



USER MANUAL

DLF-Series

Digital Label Finishers



Revision 2.0



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



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

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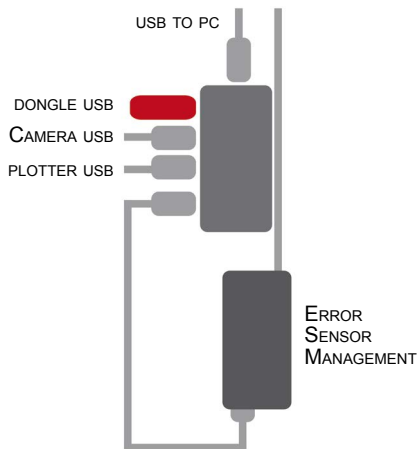
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SYSTEM REQUIREMENTS

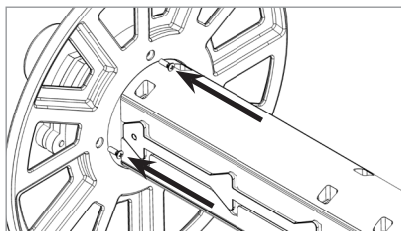
The cutting manager works on Windows OS from Windows 8.1. We do not guarantee its functionality on previous versions. Not compatible with macOS systems.

Cutting files: Adobe Illustrator, CorelDraw or Inkscape (PDF).

Diagram connectors behind the on-off panel.

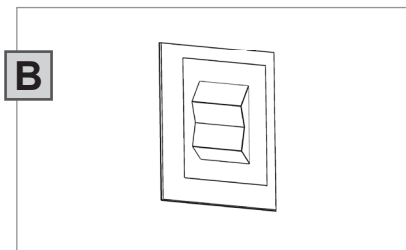
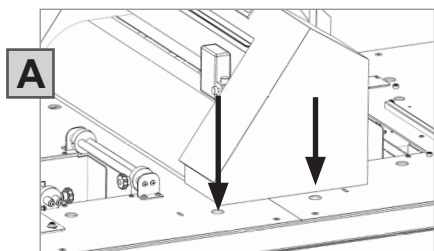


HOW TO INSTALL OUTER DISC



Using a screwdriver, install the outer disc on the Core Holder for printed rolls.

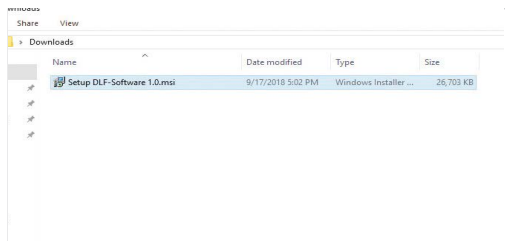
HOW TO INSTALL THE PLOTTER



A. Pull the plotter from the packaging and place it on the plate, make sure to push the rubber feet into the holes.

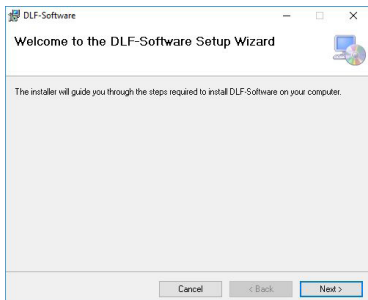
B. Plug the machine and switch on.

HOW TO INSTALL THE CUTTING PLOTTER

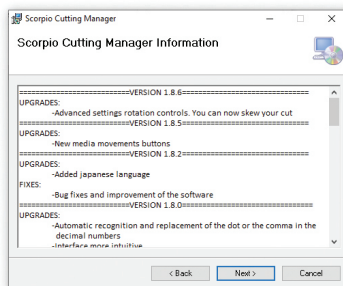


1. Click on “Setup DLF-Software 1.0.msi” and follow the step by step instructions to complete the installation.

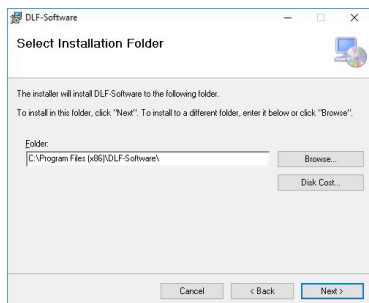
Please DO NOT connect the DLF USB to your PC before the installation is complete



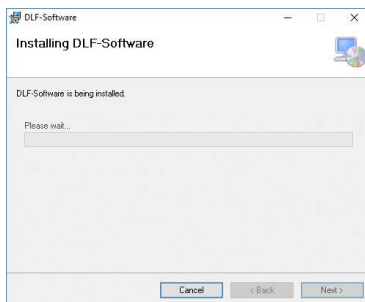
2. Click NEXT



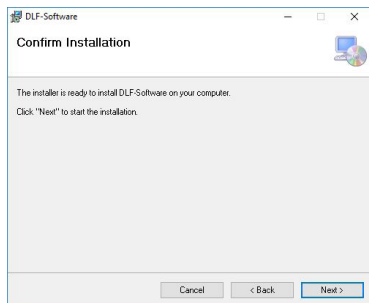
3. Click NEXT



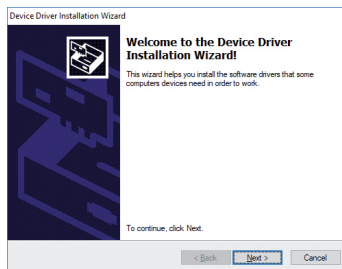
4. Click NEXT



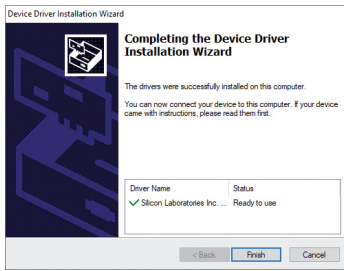
5. Click NEXT



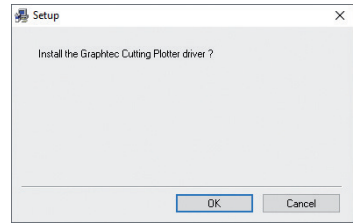
6. In process



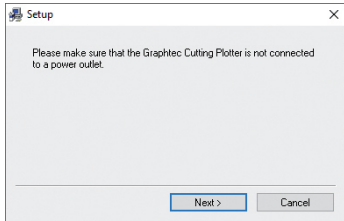
7. Click NEXT



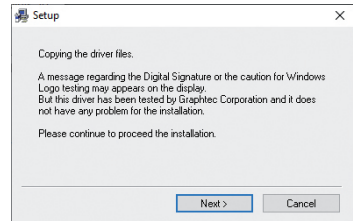
8. Click FINISH



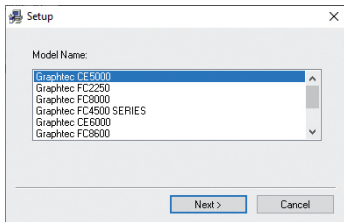
9. Click OK



10. Click NEXT (Remove the DLF USB from your pc, and turn off the DLF)

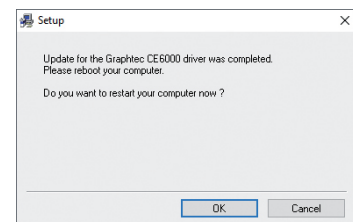


11. Click NEXT



12. Choose the right model name of your Graphtec (CE7000-40).

Click NEXT

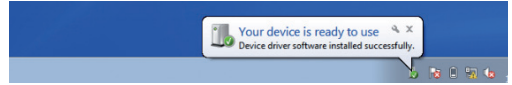
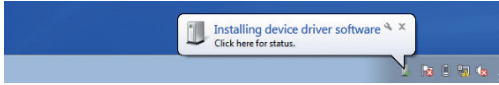


13. Wait until the sign "Update for the Graphtec CE7000-40 driver was completed" shows up. You may need to restart the computer.

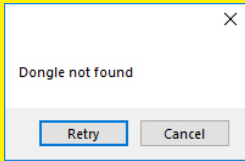
Click OK

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.

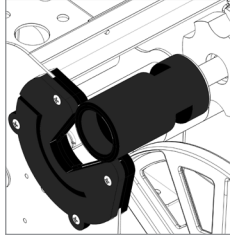
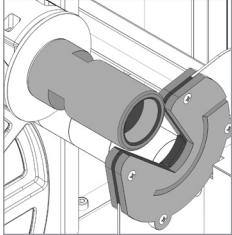


CM Software will generate a folder in the Windows start menu.



If the USB dongle is not installed correctly or is unplugged, the following error will appear.

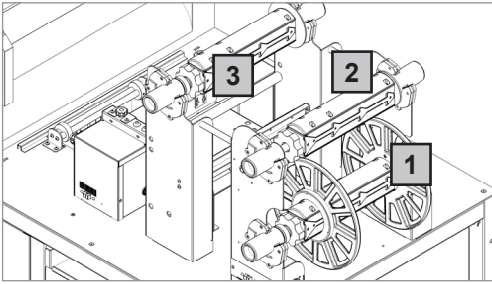
HOW TO INSTALL THE CORE HOLDER



The grey handle must match with the grey holder and the black handle with the black holder.

