Assist

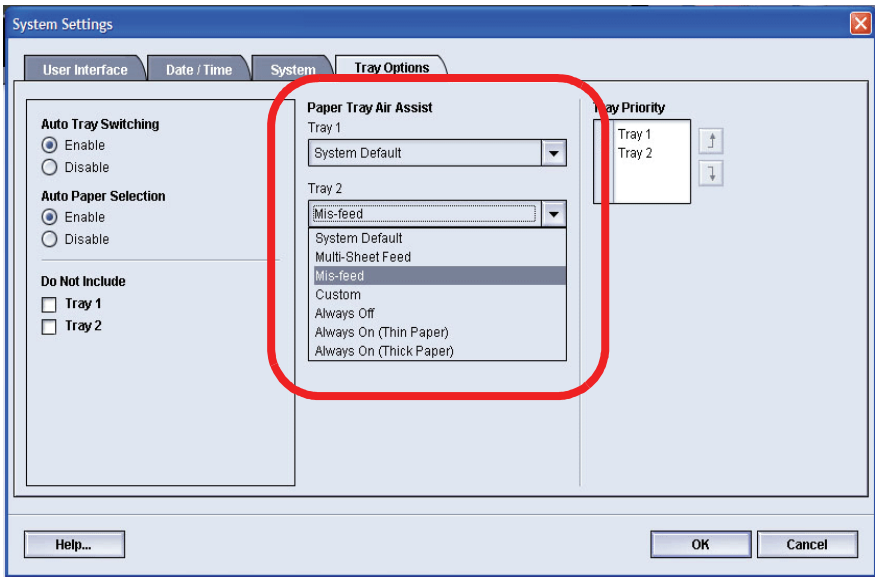


Blowers help control the environmental conditions in the paper trays to ensure optimum print capability:

- Each paper tray has two blowers and two fans. The blowers are located in the front of each tray, while the two fans are located on the right-side of the tray.
- The lead edge blower is on at all times and produces heated air if one of the following selections are made: Coated paper, Transparencies, or Plain paper 106 g/m^2 or heavier. The trail edge blower is on at all times and does not produce heated air.
- The paper trays also have air adjustment levers on the drawer to regulate the direction of the air:
  - If the paper weight is between 60 and 256 g/m^2, the position of the air adjustment levers should be toward the front of the tray.
  - If the paper weight is between 257 and 300 g/m^2, the position of the air adjustment levers should be positioned toward the rear of the tray.

If you adjust the blowers on the tray to accommodate a particular type of paper (for example, thin or thick), you want to make adjustments on the Tray Options window from the Administrator mode. This will provide optimal output quality of your prints. To make these adjustments, use the following procedure:

1. From the System Setting window, select the Tray Options tab.



2. Select either the desired tray.

3. From the pull-down menu, select the option which best correlates with the selected paper for that tray and the adjustments made to the tray air adjustment levers.

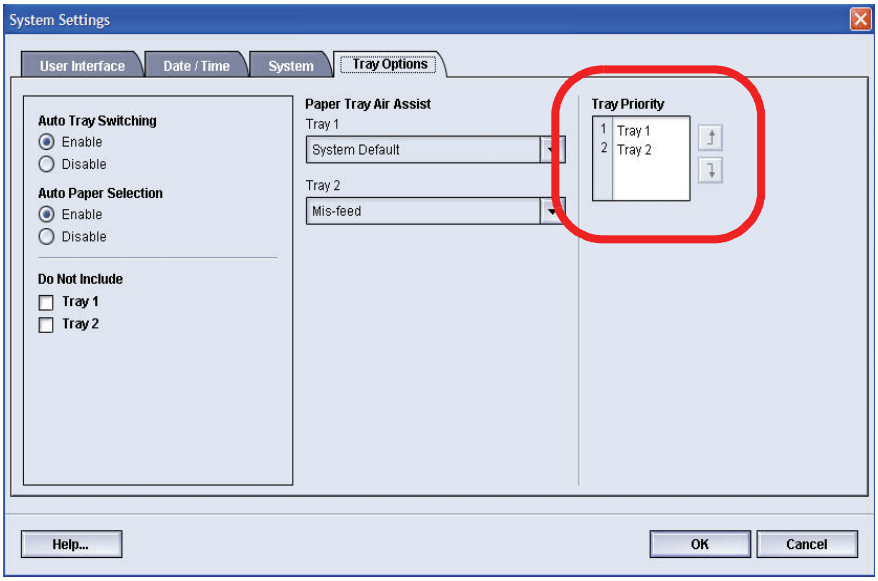
   The options include the following:

   - System Default: This option is the default setting. With this option the paper tray blowers automatically adjust using settings that are optimized for Xerox papers.
   - Multi-Sheet Feed: Select this option if you want the paper tray blower automatic settings to incrementally adjust in order to reduce multifeeds.
   - Mis-feed: Select this option if you want the paper tray blower automatic settings to incrementally adjust in order to reduce misfeeds.
   - Custom: With this option, the paper tray blowers are controlled by parameters that are set by your Service Representative.
   - Always Off: Select this option if you want the paper tray blowers always switched off; in this mode, the blowers are not automatically controlled. This mode is reserved for special media.

- Always On (Thin Paper): With this option, the paper tray blowers are not automatically controlled, but the are always switched on. This mode is also reserved for special media.
- Always On (Thick Paper): With this option, the paper tray blowers are not automatically controlled, but they are always switched on. This mode is reserved for special media.

4. Select **OK** to close the System Settings window.

Tray Priority



Select the priority order for each paper tray. If the Auto Tray Switching feature is enabled and each paper tray contains the same paper size and weight, the digital press feeds paper from the tray set at Priority 1. If there is no paper in the Priority 1 tray, the Priority 2 tray is automatically selected and so on.

Use the following procedure to set the priority for each paper tray.

1. From the System Setting window, select the Tray Options tab.
2. Click once on a desired paper tray.
3. Click the up or down arrow button to the right of it in order to move it up or down in the priority list.
4. Repeat this procedure for each Priority. You cannot set the same paper tray for more than one Priority at a time.
5. Select **OK** to save your settings and close the System Settings window.

3. Profiles

Overview

Profiles allows you to create and customize profiles for Custom Paper, Alignment, and Decurler. These profiles are used at the point of need for specialized print jobs which may require different types of media, such as lightweight or heavy stock. Using a customized profile can provide optimum image and output quality.

NOTE: *The Profiles features can only be accessed from the Administrator mode.*

Alignment

When printing duplex jobs and using different media types (including paper type, weight, and coating/uncoating), the output may require specific handling by the digital press as it is moving through the paper path. With certain media types and duplex jobs, the images on Side 1 and/or Side 2 may be misregistered, skewed, perpendicularly misaligned, or stretched.

The Alignment Adjustment feature allows you to create and store a maximum of twenty different Alignment Adjustment Profiles. These profiles allow you to accommodate different media types and how the image is registered, aligned, or magnified for Side 1 and Side 2 output. These profiles may be used at point of need in order to ensure optimum output quality of your print.

NOTE: *You can create Alignment Profiles without associating them to a specific Custom Paper Profile. The reverse is also true: You can create an Alignment Profile and associate it to a specific Custom Paper Profile. For example, Custom Paper Profile 2 may be affiliated with Alignment Profile 2, so that when Custom Paper Profile 2 is in use, Alignment Profile 2 is also in use.*

When creating Alignment Profiles for Side 1 and/or Side 2 prints, be aware of the following:

- Side 1/Side 2 images may be misregistered because the paper is not the exact same size. It may vary slightly, with differences of plus or minus 1mm, causing the image to be misregistered. To reduce the possibility of size differences, it is recommended that you use paper from the same lot when running duplex jobs.
- During the fusing process, the heat and pressure applied to the paper causes the paper to stretch. If the images on Sides 1 and 2 are the same size, the stretching of the paper may cause the image on Side 1 to be slightly larger than the image on Side 2.
- Creating an Alignment Profile for these types of jobs allows you to reduce or eliminate the images being larger on Side1 than on Side 2 prints.

NOTE 1: *Your Alignment Profile may or may not be affiliated with a Custom Paper Profile.*

NOTE 2: *Once an Alignment Profile is set and in use, your color server will not reflect that profile in the print options for print jobs.*

NOTE 3: *After an Alignment Profile is set, it remains active until you reenter Administrator mode and switch it off. If an active Alignment Profile is not associated with a Custom Paper Profile, it is used for each paper tray to which it is assigned.*

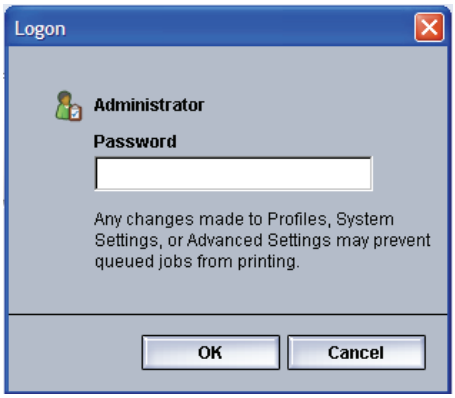
Alignment Adjustment Profile procedure

Use the following procedure to create/modify an Alignment Profile for adjusting Side 1/Side 2 image output.

NOTE: *If you require a Custom Paper Profile associated with this Alignment Profile, you can set the Custom Paper Profile information either now or after you create the Alignment Profile.*

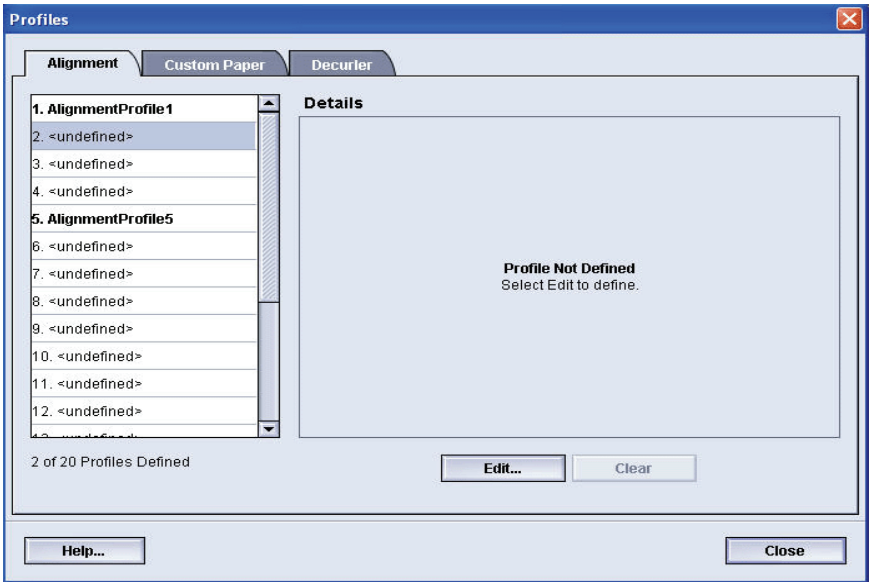
1. Select the Logon button from the main UI window.

