Mini DLF Series
USER MANUAL

DLF-140S / DLF-220S
Tabletop Label Finishing Systems

v 1.1

THIS PRODUCT IS CERTIFIED:

CE ✔ RoHS COMPLIANT 2002/95/EC FC 245452TRF

IMPORTANT: Please keep the original packaging in case you need to process a return. If we receive the system in non-original packaging, the warranty will be void.

IMPORTANT: The latest version of the DLF software is available on our website, **afinialabel.com** or **afinialabel.co.uk**

Table of Contents

HOW TO INSTALL THE CUTTING PLOTTER

1. Download the zipped DLF Installer from the Afinia Label Support webpage.

    http://afinialabel.com/product-support/

2. Extract the installer from the .zip file.

3. Double click the extracted **Setup DLF-Software.msi** file.

4. Follow the on-screen instructions to complete the installation.

Plug in the USB camera and the USB dongle, they will auto-install.
If your computer already has a camera installed, we recommend disabling it. If you do not, your pc will ignore the camera on the plotter.
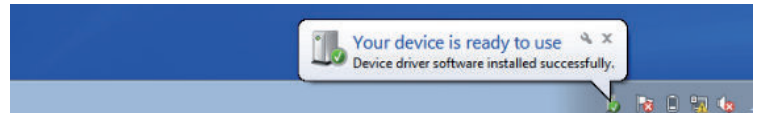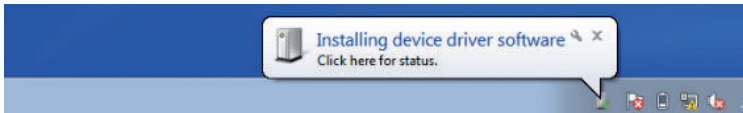
The Cutter Management Software will generate a folder in the Windows start menu.
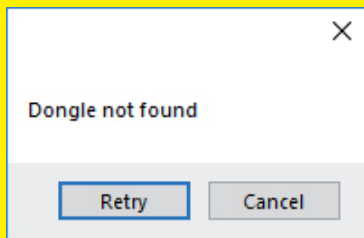
If the USB dongle is not installed correctly or is unplugged, the following error will appear.

SYSTEM REQUIREMENTS

DLF Cutter Management software is compatible with Windows XP and next versions;
CPU memory 4GB;

Cut Files: Adobe Illustrator or and Corel Draw (save as PDF file).
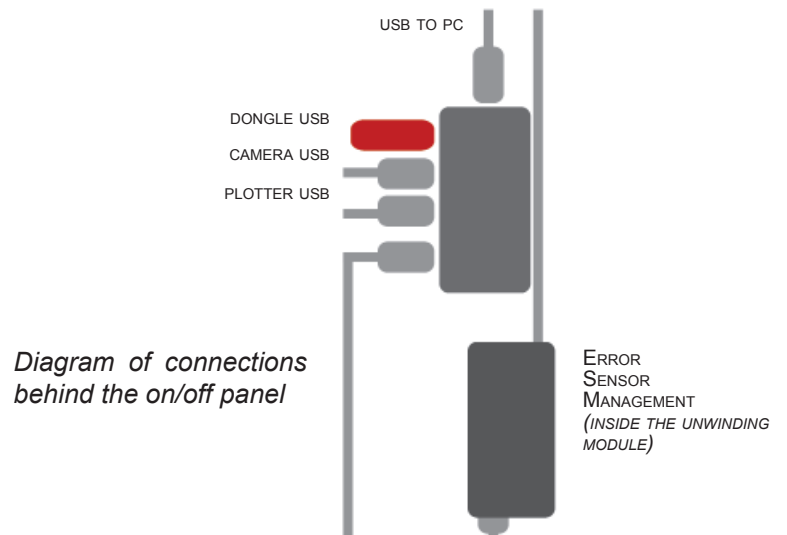
USB TO PC

DONGLE USB
CAMERA USB
PLOTTER USB

Diagram of connections behind the on/off panel

ERROR SENSOR MANAGEMENT
(*INSIDE THE UNWINDING MODULE*)

CUT FILE SPECIFICATIONS

Cut Files: Adobe Illustrator and/or Corel Draw (save as PDF file).
The artwork file within the cutting shape must include a registration square
black mark having a size of 4x4mm (0.16" x 0.16") or 2x2mm (0.08" x 0.08").

Only the cut lines and black mark (not needed for the blank labels) can be in the saved cut file. Graphics layers must be deleted or the cut line shapes must be copied in a new file and saved instead of hiding or disabling any extra content.
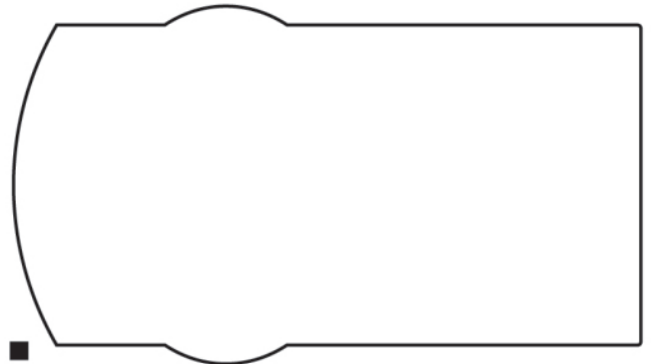
The cut lines do not require any special color or thickness.

The black mark MUST ALWAYS be placed in the lower left corner of the layout file.

IMPORTANT: The black mark must be the topmost object in the top layer of the layout file.

(to send an object to the topmost position within a layer, select the object and click Object > Arrange > Bring to Front)
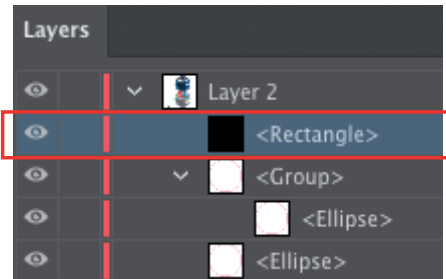
BLACK MARK POSITION IN THE CUT FILE AND PRINTED ARTWORK

Black mark size: 4mm x 4mm (0.16" x 0.16") or 2mm x 2mm (0.08" x 0.08"), no outline

black mark can overlap label on bottom

minimum distance from left side of label graphics 4mm (0.16")

for round or complex labels, the black mark can partially overlap the left side of label.

4mm is the minimum distance betwen black mark and label graphics on bottom side.
Black mark **MUST** be the leftmost object.

5

BLACK MARK POSITION IN THE MEDIA

distance of black mark from left edge:
min 10mm (0.39")
max 20mm (0.79")

distance of cut line from right edge:
min 10mm (0.39")
max 85mm (3.35")

label step

HOW TO DESIGN BLANK LABEL FILES

Blank mode

Blank labels mode ☐

Step (mm): 0
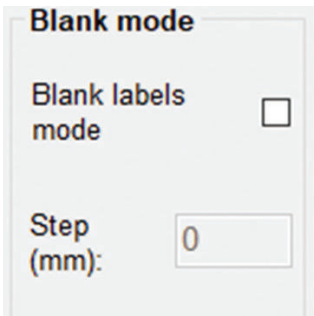
To use the "Blank Label Mode" feature to cut blank labels (without a registration mark), follow these steps:

1. Import the cut file (without a registration mark) into the software.

2. Select the "blank label" feature from the software and enter the number of copies that you wish to cut.

3. Click "Start".

Lower edge of file

1
2

1. Diecut shape
2. Size of file artboard
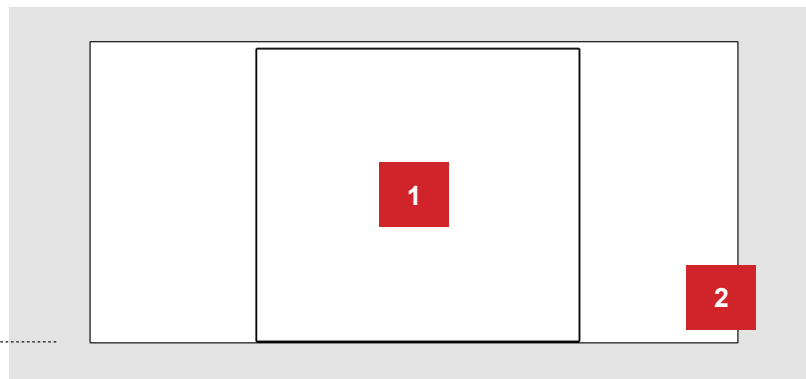
The diecut shape must be attached to the bottom edge of the file. The distance you leave will automatically be added to the gap that you will enter in the "STEP" box.

⚠ WARNING: Please note that enabling the blank label feature will disable both the cut test and Y offset adjustment.

MEDIA PATH

REWINDING MODULE

UNWINDING MODULE

WASTE MATRIX

LAMINATED ROLL

FINISHED ROLL
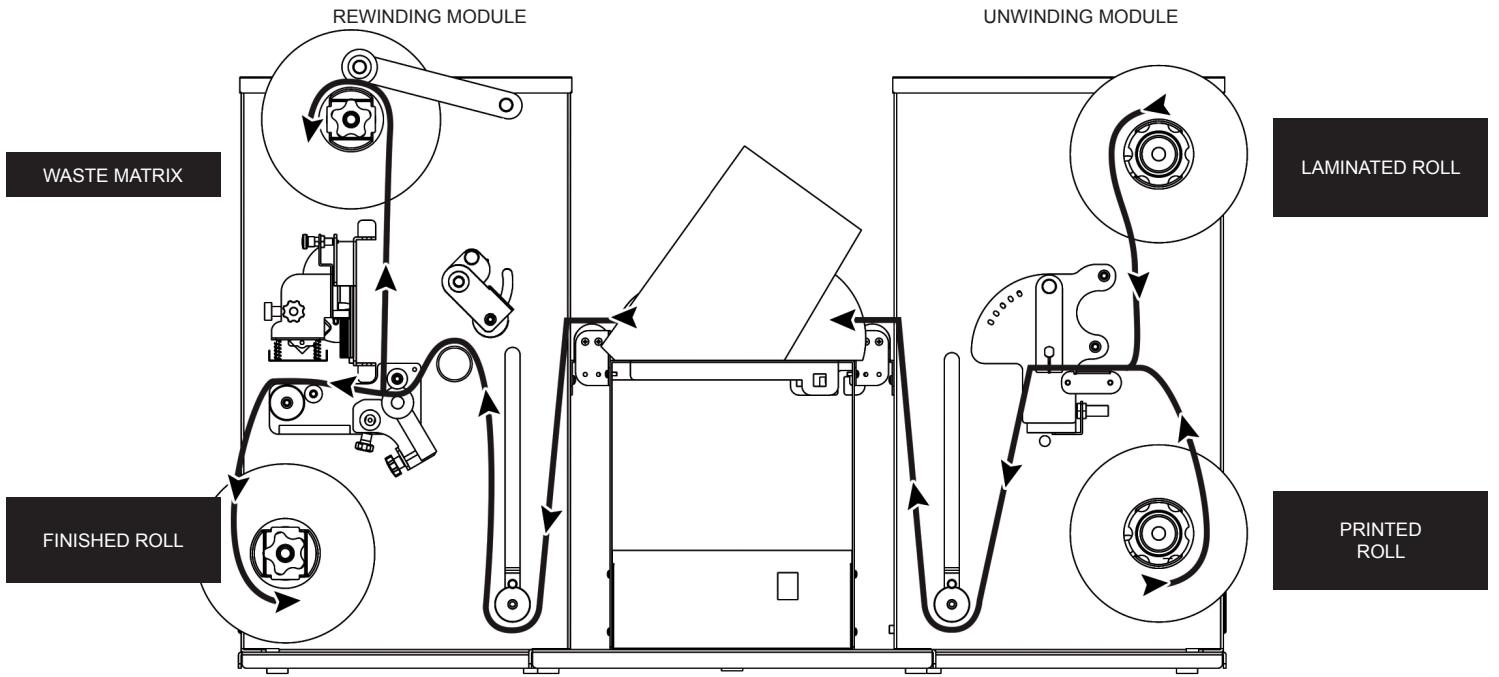
PRINTED
ROLL

HOW TO LOAD PRE-PRINTED STOCK AND LAMINATE

⚠️ **IMPORTANT:**
Cover the sensor with the blue cap if you are not using laminate.

