Duplo

from print to documents

OPERATION MANUAL

SOFTWARE
PC CONTROLLER

PC CONTROLLER

[DBMi Saddle System]

Be sure to read this manual prior to use.
Please leave this manual at the site of use for easy reference.

Introduction

Thank you for purchasing a Duplo product.

Be sure to read this manual prior to using the product.

After reading, leave the manual at the site of use for easy reference whenever questions related to the product arise in the future.

Symbols

In this manual, several symbols are used to indicate important warnings. Please make sure to read instructions accompanied by these symbols. These symbols have the following meanings.

Note Describes instructions which must be followed in use.
Be sure to read the instructions to avoid problems due to incorrect operations.

Memo Indicates supplementary or useful information.

Ref. Describes names of related items and supplementary instructions.

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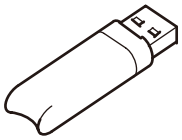
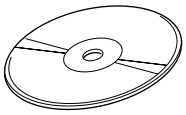
- Celeron and Core are registered trademarks or trademarks of Intel Corporation in the U.S. and other countries.
- All other product names and company names used in this manual are trademarks or registered trademarks of the respective companies.

Accessories



Protection key



CD-R unit

System Requirements

The following hardware and software are required to use the PC CONTROLLER.

- CPU
  Minimum: Celeron® M CPU 410 1.46 GHz and the equivalent processor
  Recommended: Core™2Duo T8100 2.1 GHZ and the equivalent processor
- Display
  Minimum: 1024 x 768 pixels resolution
  Recommended: 1280 x 1024 pixels resolution
- OS
  – Windows® XP Service Pack3 or later
  – Windows Vista® (32bit) Service Pack1 or later
  – Windows® 7 (32/64bit)
- RAM
  Minimum: 1 GB
  Recommended: 2 GB
- Hard-disk space
  10 GB or more
- CD-ROM drive (only at the time of installation)
- Internet connection environment (only at the time of installation)
- USB
  1.1 or more
- USB port
  2 ports (for USB cable and for protection key)

The following devices can be controlled when using the PC CONTROLLER

– DBM-400STR
– DSC-10/60i
– DCR-ST
– DBMS-F
– DBMS-S
– DBMS-T
– DKT-200

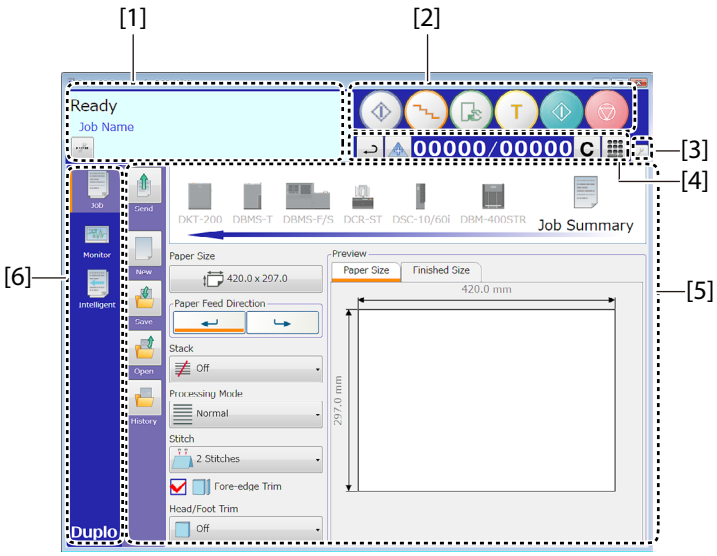
Contents

Memo

Chapter 1 Before Use

1. Outline of Screen

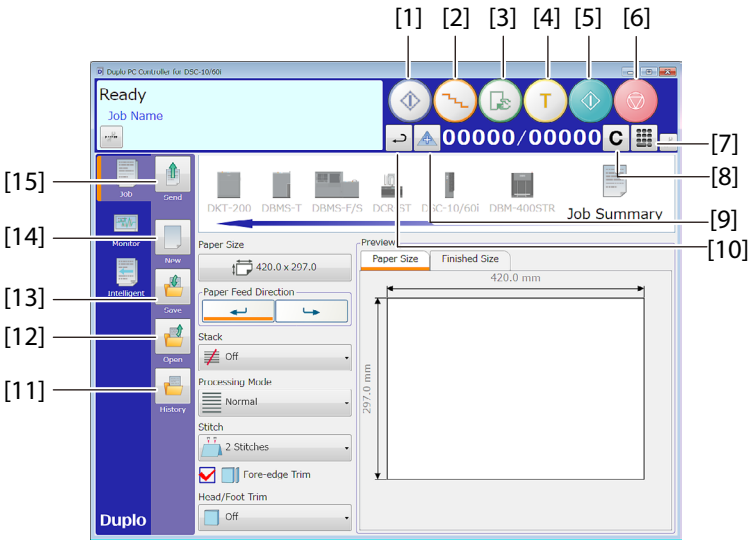
1-1. General



No.	Name	Function
[1]	Message box	Displays messages on the status of the bookletmaking system, and status of the PC CONTROLLER.
[2]	Action buttons	Buttons for adjusting, operating or stopping the bookletmaking system and testing bookletmaking.
[3]	Menu buttons	Displays the setting menu of the PC CONTROLLER.
[4]	Counter	Displays the number of sets input and the number of sets processed.
[5]	Work area	Displays the job window or the monitor window. The Job window displays the details of the job that you are currently setting. The Monitor window displays errors that have occurred in each machine.
[6]	Screen switch button	Button for switching the work area. Pressing the [Job] button displays the job window and pressing the [Monitor] button displays the monitor window. The job window is displayed on the top screen.

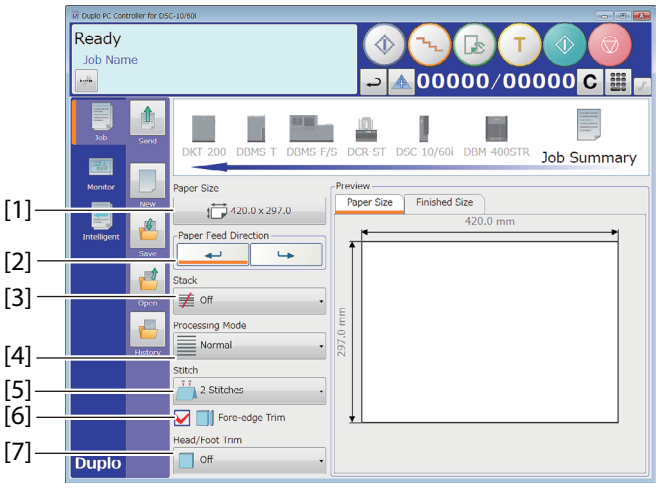
1-2. Details

A. Buttons



No.	Name	Function	
[1]	Preset button	Performs presetting. The presetting allows the system to acquire data on paper.	
[2]	Step button	Performs step by step operations to adjust positions of each guide on the bookletmaking system.	
[3]	Hand feed button	Button for feeding paper by hand.	
[4]	Test button	Button for bookletmaking only one set on the bookletmaking system to check the bookletmaking state.	
[5]	Start button	Button for starting bookletmaking. Display changes to ⏸ during bookletmaking operation. Click this button to change to the waiting mode.	
[6]	Stop button	Button for stopping bookletmaking.	
[7]	Numeral value input button	Button for inputting the number of sets.	
[8]	Count clear button	Clear the number of sets processed if the number is not 0, and clear the number of sets to be processed if it is 0.	
[9]	Count method switch button	Switches between counting up and counting down the number of sets processed.	
		▲(Count up)	Count up the number of sets processed from 0.
		▼(Count down)	Decrease the number of sets processed from the number of sets to be processed and displays the remaining number of sets.
[10]	Count repeat setting button	Sets count repeat on or off.	
		⮌ (OFF)	When completing the number of sets to be processed, the bookletmaking system will stop automatically.
		⮌ (ON)	When completing the number of sets to be processed, the bookletmaking system will clear the number of sets processed, and enter the waiting mode.
[11]	History button	Button for displaying the history of jobs sent to the bookletmaking system.	
[12]	Open button	Button for opening saved job data and displaying it in the job window.	
[13]	Save button	Button for saving created jobs.	
[14]	New job button	Button for creating new jobs.	
[15]	Send button	Button for sending jobs displayed on the job window to the bookletmaking system.	