2. From the Logon window, enter the Administrator password and select **OK**.

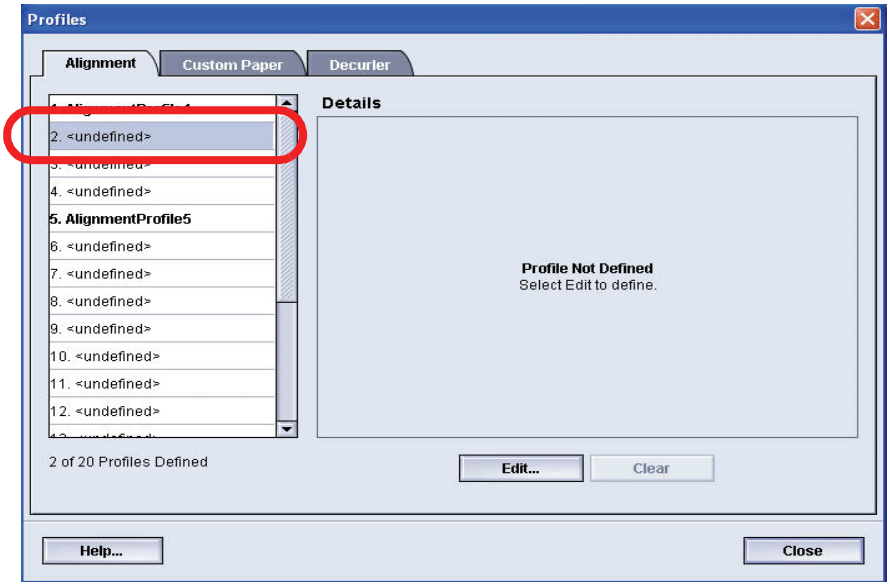


3. Select the Profiles button.

4. From the Profiles window, select the Alignment tab.



5. To create a ***new*** alignment procedure, select a undefined profile.

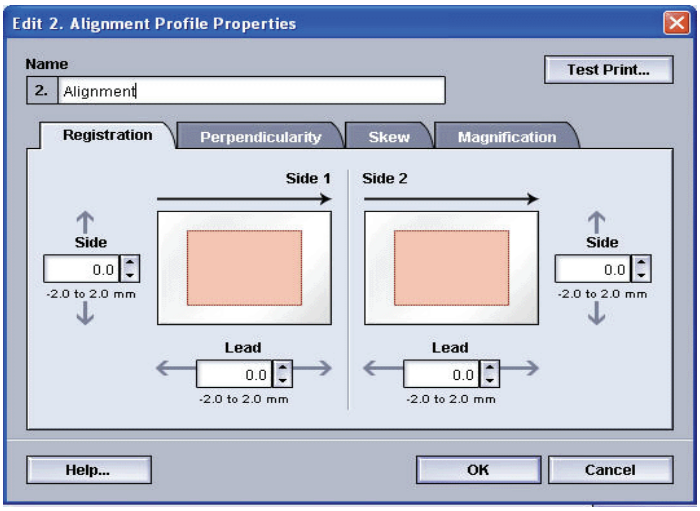


If you are editing an existing profile, go to Editing an existing Alignment profile.

6. Next: Creating an Alignment profile.

Creating an Alignment profile

7. Click the Edit button; the Alignment Profile Properties window opens.

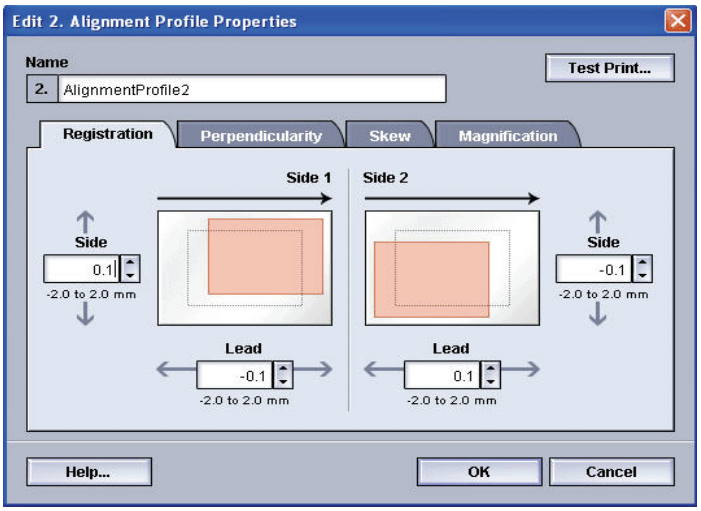


8. Type a name for this profile (the example in this procedure uses the name “AlignmentProfile2”).

9. Next: Selecting the Registration options.

Selecting the Registration options

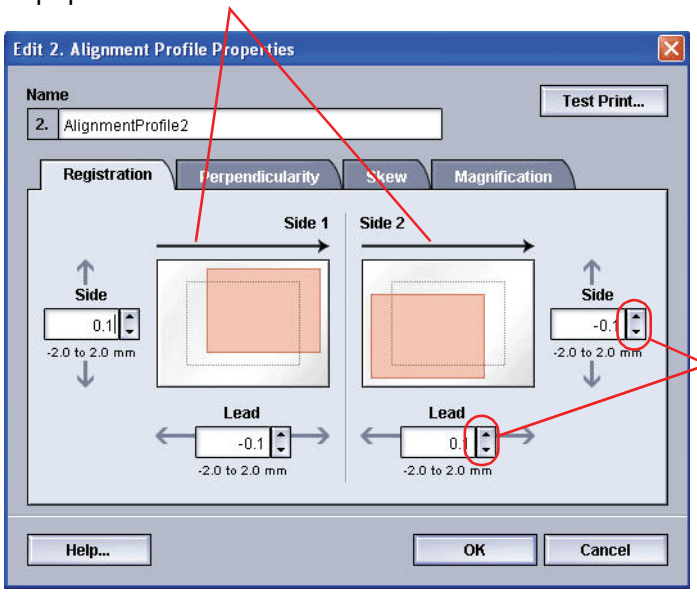
10. Make the desired selections to the Registration option.



- **Lead Registration**: Use this feature to adjust the lead edge of the image for Side 1 and/or Side 2 registration.
- **Side Registration**: Use this feature to adjust the side edge of the image for Side 1 and/or Side 2 registration.

  The factory default setting is zero (0).

These arrows indicate the paper feed direction



Use the up/down arrow buttons to make the desired selections..

As you click the up/down arrow buttons, the illustration moves indicating the direction that the image will move on the paper.

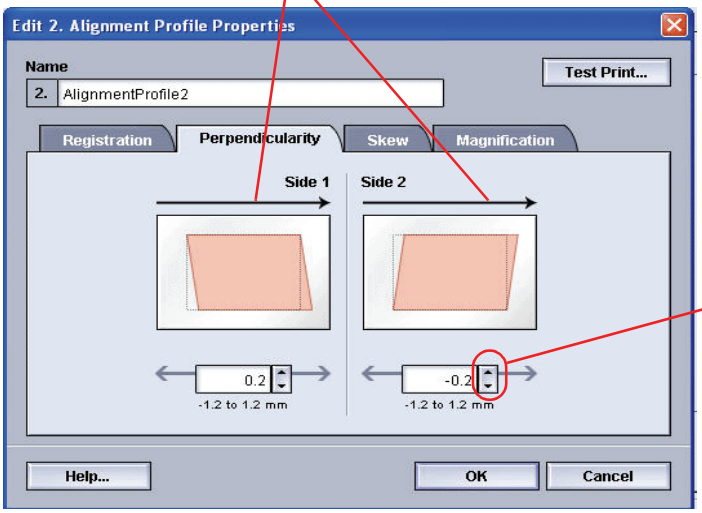
11. Next: Selecting the Perpendicularity options.

Selecting the Perpendicularity options

12. Make the desired selections to the Perpendicularity option. Use this feature to adjust the image digitally on the drum so that it will align with the paper for both Side 1 and Side 2.

The factory default is zero (0).

These arrows indicate the paper feed direction



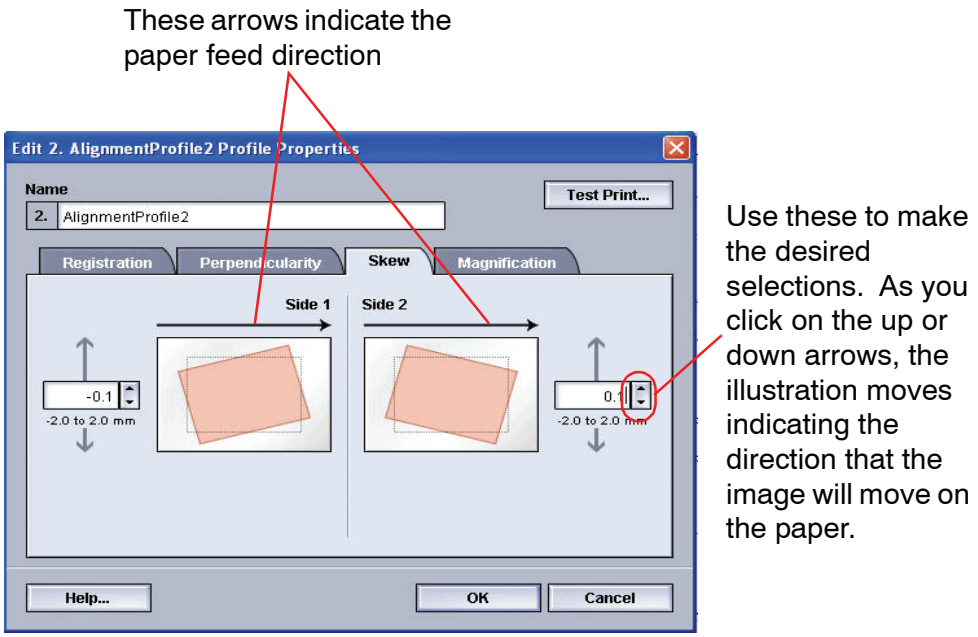
Use these to make the desired selections. As you click on the up or down arrows, the illustration moves indicating the direction that the image will move on the paper.

13. Next: Selecting the Skew options.

Selecting the Skew options

14. Make the desired selections to the Skew option. Use this feature to adjust the paper so that the image for Side 1 and/or Side 2 are not skewed but aligned with each other.

The factory default is zero (0).

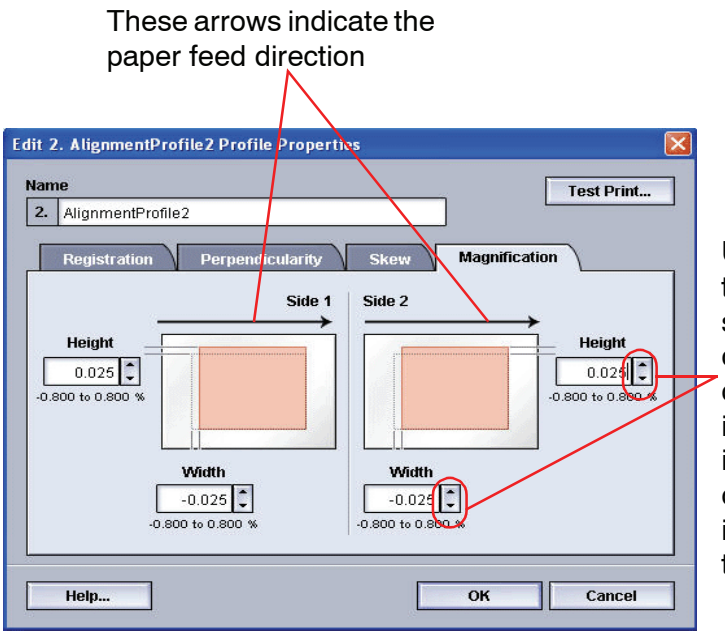


15. Next: Selecting the Magnification options.

Selecting the Magnification options

16. Make the desired selection to the Magnification option. Use this feature to correct for image stretch from Side 1 to Side 2. The image may be enlarged or reduced as necessary.