Load the printed roll and move it against the roll guide.

Tighten the core holder.

Load the lamination roll, move it along the supply shaft to align it with the web.

IMPORTANT: the lamination roll always needs to be narrower than the web width. *Example: if the web width is 7" then the lamination roll needs to be less than 7" (let's say ¼ inch on each side).*

Until the laminate is attached to the stock, it is best to leave the core holder loose.

Insert the media into the coupling rollers.

Use the knob to adjust the pressure on the rollers in order for the laminating film to adhere to the media and avoid any possible air bubbles.

We typically suggest the second hole from the left, as shown in the picture.

Holding the laminating film with both hands, pull it underneath the guide roller, center it, and adhere the laminating film to the web. Attach the liner onto the cardboard takeup.

Check the alignment between the laminate and the stock; laminate should not be off the edge. Adjust the laminate roll position if needed.

Tighten the core holder when the laminate is properly aligned.

PLEASE REVIEW THE LAMINATION PATH ON PREVIOUS PAGE!

When the LEDs on the control board are off, the device works via manual feeding.

Move the media into the rollers and press the FORWARD button.

If you push the BACKWARD button, the rollers will roll the media backwards.

When the green LED is on, the automatic feeding is activated and operated by the ultrasonic sensor. When both yellow and green LEDs are on, it indicates the system is in error mode. This is normally due to the media or laminate roll being empty or not detected. If this is not the cause, please reset the sensor.

HOW TO SET THE LAMINATION AND MEDIA SENSORS

LAMINATE SENSOR

This operation has to be done without lamination in place.

Turn the screw on the sensor clockwise or counterclockwise.

If there is no lamination in place, the LED will be on.

If there is lamination in place, the LED will be off.

MEDIA SENSOR

Push the button on the sensor.

If there is no paper in place, the LED will be off.

If there is paper in place, the LED will be on.

HOW TO ADJUST THE CLUTCH

Both core holders (laminating and unwinding core holders) are clutched and can be adjusted independently.

Adjust the clutch by tightening or loosening the aluminium handle.

WHEN TO ADJUST THE CLUTCH

It is important to keep the media and laminating film under tension using the clutch adjustments. If the tension is too tight, the roller system may be damaged; if the tension is too loose, the media will not be laminated properly.

HOW TO LOAD THE LAMINATED MEDIA INTO THE PLOTTER
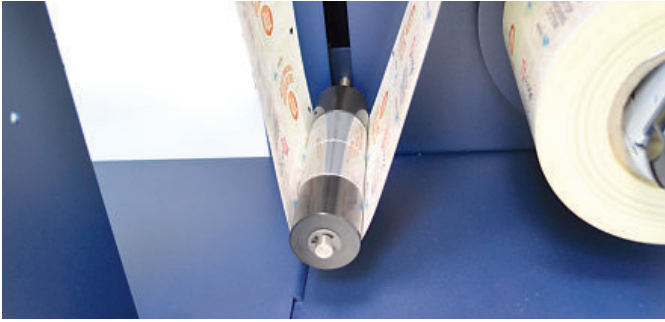
Pull the laminated media under the tension arm, then pass it between the aluminium rollers. The guide can be adjusted to prevent the media from shifting.
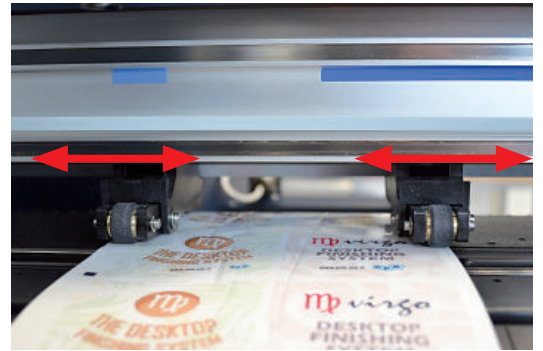
Press the handle on the rear of the plotter down.

Pull the media through the plotter, keeping the media edge in contact with the alignment points. Set both pinch rollers close to the media edge.

While holding the media in the aligned position with one hand, lift the handle on the rear of the plotter with the other to secure the media.

Press button 2 as requested on plotter's display.

HOW TO RUN THE CUT TEST AND START A JOB

>> *How to run the black mark mode*

Refer to page 16 for more information on the Cutter Management user interface.

1. Open DLF Cutting Manager.
2. Press "*OPEN PDF*" or "*OPEN LAST JOB*" to load the Cut File.
3. Look at the left window where the camera reading preview is shown, press "*FORWARD MEDIA*" arrow to move the web until the black mark goes in the center position of the blue rectangle area.
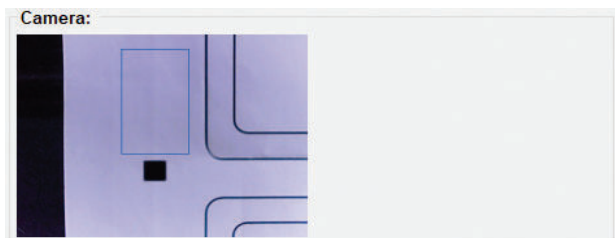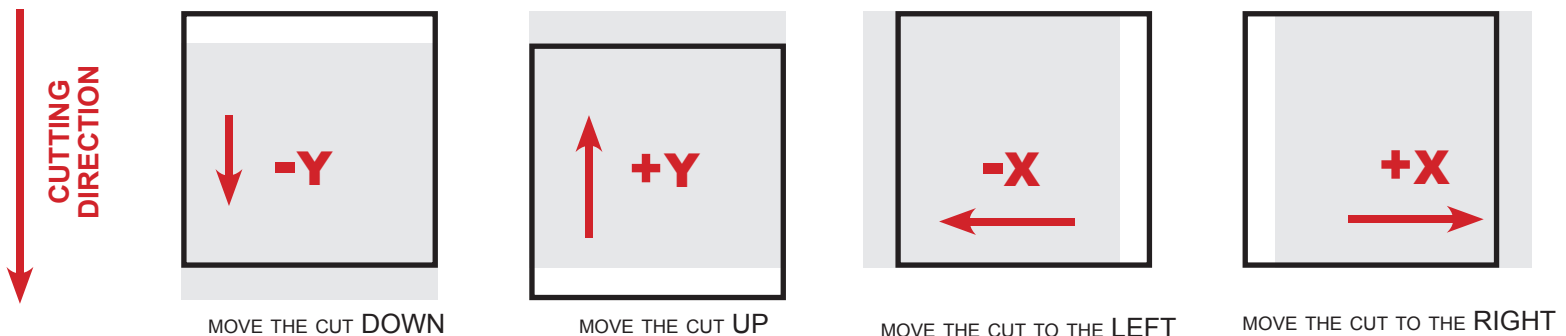

NO
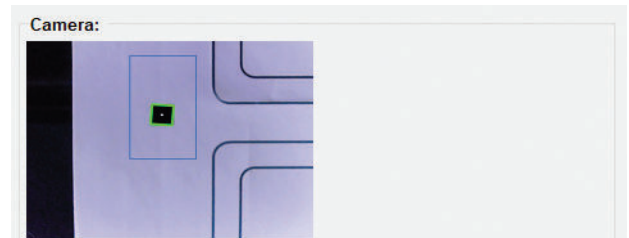
YES

4. In "*DISTANCE BETWEEN BLACK MARKS*" box, enter the distance from the top of one black mark to the top of the next.
5. Press "*CUT TEST*" to check for cut depth. If the liner has been cut, decrease the cutter pressure value in the cut force box. If label tears, increase the cutter pressure value in the cut force box.
6. Make sure label is aligned with the cut. **Through X and Y values in the software, adjust offsets if cut doesn't match label.**

CUTTING DIRECTION

-Y — MOVE THE CUT DOWN

+Y — MOVE THE CUT UP

-X — MOVE THE CUT TO THE LEFT

+X — MOVE THE CUT TO THE RIGHT

7. Once the cut settings are properly set, select "*COPY MODE*" **ON** if you desire a preset quantity of copies or **OFF** if to cut until the media roll is empty.
8. Set the black mark size" in "*BLACK MARK MODE*" area.
9. Press "*START*".

IMPORTANT:
Whenever you lift and lower the lever while you are in black mark mode, wait until the plotter head has moved to the right.

>> *How to run in blank mode*

1. Press "*OPEN PDF*" or "*OPEN LAST JOB*" to load the cut file.
2. Set the copy mode **ON**, and set 2 as number of copies.
3. Click "*START*".
4. Check the horizontal position and the gap between the cuts.
5. If necessary, adjust the offset X and the distance between each cut in the "*STEP*" box.
6. Once the cut is set properly, select copy mode: ON if you desire a preset quantity of copies, or OFF to cut until the media roll is empty.
7. Click "START".