IMPORTANT: screws must be face down.

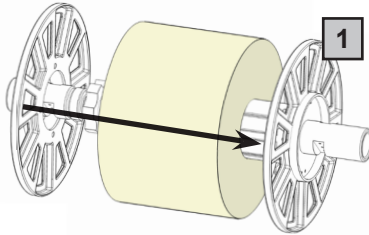
HOW TO LOAD AND OPERATE THE LAMINATION MODULE



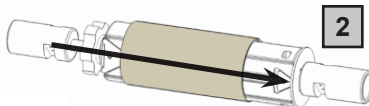
Core Holder No. 1 > Printed roll

Core Holder No. 2 > Liner roll

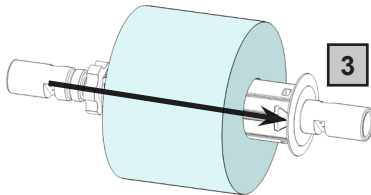
Core Holder No. 3 > Laminate roll



Load the printed roll and move it against the roll guide. Tighten the core holder.



Load an empty cardboard core onto the shaft intended for laminate liner rewinding. Tighten the core holder.

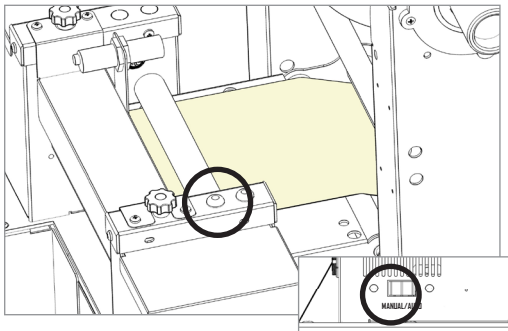


Load the lamination roll, move it along the supply shaft and make sure the lamination is aligned with the media roll.

IMPORTANT: the lamination roll always needs to be narrower than the web width.

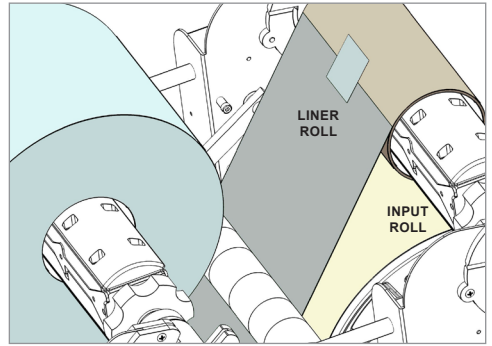
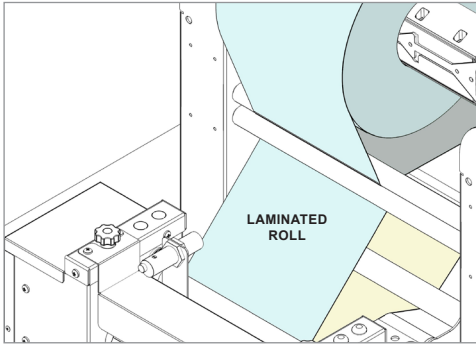
Example: if the web width is 7" then the lamination roll needs to be lesser than 7" (let's say ¼ inch on each end).

At this point you can tighten the core holder.



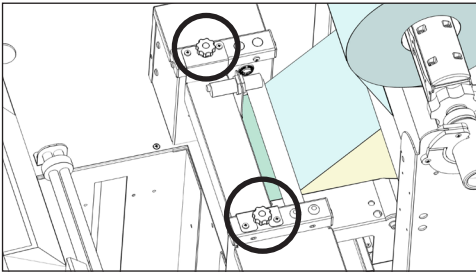
When the LEDs on the control board are off, the device works on a manual feeding.

Move the media through the rollers and press the FORWARD button. The media will be loaded through the rollers whereas if you push the BACKWARD button, the rollers will roll the media backwards.



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

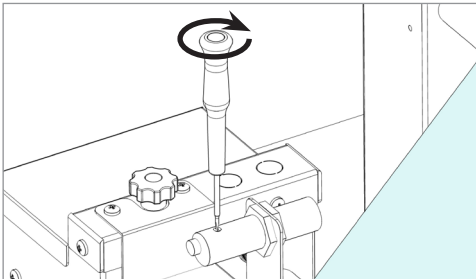
!PLEASE LOOK AT THE LAMINATION PATH! (PAGE 25)



Using the two black knobs located at the top of the roller assembly to adjust the pressure of the rollers. This will apply pressure on the laminating film to adhere to the media avoiding any possible air bubbles.

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. The cause is due to the media or laminate roll is not detected or it is run out. If this is not the cause, please reset the sensor.

HOW TO SET THE LAMINATION SENSOR



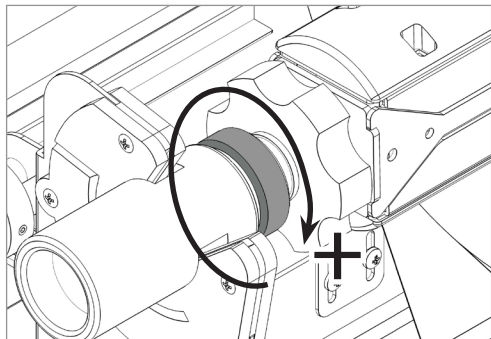
laminate sensor

Turn the screw on the sensor clockwise or anticlockwise. This operation has to be done without lamination in place.

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

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

HOW TO ADJUST THE CLUTCH



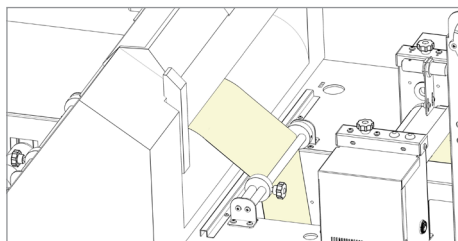
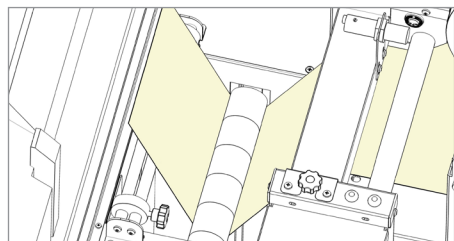
Both core holders are clutched (unpowered), they are the same and they work independently.

It is possible to adjust the clutch by screwing or loosening the aluminium handle.

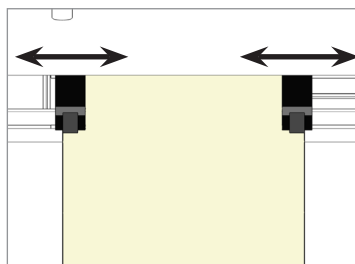
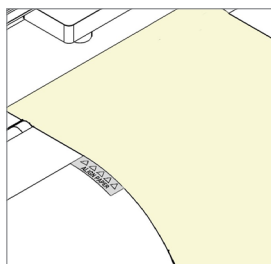
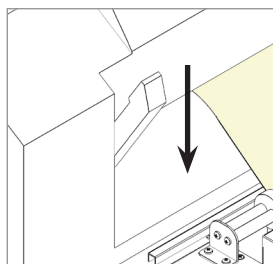
WHEN TO ADJUST THE CLUTCH

It is important to keep the media and laminating film in tension thanks to the clutch adjusting. If the tension is too tight the roller system will get damaged or if the tension is too loose, the media will not be laminated properly.

LOAD THE MEDIA INTO THE PLOTTER

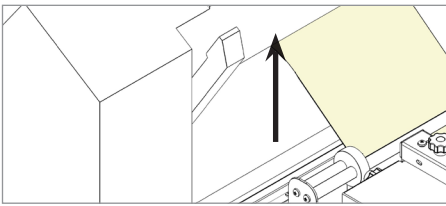


Pull the laminated media underneath the tension arm, then pass it through the aluminium rollers, the guide can be adjusted preventing the web from rolling.



Put the lever, located in the rear of the plotter, in the down position. Pull the media through the plotter and keep the media edge aligned to the alignment points.

Set both pinch rollers at the media edge.



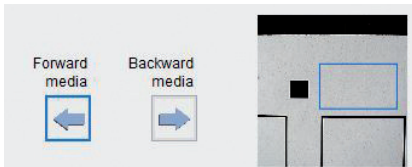
While holding down the media in the aligned position, lift the lever back to its up position. This will lock the media in place.
Press button 2 as requested on plotter's display.

HOW TO RUN THE CUT TEST AND START A JOB

>> How to run the black-mark mode

User Interface at page 16 might be helpful.