The factory default is zero (0).

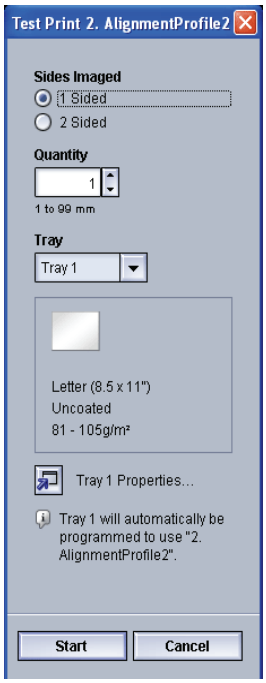


TIP: It is recommended that you choose only *one* Alignment Profile feature (such as Registration), and then run a set of Test Prints to evaluate the registration on that output. If you want multiple Alignment Profile features selected, individually select each feature, run Test Prints for that feature, and evaluate the output. After you determine that the output for the selected feature is acceptable, then you can select another Alignment Profile feature to adjust.

17. Next: Running test prints.

Running test prints

18. Select the **Test Print** button; a new window opens.



a. Select the **2 Sided** button.

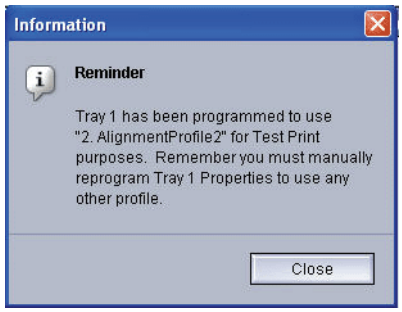
NOTE: *If you want to check the registration for 1 Sided prints only, select the 1 Sided button.*

b. Select **10** test prints by clicking the **Up** arrow button to change the number of test prints generated.

c. Select the desired paper tray from the pull-down list.

d. If necessary, select the Tray Properties button and make any desired settings.

e. Select Start. The UI displays this message after the test prints are printed:



f. Retrieve your prints.

g. Discard the first few prints, as inconsistency tends to be greater with these images.

19. Evaluate the test prints by holding your 2 Sided output at eye level near a light source. This will allow you to see the registration marks for both Side 1 and Side 2 of the output.

a. If you determine that the registration between Side 1 and Side 2 is unacceptable and needs adjusting, repeat this procedure starting at Selecting the Registration options.

TIP: You may need to repeat this procedure numerous times until you achieve acceptable output prints.

b. If the printed output for both Sides 1 and 2 is acceptable, select OK to save and close the Profiles window.

NOTE: *Once you have selected OK to save and close the Profiles window, the new profile procedure (for example, AlignmentProfile2) can be selected from the Tray Properties window whenever you want to run a job using this profile.*

20. Next: Editing an existing Alignment profile.

Editing an existing Alignment profile

21. If you are editing an existing Alignment profile:

a. From the Profiles window, Alignment tab, select the desired profile.

b. Click the Edit button.

c. Repeat this procedure starting at Selecting the Registration options.

Custom Paper

Different media (including paper type, weight, and coating/ uncoating) may require specific handling by the digital press as it is moving through the paper path. For example, some media types may skew or curl as they progress through the printing path of the digital press. This may occur on frequently-run jobs and/or jobs with a high volume output.

The Custom Paper feature allows you set custom paper profiles for different types of media and jobs, such as outlined in the above paragraph. These profiles may be used at point of need in order to ensure optimum output quality of your prints/jobs.

By setting custom paper profiles for specific media types, you can avoid output prints that are skewed, curled, have too much toner or not enough toner in areas, or images that are not registered properly on the output print, such as Side 1 and/or Side 2 images that are misregistered.

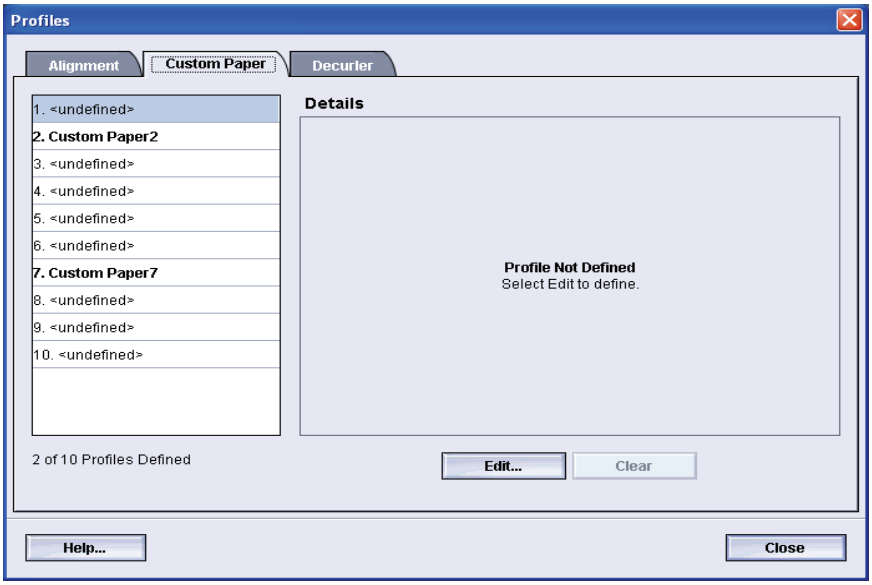
NOTE 1: *Once a Custom Paper Profile is created, the digital press passes this information on to your color server. The color server in turn reflects this information in the print options for print jobs.*

NOTE 2: *Adjusting registration for Side 1 and/or Side 2 images is discussed in detail in the Alignment feature. Refer to the Alignment feature.*

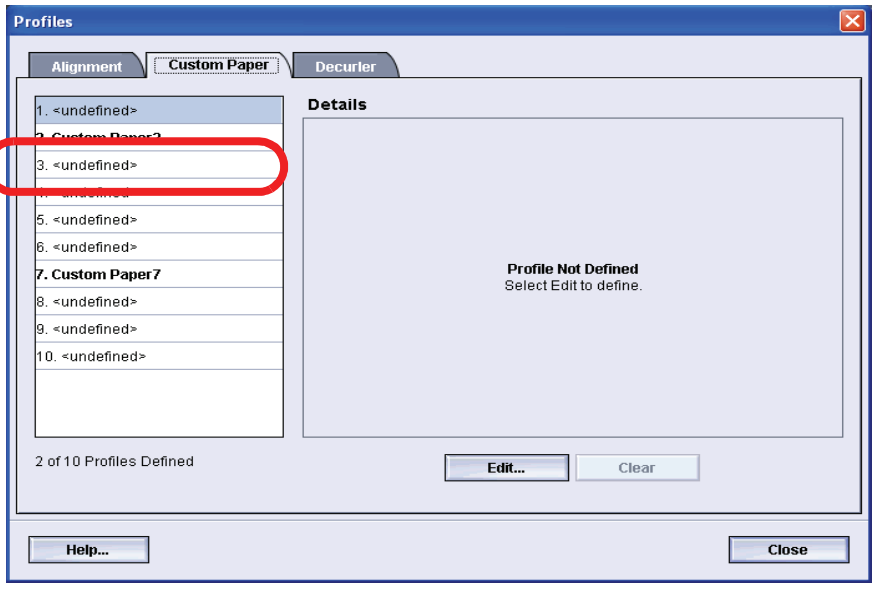
Custom Paper procedure

Use the following procedure for creating/modifying a Custom Paper Profile.

1. From the Profiles window, select the Custom Paper tab.



2. To create a ***new*** custom paper procedure, select a undefined profile.

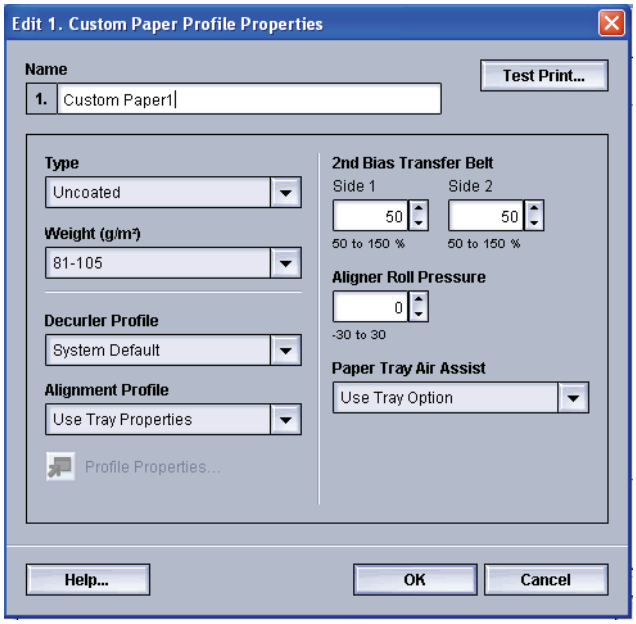


If you are editing an existing profile, go to Editing a Custom Paper profile.

3. Next: Creating an Custom Paper profile.

Creating an Custom Paper profile

4. Click the Edit button; the Custom Paper Profile Properties window opens.

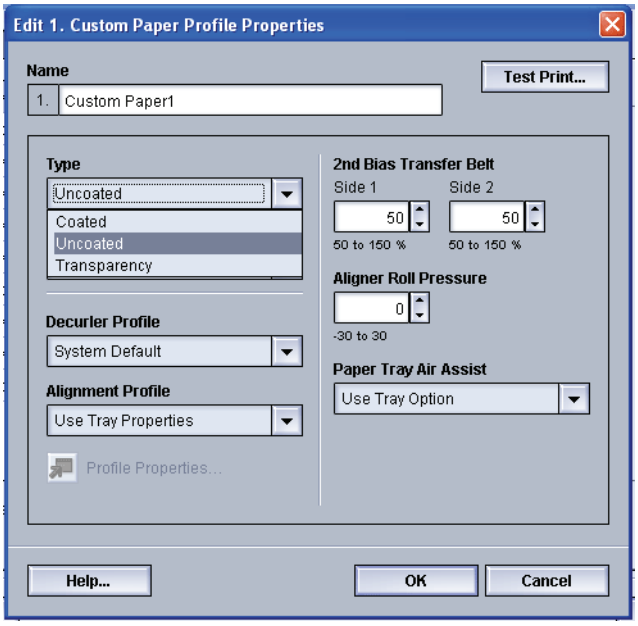


5. Type a name for this profile (the example in this procedure uses the name “Custom Paper1”).

6. Next: Selecting the desired paper type.

Selecting the desired paper type

7. Select the desired paper Type from the pull-down menu.

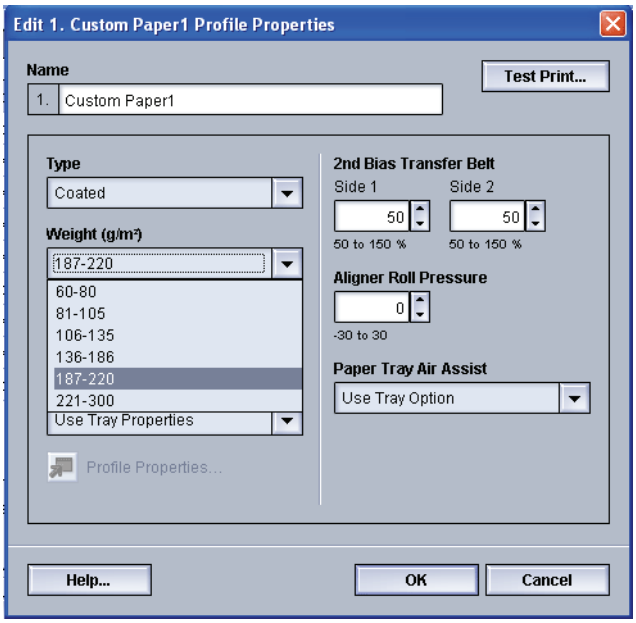


TIP: The paper type does **not** have to match the actual type of paper you are loading in the tray. When creating a Custom Paper Profile, select a paper type that is rarely or never used as your standard paper types. This ensures that when running commonly used paper types, the digital press does not load a Custom Paper Profile for those types.