## HOW TO LOAD THE MATRIX REMOVER CORE HOLDER

> ⚠ **WARNING:** Before starting a job, always remove any waste media from the matrix takeup core.
>
> Adhere the waste matrix uniformly on the cardboard core.
>
> **System operating issues may occur if the above suggestions are not followed.**

1. Load empty cardboard core(s) and tighten the core holder, then place the motorized core holder in position
2. Peel back the matrix
3. Pull the matrix and attach it to the matrix remover core holder
4. Pull down the waste press and relocate the o-rings to be over the waste matrix
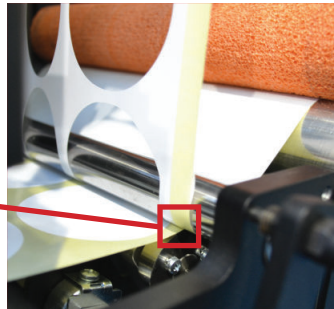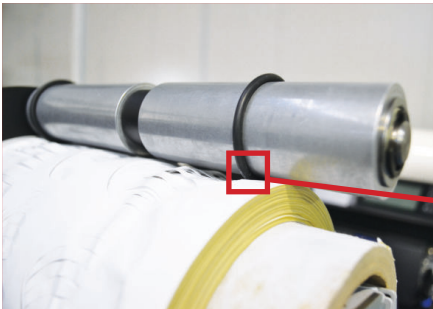

5. Close the sponge roller

HOW TO LOAD THE REWINDER CORE HOLDER AND SET THE SLITTER MODULE

1. Load empty cardboard core(s) and tighten the core holder, then place the motorized core holder in position.

    Cardboard core(s) should not be wider than the width of the finished roll

2. Pull the media through the aluminium rollers and attach the labels to the core using a waste label.
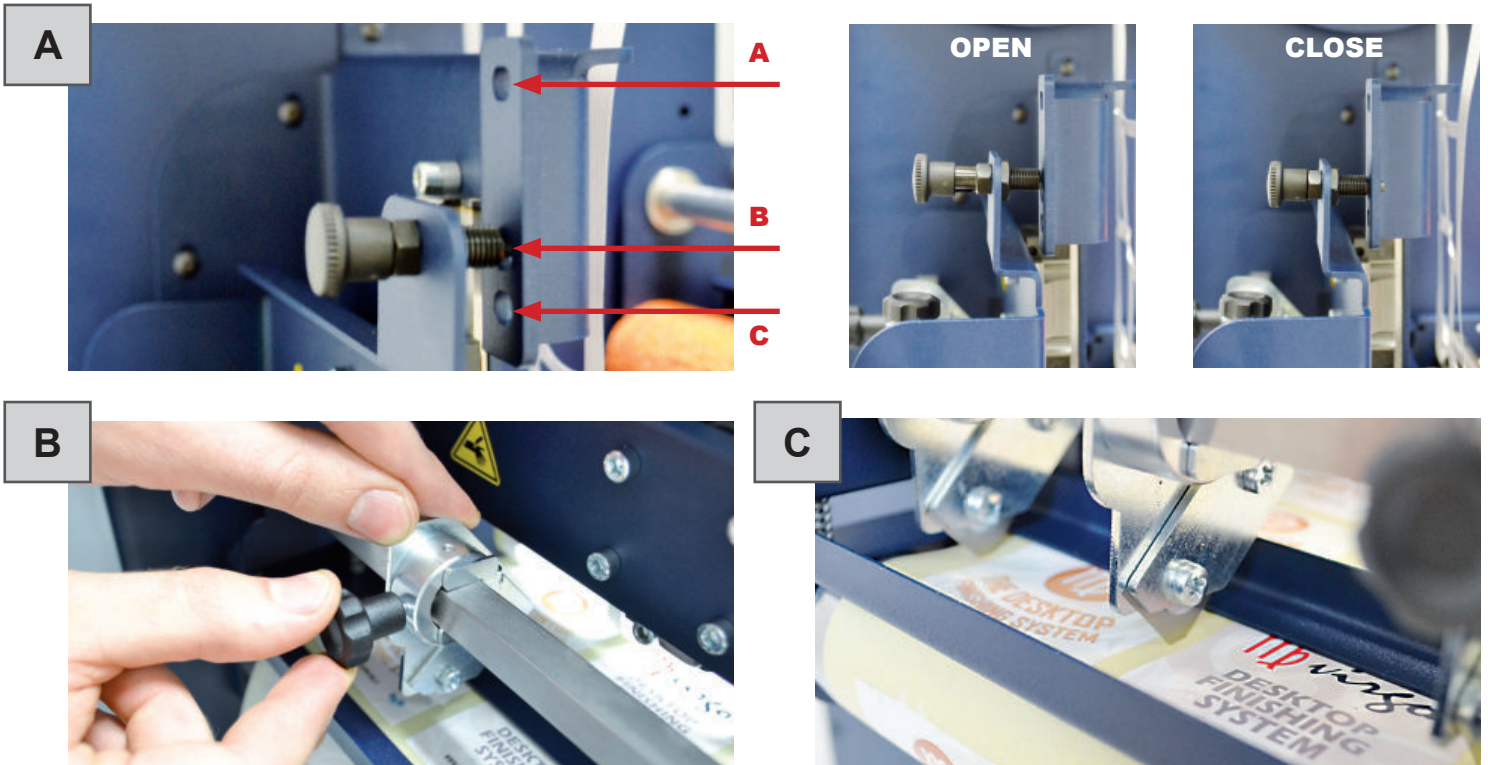
Slitter module has 3 positions:

1. Upper position (A), the blades are lifted to allow the media loading.

2. Middle position (B), align the blades with the edges and the center of the labels, tighten the thumb screw once the blade is in position.

3. Lower position (C), the blade(s) are lowered to cut through the media.

1. Turn ON the Matrix Remover module to rewind and start to slit the media, then turn OFF.

2. Cut the labels at the same point where the first "good" labels are visible.

3. Make sure the tension on all rolls is even, and attach each label to the core using a waste label or tape.

4. Turn the Matrix Remover module ON.

5. Press Resume to continue.

HOW TO ADD OR REMOVE A BLADE HOLDER

1

Remove the iron bar by unscrewing the black thumb screw.
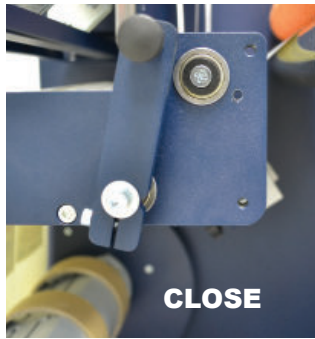
2

Slide the blade holder on or off.
Replace the slide iron bar and rescrew the thumb screw.
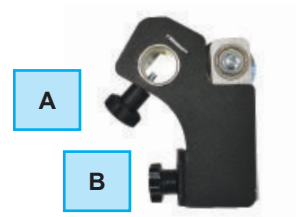
MEDIA GUIDE ALIGNMENT

Media guides should be adjusted in order to prevent the web from shifting position.

HOW TO USE THE BACKSLITTER

OPEN   CLOSE

Use the backslitter to remove unwanted waste from the edge of the roll.

A

B

A = Knob used to secure the position after choosing desired width.

B = Knob to increase or decrease the cutting force

Tighten knob "A" to secure the position after choosing desired width.

Use knob "B" to increase or decrease the cutting force on the support.

Clockwise = Increases the cutting force

Counterclockwise = Decreases the cutting force

If done correctly, you should achieve the results displayed in the photos.

NOTE:
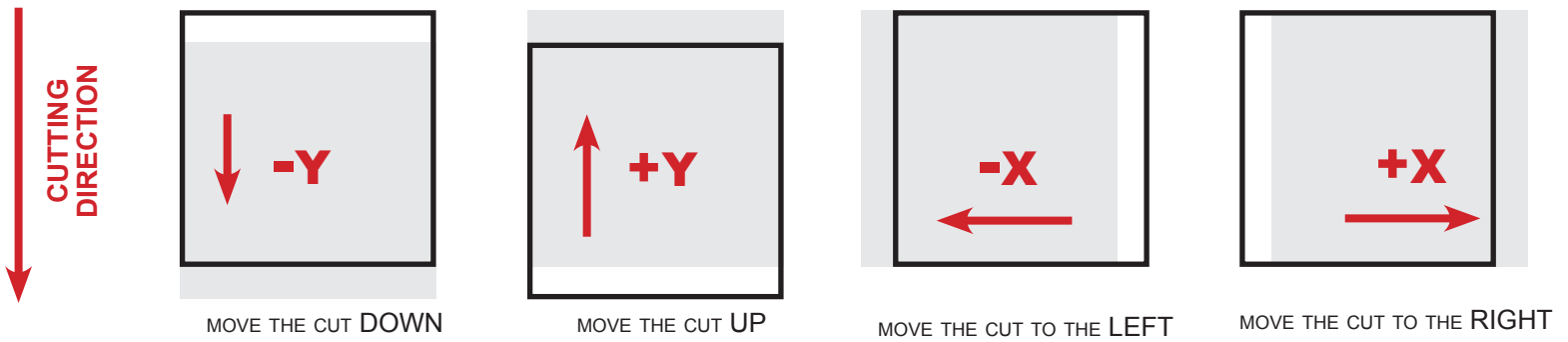The cutting force of these blades are already calibrated for standard use.

DLF Cutting Manager

Annotations on next page

Virgo - Digital Finishing System

Advanced ▾ **20**

PDF preview:

1

Camera:

13

12

11 Offset Y 0 mm

11 Offset X 0 mm

+ ↑ ↓ -

Blank mode

18 ☐ Blank labels mode

19 0 Step (mm):

Blackmark mode

16

17

Distance between blackmarks (mm):

Blackmark 2mm ☐

Blackmark 4mm ☑

Copy mode

14 On/Off ☐

Copies:

15 1

0 of

← Backward media → Forward media **8**

9 Cutting force

10 Cutting speed (mm/s)

Open PDF **2**

Open last job **3**

Job completed **4**

Start **5**

Pause **6**

Cut test **7**

16

1. Cut File preview

2. Open and load Cut File

3. Open and load the previous Cut File used

4. Status bar

5. Start/stop the cutting process (in black mark mode, a Cut Test must be run first)

6. Pause/resume the cutting process

7. Run one cut at time to check the values set (feature available in black mark mode only)

8. Arrow buttons to move the media forward or backward

9. Set the cut force

10. Set the cutting speed

11. Offset adjustments

CUTTING DIRECTION

-Y

MOVE THE CUT DOWN

+Y

MOVE THE CUT UP

-X

MOVE THE CUT TO THE LEFT

+X

MOVE THE CUT TO THE RIGHT

12. Camera preview

13. Screenshot of the previous black mark

14. Turn Copy quantity on or off

15. Number of labels to cut (Copy mode must be On)

16. Set the black mark top-to-top distance

17. Set black mark size

18. Enable blank media cutting (no black mark printed)

19. Set the gap between labels during blank media cutting

20. Advanced options (see next page)

ADVANCED OPTIONS
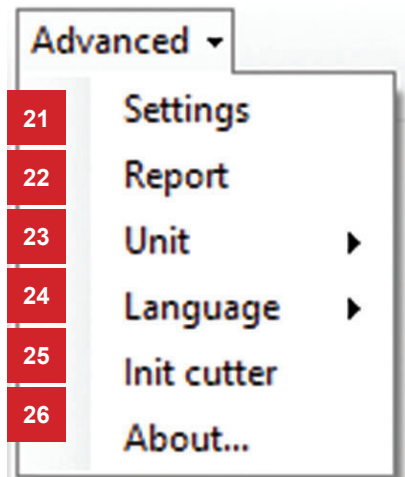
21. Settings

22. Report

23. Set unit (mm or inch)

24. Set the language interface

25. Restore of plotter settings

**26.** Shows the software version

Settings (21)
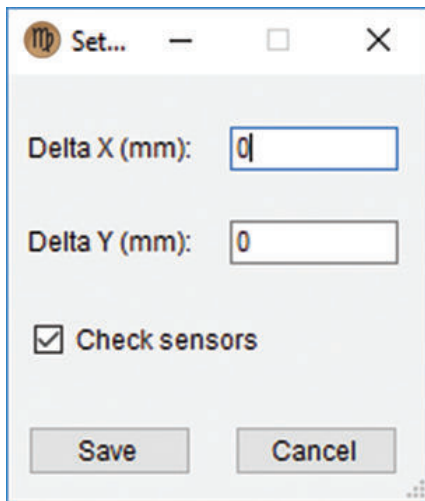
Delta X and Y show the predefined offset adjustment.