1. Open DLF Cutting Manager.
2. Press "OPEN PDF" or "OPEN LAST JOB" to load the cutting file.
3. Look at the camera preview, hold down "BACKWARD MEDIA" or "FORWARD MEDIA" arrows to move the web until the black-mark goes in the center position of the blue rectangle area.



no



yes

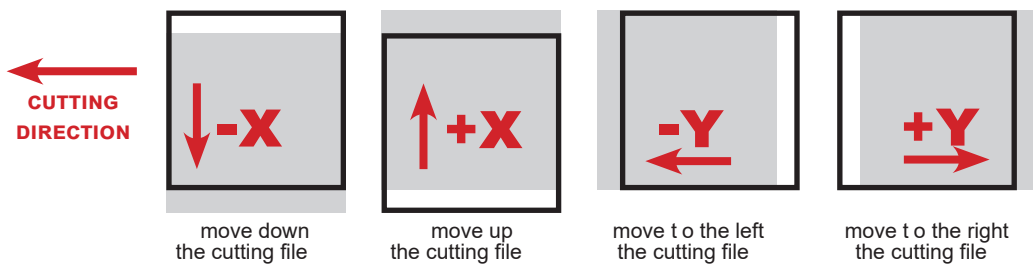
4. Measure the distance in (MM) between the top of one black-mark to top of the next black-mark, key in this value in the "DISTANCE BETWEEN BLACKMARKS" box section.



IMPORTANT:

Working with DLF-220L or DLF-350L models, please open "**ADVANCED BUTTON**", click on Settings and uncheck Media/Lamination Sensor option, then save and close the pop up.

5. Make sure the "Enable" in the blank mode is unflagged.
6. 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 doesn't detach, increase the cutter pressure value in the cut force box.
7. Make sure label is aligned with the cut. **Through X and Y values, adjust offsets if cut doesn't match label.**



- Once the cut settings are properly set, select “**COPY MODE**” **ON** if you desire a preset quantity of copies or **OFF** if you desire unlimited copies until the media roll is finished.
- Set the black-mark size” in “**BLACK-MARK MODE**” area.
- Press “**START**”.



IMPORTANT:

Whenever you lower and rise the lever while you are in black-mark mode, hold down the forward media arrow button to move again the plotter’s head down.

>> How to run the blank mode

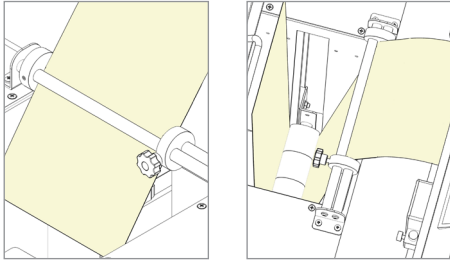
- Press “**OPEN PDF**” or “**OPEN LAST JOB**” to load the cut file.
- Set the copy mode **ON**, and set 2 as number of copies.
- Click “**START**”.
- Check the horizontal position and the gap between the cuts.
- If necessary, adjust the offset X and the distance between each cut in the “**STEP**” box.
- 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.
- Working with *DLF* models, please open **Advanced** button, click on **Settings** and uncheck **Media/Lamination Sensor** option, then save and close the pop up.
- Click “**START**”.



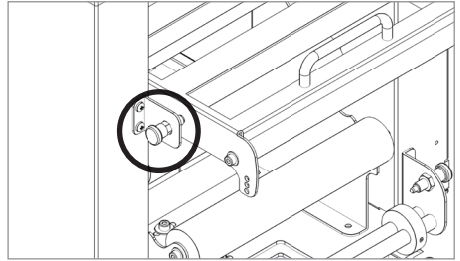
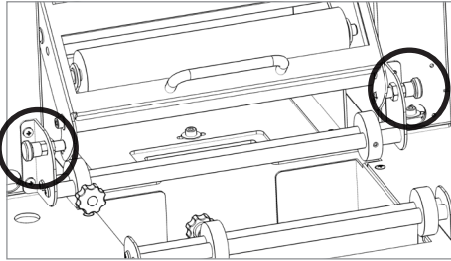
IMPORTANT:

Working with *DLF-220L* or *DLF-350L* models, please open “**ADVANCED BUTTON**”, click on **Settings** and uncheck **Media/Lamination Sensor** option, then save and close the pop up.

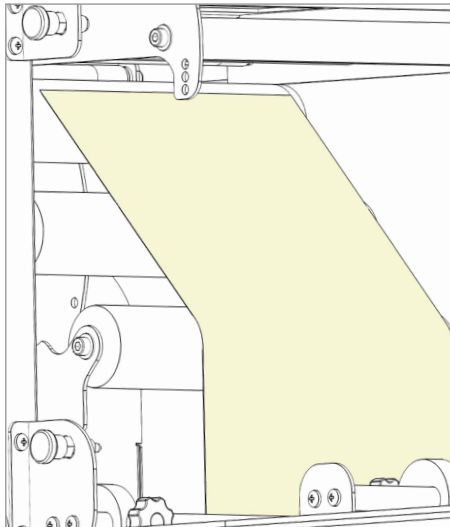
HOW LOAD THE MATRIX REMOVER & SLITTER



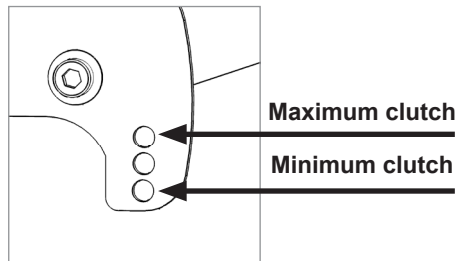
After you CUT TEST is successful, press "START" to cut a few labels until you think you have enough media to load onto the matrix remover.



Pull the sides of the black knobs and lift up the clutch system, other black knobs will keep it open.



Pull the media through the aluminium rollers first (the guide can be adjusted in order to prevent the web from rolling) then through the clutch system. Close the loading system and the media will be automatically loaded into the clutch path.



The user can adjust the clutch force thanks to the position of the clutch system.

Maximum Clutch (rewinded roll more tight)

Minimum Clutch (rewinded roll less tight)

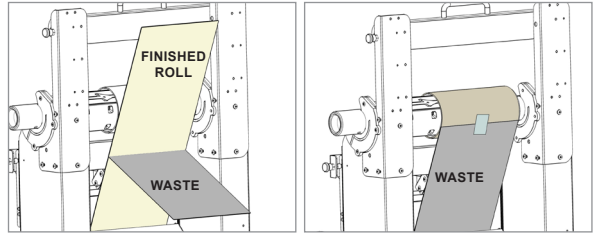
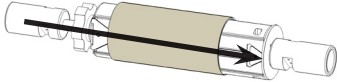
HOW TO LOAD THE MATRIX REMOVER CORE HOLDER



WARNING: Before starting a job, always remove the waste media from the matrix remover core.

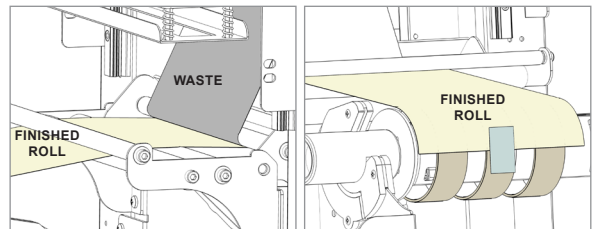
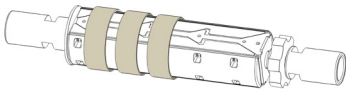
Tape the matrix securely onto the cardboard core.

System operating issues may occur if the above suggestions are not followed.

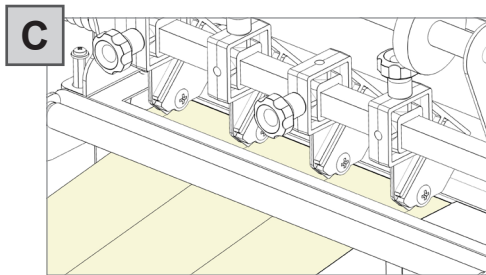
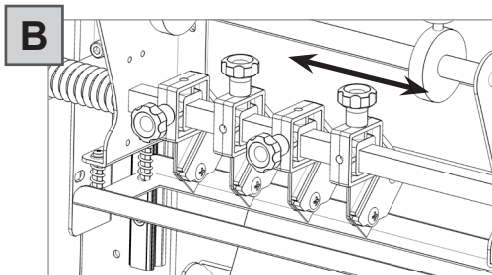
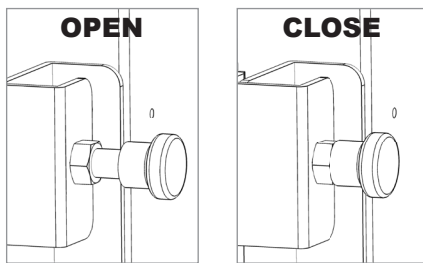
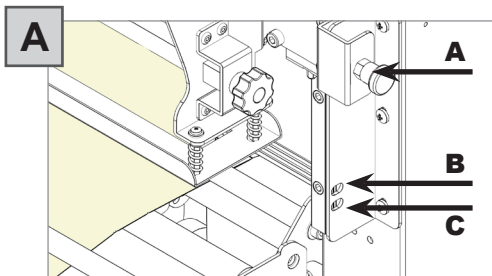


1. Load empty cardboard core(s) and tighten the core holder, then place the motorized core holder in position.
2. Peel back the matrix.
3. Pull the matrix and attach it to the matrix remover core holder.