8. Next: Selecting the desired paper weight.

Selecting the desired paper weight

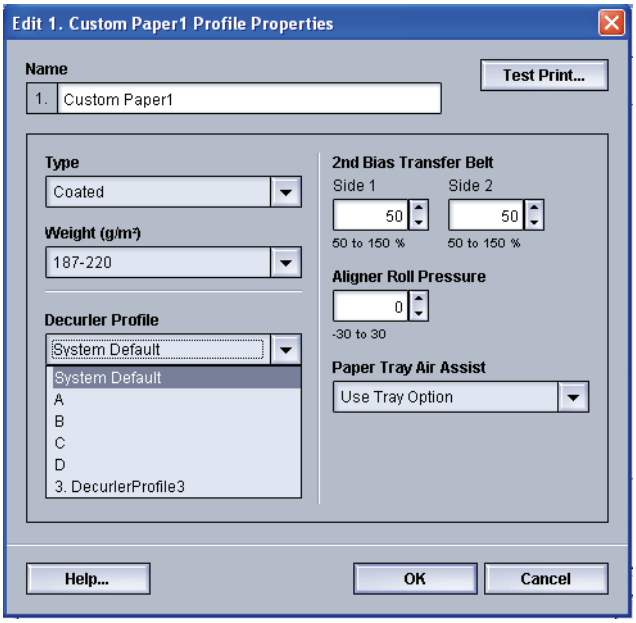
9. Select the desired paper Weight from the pull-down menu.



10. Next: Selecting other options for your Custom Paper profile.

Selecting other options for your Custom Paper profile

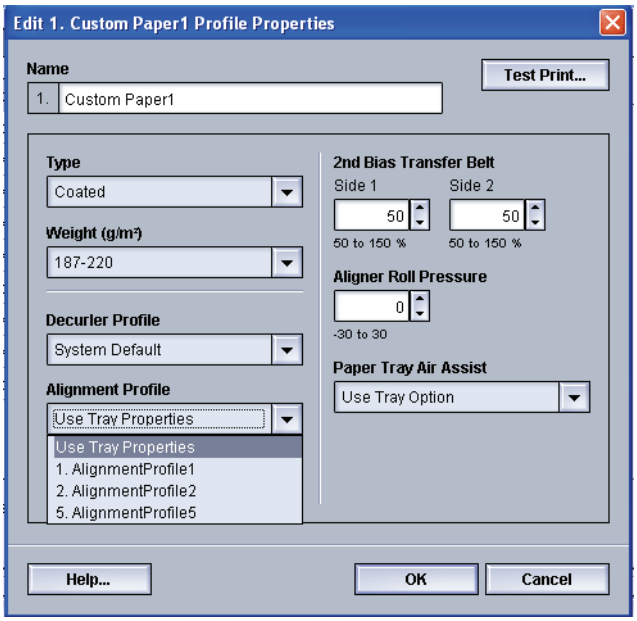
11. If required, select a Decurler Profile from the pull-down menu.



TIP: The default setting is System Default. It is recommended that you leave this option at its default setting until you run test prints and evaluate the output of the prints. Test Print is discussed in more detail in Running test prints.

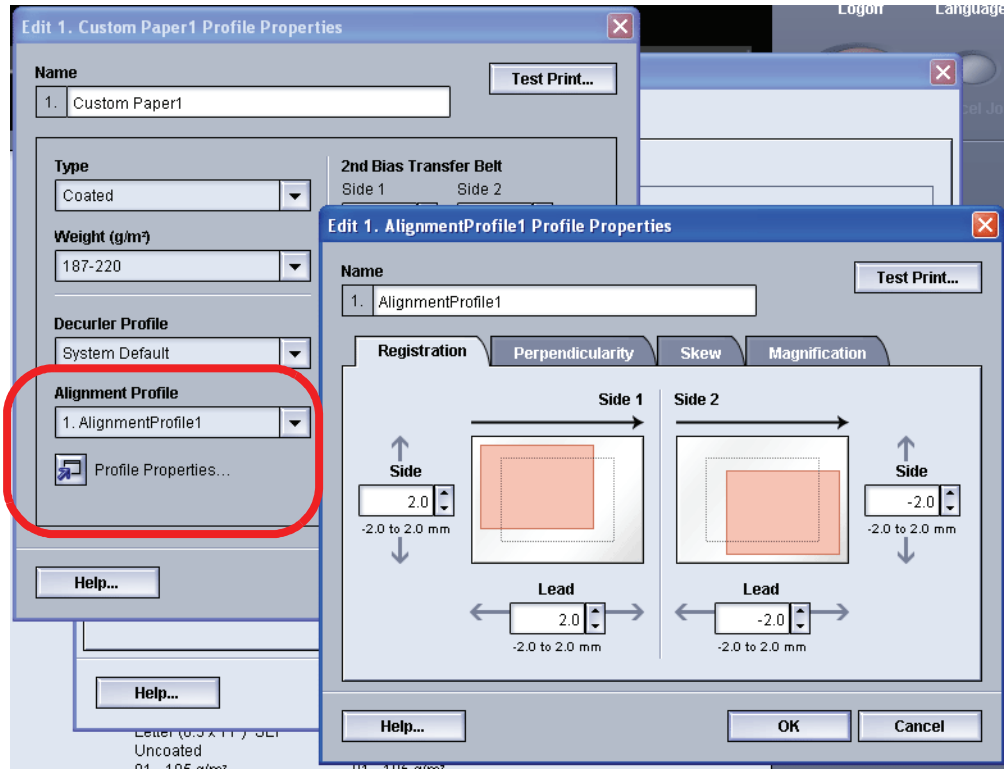
NOTE: *Use the Decurler feature in order to compensate for paper curl in your output prints. For Decurler information, refer to page 3-32.*

12. If required, select an Alignment Profile from the pull-down menu.



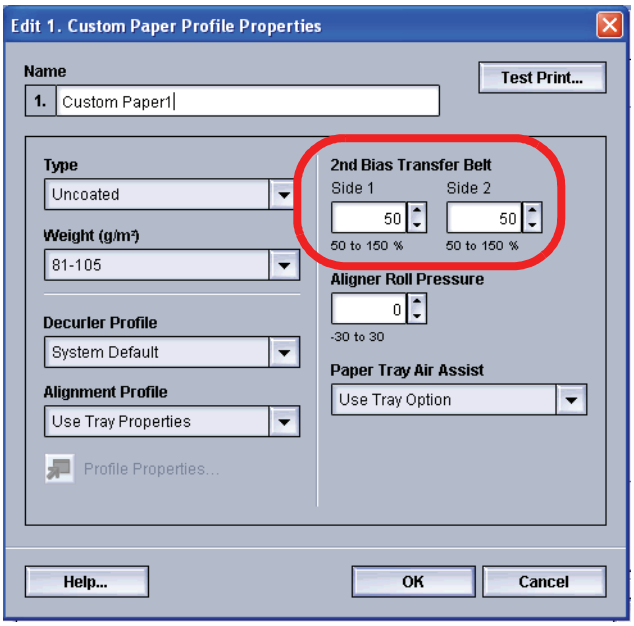
TIP: The default setting is Use Tray Properties. It is recommended that you leave this option at its default setting until you run test prints and evaluate the output of the prints. Test Print is discussed in more detail in Running test prints.

NOTE: *If you select a specific Alignment Profile, the Profiles Properties button becomes accessible. By clicking on this button, the UI opens the Alignment Profile window for the selected profile, and you can edit that Alignment Profile if necessary.*



NOTE: *For Alignment information, refer to page 3-2.*

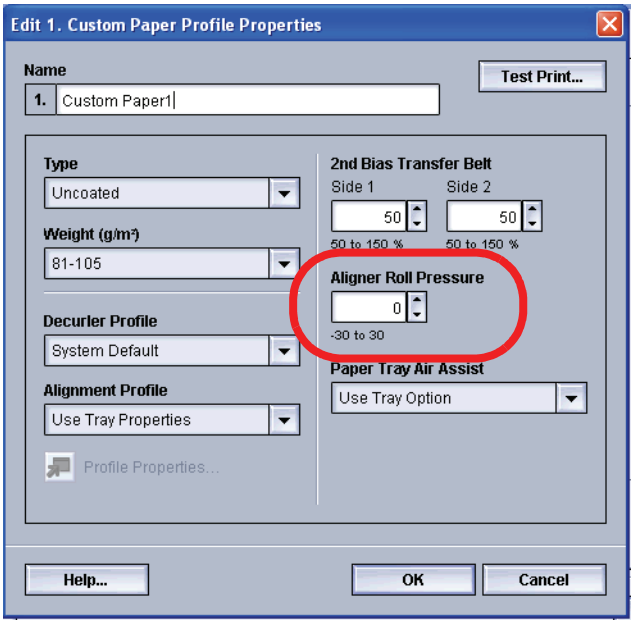
13. If required, choose 2nd Bias Transfer Roll settings for Sides 1 and 2.



TIP: The default setting for both Sides 1 and 2 is 100%. It is recommended that you leave this option at its default setting until you run test prints and evaluate the output of the prints. Test Print is discussed in more detail in Running test prints.

NOTE: *Refer to page 3-26 for information on the 2nd Bias Transfer Belt.*

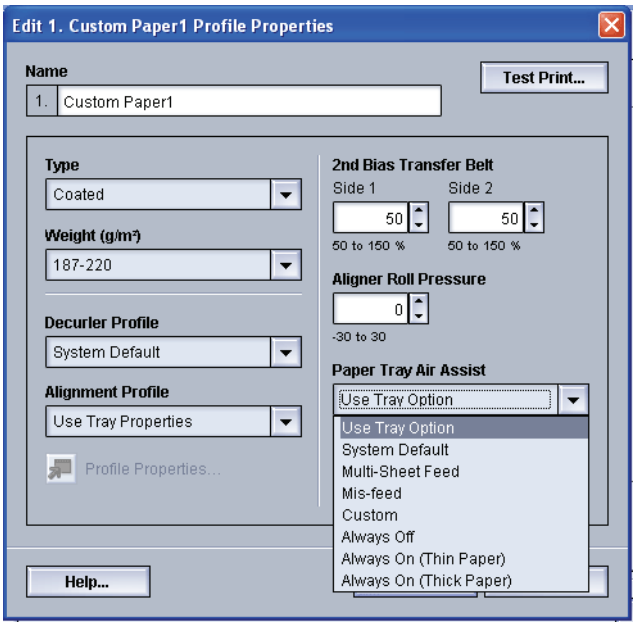
14. If required, choose an Aligner Roll Pressure setting.