After each cut, the Delta X and Y will save the sum of the predefined offset and values set by the user.

Media/Lamination Sensors feature allows the user to activate or deactivate the sensor used for monitoring the presence of material.

Whenever you make changes to the settings, press save to set the new values.

Report (22)
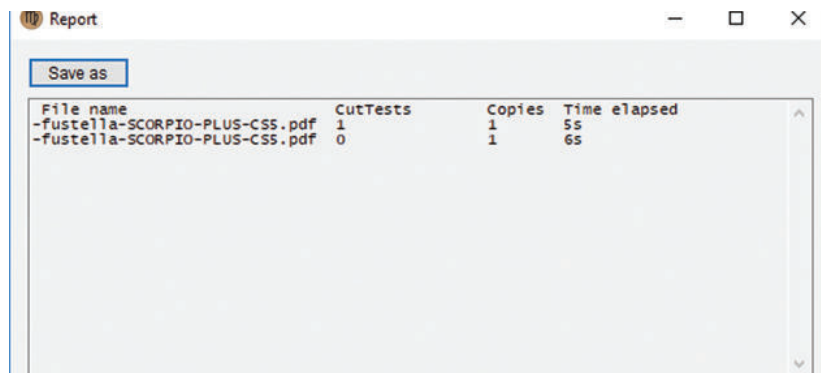
Report will display the cuts run by the Cutting Manager system.

Each session report is automatically added and saved into the history report when the Cutting Manager is closed.

Tthe complete report history file of all the jobs run since cutting manger has been installed is located in the directory "*YourDocumentsFolder/ DLF Cutting manager/CutHistory.txt*".

To save the file to a different location, click "*SAVE AS*" and browse to the location you want.

18

ERROR MESSAGGES

If the plotter is not correctly connected to the computer, the following errors will be displayed at application launch:
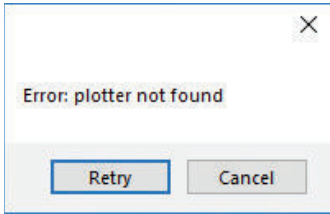
Make sure the plotter is switched on and properly connected.
In case it is turned off, turn the plotter on and then press the button 2 on the control panel. Wait until the display shows "READY" as its status. Then, press retry on the popup window.
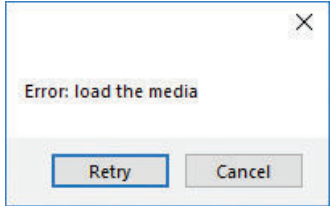
Ensure the media is loaded properly. Raise the lever on the plotter, then press the number 2 on control panel. Wait until the display shows "READY" as its status. Then, press retry on the popup window.

BLACK MARK DETECTION

It is important that the camera is reading the black mark properly.

Press the ARROW buttons to move the media until the black mark is in the center position of the blue rectangle. If necessary, slide the camera to left or to right in order to get the black mark centered as much as possible.
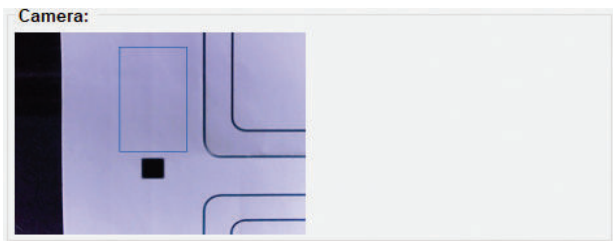
WRONG POSITION

CORRECT POSITION

HOW TO UPDATE SOFTWARE

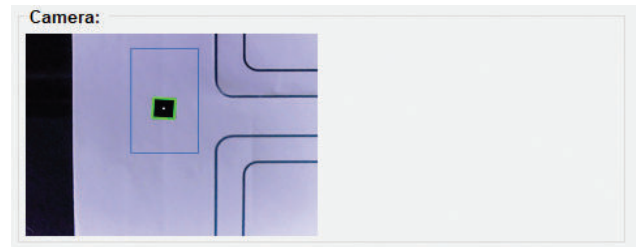*1.* Go to the Windows Control Panel.
2. Uninstall DLF Cutting Manager.
3. Download the new Cutting Manager release from the website and run the installation.

HOW TO RESTORE PLOTTER SETTINGS

1. Turn off the plotter.
2. Turn on the plotter while pushing the UP arrow on the panel.
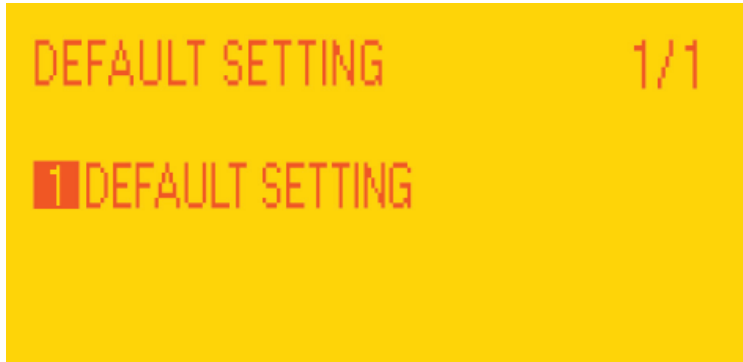
3. Wait until the display shows "DEFAULT SETTING".
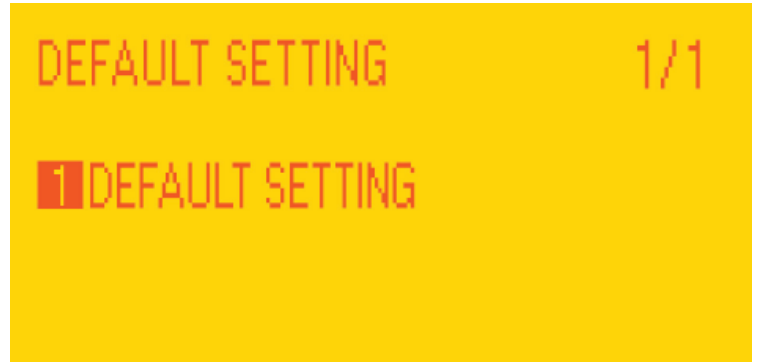
4. Press button 1.

5. Press button 1.

6. In process.

7. When the display shows "SET DEFAULT COMPLETE" turn off the plotter.

8. Turn on the plotter and Choose the language and press enter.

LENGTH UNIT

1 METRIC
2 INCH

9. Select metric by pressing button 1 and then enter.

SELECT
1 ROLL-1 FRONT EDGE
2 ROLL-2 CURRENT POSITION
3 SHEET

10. Press button 2.

1: Condition no. 1
CB09U+0 S30 F14 A2
READY

MA NUL

1 VIEW

11. Wait until on the display appears "READY".
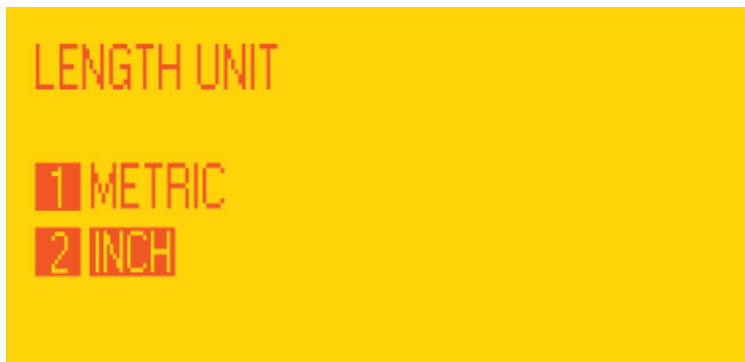
1 TOOL **2** ARMS **3** AREA **4** MEDIA
▲ I/F ▼ ADV. ◄ TEST
CUTTING
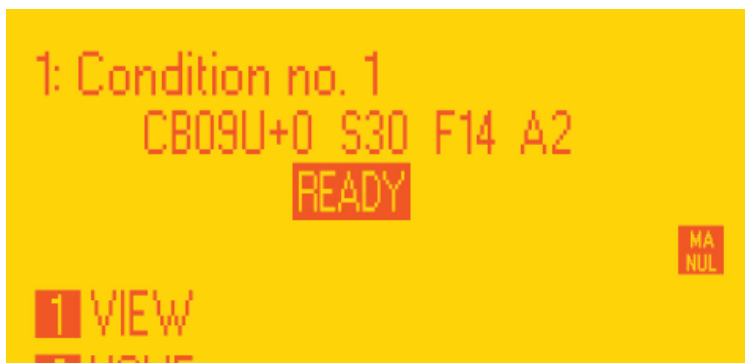
12. Press "PAUSE/MENU" button.

▲
1 TOOL UP/DOWN
2 STEP PASS
3 OFFSET FORCE
4 OFFSET ANGLE
▼

13. Go to page 2 by using the arrows on plotter's panel.

◄ TOOLS SETTING   2/3
▲
1 DATA SORTING
2 TOOL UP SPEED
3 CONDITION PRIORITY

14. Press button 1.

DATA SORTING

1 ON
2 OFF
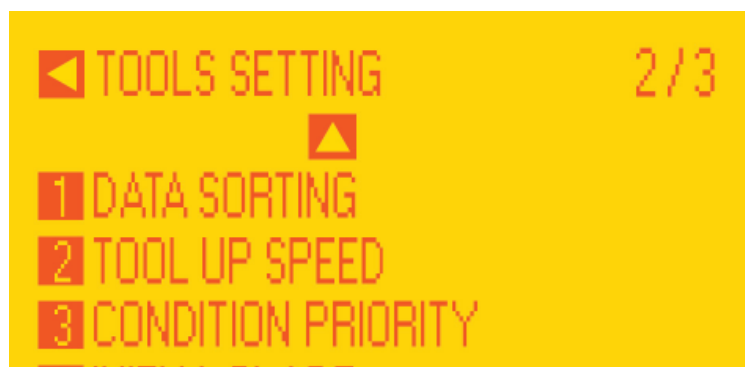
15. Press button 1, then Enter.

SELECT
1 ROLL-1 FRONT EDGE
2 ROLL-2 CURRENT POSITION
3 SHEET

16. Restart the plotter and press button 2.

17. Wait until on the display appears "READY".
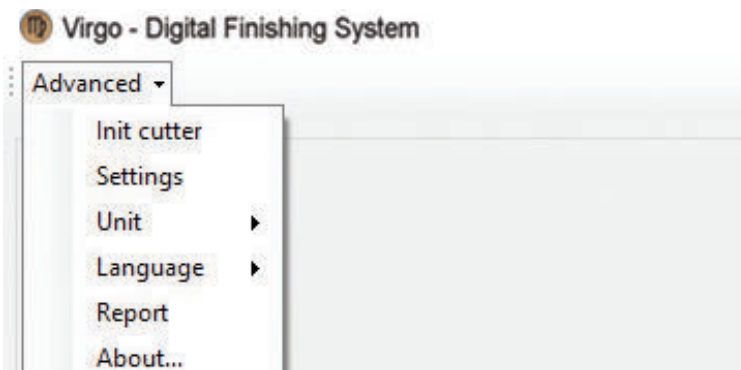
18. Open the Cutting manager and click on "Advanced" and then select "Init cutter".