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

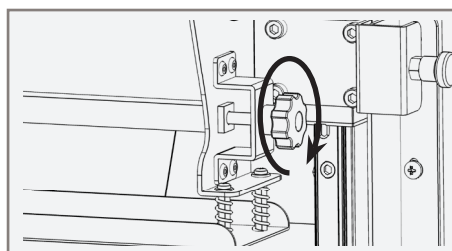


1. Load empty cardboard core(s) and tighten the core holder, then place the motorized core holder in position.
(Cardboard core(s) width should equal (or narrower) the width of the finished roll).
2. Pull the media through the aluminium rollers and attach the labels to the core using a waste label.

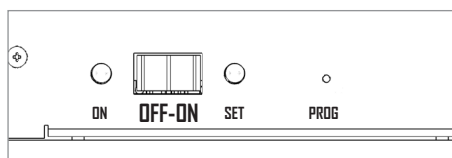


Slitter module has 3 positions:

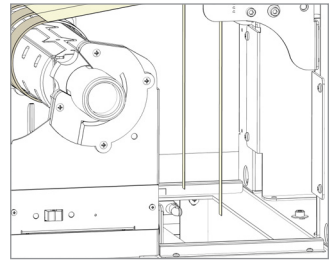
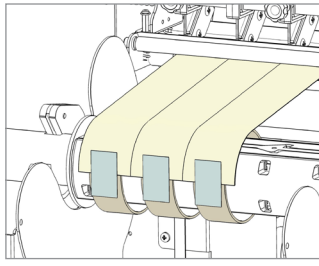
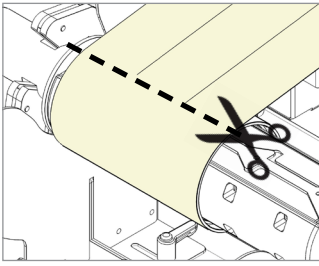
- Upper position (A), the blades are lifted to allow the media loading;
- Middle position (B), align the blades with the edges and the center of the labels, tighten the thumb screw once the blade is in position;
- Lower position (C), the blade cut the media.



The black knobs lock the slitter module in the requested position. Screw the thumb knobs to move the blades to the right or to the left.



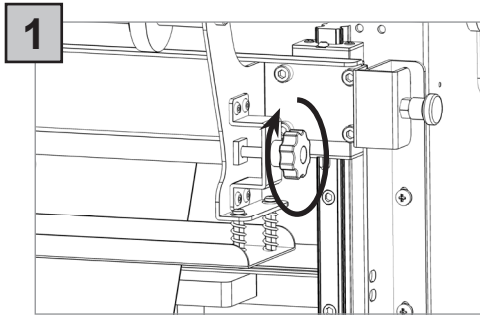
3. Turn ON the Matrix Remover module to rewind and start to split the media, than turn OFF.



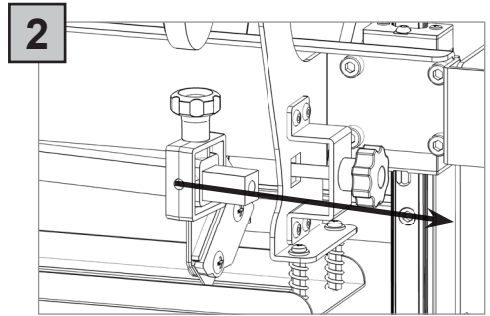
4. Cut the labels when the first “good” labels are visible;
5. Make sure the tension on all rolls is even and attach each label to the core using a waste label;
6. Feed edges trim waste into the waste basket under the hole.

Press RESUME to start your finishing process.

HOW TO ADD OR REMOVE A BLADE HOLDER

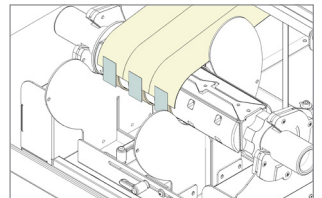
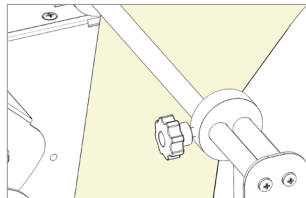
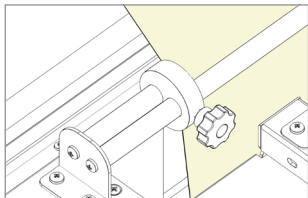


1 Remove the iron bar by unscrewing the black thumb screw.



2 Slide in or out the blade holder. Relocate the slide iron bar in its position and rescrew the thumb screw.

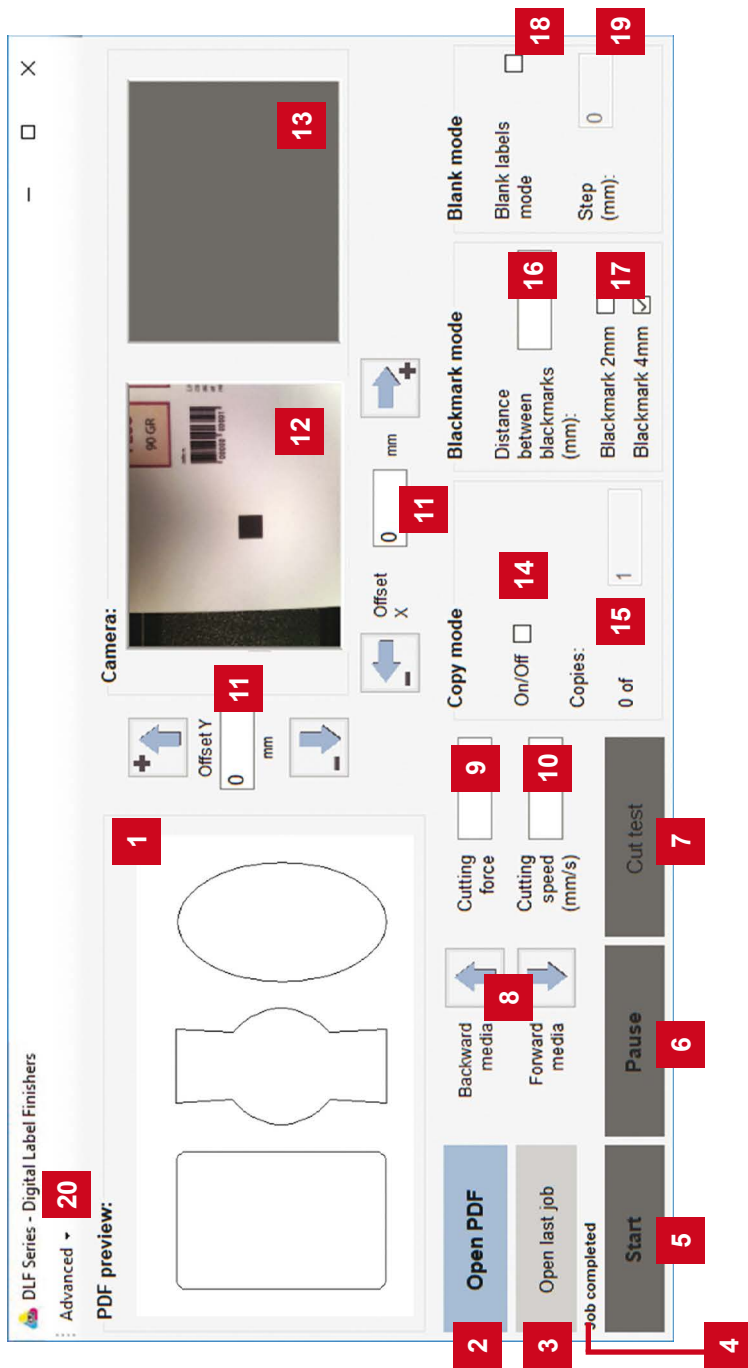
METAL GUIDE ALIGNMENT



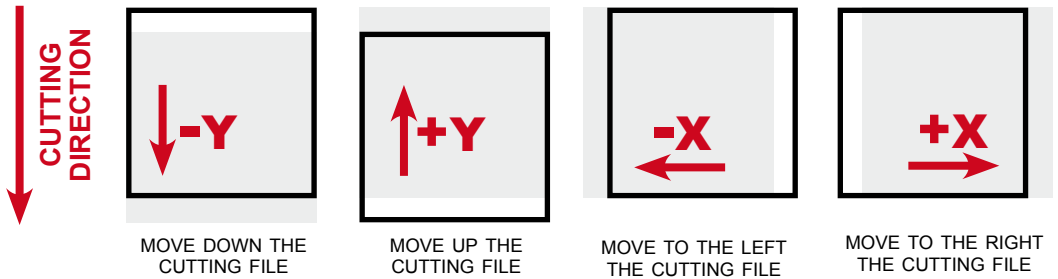
Metal guides can be adjusted in order to prevent the web from rolling.