TIP: The default setting is 0. It is recommended that you leave this option at its default setting until you run test prints and evaluate the output of the prints. Test Print is discussed in more detail in Running test prints.

NOTE: *Refer to page 3-30 for information on the Aligner Roll Pressure.*

15. If required, choose a Paper Tray Air Assist option from the pull-down menu.



TIP: The default setting Use Tray Option. It is recommended that you leave this option at its default setting until you run test prints and evaluate the output of the prints. Test Print is discussed in more detail in Running test prints.

NOTE: *Refer to page 3-31 for information on the Paper Tray Air Assist.*

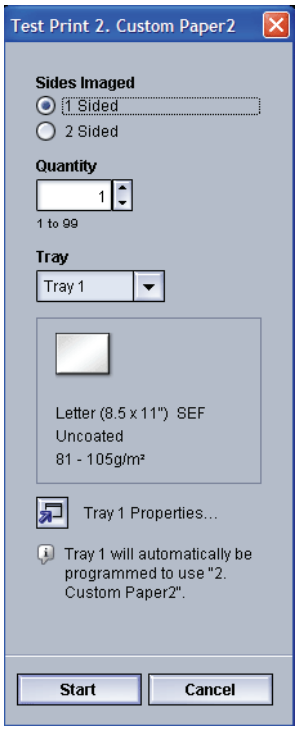
16. Load your custom paper in the desired paper tray.

17. Ensure that you select the correct paper information in the Tray Properties window (size, weight, type). From the Type pull-down menu, select the correct Custom Paper Profile.

18. Next: Running test prints.

Running test prints

19. Select the **Test Print** button; a new window opens.



a. Select the **2 Sided** button.

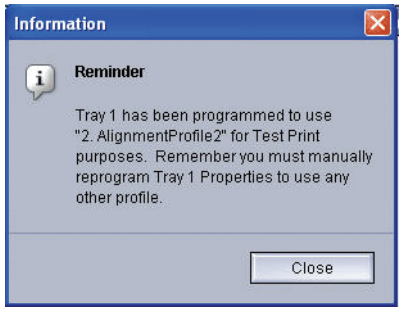
NOTE: *If you want to check the registration for 1 Sided prints only, select the 1 Sided button.*

b. Select **10** test prints by clicking the **Up** arrow button to change the number of test prints generated.

c. Select the desired paper tray from the pull-down list.

d. If necessary, select the Tray Properties button and make any desired settings.

e. Select Start. The UI displays this message after the test prints are printed:



f. Retrieve your prints.

g. Discard the first few prints, as inconsistency tends to be greater with these images.

20. Evaluate the test prints by holding your 2 Sided output at eye level near a light source.

a. If you determine that further custom paper adjustments are required, repeat this procedure starting at Selecting the desired paper type.

TIP: You may need to repeat this procedure numerous times until you achieve acceptable output prints.

b. If the printed output for both Sides 1 and 2 is acceptable, select OK to save and close the Profiles window.

NOTE: *Once you have selected OK to save and close the Profiles window, the new profile procedure (for example, Custom Paper1) can be selected from the Tray Properties window, the Type feature, whenever you want to run a job using this profile.*

21. Next: Editing a Custom Paper profile.

Editing a Custom Paper profile

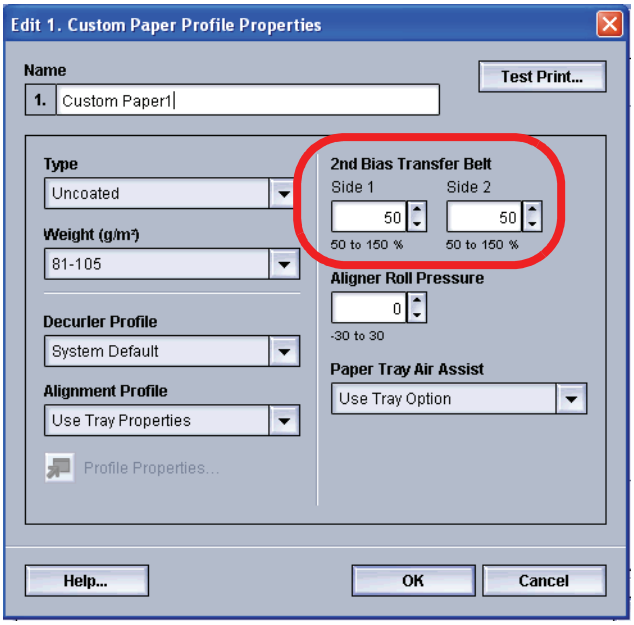
22. If you are editing an existing Custom Paper profile:

a. From the Profiles window, Custom Paper tab, select the desired profile.

b. Click the Edit button.

c. Repeat this procedure starting at Selecting the desired paper type.

Second Bias Transfer Belt



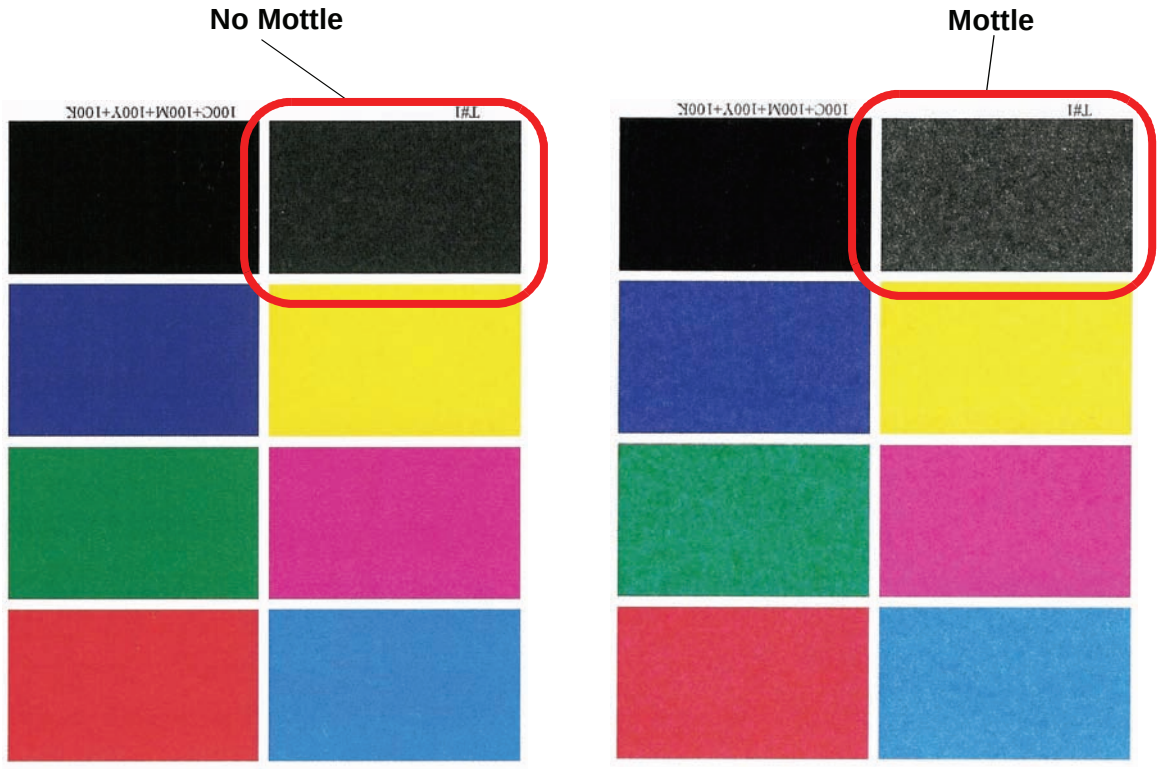
The Second Bias Transfer Belt is where the image is transferred from the belt to the paper. The Second Bias Transfer Belt feature is normally used with heavier weight paper, such as 220 g/m^2 and greater, 10 pt, or 12 pt, which are just three examples; however there are times when it is also used with lighter weight paper as well.

When using either heavier or lighter weight paper, you may want or need to adjust Side 1 for all 1-sided jobs. If defects continually occur in a printed job when using heavier weight paper, perform the following steps to determine if a Custom Paper Profile with Side 1 or Side 2 (2nd Bias Transfer Belt) adjustments are appropriate.

1. If the job is printed face down or 1-N, check Side 1 for defects on the topside (upper portion) of the stacked sheets, and check Side 2 for defects on the downside (lower portion) of the stacked sheets.
2. If the job is printed face up or N-1, check Side 2 for defects on the topside (upper portion) of the stacked sheets, and check Side 1 for the downside (lower portion) of the stacked sheets.

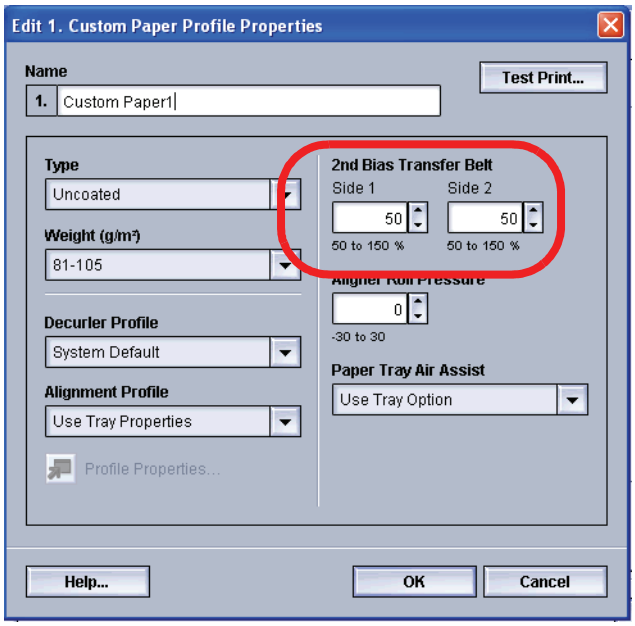
3. Use the 2nd Bias Transfer Belt feature when your:

a. Prints may have **mottle**, which is uneven spotty toner coverage that occurs when printing large, solid areas of flat color.

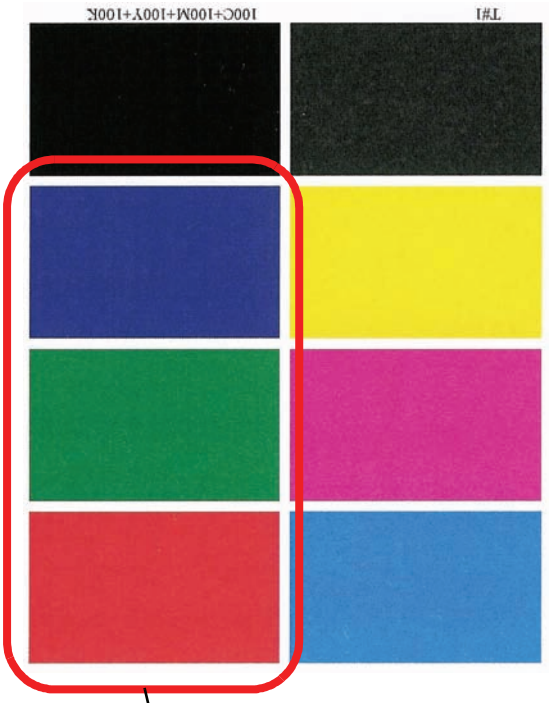


If mottle exists and it is heavy weight paper, **increase** one or both of the 2nd BTB values.