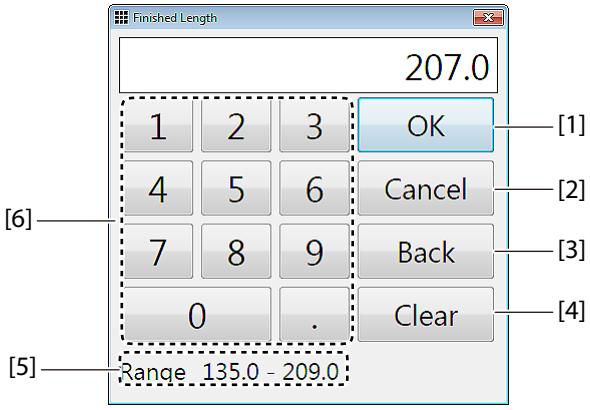
B. Setting Items



No.	Name	Function
[1]	Paper Size	Displays the size of paper stacked on the paper feeding unit. Select the size from here.
[2]	Paper Feed Direction	Displays the paper feed direction. Select a direction from here.
[3]	Stack	Displays the method to stack paper on the stacker. Select a stacking method from here. This is displayed only when the stacker is connected to the system.
[4]	Processing Mode	Displays the process mode (paper feeding method). Select a mode from here.
[5]	Stitch	Displays the stitching type. Select a type from here.
[6]	Fore-edge Trim	Displays whether fore-edge trimming is required or not.
[7]	Head/Foot Trim	Displays whether head/foot trimming is required or not. This is displayed only when the DKT-200 is connected to the system.

C. Numeral Value Input Screen

Clicking the numeral value input button displays the numeral value input screen, which allows you to change values. When characters of ○○ mm in the preview area on each screen is displayed in blue, clicking the blue characters displays the numeral value input screen.



No.	Name	Function
[1]	OK	Determines the input value and closes the numeral value input screen.
[2]	Cancel	Closes the numeral value input screen without changing the value.
[3]	Back	Deletes only one digit of numeral value input.
[4]	Clear	Completely deletes the numeral value input.
[5]	Setting range display area	Displays the adjustable range of each setting.
[6]	Keypad	Use to input numeral value.

Chapter 2 Starting/Stopping/Default Settings

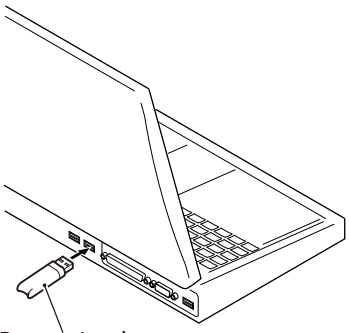
1. Starting Bookletmaking System

1 **Make sure that the cable connector connecting the DSC-10/60i and PC is correctly inserted.**

2 **Start the PC.**

3 **Turn on the power of the DSC-10/60i.**
The power switches of all the machines connected are turned on simultaneously.

4 **Connect the protect key.**



5 **Start the PC CONTROLLER.**
After quitting the PC CONTROLLER, wait for five seconds or more before starting it.

2. Ending Bookletmaking System

1 **Make sure that the bookletmaking system has completely ended processing.**

2 **Quit the PC CONTROLLER.**
If data has not been saved, a confirmation message will be displayed.
Click [Yes] or [No].

3 **Turn off the power of the DSC-10/60i.**
The power switches of all the machines connected are turned off simultaneously.

3. Default Settings

It is needed to change the default settings for the following cases before starting bookletmaking operation. Contact your dealer.

3-1. When the Default Settings are Needed

- When changing the unit of length used for bookletmaking operation from mm to inch, or from inch to mm.
- When changing the language displayed on the PC CONTROLLER.
- When adding optional parts to the machine in the system.
- When changing optional parts used in the system.
- When changing the connection of the DKT-200.

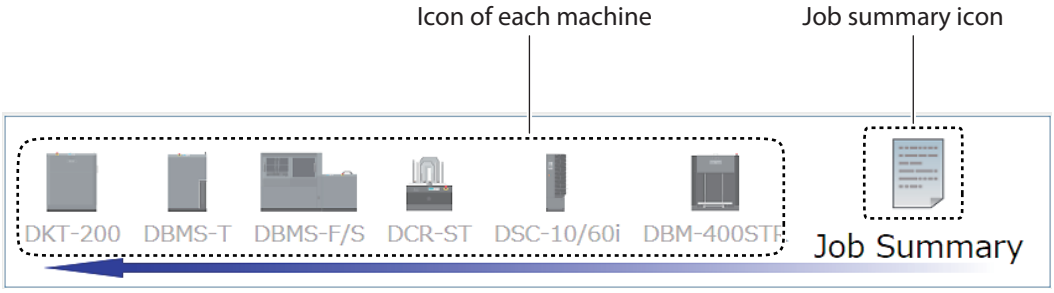
3-2. After Re-installation

Some data files of PC CONTROLLER such as setting files are kept even after removing from the PC used. The unit can be used continuously in the state set before uninstallation even after re-installation.

However, the default settings are needed once you have deleted all the folders related to the PC CONTROLLER from of the PC.

Chapter 3 Setting and Saving Jobs

The job summary icon and the icon of each machine connected to the system are displayed in the job window. Clicking each icon displays the setting screen. First make basic settings such as paper size and bookletmaking mode on the job summary screen, and then make further detailed settings on the setting screen of each machine.



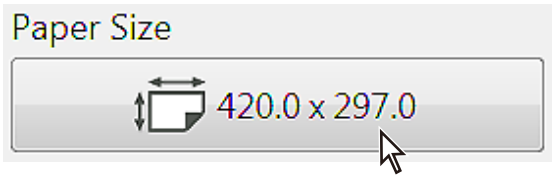
1. Setting Job Summary

Make settings related to the whole bookletmaking operations on the job summary screen.
Depending on the intended use, follow the procedures below.

- Perform bookletmaking (stitch and trim): "1-1. When Feeding Paper to the Left" (p.3-1)
- Feed paper to the left side without bookletmaking and stack paper on the DCR-ST: "1-2. When Stacking Paper on the DCR-ST with Left Feed"" (p.3-3)
- Stack paper on the DBM-400STR: "1-3. When Feeding Paper to the Right" (p.3-4)

Memo Depending on a paper size, some items cannot be selected.

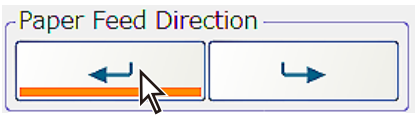
1-1. When Feeding Paper to the Left



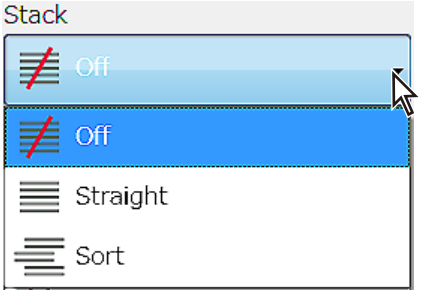
1 **Click the [Paper Size] button.**
The paper size setting window is displayed.

2 **Select a paper size.**
For custom size settings, refer to "10-2. Setting the Custom Size" (☞ p.3-34).

3 **Set [Paper Feed Direction] to left.**



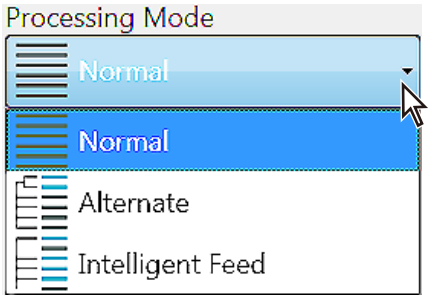
4 **Click the drop-down arrow of [Stack].**
The stacking methods are displayed.



5 **Select [Off].**

6 **Click the drop-down arrow of [Processing Mode].**

The processing modes are displayed.



7 **Select a processing mode.**

- Normal
- Alternate
- Intelligent Feed*

* Make detailed settings on the intelligent setting screen. Refer to "9. Setting Intelligent Feed" (☞ p.3-24) for details.

8 **Click the drop-down arrow of [Stitch].**

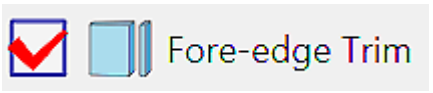
Stitching modes are displayed.

9 **Select a stitching mode.**

- Off
- 2 Stitches
- 3 Stitches*
- 4 Stitches*

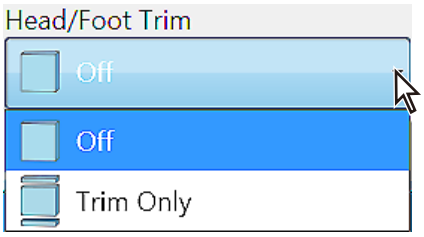
* This is displayed when the optional kit has been installed.

10 **Select the check box of [Fore-edge Trim].**



11 **Click the drop-down arrow of [Head/Foot Trim].**

This is displayed when the DKT-200 is connected to the system.



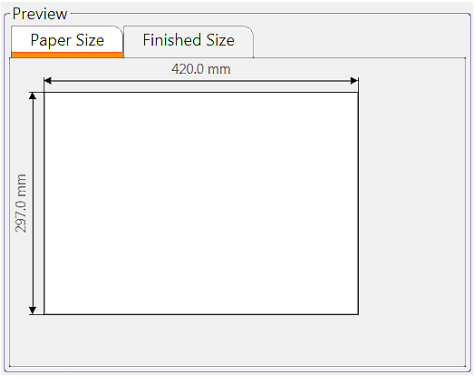
12 **Select a head/foot trimming mode.**

- Off
- Trim Only
- Trim+Punch*
- Trim+Gutter*

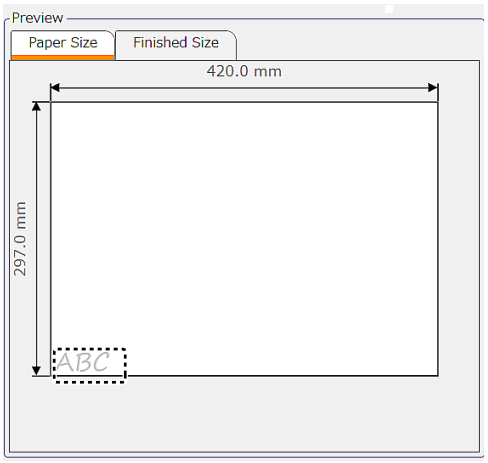
* This is displayed when the optional kit has been registered.