DLF cutting manager (DLF CM)

USER INTERFACE

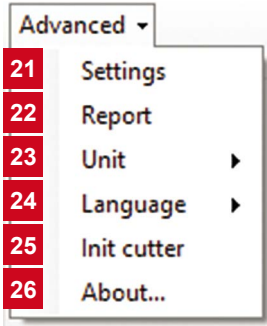


1. Cutting file preview
2. Open and load cutting file
3. Open and load the previous cutting file used
4. Status bar
5. Start/stop the cutting process. (In black-mark mode, the cutting process moves to the next black-mark after the cut test)
6. Pause/resume the cutting process
7. Run one cut at time to check the values set, feature available in black-mark mode only.
8. Arrow buttons to move the media forward or backward
9. Increase or decrease the cut force
10. Increase or decrease the cutting speed
11. Offset adjustment



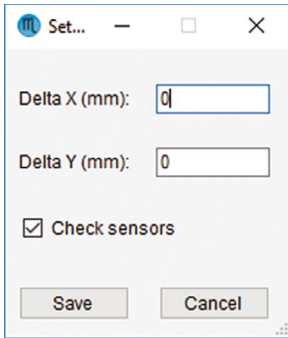
12. Current camera view
13. Screenshot of the previous black-mark detected
14. Preset quantity of labels to be cut (on) or cut to end/manual stop (off)
15. Number of labels cut
16. Set the gap between black-marks (top to top)
17. Set black-mark size
18. Enable blank media mode (no black-mark printed)
19. Set the gap between each artwork to be cut in blank media mode
20. Advanced options

ADVANCED OPTIONS



- 21. Settings
- 22. Report
- 23. Set unit (mm or inch)
- 24. Set the interface language
- 25. Restore default plotter settings
- 26. Shows the software version

Settings (21)



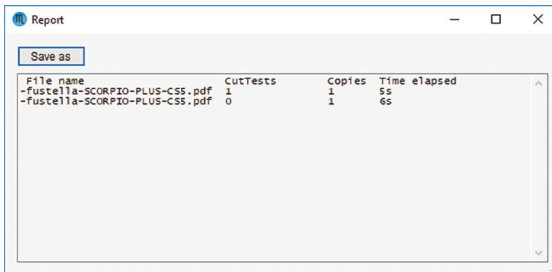
Delta X and Y show the predefined offset adjustment.

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

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

Whenever you change those settings, press save to set the new values.

Report (22)



Report displays the cuts run since Cutting Manger software has been open.

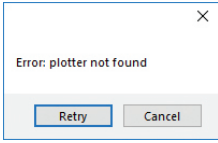
Each session report is automatically added and saved to the history report when cutting manager is closed.

You can find the complete report history file of all the jobs run since cutting manger has been installed through this link "[YourDocumentsFolder/DLF Cutting manager/CutHistory.txt](#)".

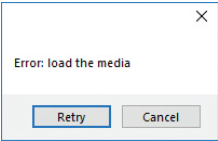
Clicking "SAVE AS" your can save wherever you prefer the current work session report

ERROR MESSAGEGES

If the plotter is not connected correctly to the computer, the following errors will be displayed at the application launch:



Make sure the plotter is switched on and properly connected. In case it is turned off, please turn the plotter on and 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.

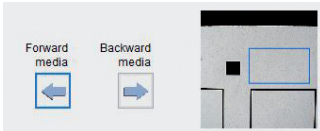


Ensure the media is loaded properly. Raise the lever on the plotter, then press the number 2 on control panel. wait until the display will show "READY" as the status. Then press retry on the popup window.

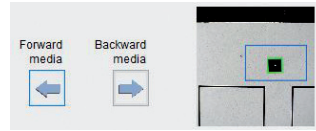
BLACK-MARK DETECTION

To prevent any issues, it is important that the camera is reading the black-mark properly.

Look at the camera preview, hold down "BACKWARD MEDIA" or "FORWARD MEDIA" arrows to move the web until the black-mark goes in the center position of the blue rectangle area.



wrong position



correct position

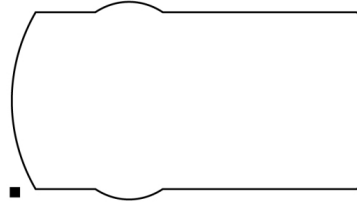
CUTTING FILE SPECIFICATIONS

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 or 2x2mm.

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 cutting shape must be 100% black (otherwise in case of dashed lines, it must be a 100% magenta normal line) and have a thickness of 1 pt.

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

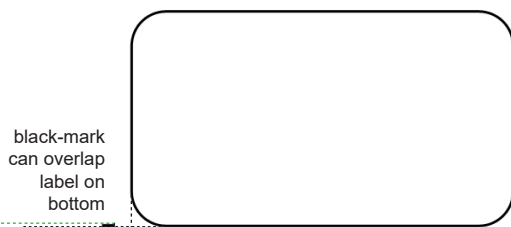
The DLF Cutting Manager (DLF CM) work with the VECTOR PDF FILE. You can create this file with Adobe Illustrator or Corel Draw.

MOST IMPORTANT:

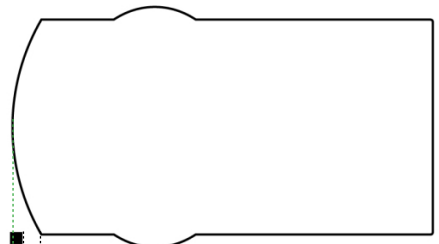
To guarantee the black marks size and its position printed correctly on the media, the artwork must be printed with the actual size, make sure to avoid any fit or scale

BLACK-MARK POSITION INTO THE CUTTING FILE AND PRINTED ARTWORK

Black-mark size: 4x4mm or 2x2mm



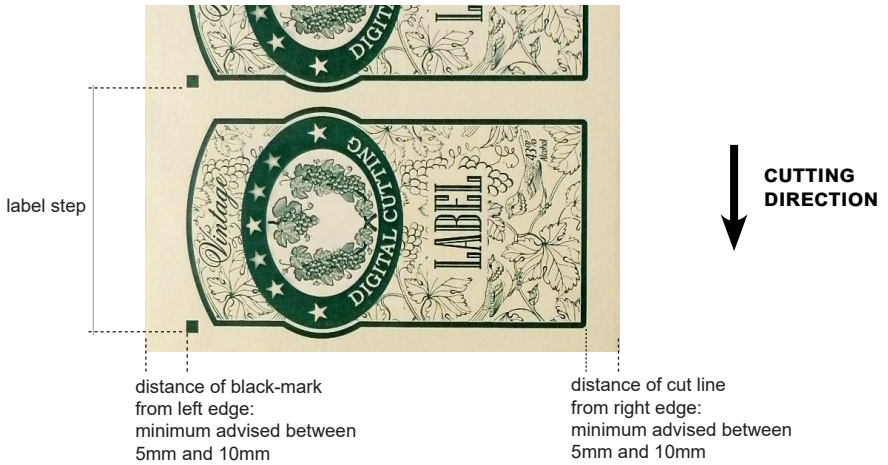
minimum distance from left side of label graphics 4mm



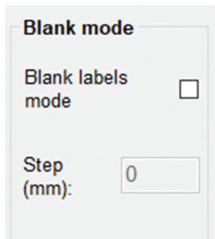
for round or complex labels black-mark can partially overlap the left side of label.

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

BLACK-MARK POSITION IN THE MEDIA

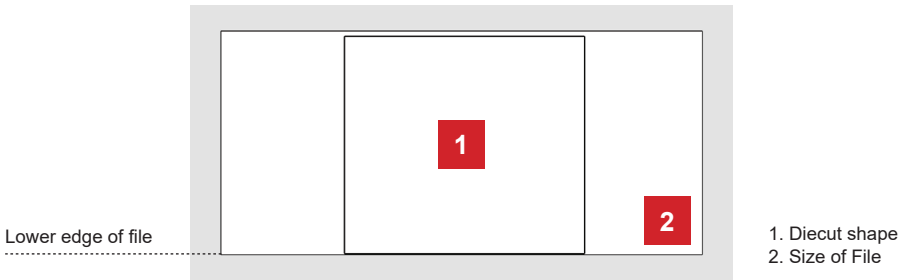


HOW TO CUT BLANK LABELS



If you wish to use the “blank label” feature to cut blank labels (without registration mark), please follow these steps:

1. Import the cut file (without 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”.



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” item.



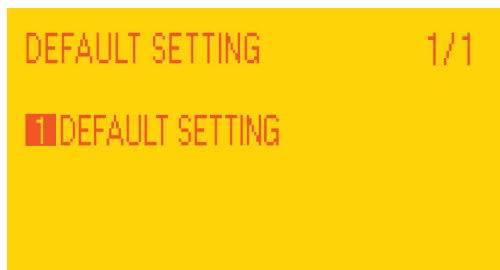
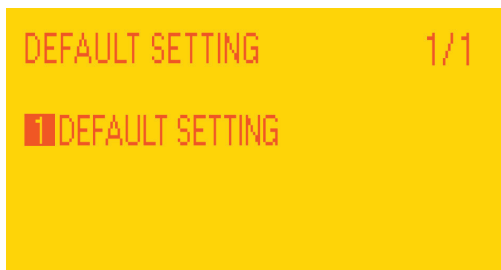
WARNING: Please note that enabling the blank label feature will disable both cut test and Y offset adjustment.