19. Wait until "Init cutter completed" is shown in the status bar. Plotter display will show "LABEL MEDIA" as status.

WHEN AND HOW TO REDUCE THE PLOTTER SPEED

When cutting labels longer than 250mm (or 10"), it is recommend to decrease the cutting speed. The amount of reduction depends on the job in process.

The cutting speed can be set within the range of 10 to 600.

MEDIA PATH

REWINDING MODULE

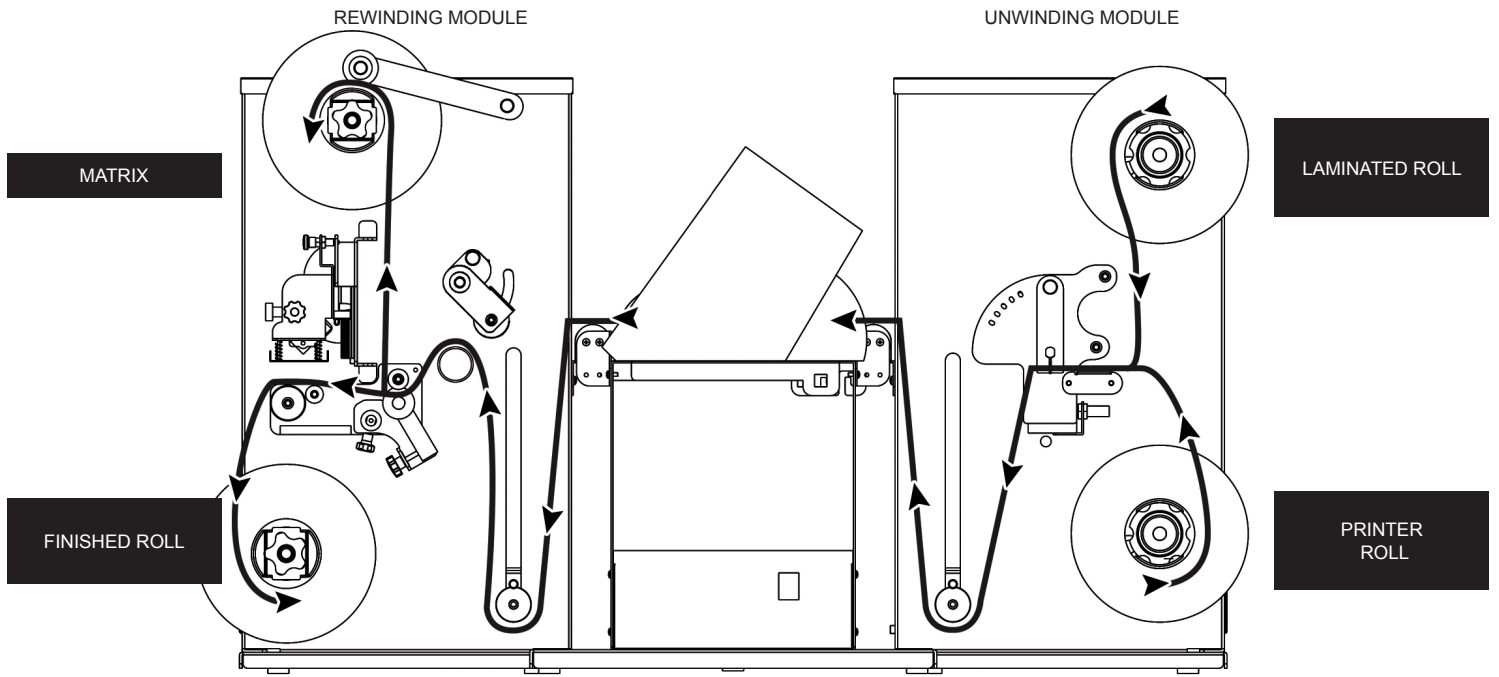UNWINDING MODULE

MATRIX

LAMINATED ROLL

FINISHED ROLL

PRINTER ROLL

ULTRASONIC SENSOR CALIBRATION

> ⚠️ **WARNING:** Before proceeding with the ultrasonic sensor calibration, turn the module that needs to be calibrated "OFF" (laminating or matrix removing).

1. Insert a paper clip into the little hole located next to the OFF-ON switch and push it down for 5 seconds. The yellow LED will light up.

2. Raise the tension arm. The yellow LED will stay on.

3. Once again, insert the paper clip down into the hole for 5 seconds. The LED will turn off.

Ultrasonic sensor calibration is complete.

LAMINATION MODULE

ULTRASONIC TENSION CONTROLLER
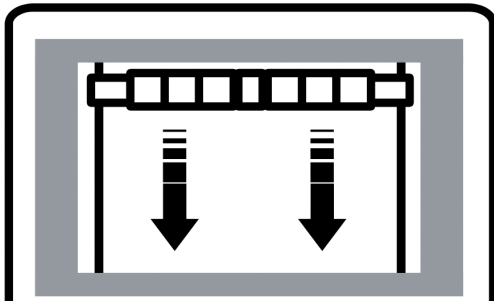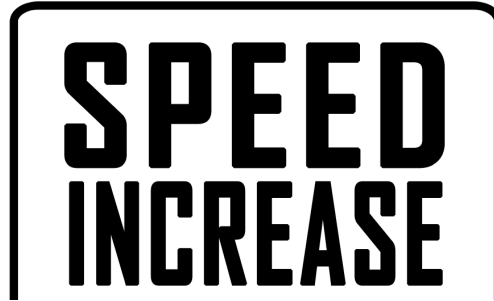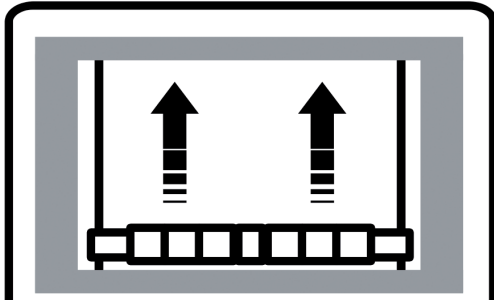
MATRIX REMOVER & SLITTER MODULE

ULTRASONIC TENSION CONTROLLER

WARNING: If what is happening is not as shown above, press and hold the button on circuit board untill the yellow LED flashes. After it flashes 5 times, release the button and perform a new test.

Cutter Plunger

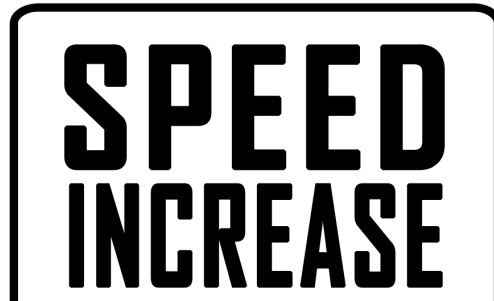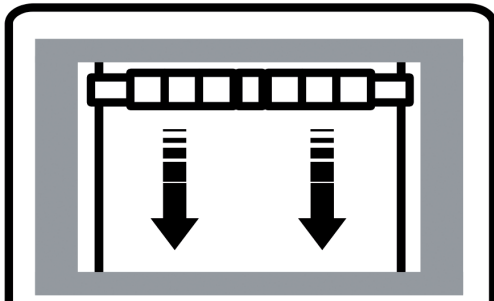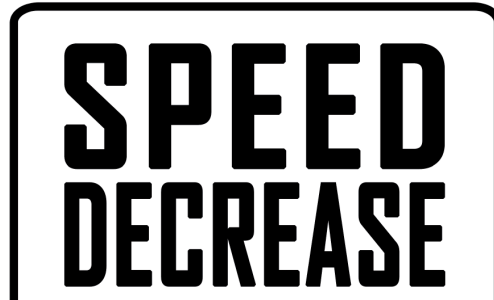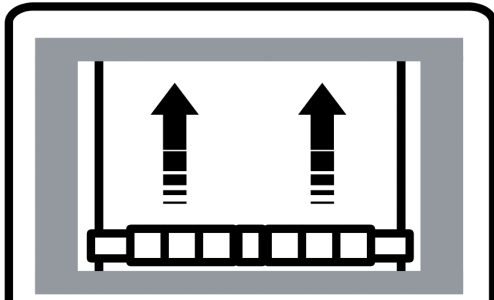The plotter cuts using a cutter blade mounted in a plunger. There are two different plungers to suit the diameter of the cutter blade to be mounted (the 0.9 mm cutter plunger is provided as a standard accessory). Be sure to mount the cutter blade in the corresponding cutter plunger.