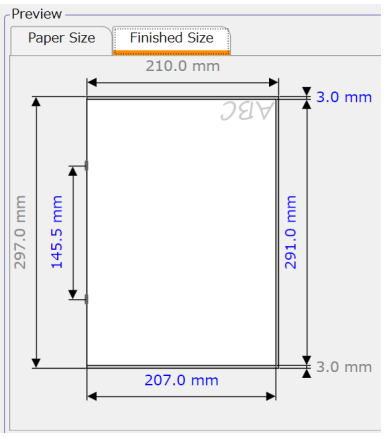
13 Check [Paper Size] and [Finished Size] in the preview area.

The finished size can be set in the [Finished Size] tab.



Memo [ABC] displayed in the preview area shows a head and foot position of the paper. As shown in the figure at the left below, the top is head and the bottom is foot in the [Paper Size] screen. On the other hand, as shown in the figure at the right below, in the [Finished Size] screen [ABC] is displayed up side down when the DBMS-F is connected. This is because the paper direction is turned 180 degrees by the DBMS-F/S and the head and foot position is switched at the trimmer.

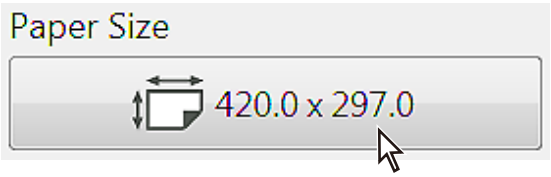




1-2. When Stacking Paper on the DCR-ST with Left Feed

1 Click the [Paper Size] button.

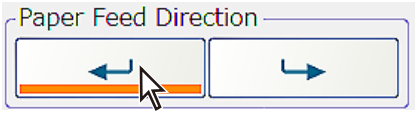
The paper size setting window is displayed.



2 Select a paper size.

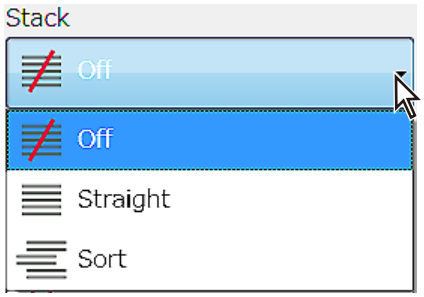
For custom size settings, refer to "10-2. Setting the Custom Size" (☞ p.3-34).

3 Set [Paper Feed Direction] to left.



4 **Click the drop-down arrow of [Stack].**
The stacking methods are displayed.

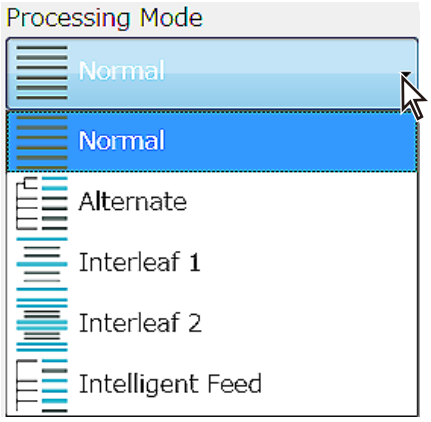
5 **Select [Straight] or [Sort].**



6 **Click the drop-down arrow of [Processing Mode].**
The processing modes are displayed.

7 **Select a processing mode.**
- Normal
- Alternate
- Interleaf 1
- Interleaf 2
- Intelligent Feed*

* Make detailed settings on the intelligent setting screen. Refer to "9. Setting Intelligent Feed" (☞ p.3-24) for details.

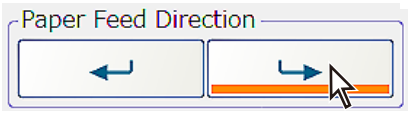


1-3. When Feeding Paper to the Right

1 **Click the [Paper Size] button.**
The paper size setting window is displayed.

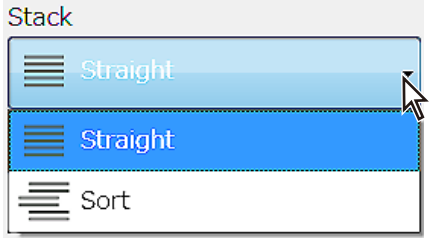
2 **Select a paper size.**
For custom size settings, refer to "10-2. Setting the Custom Size" (☞ p.3-34)

3 **Set [Paper Feed Direction] to right.**



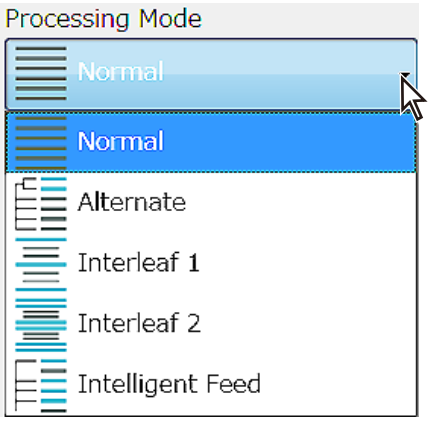
4 **Click the drop-down arrow of [Stack].**
The stacking methods are displayed.

5 **Select a stacking method.**
- Straight
- Sort



6 **Click the drop-down arrow of [Processing Mode].**

The processing modes are displayed.



7 **Select a processing mode.**

- Normal
- Alternate
- Interleaf 1
- Interleaf 2
- Intelligent Feed*

* Make detailed settings on the intelligent setting screen. Refer to "9. Setting Intelligent Feed" (☞ p.3-24) for details.

2. Setting the DBM-400STR

Memo The DBM-400STR menu is displayed only when you have set [Paper Feed Direction] to right.

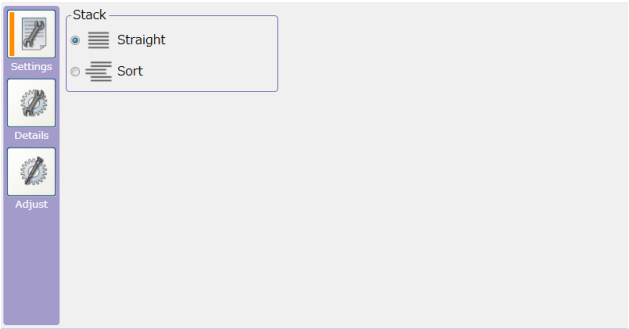
2-1. Making Basic Setting

Memo Only when [Paper Feed Direction] is set to right, the setting screen is displayed.

1 **Click the DBM-400STR icon.**

DBM-400STR

The setting screen is displayed.



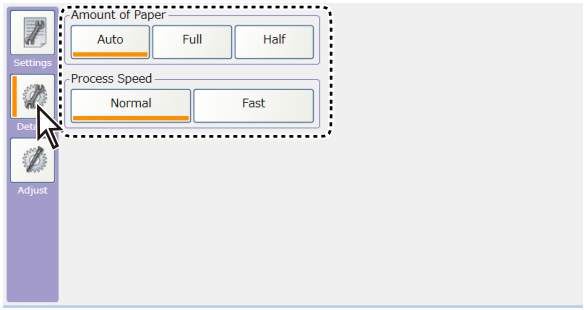
2 **Select a stacking method.**

Item	Explanation	Default
Stack	Select a stacking method on the stacker. - Sort - Straight	—

2-2. Making Detailed Settings

1 **Click the [Details] button.**
The details setting screen is displayed.

2 **Set the item as needed.**
The items that can be set are as follows.

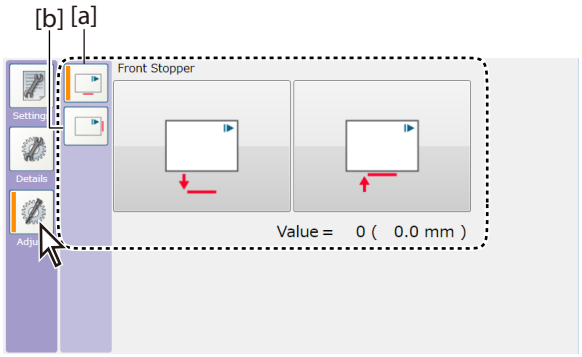


Item	Explanation	Default
Amount of Paper	Select the amount of paper to be stacked.. - Auto - Full - Half	Auto
Process Speed	Select process speed. - Normal - Fast	Normal

2-3. Making Fine Adjustments

1 **Click the [Adjust] button.**
The adjustment setting screen is displayed.