HOW TO UPDATE SOFTWARE

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

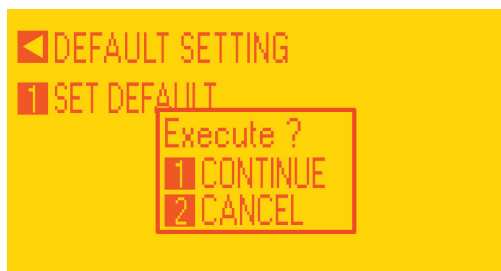
HOW TO RESTORE PLOTTER SETTINGS

1. Turn off the plotter.
2. Turn on the plotter while keeping pushed the UP arrow on the panel.



3. When the display shows "DEFAULT SETTING" press button 1.

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

- 1 VIEW
- 2 HOME

11. Wait until on the display appears "READY".



12. Press "PAUSE/MENU" then go to I/F (press up arrow key).

Esc INTERFACE 1/3
▲
1 BUFFER CLEAR
2 COMMAND
3 HP-GL ORIGIN POINT
4 HP-GL MODEL EMULATED
▼

13. Go to Command (press 2).

COMMAND

- 1 GP-GL
- 2 HP-GL
- 3 AUTO

ENT SET ◀ CANCEL

14. Select GPGL (press 1 then enter).

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

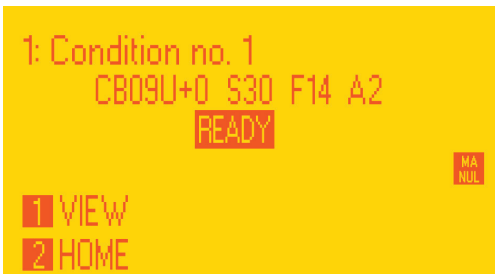
- 1 VIEW
- 2 HOME

15. Press "PAUSE/MENU".

SELECT

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

16. Restart plotter then 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”. Click “YES” to confirm



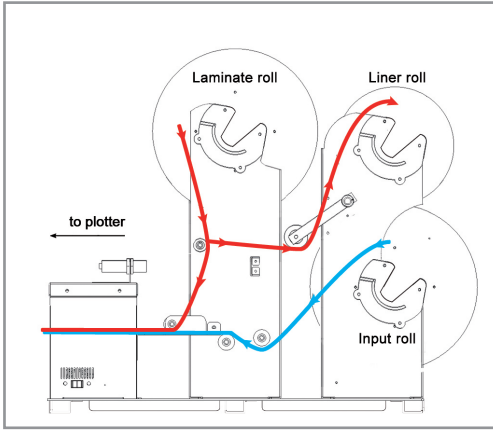
19. Wait until “Init cutter completed” will be shown in the status bar. Plotter display will show “LABEL MEDIA” as status.

WHEN AND HOW TO REDUCE THE PLOTTER FEEDING SPEED

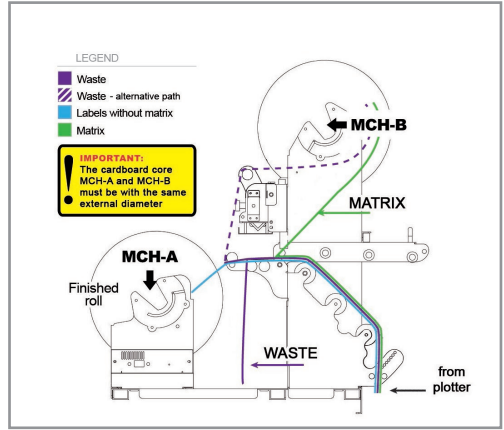
When cutting label longer than 250mm, it is recommended to decrease the cutting speed. The cutting speed reduction depends on the job in process.

The cutting speed can be set within the range of 50 to 600.

MEDIA PATH



LAMINATION MODULE



MATRIX REMOVER AND SLITTER MODULE

ULTRASONIC SENSOR CALIBRATION



WARNING: Before proceeding with the ultrasonic sensor calibration, turn “OFF” the module that needs to be calibrated (lamination or matrix&slitter modules).

LAMINATION MODULE

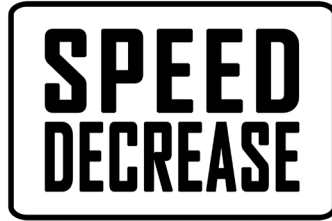
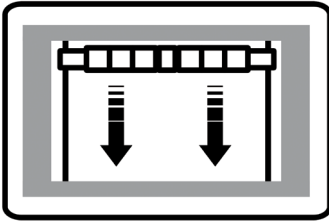
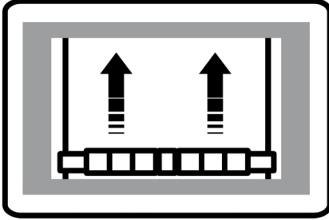
1. Raise up the tension arm up to the desired position (generally it is in the middle of the range). In that position, the system will reach the maximum unwinding’s speed. The longer your label will be, the lower tension arm position requires to be set.
2. Holding the tension arm idle at the desired position, using a paper clip, keep pushed the button into the small hole until the yellow led will flash and the unit will emit an acoustic signal.
3. The ultrasonic sensor has been calibrated and ready to be operative.

MATRIX REMOVER AND SLITTER MODULE

1. Raise up the tension arm up to the desired position (generally it is in the middle of the range). That point will determinate the tension arm working range from the bottom position. The longer your label will be, the lower tension arm position requires to be set.
2. Holding the tension arm idle at the desired position, using a paper clip, keep pushed the button into the small hole until the yellow led will have flashed 3 times.
3. The ultrasonic sensor has been calibrated and ready to be operative.

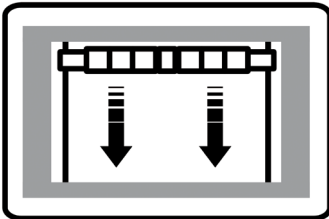
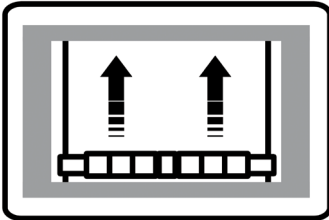
LAMINATION MODULE

ULTRASONIC TENSION CONTROLLER

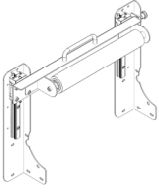


MATRIX REMOVER & SLITTER MODULE

ULTRASONIC TENSION CONTROLLER



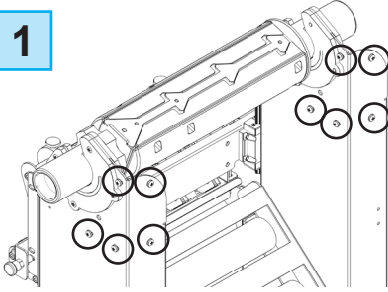
HOW TO INSTALL PRESSING ROLLER



The pressing roller facilitates the matrix removal from the die-cut roll.

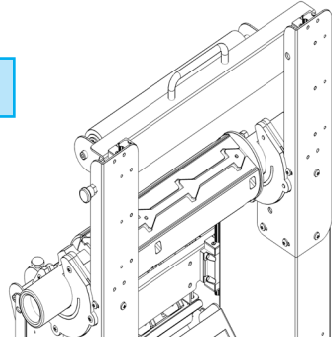
How to install the roller:

1



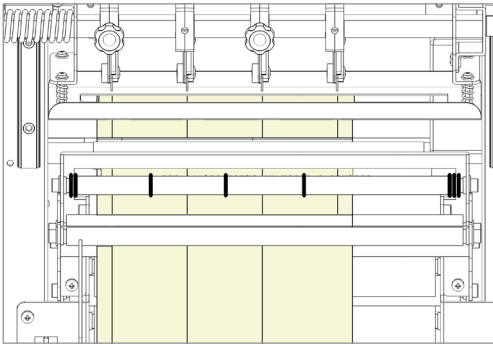
Unscrew the 10 screws on the matrix remover module.

2



Position the matrix remover roller onto the matrix remover module and secure it properly with the 10 screws.

HOW TO USED THE O-RING ON THE MATRIX ROLLER



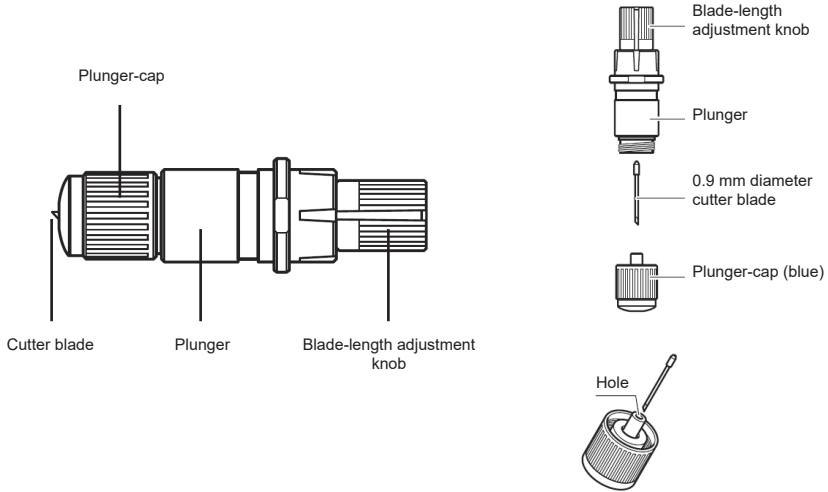
The o-rings of the matrix remover roller are used to facilitate the removal of your matrix from the labels.