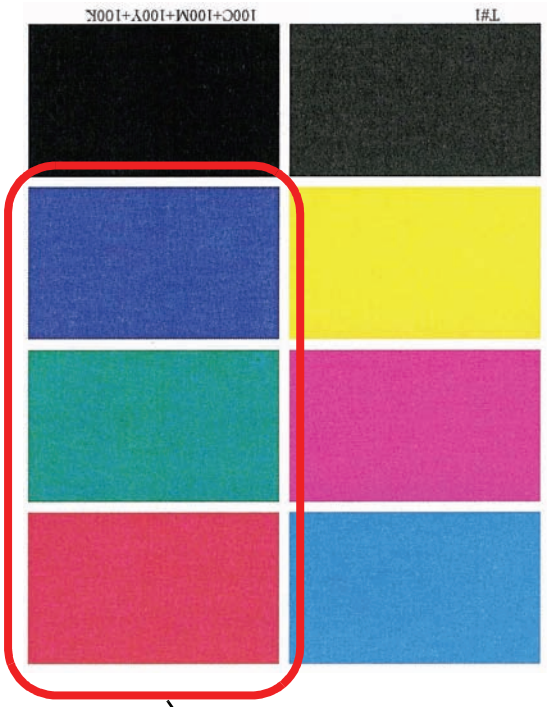
If mottle exists and it is light weight paper, **increase** one or both of the 2nd BTB values. Evaluate the image quality. If the image quality is equal to or worse than the 100% default setting, decrease one or both of the 2nd BTB values until a satisfactory image quality is obtained.



b. Prints have a color shift where the colors are much different than what you desire.

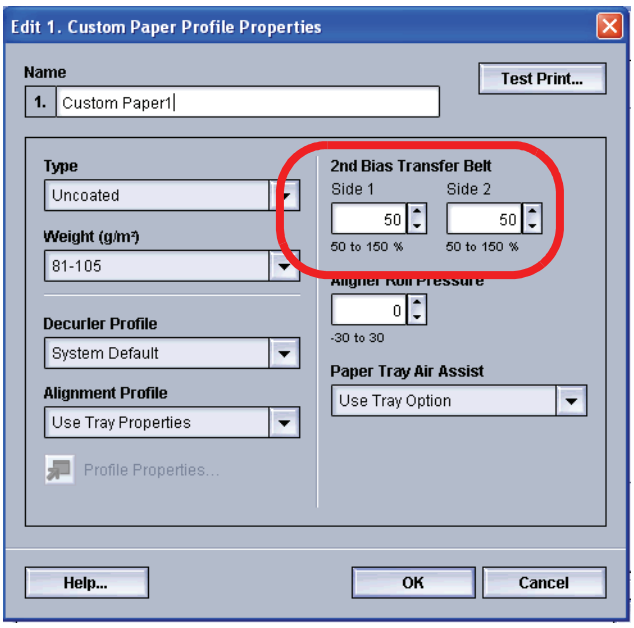


This test pattern represents an output with the desired colors.



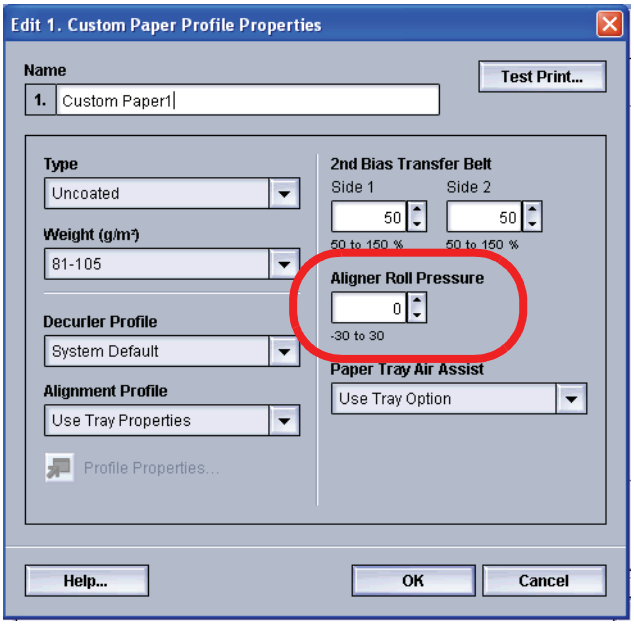
This test pattern represents an output with a shift in colors, and thereby an undesired output.

If mottle color shift exists, increase one or both of the 2nd BTB values.



Aligner Roll Pressure

Use this feature with paper types that slip and skew or have damaged edges.



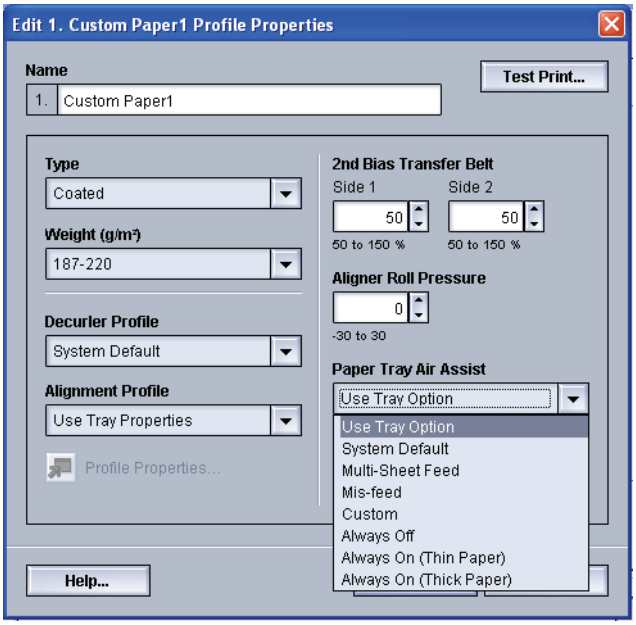
Examples:

- Some coated paper types slip and skew, thereby misregistering the image on the output prints. In this case, you may want to increase the roll pressure in order to compensate for the slippage and skewing.
- Some light-weight papers may have too much roll pressure applied to them, thereby causing edge damage to the output prints. In this case, you may to decrease the roll pressure.
- If you are experiencing numerous 8-154 faults, increase the roll pressure and continue to run the digital press.

TIP: Increasing the roll pressure for numerous 8-154 faults, allows you to postpone a service call. However, call your service representative as soon as possible in order to restore the digital press to its full feeding capabilities.

Paper Tray Air Assist

Use this feature to switch on or switch off the fans in a paper tray in order to eliminate misfeeds, paper jams, or other possible tray feeding problems. You can also select System Default or Use Tray Option if you want the digital press to decide whether or not to switch on or off the fans for a paper tray.



NOTE: *The default setting is Use Tray Option.*

Refer to page 2-26 of this book for information on each one of the Paper Tray Air Assist settings.

Decurler

TIP: Please read **all** the Decurler information *before* using the Decurler Profile procedure.

IMPORTANT! If you notice that output prints have too much curl, first try flipping over the stack of paper in the paper tray being used. You can also try running the job from a different tray. If curl is still a problem, use one of the Decurler A-D Settings; refer to the Decurler Settings A-D table on page 3-34 for your market area. If curl is still a problem ***after*** using the Decurler A-D Settings, then use the Decurler Profile procedure to eliminate the curl on your output.

Overview

When paper is exposed to heat, the paper loses moisture and curls toward the heat source. High toner coverage jobs tend to curl more due to the toner plastification effect on the paper surface. The system tries to reduce this by using mechanical devices within the paper path called decurlers.

Your system has been designed with an automatic curl control system that uses information such as:

- the amount of toner coverage on the page (for example, a page that has all text only versus a page that contains a photograph only)
- the paper weight
- coated or uncoated paper
- the current humidity and temperature

All the above factors determine the amount of pressure needed at the different decurlers in order to reduce the output curl of the paper.

With some print jobs, the output prints still may be curled more than you desire. In cases like these, use the Decurler feature to compensate for paper curl in your prints.

Paper curl is caused by many variables, including:

- The manufacturer's brand of paper and the manufacturing lot
- The weight of the paper and whether it is coated or uncoated
- The amount of dry ink/toner and the area being covered on a sheet: the heavier the coverage, the greater the tendency to curl
- The atmospheric conditions of the room where the paper is stored
- The atmospheric conditions of the room where the digital press is located
- The heat generated during the fusing processes

The digital press is equipped with an automatic curl control system that uses the variables listed above to determine the amount of pressure needed at the different decurlers in order to reduce the curl.

Decurler specifications

The Decurler has both top and bottom adjustment arms that apply pressure to the paper based on system defaults, selections made on the Tray Properties screen, or based on selections made on the Decurler Profile screen. The degree of pressure is applied independently to the top and bottom Decurler arms.

Decurler settings A-D

The default Decurler settings for Type A through Type D are shown in the following table. These settings are automatically selected by the digital press.

All Trays Paper Weights	Paper Types	Western Hemisphere Paper Type	Eastern Hemisphere Paper Type
60 - 80 g/m^2	Coated Uncoated	A A	B B
81 - 105 g/m^2	Coated Uncoated	B D	B D
106 - 135 g/m^2	Coated Uncoated	A B	A B
136 - 186 g/m^2	Coated Uncoated	A A	A A
187 - 220 g/m^2	Coated Uncoated	A A	A A
221 - 300 g/m^2	Coated Uncoated	A A	A A

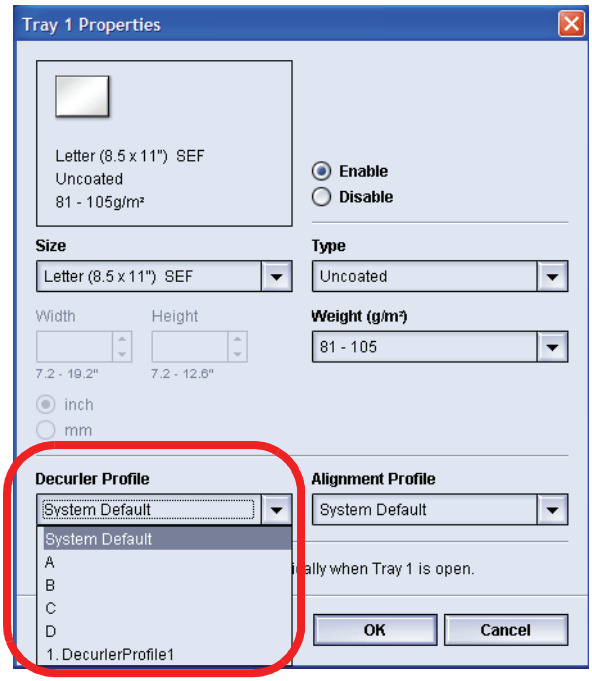
NOTE: *The settings in the above table were developed from testing a wide range of paper samples, toner area coverages, and environments. The outcome of this testing is the preset parameters shown in the table, and these parameters refer to how particular papers interact with the digital press decurling system.*

If paper curl is a problem, using one of these preset parameters usually eliminates the problem. However, due to the broad range of paper variables, image coverage, and environmental factors, these defaults settings may not result in satisfactory performance.