2 **Set the item as needed.**
The items that can be adjusted on the PC CONTROLLER are as follows.
-[a] Front Stopper (adjustable range: -9 to +9)
-[b] Head Stopper (adjustable range: -9 to +9)



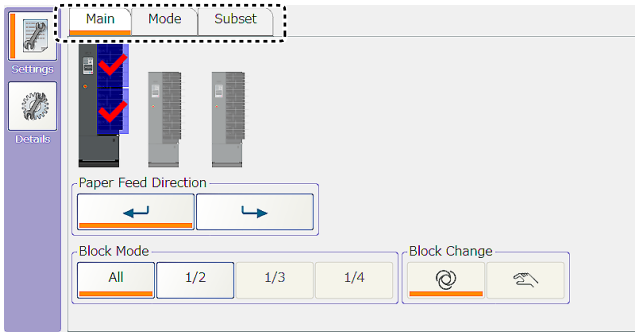
3. Setting the DSC-10/60i

3-1. Making Basic Setting

1 **Click the DSC-10/60i icon.**


DSC-10/60i

The setting screen is displayed.
There are three tabs on the setting screen: [Main][Mode] and [Subset].

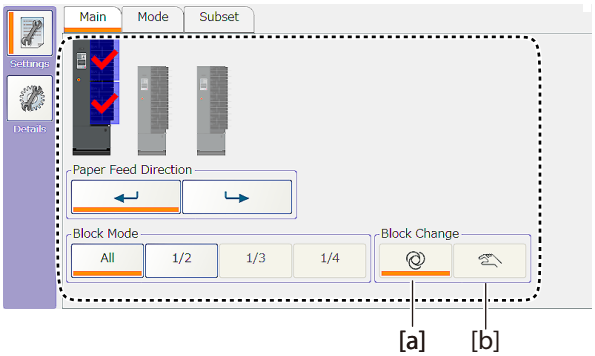


2 Click each tab to open the setting screen.

3 Set the item as needed.

The items that can be set are as follows.

[Main] Screen



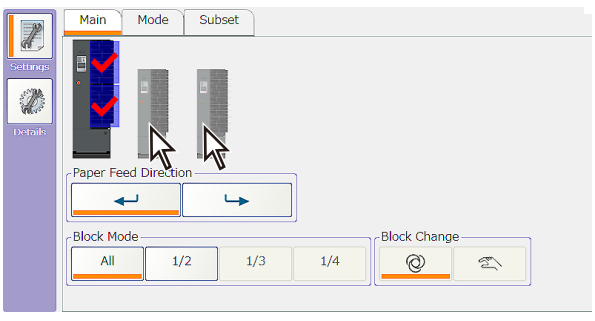
Item	Explanation	Default
Tower used	Select the tower to be used. For details, refer to "A. Setting Tower to be Used"(☞ p.3-7).	—
Paper Feed Direction	Select the paper feed direction of the tower to be used. You may not be able to select a desired direction depending on the machines connected.	Left
Block Mode	Select a block mode in which all the paper feed bins are divided into a few blocks. When you have selected other than [All], apply a check mark to the block to be used. For details, refer to "B. Setting the Block Mode"(☞ p.3-8).	All
Block Change	Select the method to start feeding a next block. When set to auto, feeding starts from a next block automatically. - [a] Auto - [b] Manual	Auto

A. Setting Tower to be Used

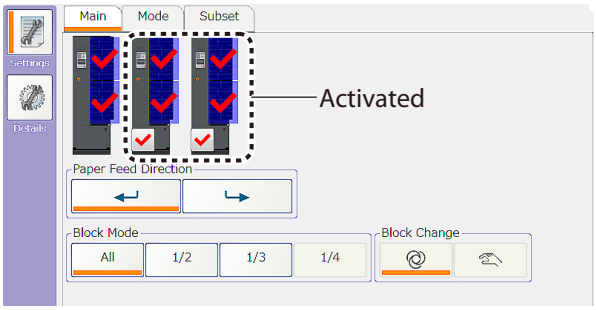
The towers connected to the system are displayed. Activate or deactivate the tower in the following way.

Activate

1) Click on the figure of the tower to be used.

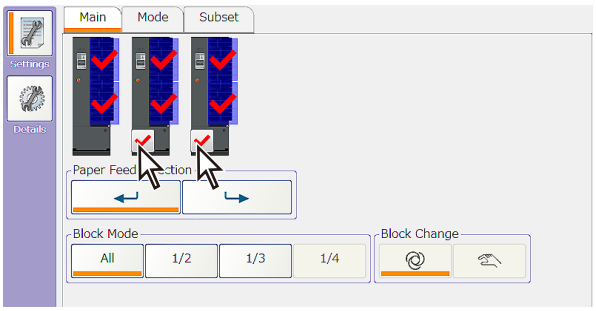


The clicked figure is enlarged and the tower is activated.

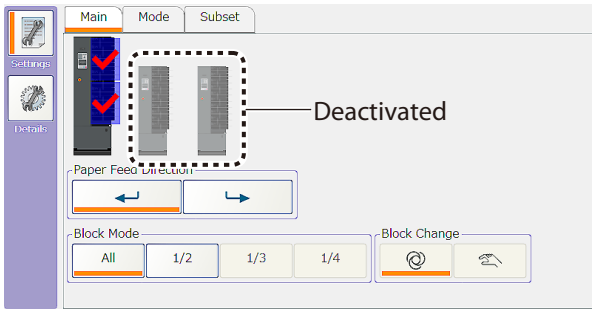


Deactivate

1) Click the check button displayed in the bottom of the tower that you are not going to use.



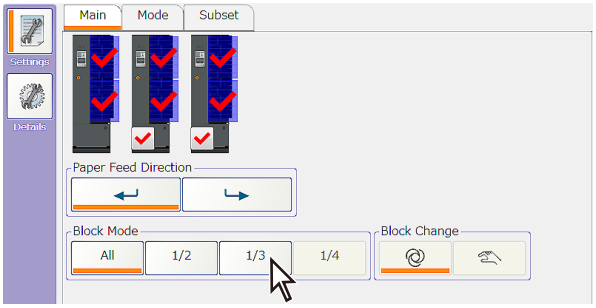
The clicked figure is shrunk and the tower is deactivated.



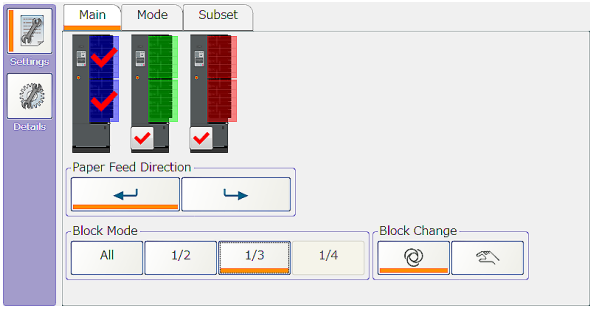
B. Setting the Block Mode

The following procedures are shown as an example of dividing blocks into three.

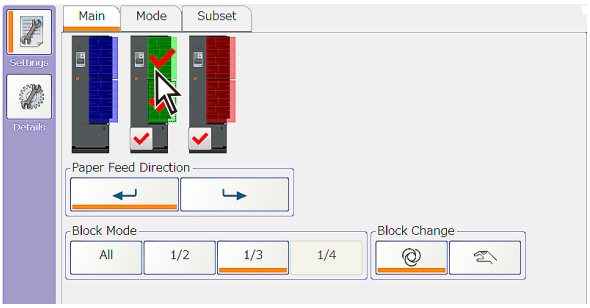
1) Select [1/3].



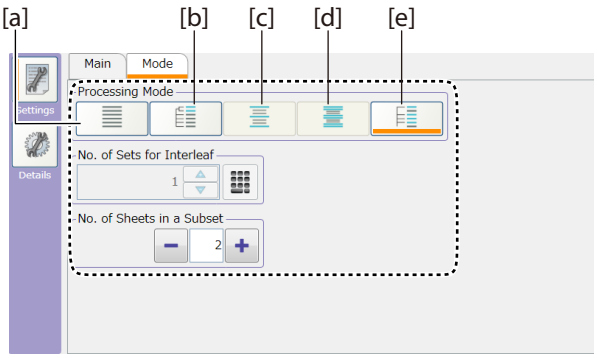
The screen to the right is displayed.



2) Click the block to be used to apply a check mark.
Paper is fed from the block with a check mark.