Place one or more o-rings (depends on the width of the label) at the center of the die-cut label.

Then proceeds with the normal loading of the media. (page 12)

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 diameter cutter plunger is provided as a standard accessory). Be sure to mount the cutter blade in the corresponding cutter plunger.



CAUTION:

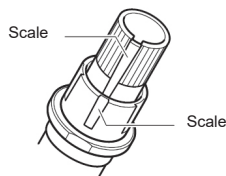
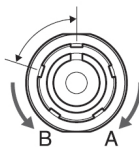
To avoid bodily injury, handle cutter blades with care.



WARNING: It may result in damaging the cutter blade or the cutting mat if the blade is extended too much. Make sure the blade length is set less than the thickness of the media.

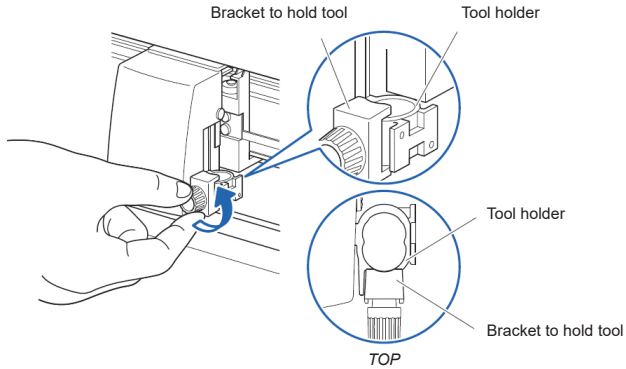
Adjust the blade length by turning the blade-length adjustment knob. Turn the knob in direction “A” to extend the blade, or in direction “B” to retract the blade. When the knob is turned by one scale unit, the blade moves approximately 0.1 mm. One full turn of the knob moves the blade approximately 0.5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

Cutter blade moves approximately 0.1 mm turning one scale unit

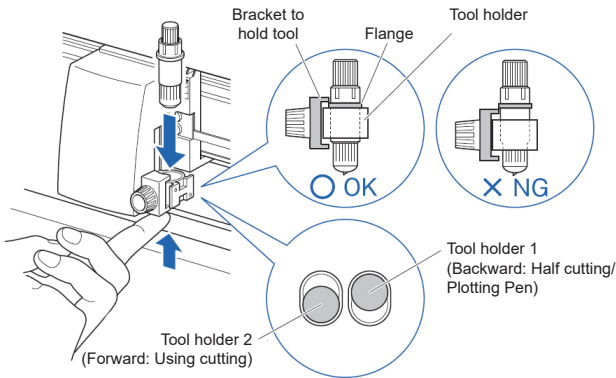


Mounting the tool

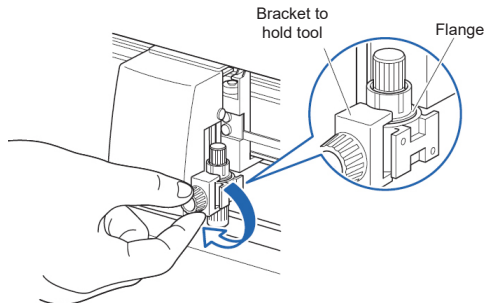
1. Loosen the tool holder screw.



2. While pushing up the tool holder, push until its flange completely touches the upper part of the holder.



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



Removing the tool

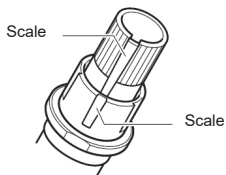
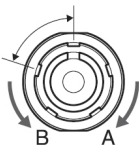
When removing the tool, turn it counterclockwise to remove the tool.

HOW TO REPLACE THE KNIFE

See page 28 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

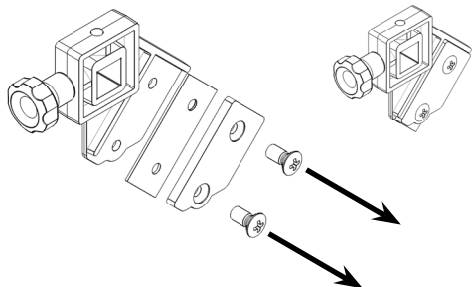


2. Turn the plunger cap in the counter-clockwise direction to remove it from the plunger.
3. Remove the blade from inside the plunger cap.
4. Remove a new blade from its pack. Insert the new blade into the hole provided in the plunger cap.
5. With the blade inserted into the plunger cap, screw on the 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, it is best to properly calibrate the knife exposure and cut force depending on the media thickness.*

HOW TO REPLACE THE SLITTER BLADE



Loosen the two screws holding the blade in place.

Replace the blade.

Fix back the screw to holding the blade in place.

HOW TO REPLACE THE CUTTING MAT

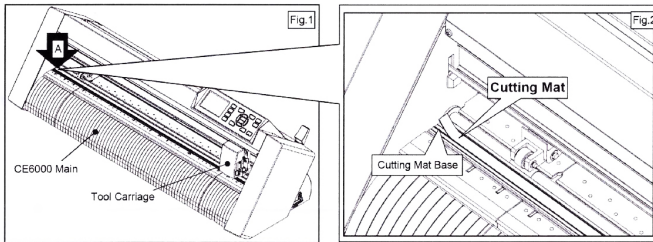


CAUTION:

**Please turn off the power when replacing the cutting mat.
Please move the tool carriage to "A" position allowing
for ease of work.**

1. Remove the cutting mat.

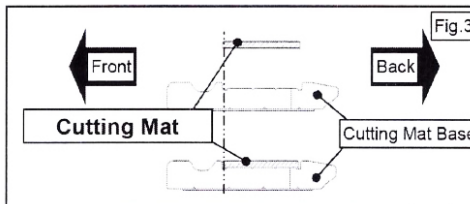
- The cutting mat is attached to the cutting base (fig.2)
- Please remove only the cutting mat from the cutting mat base from the location shown by the arrow (A) (fig.1)



- After removing the cutting mat, please make sure that there is no adhesive tape or other adhesives left on the cutting base.
- Please clean the cutting mat base before installing the cutting mat.
- Installing the cutting mat with the remaining adhesive may affect cut quality.

2. Installing the cutting mat.

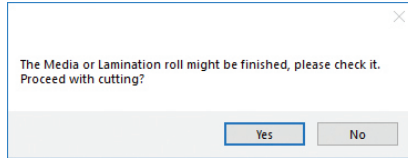
- Fit the cutting mat with the front cutting base grooves (fig.3) and attach it from the location shown by the arrow (A) (fig.1) while peeling off the release paper.



IF YOU ARE EXPERIENCING THE FOLLOWING ISSUES WITH THE ANY OF OUR DLF UNITS, PLEASE FOLLOW TROUBLESHOOTING STEPS BELOW

Yellow and Green LED's simultaneously on lamination control board (Applies to all DLF models)

Problem: Yellow and Green LED's simultaneously on 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 the yellow and green LED's on lamination control panel are on, it would indicate that either one or both of the sensors have picked up an error and the cause could be due to either the media or lamination roll has run out or the sensors may be out of sync and needs to be re-calibrated. The following steps below will show you how to tell 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 LED's on the control panel comes on, it could indicate that media has ran out and needs to be changed.
- If after loading the media through the guides and the LED is still **OFF or BLINKING** with the yellow and green LED's 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 the 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 is should always be covered with a blue cap should you decide NOT to use 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 LED's on the control panel being on, it could indicate that lamination roll has ran out and would needs to be changed.
- If the LED is still **ON** after loading the lamination roll with both the yellow and green LED's 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 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 occurs for a couple of reasons. The primary reason would be that the tension force on the on the rubber roller assembly, media core and the lamination core (If using lamination) are all out of sync and needs adjusting. Another reason could be that the media was wounded unevenly to begin with thus creating an uneven media roll. Make sure the distance between top to top black-marks is set correctly.

Fix: First check to see if you have a flat even media roll before you begin installation. An uneven media roll will cause the job to misalign itself. If that checks out ok, then you will need to adjust the tension force on the lamination module. To do this you must turn the two black knobs located at the top the rubber roller assembly to adjust the tension force until you receive satisfactory results. If needed, this may have to be done in conjunction with adjusting the clutch tension on both the lamination core (*If using lamination*) and the material core using the aluminum handles. Adjust the tension force at all three locations accordingly until you get the perfect setting and the media is properly aligned.