Decurler A-D procedure

If paper curl is interfering with digital press performance, begin by selecting an alternate Decurler Paper Type A through Type D setting

1. Select one of these Decurler A-D settings from the Tray Properties window.



2. Run the same print job again, and retrieve the output from the exit area of the digital press.

3. Check the output for curl.

   a. If the curl is eliminated, you are finished. Continue running your prints using the specific Decurler A-D setting.

   b. If the curl is still persistent, try another Decurler Paper Type (A-D).

4. If the curl continues after **each** Decurler Paper Type A-D setting is tried, continue to page 3-36.

Evaluate your print output for paper curl

Before using a specific Decurler Profile, evaluate your output for paper curl and whether or not you need to use a Decurler Profile by performing the following steps.

1. Determine if Xerox has tested your paper type and weight by going to the www.xerox.com web site and referring to the latest **Recommended Materials List** (RML) for your digital press.
2. Run a set of 10-15 prints using the system default settings for the Decurler option on the Tray Properties window.
3. Retrieve your output prints from the digital press exit area.
4. Check your output prints for paper curl; determine if they are curled upward (“cupped”) or curled downward (“bridged”).

Paper that is curled upward

Paper that is curled downward

TIP: The amount of curl on the output paper is affected by paper properties (weight, coating) and the amount of graphics and text on the paper.

5. Select the pages from your original print job that represent the extremes in curl (this *usually* indicates the print with the highest area of toner coverage).
6. Lay the curled output page on a flat surface.
7. Measure the height of the sheet, in millimeters (mm), at the four corners of the sheet.

Measuring the curl of an upward sheet

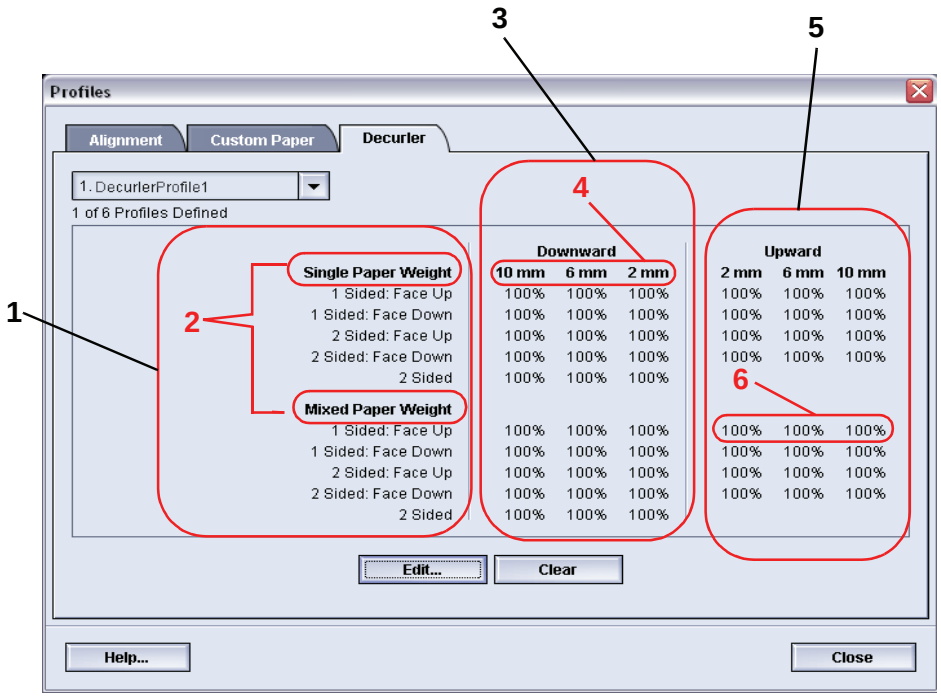
Measuring the curl of a downward sheet

   a. Add the four values, then divide by four to get an average.
   b. Record the curl average (in millimeters) on a sheet of paper.

8. Continue to the Decurler Profile options on page 3-38.

Decurler Profile options

Before you can create or use a Decurler Profile, you need to understand the function of the Decurler Profile options. The following illustration shows the Decurler Profile Properties window.



NOTE: *Items 1-6 are discussed in the sections entitled* Name *and* Downward/Upward Values.

1 Name: Refers to the Productivity Mode setting.

2 Productivity Mode:

- Single Paper Weight or Mixed Paper Weight denotes the specific Productivity Mode that is set for the machine. For more information refer to page 2-10 of this guide.
- 1 Sided: Face Up, 1Sided: Down...: Refers to the output print and correlates with the Productivity Mode.

3 Downward Value: Refers to the amount of downward curl used to eliminate the curl on the output prints.

4 10mm, 6mm, 2mm: These measurement numbers represent the amount of reverse curl that is applied to the output prints.

5 Upward Value: Refers to the amount of upward curl used to eliminate the curl on the output prints.

6 Percentage value: The number entered here represents the percentage of toner area coverage on the originals.

NOTE: *Print jobs that consist of multiple pages usually have a variety of toner area coverage; therefore a range of toner area coverage is provided by the machine. Usually the page (or pages) that create the largest amount of curl will correlate with the largest amount of toner coverage. This is the page (or pages) that you will use in order to create a specific Decurler Profile.*

Name

The Decurler Profile procedure you create/edit is based on the Productivity Mode: either **Single Paper Weight** mode or **Mixed Paper Weight** mode. For information on these productivity modes, refer to page 2-10 of this guide.

1 Sided: Face Up The values entered here are for output prints that are 1-sided, face-up.

1 Sided: Face Down The values entered here are for output prints that are 1-sided, face-down.

2 Sided: Face Up The values entered here are for output prints that are 2-sided, face-up (N-1).

2 Sided: Face Down The values entered here are for output prints that are 2-sided, face-down (1-N).

2 Sided The values entered here are for 2-sided output prints that are jamming frequently in Areas 5, 6, 7a, and 7b of the digital press and where paper curl is apparent.

Downward/Upward Values

The Downward and Upward values control a mechanism in the digital press that compensates for the curl formed in the fusing process; **this is done by inducing an equal but opposite curl in the paper**. It is similar to passing a sheet over a sharp radius, and thereby producing a curl in the direction of the radius.

The paper curl values that you recorded earlier from your calculations (Evaluate your print output for paper curl) determine the values that you enter for the Downward and/or Upward values.

The Downward and Upward values have three discrete set points of **10 mm**, **6 mm**, and **2 mm**. Each category reflects the upwards or downwards curl direction and the curl depth:

- The 10 mm, 6 mm, and 2 mm columns represent the amount of **reverse** curl (either upward or downward) that the printer produces.
- The percentage number entered for each column represents the percentage of area coverage on the output prints.

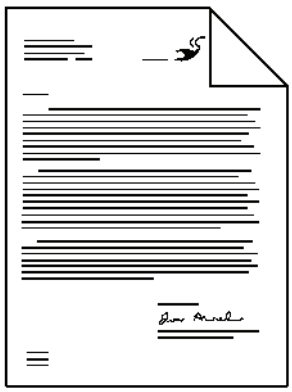
For example, paper that is curled *upwards* is adjusted using the **Upward** category of settings. Paper that is curled *downwards* is adjusted using the **Downward** category of settings.

Values entered are shown in percentage. The percentage value represents the amount of toner coverage for that curl direction (remember: 10 mm, 6mm, 2mm equals curl depth).

Example

The following example illustrates how this works:

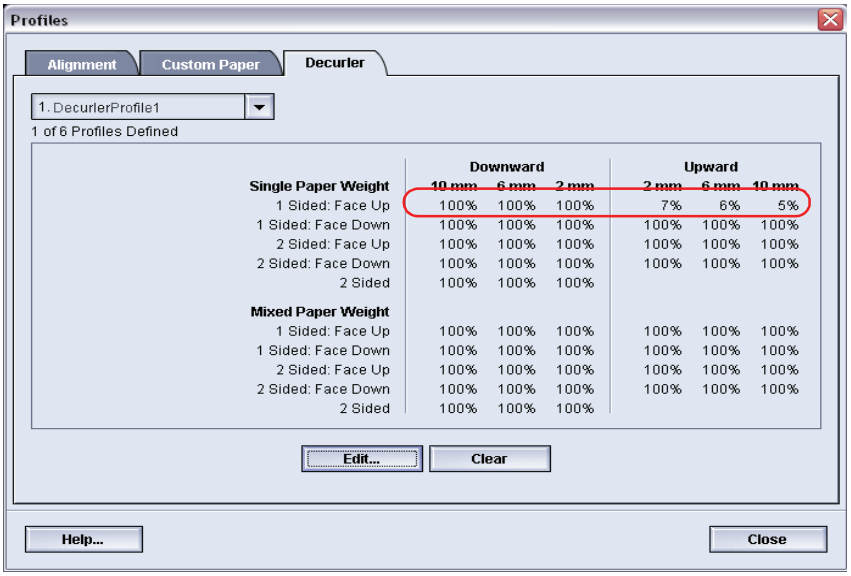
- Your input document is a black-white original, mostly text, with a 5% area coverage



- Your desired output is to print it on 24 lb. (90 g/m^2) plain paper, delivered face up to the output area

- The output print in the output area is curled upwards and was measured with a curl average of 10 mm (refer to Evaluate your print output for paper curl).

- Using the 1-Sided Face Up row, as shown below, enter the known values into the table.



  - Average curl is 10 mm upward and average toner area coverage is 5%. Therefore, select Upward and enter 5% for the 10 mm column.
  - Enter any higher number for the 6 mm (such as 6%) and the 2 mm (such as 7%).
- The printer will induce a 10 mm curl in the downward direction for the 5% toner area coverage sheets in your job.

TIP: When creating/editing a Decurler Profile, you must enter a percentage value for 3-6 cells of the Downward and/or Upward tables.

NOTE: *The default value for each cell of the table is 100%.*

Continue to the Decurler Profile procedure on page 3-42.

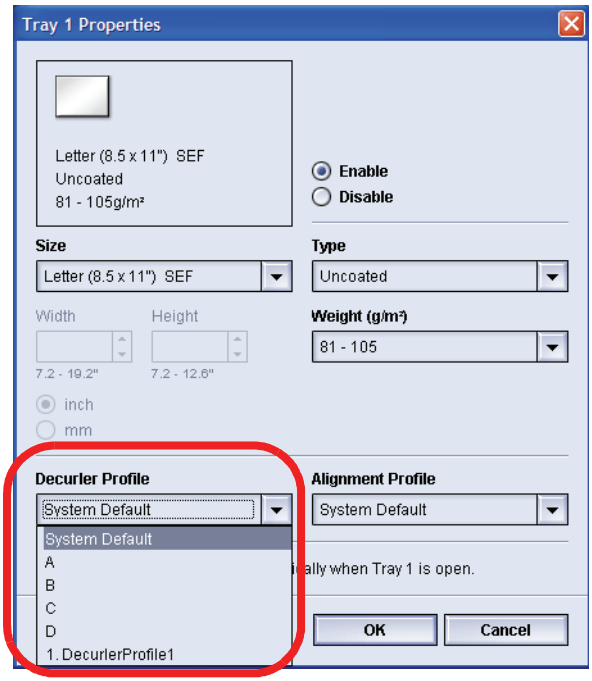
Decurler Profile procedure

IMPORTANT! Before using this procedure, use a Decurler A-D setting to eliminate the curl in our print output; refer to page 3-34. If a Decurler A-D setting is unsuccessful in eliminating your curl, evaluate the curl on the output prints (page 3-36). Once you have measured and recorded the curl on your output, then you can perform this procedure.