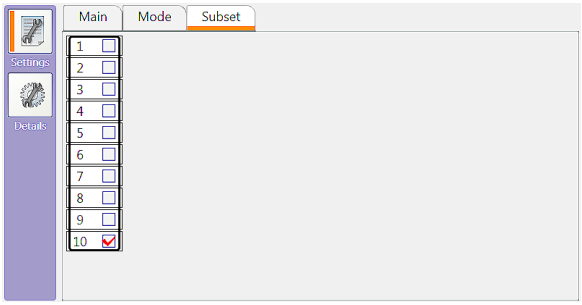


[Mode] Screen



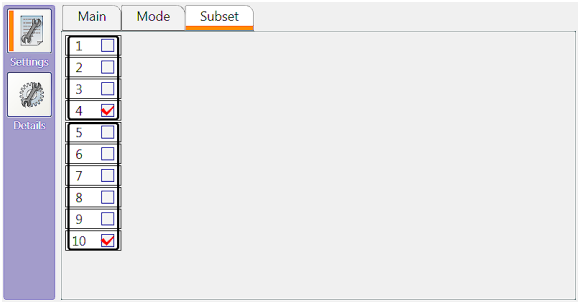
Item	Explanation	Default
Processing Mode	Select a processing mode. - [a] Normal - [b] Alternate - [c] Interleaf1*1 - [d] Interleaf2*1 - [e] Intelligent Feed*2 *1 This is displayed depending on a machine connected. *2 Make detailed settings on the intelligent setting screen. Refer to "9. Setting Intelligent Feed" (☞ p.3-24) for details.	Normal
No. of Sets for Interleaf	Specify the number of sets for which a piece of interleaf paper is inserted. This can be specified only when [Interleaf] is selected for [Processing Mode].	1
No. of Sheets in a Subset	Specify the number of sheets in a subset. - 2 to 10 *This is displayed only when [Processing Mode] is set to [Intelligent] and [Stack] is set to [Off].	2

[Subset] Screen



Make settings for "subset feeding" to feed a set of paper after dividing into several sets.
The following procedures are shown as an example of using three towers and setting the block mode to [1/3].

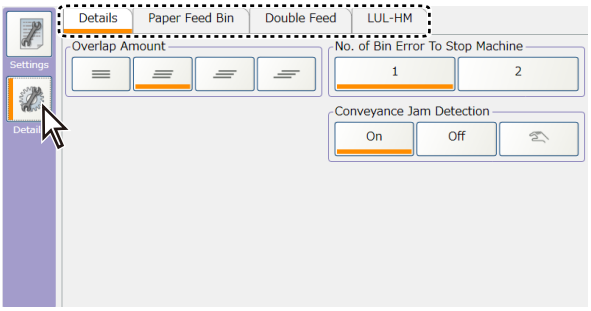
1) Click [Subset].
   The screen shown above is displayed.
2) Click the check box of the paper feed bin to be divided to apply a check mark.



Memo
- The subsets cannot be made between different towers.
- The maximum number of subsets is ten.
- Even when you use the block mode in other than [All], make subset settings for only one block. Even the block shifts from one to the next, the subsets are fed in the same pattern.

3-2. Making Detailed Settings

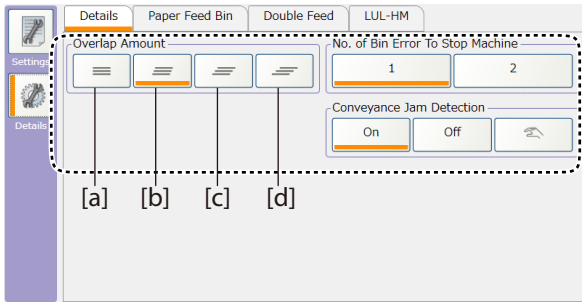
1 **Click the [Details] button.**
The details setting screen is displayed.
There are four tabs on the details setting screen: [Details] [Paper Feed Bin] [Double Feed] and [LUL-HM].



2 **Click each tab to open the setting screen.**

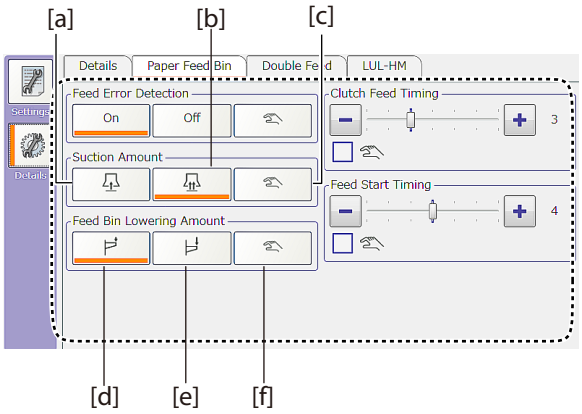
3 **Set the item as needed.**
The items that can be set are as follows.

[Details] Screen



Item	Explanation	Default
Overlap Amount	Set the overlap amount. - [a] 0 mm/0 inch - [b] 2.5 mm/0.10 inch - [c] 5 mm/0.20 inch - [d] 10 mm/0.39 inch	0 mm/0 inch *2.5 mm/0.10 inch when the DBMS-F/S is connected.
No. of Tray Error to Stop Machine	Used to select whether to activate the waiting mode every time a paper feed error occurs or to activate the waiting mode after the same error occurs twice continuously on the same paper feed bin, if a paper feed error has occurred. - 1 - 2* *When [Processing Mode] is set to [Interleaf1] [Interleaf2] or [Intelligent Feed], you cannot set [No. of Tray Error to Stop Machine] to [2].	1
Conveyance Jam Detection	Select whether to detect a paper jam in the conveyance path. - On - Off - Manual* *You can make settings for the whole tower.	On

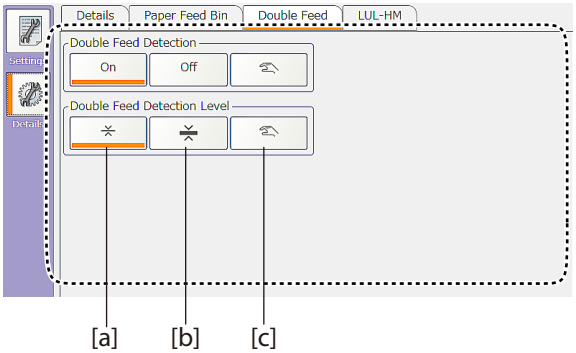
[Paper Feed Bin] Screen



Item	Explanation	Default
Feed Error Detection	Select wheter to use the feed error detection function. Normally set it to [On]. When other than [Off] is selected, you need to perform presetting. - On - Off - Manual*	On
Suction Amount	Select the suction amount. When suction is so strong that mis-feeding occurs, select "weak." - [a] Weak - [b] Strong - [c] Manual*	Strong
Tray Lowering Amount	Select the tray lowering amount. When collating folded paper, select "large." - [d] Small - [e] Large - [f] Manual*	Small
Clutch Feed Timing	Specify the clutch feed timing (the period of rotation of the conveyance belt). To collate long paper such as A3 paper, increase the timing. To collate short paper, decrease the timing. - 1 to 7 - Manual*	3
Feed Start Timing	Speify the feed start timing. "-" makes the timing faster and "+" makes it slower. - 1 to 7 (1: -10 mm/-0.39 inch, 2: -5 mm/-0.20 inch, 3: -2.5 mm/-0.10 inch, 4: 0 mm/0 inch, 5: +2.5 mm/+0.20 inch, 6: +5 mm/0.20 inch, 7: +10 mm/0.39 inch) - Manual*	4

* You can make settings for each paper feed bin.

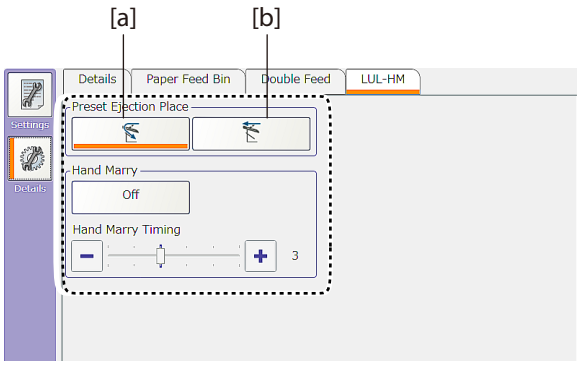
[Double Feed] Screen



Item	Explanation	Default
Double Feed Detection	Select wheter to use the double feed detection function. Normally set it to [On]. When other than [Off] is selected, you need to perform presetting. - On - Off - Manual*	On
Double Feed Detection Level	Select the double feed detection level. Normally set it to thin paper. However, if a double feed is detected even when a double feed has not occurred, change the setting to thick paper. You need to perform presetting once you change the setting. - [a] Thin paper - [b] Thick paper - [c] Manual*	Thin paper

* You can make settings for each paper feed bin.

[LUL-HM] Screen



Item	Explanation	Default
Preset Ejection Place	Select the ejection place for the paper used for presetting. - [a] Reject tray - [b] Downstream unit When other than [Normal] is selected for [Processing Mode], "downstream unit" is invalid. Depending on [Processing Mode], setting will be changed to "reject tray" automatically.	Reject tray
Hand Marry	Specify whether to use the hand marry. - On - Off	Off
Hand Marry Timing	When you set [Hand Marry] to [On], specify the timing. Adjustable range: 1 to 6	3

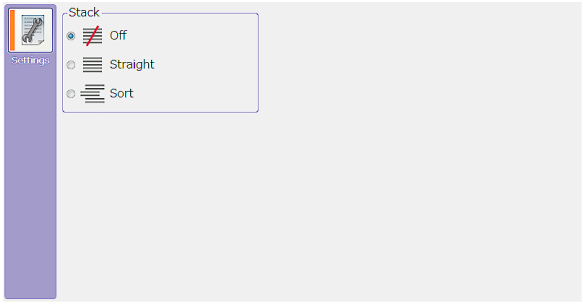
*For merge collation, the total number of sheets fed from the collator and stacked on the LUL-HM as well as their merged thickness needs to meet the specifications of the downstream unit.
Example) For the DBMS-F, the merged number of sheets must be ten or less and the merged thickness must be 1 mm/0.04 inch or less.