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* and the tensioner arm was not set-up to begin with or 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 into the correct position (****Correct position for the tensioner arm will be midpoint or lower****).
3. Once Tensioner is in the correct position, turn ON lamination module.
(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 Plotter 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: This happens if cut force in 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 it could be set too high.

Fix: If the plotter is not producing a clean cut, this can be fixed by either; increasing the cut force in *DLF CM* while decreasing the blade exposure until the unit provides satisfactory results or you can also decrease the cut force and increase the blade exposure until it produces a perfect cut. Adjust both accordingly until the correct cut setting has been achieved.

If the plotter is cutting through the media, this can be fixed by decreasing both the cut force and blade exposure to factory settings and start by increasing the cut force until you get a clean cut. You may have to increase the blade exposure while decreasing the cut force there's a clean cut and the correct settings is has been achieved.

(NOTE**You can continue to increase the blade exposure if necessary, but remember that when you increase the blade exposure, do not simultaneously increase the cut force or you will cut through the cutting mat below the media. It is always best to increase one setting while decreasing the other or just increasing one setting only, normally the blade. Never increase both settings simultaneously)**

Plotter error “E01019 Hardware Y Position Alarm Power off then on”

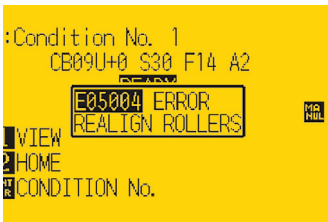


Problem: The plotter displays an error “E01019 Hardware Y Position Alarm Power off then on”.

Cause: This error occurs when 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, you must first power off the plotter, turn the plotter back on, wait for the display on the plotter to load, then press the number “2” as instructed on the plotter to complete the set-up.

Plotter error “E05004 Hardware Realign Push Rollers Confirm”

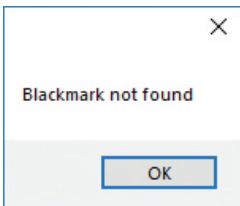


Problem: The plotter displays an error “E05004 Hardware Realign Push Rollers Confirm”

Cause: This error occurs when 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.

Cutting Manager error “Black-mark not found”



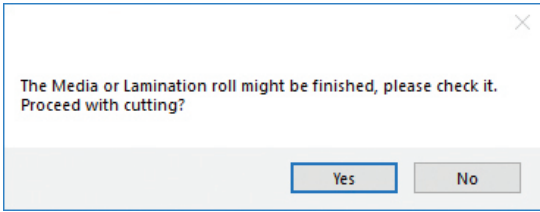
Problem: After starting a job in *DLF CM*, you get an error “Black-mark not found”.

Cause: This problem occurs when after you start the job and the software can’t detect the black-mark on the media. The reason for this could be the following; the media is missing a marker to begin with; the media is not aligned with

the arrows points labeled on the front and back of the plotter; the plotter’s camera is not positioned correctly; and the plotter’s camera is picking up too much exposure from the sunlight or another light source.

Fix: To fix this, before you start any job in *DLF CM* be sure to always do the following; check and make sure the media has a black-mark printed on it to begin with; manually aligned the media with the arrows points labeled on the front and back of the plotter (*This is done with the plotter’s rear handle in the down position*; make sure to position the plotter’s camera over the blackmark in order to centered marker as much as possible on the software camera preview.

The Media or Lamination roll might be finished, please check it. Proceed with cutting?

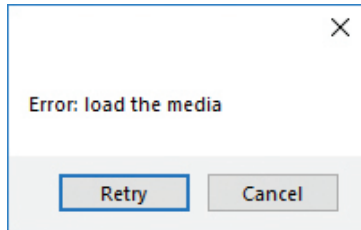


Problem: Yellow and Green light simultaneously on lamination control board.

Cause: When both the yellow and green LEDs on lamination control panel are on, it would indicate that either the media or lamination sensor have picked up an error or the sensors may be out of sync and need to be calibrated.

Fix: To fix this, please refer to the “Yellow and Green LED’s simultaneously on lamination control board” guide above to resolve.

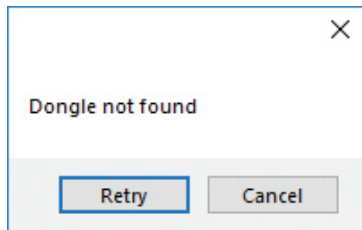
Error: load the media



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

Fix: Rise 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.

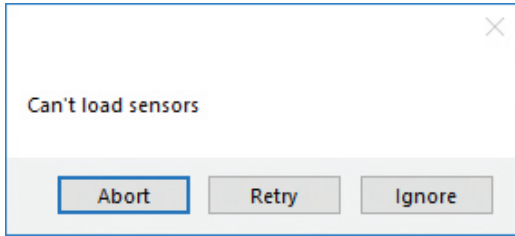
Dongle not found



Cause: the software has been opened while the dongle (the red key) was not plugged to the internal hub or the usb from the DLF was not plugged to the pc.

Fix: Plug the dongle to the hub, or the DLF usb to the pc and click retry.

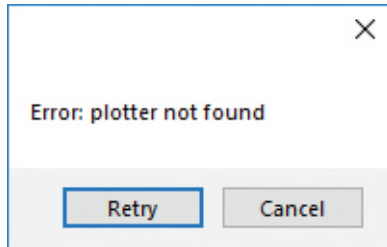
Can't load sensors



Cause: Media/Lamination 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 do not want to keep activated the sensors, click Ignore.

Error: plotter not found

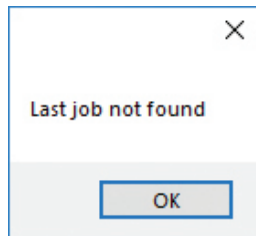


Cause: The plotter might be switched off or not properly connected.

Fix: Make sure the plotter is turned on and properly connected.

In case it is turned off, please turn the plotter on and 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.

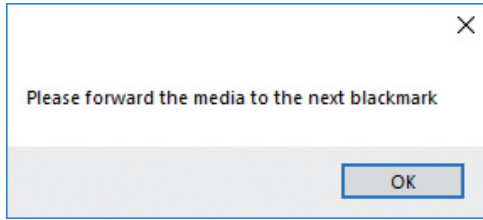
Last job not found



Cause: You will get this error when you try to open the last job when you run Cutting Manager for the first time after the installation.

Fix: Choose your file through "Open PDF".

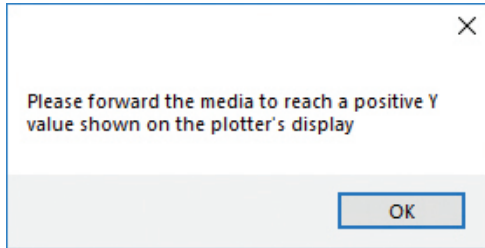
Please forward the media to the next black-mark



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). **Keep in mind also 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 happens when the media has been just loaded.

Fix: Move to the next black-mark. If it is not enough, forward until you have reached Y coordinate value major than 0.

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



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.

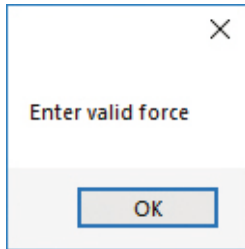
Fix: Move forward until you have reached positive Y coordinates.

Error after opening a .pdf file

- Cause:**
- The antivirus doesn't allow the software to open the file
 - The file is loaded from a server web or a remote disk. This may create issues sometimes
 - The file is not properly built

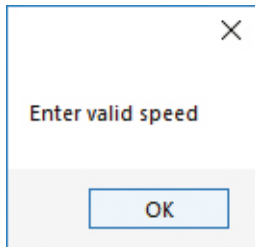
- Fix:**
- Add the cutting manager to your antivirus's whitelist
 - Move your file to your computer
 - The cutting file must contain only:
 - The contours lines
 - The Black-Mark, in case of Black-Mark mode cutting

Enter valid force



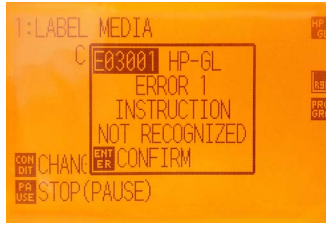
- Fix:** Force must be an integer value from 1 to 31. Try again by typing the correct value.

Enter valid speed



- Fix:** Speed must be an integer value from 10 to 600. Try again by typing the correct value

ERROR 1 instruction not recognised



Fix: Turn off plotter and close the Cutting manager.

Restart plotter than press the button 2 on control panel and wait until the display will show “READY” as status.

Restart Cutting Manager software

In the case the plotter does not execute any command requested by Cutting Manager, for more than 30 seconds check if the camera is working correctly (put something under the lens and make sure it is shown on the Camera preview as well).

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

If the camera is working now but the plotter still does not execute any cut, refer to “ERROR 1 instruction not recognised” and follow the instructions. Check if camera restarts, and try again.

If the camera is working, but the plotter doesn’t execute any cut, refer to “ERROR 1 instruction not recognized” and follow the instructions.