1. Load a specific Paper Tray with the paper you wish to use for a job. Make the correct paper selections on the Tray Properties window for the paper being used and run a few test prints.
   a. If there is too much curl, **save the stack** and continue to the next step.
   b. If the test prints are acceptable, you are finished.

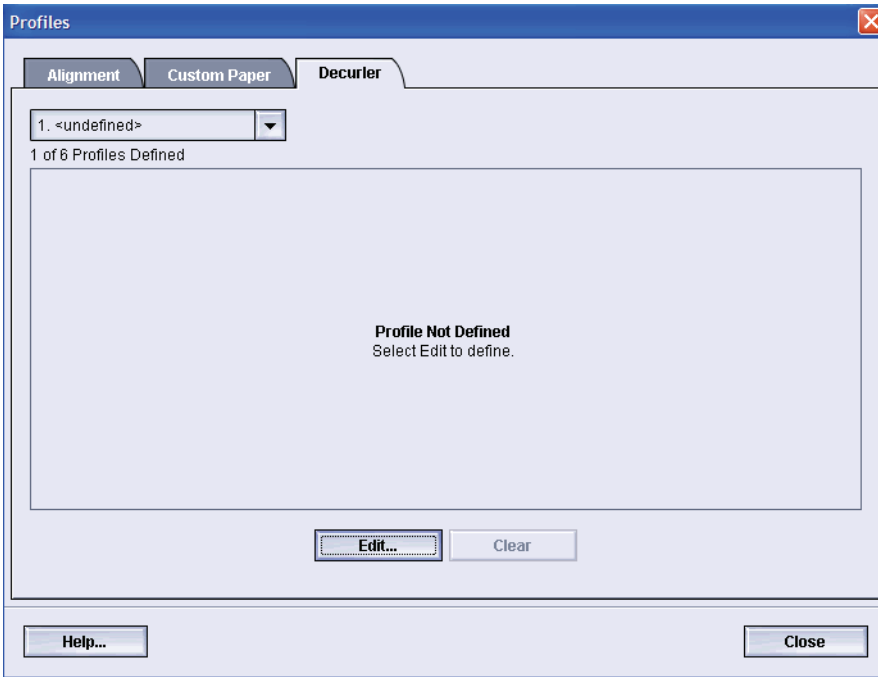
NOTE: *For the purpose of this procedure, Paper Tray 1 is used as the example.*

2. Select one of these Decurler A-D settings from the Tray Properties window.

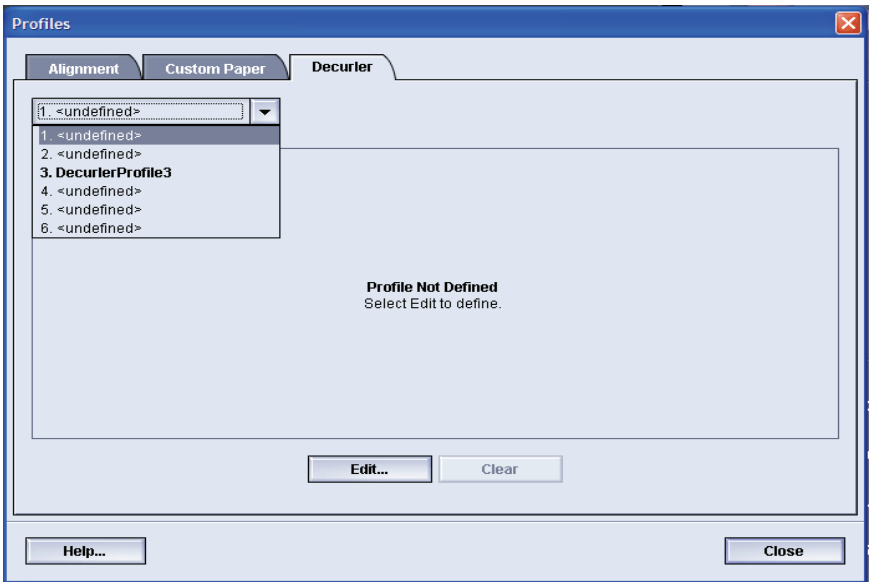


3. Run the same print job again, and retrieve the output from the exit area of the digital press.

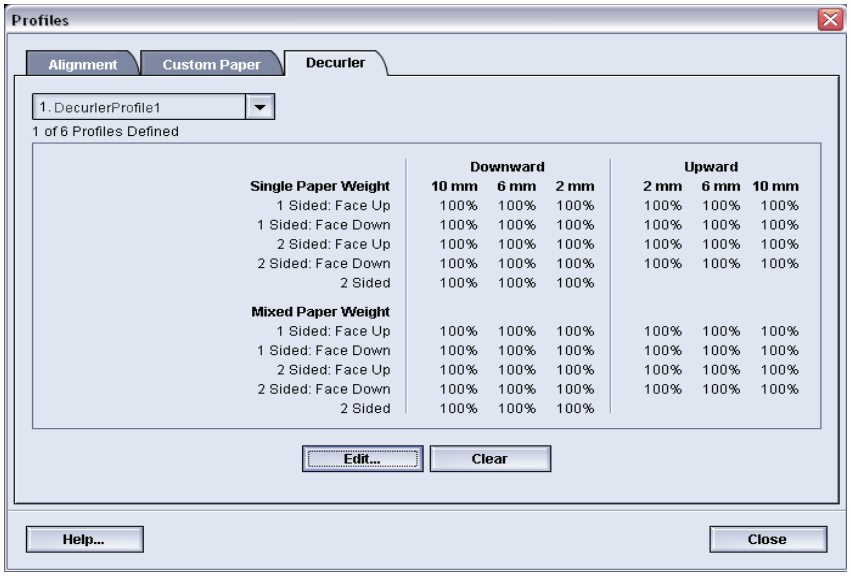
4. Check the output for curl.
   a. If the curl is eliminated, you are finished. Continue running your prints using the specific Decurler A-D setting.
   b. If the curl is still persistent, try another Decurler Paper Type (A-D).
5. If the curl continues after **each** Decurler Paper Type A-D setting is tried, continue to the next step.
6. Logon on **Administrator** and select the **Profiles** button.
7. From the Profiles window, select the Decurler tab.



8. To create a ***new*** decurler profile, select a undefined profile and click Edit.



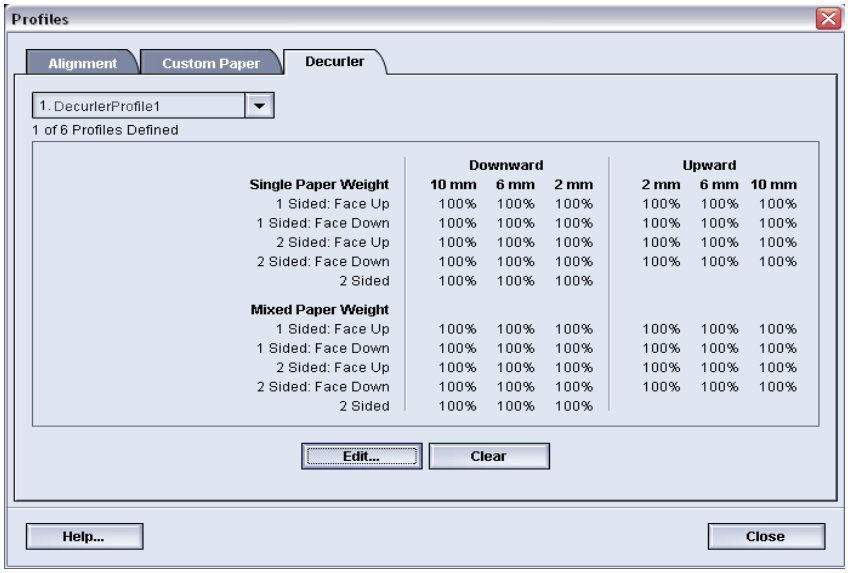
The Decurler Profile Properties window opens.



9. Type a name for this profile (the example in this procedure uses the name “DecurlerProfile1”).

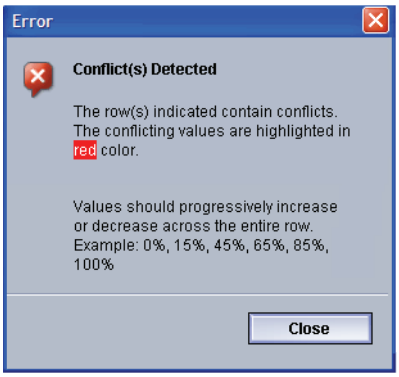
10. Measure and record the curl amount of the output print which contains the most curl. Refer to Evaluate your print output for paper curl.

11. Enter your curl calculations in the Downward/Upward tables.



12. Select OK to save and close the profile.

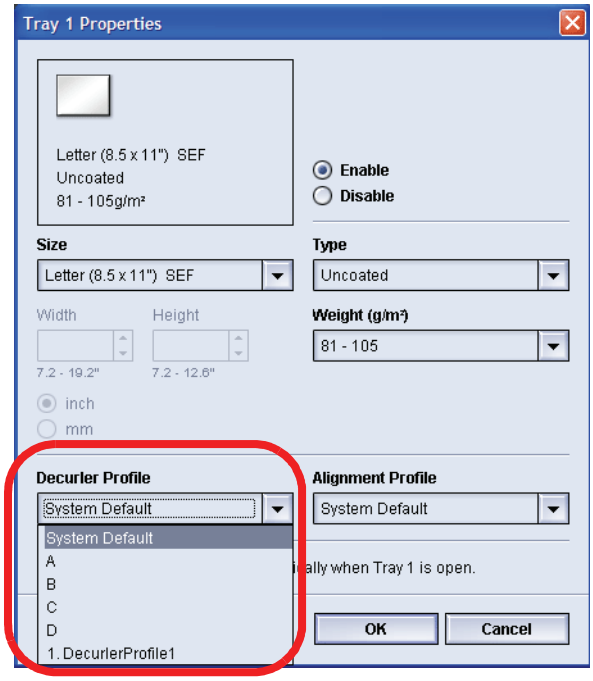
NOTE: *If the values entered in the Downward and Upward tables have conflicting values (not in ascending or descending order across an entire row), an error message is displayed and you must be reenter the values until they do not conflict.*



13. Close the Profiles window.

NOTE: *Once you have selected OK to save and close the Profiles window, the new profile procedure (for example, DecurlerProfile1) can be selected from the Tray Properties window, the Decurler pull-down menu, whenever you want to run a job using this profile.*

14. From the Tray Properties window, select the Decurler Profile that you just created/edited (for example, DecurlerProfile1).



15. Select the pages from your original print job that represent the extremes in curl.

16. Enter a print quantity of 20-25 and print these pages.

17. Retrieve your output and compare the paper curl condition of the original stack with the paper curl of the new stack.

a. **If the curl is eliminated in the new output stack, continue printing the job and you are finished.**

b. If the curl in the new stack is in the opposite direction from the original paper output, you may have to adjust the average toner coverage amount entered in the Decurler Profile; repeat this procedure starting at Step 6.

c. If the curl is eliminated in one stack but not the other, additional adjustments are required; proceed to the next step.

TIP: You may need to repeat this procedure numerous times until you achieve acceptable output prints.

18. If you are editing an existing Decurler profile:
    a. From the Profiles window, Decurler tab, select the desired profile.
    b. Click the Edit button.
    c. Repeat this procedure starting at Step 6.
19. If you are not successful in reducing the curl, call your Xerox service representative.