4. Setting the DCR-ST

Memo Only when [Paper Feed Direction] is set to left, the setting screen is displayed.

1 Click the DCR-ST icon.

The setting screen is displayed.



2 Select a stacking method on the stacker.

Item	Explanation	Default
Stack	Select a stacking method on the stacker. When set to Off, paper is sent to the downstream unit through the bypass. - Off* - Straight - Sort	—

*This is not displayed when there is no downstream unit connected to the stacker.

5. Setting the DBMS-F/S

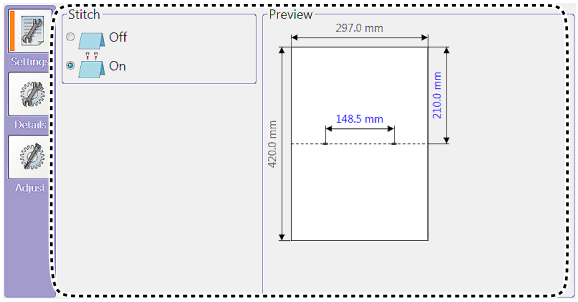
Memo Only when [Paper Feed Direction] is set to left and [Stack] is set to [Off], the setting screen is displayed.

5-1. Making Basic Setting

1 Click the DBMS-F/S icon.

DBMS-F/S

The setting screen is displayed.



2 Set the item as needed.

The items that can be set are as follows.

Item	Explanation	Default
Stitch	Select a stitching mode. - Off - On (2 stitches) - 3 Stitches* - 4 Stitches* *This is displayed when the optional kit has been installed.	On
Preview	Specify [Stitch Width] and [Scoring Position].	—

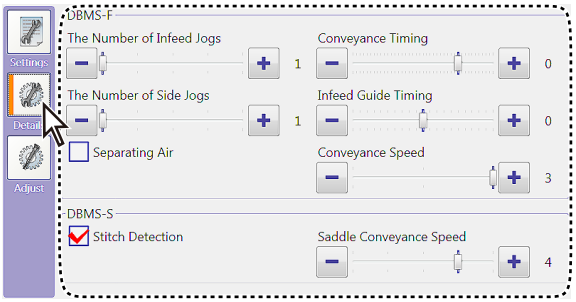
When you have changed [Stitch] and [Stitch Width], [Head/Foot Trim] for the DKT-200 is changed to [Off]. When you have changed [Scoring Position], [Trim Position] of the DBMS-T is changed as well. In the bottom of the window, the message [You have changed the setting. This change has also changed settings of the downstream.] is displayed. Check the setting of the downstream unit.

5-2. Making Detailed Settings

1 **Click the [Details] button.**

The details setting screen is displayed.

2 **Set the positions of the guides and stoppers as needed.**



DBMS-F

Item	Explanation	Default
The Number of Infeed Jogs	Specify the number of infeed jogging. Adjustable range: 1 to 5	1
The Number of Side Jogs	Specify the number of side jogging. Adjustable range: 1 to 5	1
Separating Air	Set whether to use the separating air. When paper does not align at the in-feed guide because the paper size is large or the number of sheets are large, use the separating air.	Off
Conveyance Timing	Specify the horizontal conveyance timing. The larger the number, the faster the timing. The smaller the number, the slower the timing. Adjustable range: -30 to 10 Amount per unit: 11 mm (0.43 inch)	0
Infeed Guide Timing	Specify the infeed guide timing. The smaller the number, the slower the timing. Adjustable range: -10 to 10 Amount per unit: 11 mm (0.43 inch)	0
Conveyance Speed	Specify the conveyance speed. Adjustable range: 1 to 5 1=800 mm (31.50 inches)/second, 2=1000 mm (39.37 inches)/second, 3=1100 mm (43.31 inches)/second	3

DBMS-S

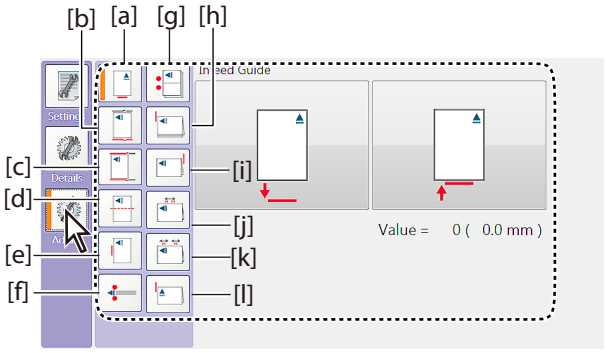
Item	Explanation	Default
Stitch Detection	Specify whether to use the stitch detection function.	On
Saddle Conveyance Speed	Specify the saddle conveyance speed. Adjustable range: 1 to 5 1=270 mm (10.63 inches)/second, 2=710 mm (27.95 inches)/second, 3=920 mm (36.22 inches)/second, 4=1200 mm (47.24 inches)/second, 5=1400 mm (55.12 inches)/second	4

5-3. Making Fine Adjustments

1 **Click the [Adjust] button.**

The adjustment setting screen is displayed.

2 **Click each tab to open the setting screen.**



The adjustable items on the PC CONTROLLER are as follows.

- [a] Infeed Guide (Adjustable range: -20 to 20)
- [b] Side Guide (Adjustable range: -20 to 20)
- [c] Side Guide Adjustment (Adjustable range: -10 to 10)
- [d] Scoring Position (Adjustable range: -20 to 20)
- [e] Head Stopper (Adjustable range: -20 to 20)
- [f] Score Roller Gap (Adjustable range: -9 to 9)
- [g] Fold Roller Gap (Adjustable range: -9 to 9)
- [h] Buffer Stopper (Adjustable range: -25 to 25)
- [i] Pusher Position (Adjustable range: -80 to 80)
- [j] Stitch Position (Adjustable range: --80 to 80)*1
- [k] Stitch Width (Inside) (Adjustable range: -5 to 5)
  Stitch Width (Outside) (Adjustable range: -15 to 5)*2
- [l] Tucker Stopper (Adjustable range: -80 to 80)

*1: The stitch position is limited depending on the pusher position.

*2: This is displayed when [4 Stitches] is selected.

Memo Some of the items cannot be adjusted depending on the settings you made.

6. Setting the DBMS-T

Memo Only when [Paper Feed Direction] is set to left and [Stack] is set to [Off], the setting screen is displayed.

6-1. Making Basic Setting

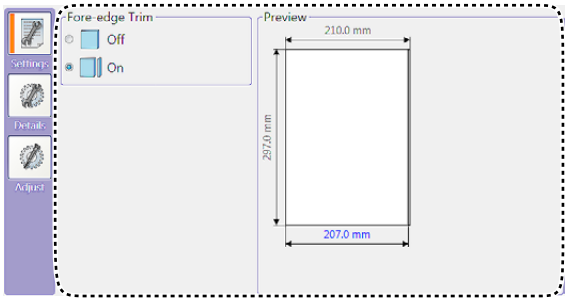
1 **Click the DBMS-T icon.**

DBMS-T

The setting screen is displayed.

2 **Set the item as needed.**

The items that can be set are as follows.



Item	Explanation	Default
Fore-edge Trim	Select whether to trim the fore-edge. - On - Off	On
Preview	Specifies the length after fore-edge trimming [Trim Position].	—

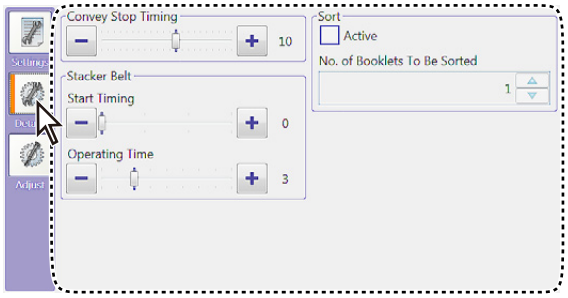
6-2. Making Detailed Settings

1 **Click the [Details] button.**

The details setting screen is displayed.

2 **Set the item as needed.**

The items that can be set are as follows.



Item	Explanation	Default
Convey Stop Timing	Specify the convey stop timing. Adjustable range:-2 to 19	10
Stacker Belt Start Timing*1	Specify the stacker belt start timing. The larger the number, the slower the timing. The smaller the number, the faster the timing. Adjustable range: 0 to 3	0
Stacker Belt Operating Time*1	Specify the stacker belt operating time. The larger the number, the longer the time. The smaller the number, the shorter the time. Adjustable range: 1 to 9	3
Sort*2*3	Specify whether to activate the sorting function.	Off
No. of Booklets To Be Sorted*2	Specify the number of booklets to be sorted. Adjustable range: 1 to 1000	1

*1: When the downstream unit is connected to the DBMS-T, this item is not displayed.