Plunger-cap

Cutter blade   Plunger   Blade-length adjustment knob

Blade-length adjustment knob

Plunger

0.9 mm diameter cutter blade

Plunger-cap (blue)

Hole
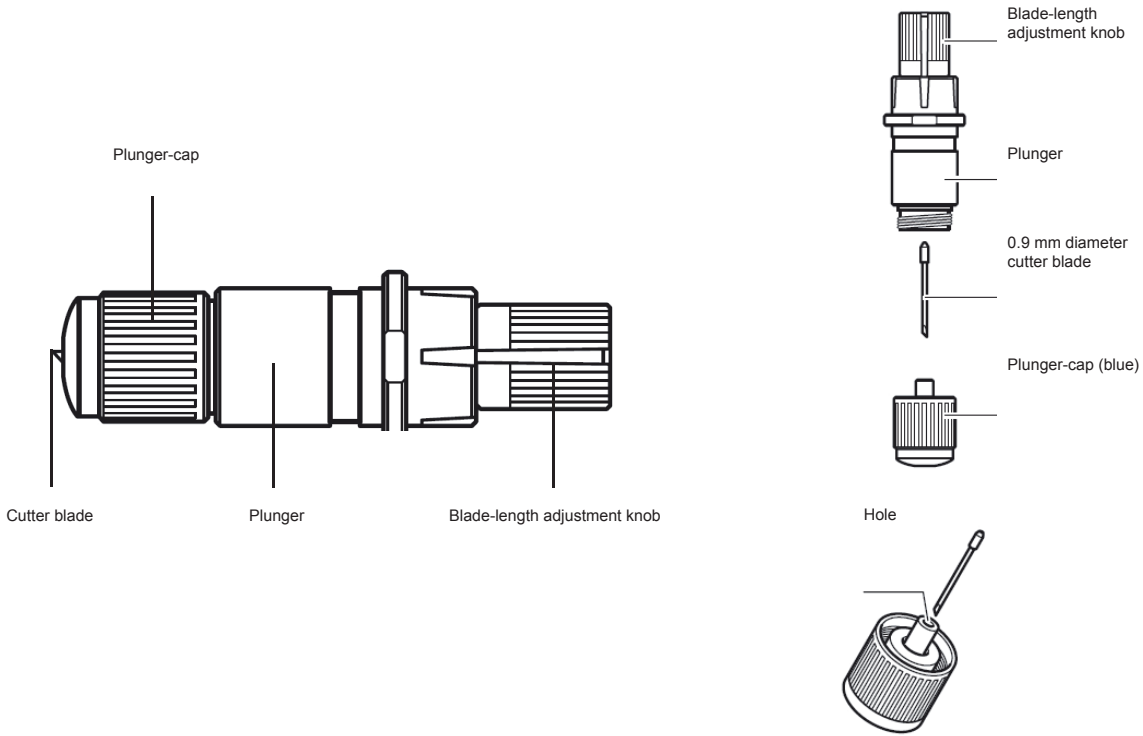
CAUTION:
To avoid bodily injury, handle cutter blades with care.

WARNING: Damage to the cutter blade or the cutting mat may occur if the blade is extended too far. The exposed blade length should be set to less than the thickness of the media.

Adjust the blade length by turning the blade-length adjustment knob. Turn the knob in direction "A" to extend the blade, or in direction "B" to retract the blade. When the knob is turned by one scale unit, the blade moves approximately 0.1 mm. One full rotation of the knob moves the blade approximately 0.5 mm.

Cutter blade moves approximately 0.1 mm turning one scale unit

B   A

Scale

Scale
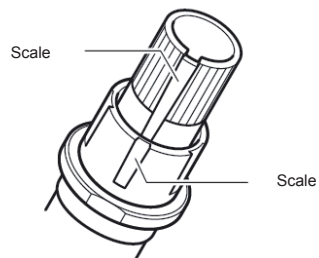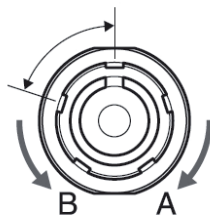
Mounting the tool

1. Loosen the tool holder screw.

Bracket to hold tool   Tool holder

Tool holder

Bracket to hold tool

TOP
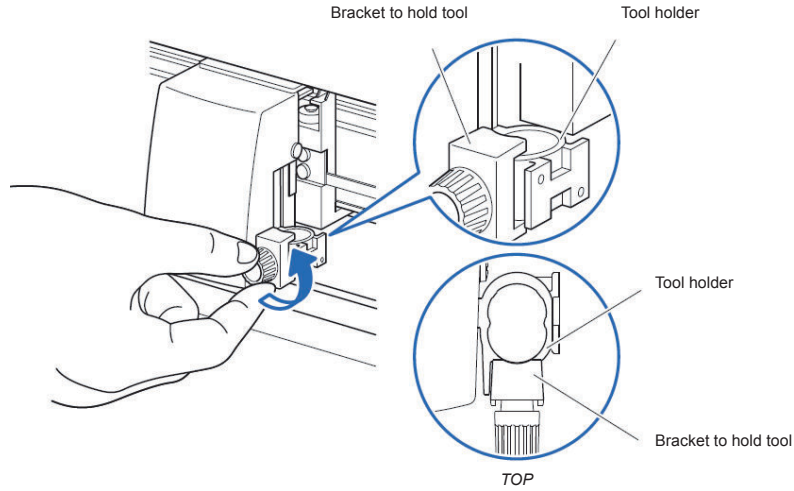
2. Push the tool holder up until its flange completely touches the upper part of the holder.

Bracket to hold tool   Tool holder

Flange

○ OK   ✕ NG

Tool holder 1
(Backward: Half cutting/
Plotting Pen)

Tool holder 2
(Forward: Using cutting)
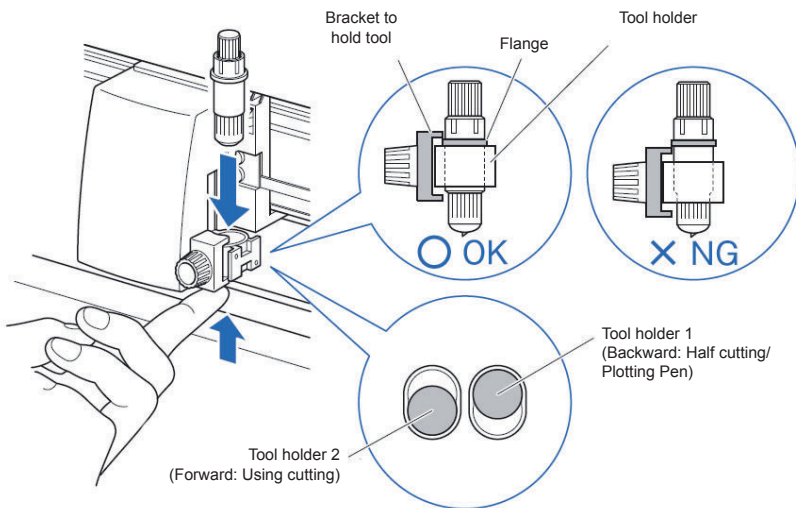
SUPPLEMENT:
When using with half cutting and plotter pen, set the seal in Tool Holder 1 (backward), and when using cutting out (perforated cut), set the seal in Tool Holder 2 (forward).

3. Make sure that the tool bracket is engaged on the tool's flange, then tighten the screw.

Bracket to hold tool   Flange
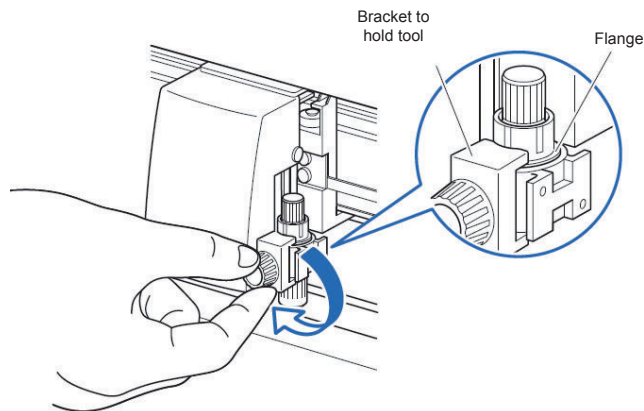
Removing the tool

Turn the tool counterclockwise for removal.

HOW TO REPLACE THE KNIFE

See page 24 for the structure of the cutter plunger.

1. Turn the blade-length adjustment knob in the direction of the B arrow and pull the blade into the plunger.

Cutter blade moves approximately 0.1 mm turning one scale unit

Scale

B   A

Scale
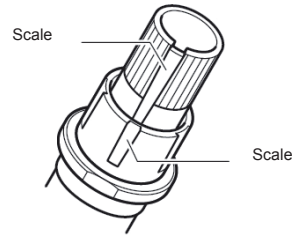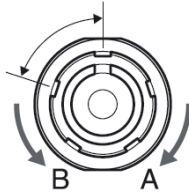
2. Turn the plunger cap in the counterclockwise direction to remove it from the plunger.
3. Remove the blade from inside the plunger cap.
4. Remove a new blade from its pack. Insert the new blade into the hole provided in the plunger cap.
5. With the blade inserted into the plunger cap, screw on the plunger from above.
6. Fix the plunger cap by turning it clockwise.

⚠️ ATTENTION: *In order to preserve the lifespan of the plotter knife and not to wear it out quickly, make sure to properly calibrate the knife exposure and cut force depending on the media thickness.*

HOW TO REPLACE THE SLITTER BLADE
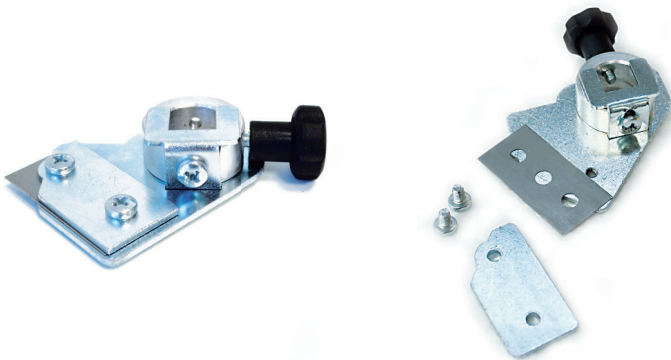
Remove the two screws holding the blade in place.

Replace the blade.

Replace the two screws holding the blade in place.

HOW TO REPLACE THE CUTTING MAT

<div style="border: yellow box">

CAUTION:
Turn off the power when replacing the cutting mat.

</div>

1. Remove the cutting mat.

- The cutting mat is attached to the cutting base (fig.2)
- Remove only the cutting mat from the cutting mat base as shown

Fig.1 — CE6000 Main, Tool Carriage, A
Fig.2 — Cutting Mat, Cutting Mat Base
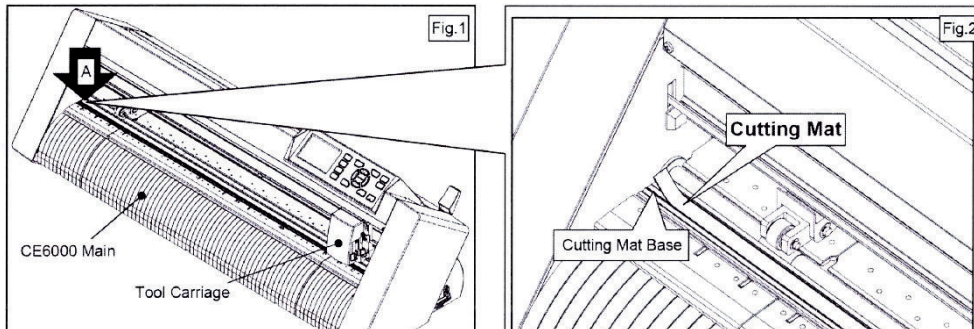
- After removing the cutting mat, please make sure that there is no adhesive tape or other residue left on the cutting base.
- Clean the cutting mat base before installing the new cutting mat. Installing the new cutting mat with the remaining adhesive may affect cut quality.

2. Installing the cutting mat.

- Fit the cutting mat with the front cutting base grooves (fig.3) and attach it to the location shown by the arrow (A) (fig.1) while peeling off the release paper.

Fig.3 — Front, Back, Cutting Mat, Cutting Mat Base
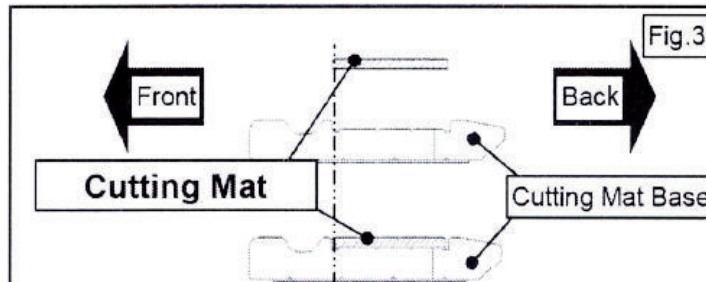
IF YOU ARE EXPERIENCING THE FOLLOWING ISSUES WITH THE ANY OF OUR DLF UNITS, PLEASE FOLLOW TROUBLESHOOTING STEPS BELOW

Yellow and Green LEDs are simultaneously illuminated on the lamination control board (Applies to all DLF models)

Problem: Yellow and Green LEDs are simultaneously illuminated on the lamination control board. This will also create the following error:

Cause: All DLF Digital Finishing Systems are equipped with two reflective sensors on the lamination module. One is the media sensor, located right after the first two guide rollers, and the other is the lamination sensor, mounted between the two black knobs on the rubber roller assembly.

When both of the LEDs on the lamination control panel are on, it means one or both of the sensors have picked up an error. Either the media or lamination roll has run out, or the sensors may be out of sync and need to be re-calibrated.
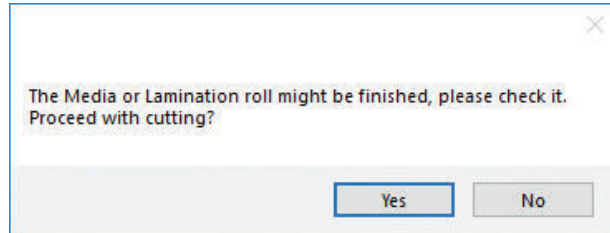
The following steps below to determine when each sensor is in error mode and how to correct it, or help you re-calibrate each sensor, if needed.

Media Sensor

The media sensor is used to detect the presence of the media. The LED on this sensor should always be **ON** after the media has been loaded properly through all the guides; this would also indicate that the sensor is in good working condition.

Things to remember about this sensor:
• If the LED on this sensor is OFF after the media roll has been loaded and both the yellow and green LEDs on the control panel are on, it could indicate that media has run out and needs to be changed.
• If, after loading the media through the guides, the LED is still **OFF or BLINKING** with the yellow and green LEDs on the control panel being on, it would indicate that the sensor is out of sync and needs to be re-calibrated.

Recalibrating the Media Sensor:
*(**NOTE** This operation has to be done while the media is loaded)*
1. Hold down the calibration button located on the media sensor until the LED flashes off then on. The result should be a solid LED on the sensor.

Lamination Sensor

The lamination sensor is used to detect the presence of lamination material. The LED on this sensor should always be OFF after the lamination roll has been loaded properly; it would also indicate that the sensor is in good working condition.
(*NOTE* This sensor should always be covered with the included blue cap if you are NOT using lamination on your media.)

Things to remember about this sensor:
• If the LED on this sensor is **ON** after the lamination roll has been loaded with both the yellow and green LEDs on the control panel being on, it could indicate that lamination roll has run out and would needs to be changed.
• If the LED is still **ON** after loading the lamination roll with both the yellow and green LEDs on the control panel being on, it would indicate that the sensor is out of sync and needs to be re-calibrated.

Re-calibrating Lamination Sensor:
(**NOTE**This operation has to be done with the lamination roll in place)

1. Locate the small screw on the lamination sensor.
2. Turn the screw on the sensor either clockwise or counter clockwise just until the LED on the sensor turns off.

If calibrated properly, the LED should stay OFF when the lamination roll is detected and turn ON when lamination roll has run out.

Media not aligned properly

Problem: If the media is not aligned properly after running a couple of jobs.

Cause: This problem can occur for a few reasons:
• The media was wound unevenly before loading, creating an uneven roll
• The tension force on the on the rubber roller assembly is uneven
• The clutch tension on the media or laminate roll is not set correctly
• The laminate (if using) is out of alignment with the media
• The top-to-top distance between black marks (label step) is not set correctly

Fix: Check to see if you have a flat and even media roll before you begin installation. An uneven media roll can cause inconsistent alignment.

If the roll is okay, adjust the tension force on the lamination module. Turn the two black knobs at the top the rubber roller assembly to adjust the tension force until you receive satisfactory results.

You may also need to adjust the clutch tension on both of the lamination cores *(if using lamination)* and the material core using the aluminum handles. Adjust the tension force at all three locations accordingly until the media stays aligned.

Verify the laminate is aligned with the media.

Double check the top-to-top distance between black marks (label step).

Plotter error "E01017 Hardware X Position Alarm - Power off then on"

Problem: The plotter displays an error _"E01017 Hardware X Position Alarm Power off then on"._

Cause: The plotter will give you this error after starting a job in _DLF CM_ if the tensioner arm was not set up to begin with, or if the tensioner arm was positioned too high after turning on the lamination module.

(**NOTE** To set the tensioner arm properly, the arm must always be at a midpoint position or lower before turning on the lamination module).

Fix:
1. To set-up the tensioner arm, first turn off lamination module.
   (**NOTE** The lamination module must be off for the next steps to work)

2. Use the arrow buttons at the top of the control panel to manually feed the media forward until the arm descends to the **midpoint or lower**.
3. Once the tensioner is in the correct position, turn the lamination module ON.
   (If done successfully, the tensioner arm will automatically re-adjust itself, thus activating the unwinder motor).
4. Restart Cutting Manager software

Plotter is not cutting or is cutting all the way through the material

Problem: After starting a job, you notice that the plotter is not producing a clean cut through the media or the plotter is cutting all the way through the media.

Cause: Cut force or blade exposure may be set too low if it's not producing a clean cut, or if it's cutting all the way through the media, cut force or blade exposure could be set too high.

Fix: If the plotter is not cutting through the media, increase the cut force in the Cutter Manament software, or increase the blade exposure until the cut is successful.

NOTE: Too much blade exposure can create other problems, such as cutting through the liner and damaging the cutting mat.

If the plotter is cutting through the media, decrease both the blade exposure and cut force to factory settings until you get a clean cut. Increase either the cut force or the blade exposure until a clean cut occurs.

**NOTE** You can continue to increase the blade exposure if necessary. Do not simultaneously increase the cut force or you risk damaging the cutting mat below the media.

It is always best to increase one setting at a time; never increase both cut force and blade exposure simultaneously.

## Plotter error "E01019 Hardware Y Position Alarm Power off then on"

Problem: The plotter displays an error *"E01019 Hardware Y Position Alarm Power off then on"*.

Cause: The blade tray was moved from side to side by the user after loading the media onto the plotter and with the rear plotter lever in the up position.

Fix: To fix this error, power-cycle the plotter. Wait for the display on the plotter to load, then press the number 2, as instructed on the plotter to complete the setup.

Plotter error "E05004 Error Realign Rollers"
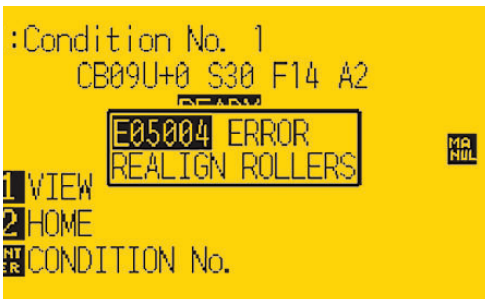
Problem: The plotter displays an error *"E05004 Error Realign Rollers"*

Cause: The pinch rollers are not aligned properly with the plotter's grips.

Fix: Before feeding the material through the plotter (While the rear lever is in the down position) be sure that the pinch rollers are aligned properly with the plotter's grips.

Plotter error "E03001 Error 1 instruction not recognized"
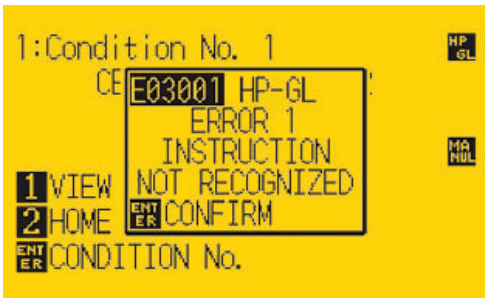
Problem: The plotter displays an error *"E03001 Error 1 instruction not recognized"*

Fix: Turn the plotter off and close the Cutting Manager. Restart the plotter, then press the button 2 on control panel and wait until the display shows "READY" as its status. Restart the Cutting Manager software

If the plotter does not execute any command requested by Cutting Manager for more than 30 seconds, check that the camera is working correctly. To do this, put something under the lens and verify it is shown in the on-screen Camera preview.

If the camera is not working, unplug the camera usb cable, plug it back in, and restart both the plotter and the Cutting Manager.

If the camera is working but the plotter doesn't execute any cut, refer to "<u>ERROR 1 instruction not recognized</u>". Repeat the above fix instructions.

Cutting Manager error "Black mark not found"
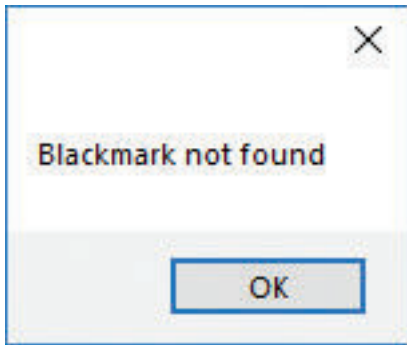
**Problem:** After starting a job in *DLF CM*, you get the error *"Black mark not found"*.

Cause: The software can't detect the black mark on the media. The reason for this could be:

- The media is missing a mark
- The media is not aligned with the load guides labeled on the front and back of the plotter
- The wrong size mark is selected in the Cutter Management software
- The plotter's camera is not positioned correctly
- The plotter's camera is picking up too much exposure from sunlight or another light source

Fix: Before you start any job in the Cutter Management software, be sure to always do the following:

- Check that the media has a black mark printed on it to begin with
- Manually align the media with the load guides, labeled on the front and back of the plotter *(this is done with the plotter's rear handle in the down position)*
- Check that the selected mark size matches that in the printed labels
- Position the plotter's camera over the black mark in order to center the mark as much as possible on the software camera preview
- Remove any interfering light source

## *The Media or Lamination roll might be finished, please check it. Proceed with cutting?*
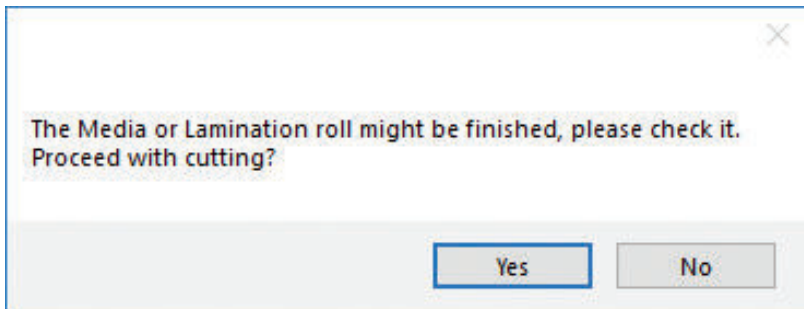
Problem: Yellow and green light simultaneously active on lamination control board.