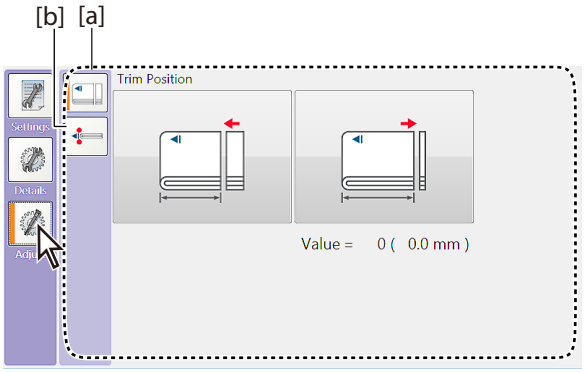
*2: When the downstream unit is connected to the DBMS-T and the kicker is not connected to the system, this item is not displayed.

*3: After sending job data to the bookletmaking system or clearing the number of sets, sorting will be started from the beginning. Therefore when you have resent job data, the number of sets processed that is displayed on the counter may not match the number of sorted booklets. For example, when [No. of Booklets To Be Sorted] is set to 5 and the number of sets already processed is 13, there should be two bundles of processed booklets on the stacker. However if you resend job data at this point, the machine will start sorting when the number of sets processed reaches 18 instead of 15. As a result, there will be three bundles of processed booklets with 5 sets in each and one bundle of processed booklets with 3 sets on the stacker.

6-3. Making Fine Adjustments

1 **Click the [Adjust] button.**

The adjustment screen is displayed.



2 **Set the item as needed.**

The items that can be adjusted on the PC CONTROLLER are as follows.

-[a] Trim Position (adjustable range: -25 to +25)*1

-[b] Roller Gap (adjustable range: -12 to +20)*1

*1:The adjustable range is limited depending on the trimming position.

*2: The adjustable range is limited depending on the number of sheets.

Memo Some of the items cannot be adjusted depending on the settings you made.

7. Setting the DKT-200

Memo Only when [Paper Feed Direction] is set to left and [Stack] is set to [Off], the setting screen is displayed.

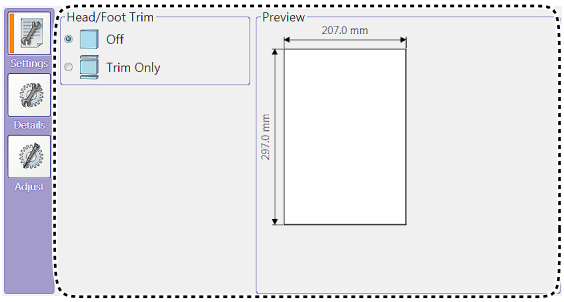
7-1. Making Basic Setting

1 **Click the DKT-200 icon.**

The setting screen is displayed.

2 **Set the item as needed.**

The items that can be set are as follows.



Item	Explanation	Default
Head/Foot Trim	Set the details of head/foot trimming. - Off - Trim Only - Trim+Punch* - Trim+Gutter* *This is displayed when the optional kit has been registered.	Off

Item	Explanation	Default
Preview	Specify the length after head/foot trimming [Trim Position].	—

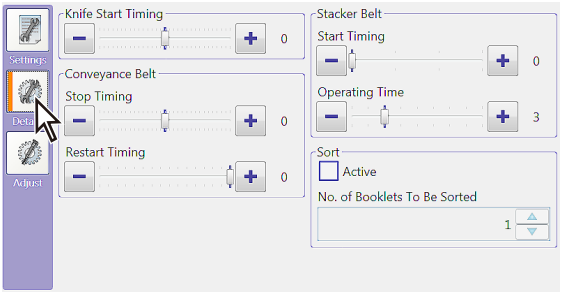
7-2. Making Detailed Settings

1 **Click the [Details] button.**

The details setting screen is displayed.

2 **Set the item as needed.**

The items that can be set are as follows.



Item	Explanation	Default
Knife Start Timing	Specify the knife start timing. The larger the number, the faster the timing. The smaller the number, the slower the timing. Adjustable range: -15 to 15	0
Conveyance Belt Stop Timing	Specify the conveyance belt stop timing. The larger the number, the faster the timing. The smaller the number, the slower the timing. Adjustable range: -15 to 15	0
Conveyance Belt Restart Timing	Specify the conveyance belt restart timing. The larger the number, the faster the timing. The smaller the number, the slower the timing. Adjustable range: -15 to 0	0
Stacker Belt Start Timing	Specify the stacker belt start timing. The larger the number, the slower the timing. The smaller the number, the faster the timing. Adjustable range: 0 to 3	0
Stacker Belt Operating Time	Specify the stacker belt operating time. The larger the number, the longer the time. The smaller the number, the shorter the time. Adjustable range: 1 to 9	3
Sort*1*2	Specify whether to activate the sorting function.	Off
No. of Booklets To Be Sorted*	Specify the number of booklets to be sorted. Adjustable range: 1 to 999	1

*1: This is displayed when the kicker is attached.

*2: After sending job data to the bookletmaking system or clearing the number of sets, sorting will be started from the beginning. Therefore if you send job data again, the number of sets processed displayed on the counter may not match the number of sorted booklets. For example, when [No. of Booklets To Be Sorted] is set to 5 and the number of sets already processed is 13, there should be two bundles of processed booklets on the stacker. However if you send job data again at this point, the machine will start sorting when the number of sets processed reaches 18 instead of 15. As a result, there will be three bundles of processed booklets with 5 sets in each and one bundle of processed booklets with 3 sets on the stacker.

7-3. Making Fine Adjustments

1 **Click the [Adjust] button.**

The adjustment screen is displayed.

2 **Set the item as needed.**

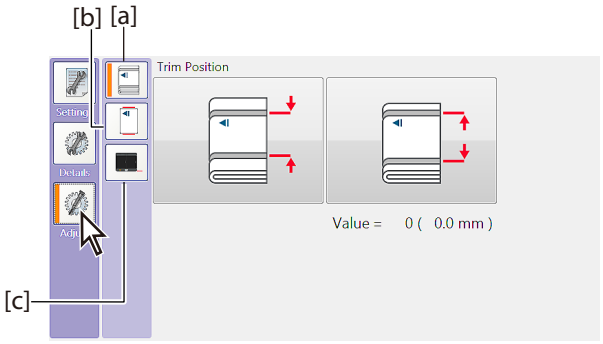
The items that can be adjusted on the PC CONTROLLER are as follows.

-[a] Trim Position (adjustable range: -15 to +15)*1

-[b] Head/Foot Guide (adjustable range: -15 to +15)*1

-[c] Movable Table (adjustable range: -15 to +15)

*The adjustable range may be limited depending on the situation.



Memo Some of the items cannot be adjusted depending on the settings you made.

8. Setting the DKT-200 Head/Foot Trim Width

In the normal head/foot trimming, the same amount is trimmed at both sides. When the OFFSET TRIM KIT (option) is installed to the DKT-200, you can specify different trimming width between the head and the foot. "Offset trim" means to widen trimming width either at the head or the foot.

Note **After setting the trimming width on the PC CONTROLLER, make sure to adjust the head/foot guide manually (p.3-23). If you perform a trimming operation before adjusting the guide manually, the guide may cut into paper, leading to a damage to the machine.**

8-1. Specifying the Trimming Width

Memo Here we explain how to specify the trimming width in the DKT-200 preview area. Other than in the DKT-200 preview area, you can specify the head/foot trimming width in the [Finished Size] tab in the preview area of the job summary screen in the same way as below.

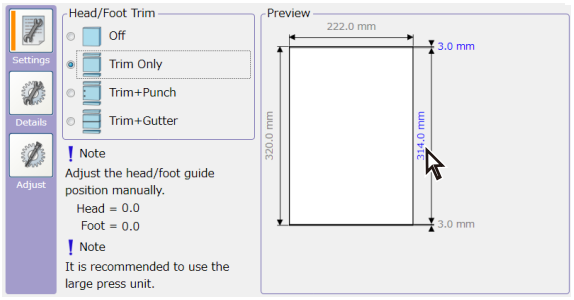
To specify the different width between the head and the foot, the following three conditions need to be satisfied.

- The width of the booklet conveyed to the DKT-200 is 341 mm/13.42 inches or less.
- The respective width of the head and foot is between 1 mm and 30 mm/0.04 inch and 1.18 inches.
- The difference of the trimming width between the head and foot is between 0 mm and 21 mm/0 inch and 0.83 inch.

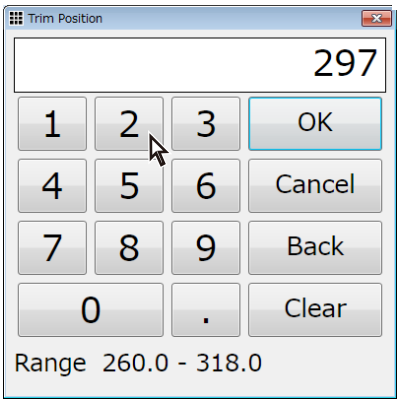
  Example)

  When the trimming width at the head side is 1 mm/0.04 inch, the trimming width at the foot side varies between 1 mm and 22 mm/0.04 inch and 0.87 inch depending on the finished size.