Cause: When both the yellow and green LEDs on lamination control panel are on, either the media or lamination sensor have picked up and error or the sensors need to be recalibrated.

Fix: To fix this, refer to the *"Yellow and Green LEDs are simultaneously illuminated on the lamination control board"* guide on page 29 to resolve.
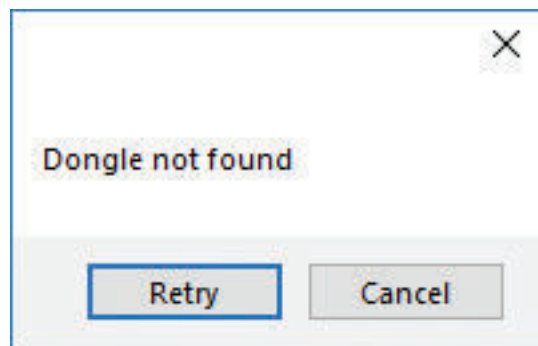
Error: load the media
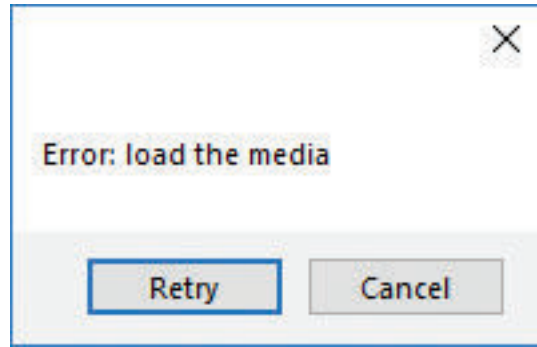
Cause: You launched the Cutting Manager while the plotter's lever was down

Fix: Raise the lever on the plotter, then press the button 2 on control panel and wait until the display will show "READY" as status. Then press **Retry** on the popup window.
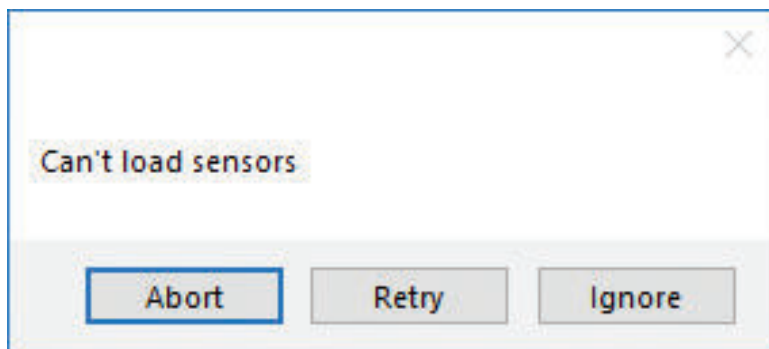
Dongle not found

Cause: You launched the Cutting Manager while the plotter's lever was down

Fix: Plug the dongle in correctly and click **Retry** (clicking **Cancel** will close the Cutting Manager)
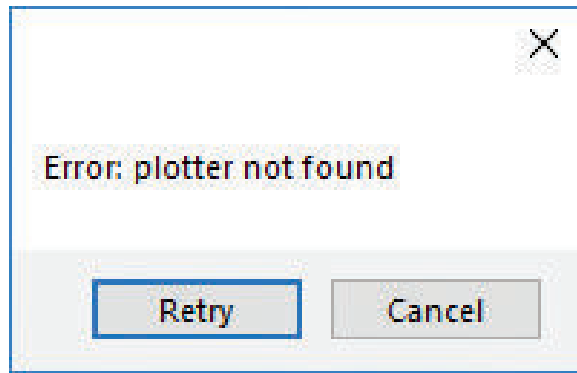
Can't load sensors

Cause: Media and laminate sensors might be not plugged in correctly or turned off

Fix: Check if sensors are powered up and plugged correctly into the black sensor box, then Retry. If you are not using the sensors, click Ignore.
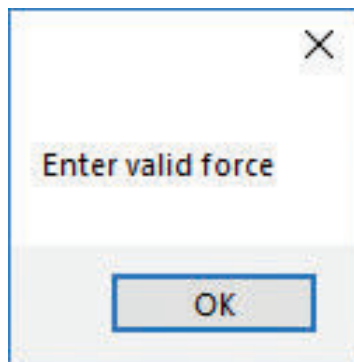
Error: plotter not found

Cause: The plotter might be switched off or not properly connected

Fix: Make sure the plotter is turned on and properly connected.
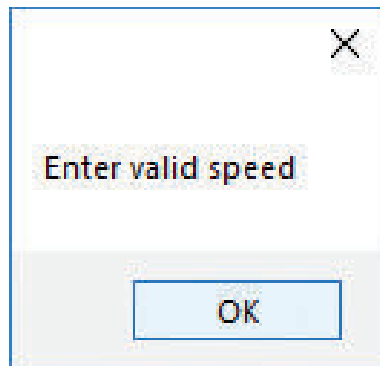
If it is turned off, please turn the plotter on and then press the button 2 on control panel. Wait until the display shows "READY" as its status. Then press retry on the popup window.
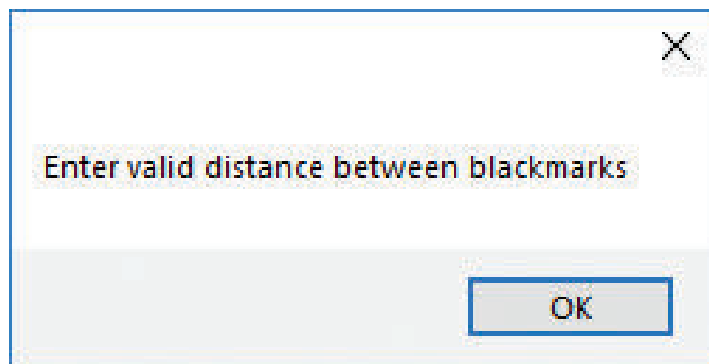
Enter valid force

Fix: Force must be an integer value from 1 to 31. Try again by typing the correct value.
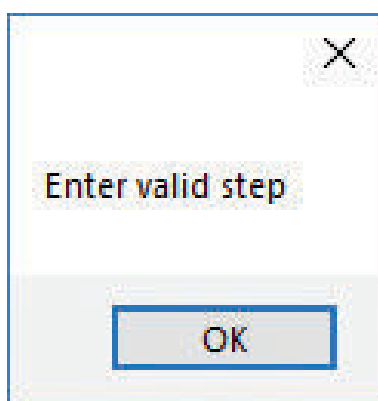
Enter valid speed

Fix: Speed must be an integer value from 10 to 600. Try again by typing the correct value
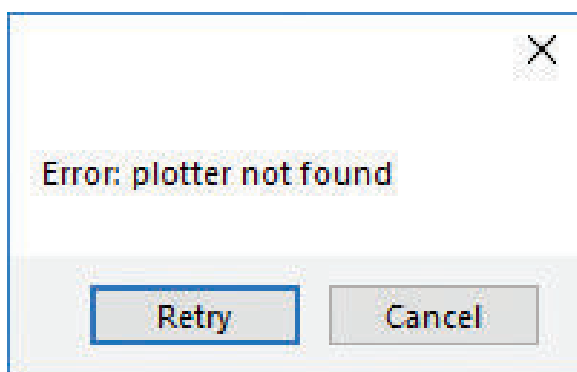
Enter valid distance between black marks

Enter valid distance between blackmarks

OK

Fix: Distance between black marks must be greater than 0. Try again by typing the correct value

Enter valid step

Enter valid step

OK

Fix: Distance between cuts cannot be a negative value. Try again by typing the correct value

Please forward the media to the next black mark
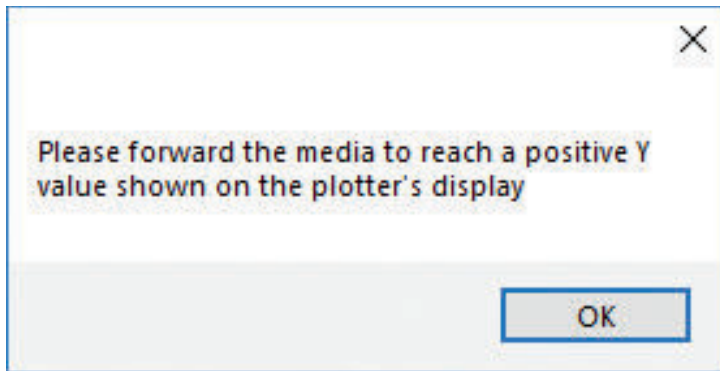

Error: plotter not found

Retry   Cancel

Cause: The starting Y position of the cut is a negative value (you can see coordinates on plotter's display when you move the media with arrows).

Note that the offset influences the starting position of the cut. So, if you start the cut at Y coordinates 0, while you have an offset Y value of -10, you will still get this error.

This error might happen when the media has just been loaded, or if the media is moved backwards in the software.

Fix: Move to the next black mark and set a positive Y coordinate value.

Please forward the media to reach a positive Y value shown on the plotter's display

Please forward the media to reach a positive Y value shown on the plotter's display
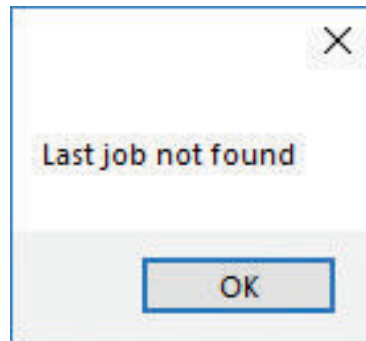
OK

Cause: The starting Y position of the cut is a negative value (you can see coordinates on plotter's display when you move the media with arrows).
This error might happens when the media has been just loaded.

Fix: Move forward until you have reached positive Y coordinates.

Last job not found

Last job not found

OK

Cause: You will get this error when you try to open the last job while running the Cutting Manager for the first time after the installation, or if the PDF file from the last job was moved, renamed, or deleted.

Fix: Choose your file through "Open PDF"

If the offset values seem to be higher than expected, check if they are decimal number.

Fix: Replace the comma with a dot or vice versa.

Make sure to check/replace the comma or dot for Delta Y and X values in Advanced > Settings