1 **Click the trim position (blue character) in the preview area.**



The numeral value input screen is displayed.

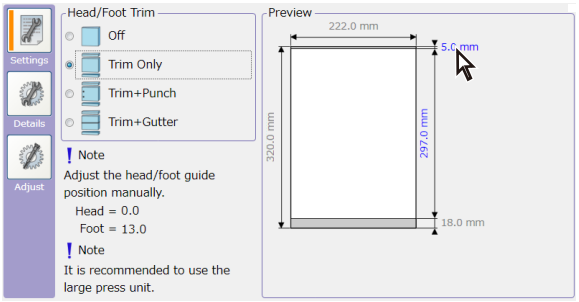


2 **Input the length of the trim position.**

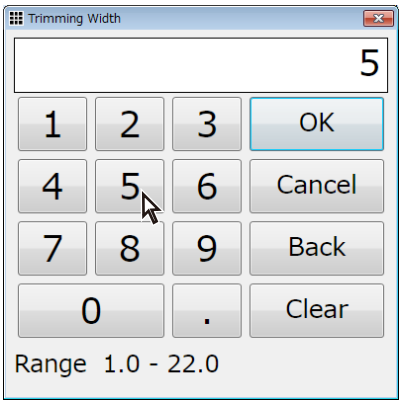
In the preview area of the job summary screen, [Finished Width] is displayed on the top of the screen instead of [Trim Position].

3 **Click [OK].**

4 **Click the trimming width (blue character) in the preview area.**



The numeral value input screen is displayed.



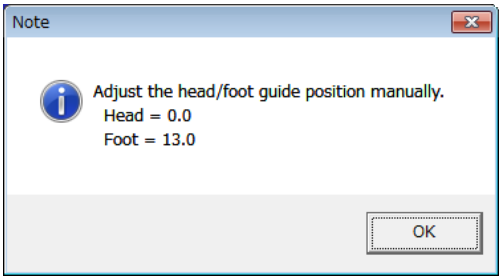
5 **Input the trimming width.**

6 **Click [OK].**

The stitching position and adjustment value of the tucker stopper of the DBMS-S are automatically adjusted.

7 **Press the [Send] button in the job window.**

The job data currently displayed in the job window is sent to the system and the message to the right is displayed.



8-2. Adjusting Head/Foot Guide of the DKT-200

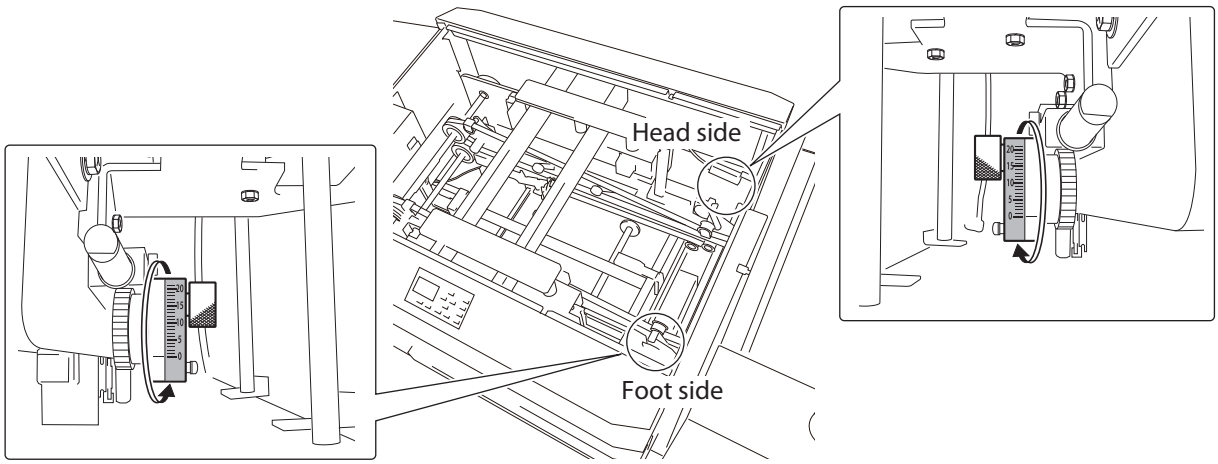
1 **Open the top cover of the DKT-200.**

2 **Loosen the knob screw of the adjustment dial of the head/foot guide.**

If you turn the knob screw too much, it will come off the machine.

3 **Check the value shown in the screen of step7 and move the adjustment dial to align the indicator with the value.**

Moving one division changes the trimming width in 1 mm increments. If you cannot see the dial, press and hold the home resetting key of the DKT-200. The head/foot guide returns to its original position.



4 **Tighten the knob screw of the adjustment dial of the head/foot guide.**

Once you change the trimming width on the PC CONTROLLER, repeat steps from 1 through 4.

When you do not perform offset trimming, return the adjustment dial to the 0 position.

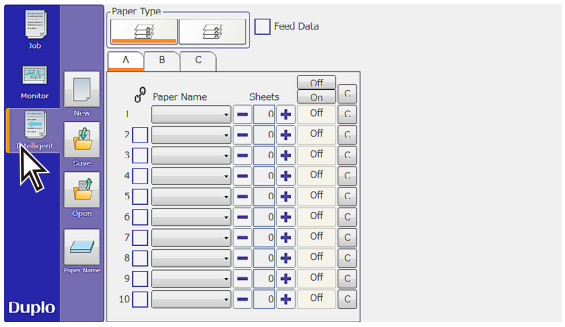
9. Setting Intelligent Feed

The collator normally feeds paper piece by piece from each bin at the same time. By using the intelligent feed function, you can specify a bin to be used and the number of sheets to feed. This function is convenient when you feed collated sets of paper using several bins alternately or feed paper in a specified order.

9-1. Specifying a Paper Name

1 **Click the [Intelligent] button.**

The intelligent feed setting screen is displayed.

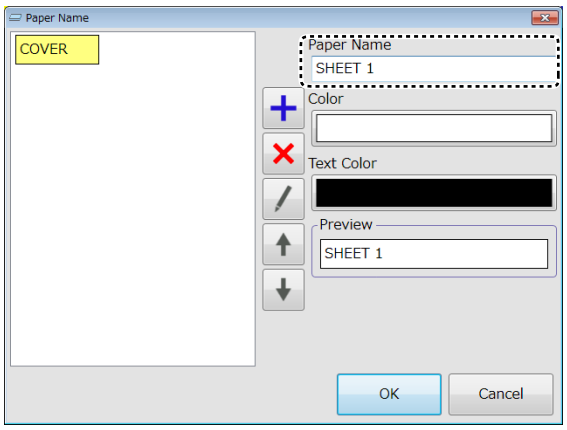


2 **Click the [Paper Name] button.**

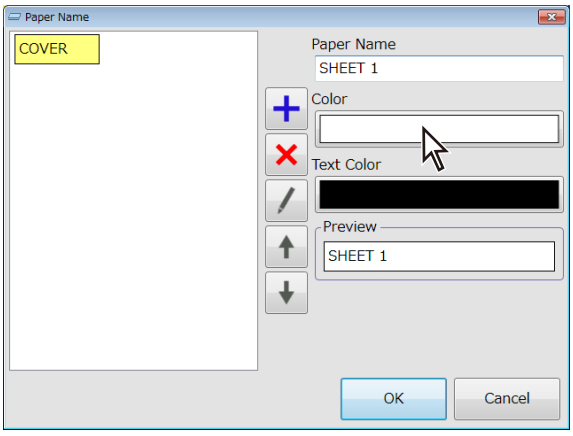
The paper name setting screen is displayed.

3 **Enter a paper name in the [Paper Name] box.**

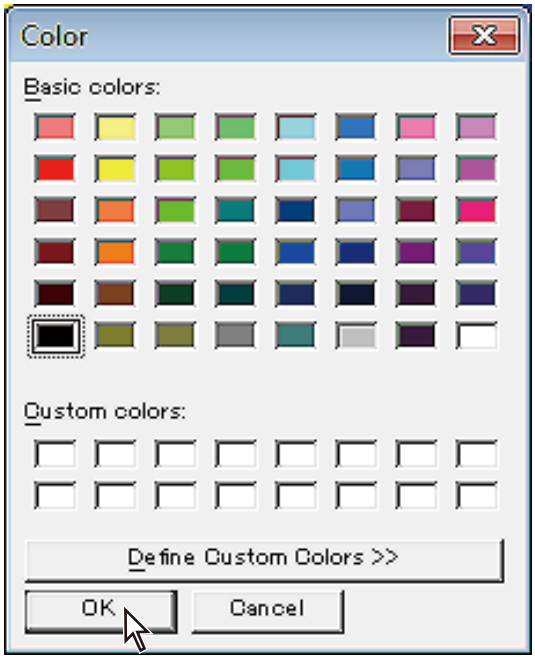
A name that already exists cannot be specified.



4 **Click the [Color] button.**

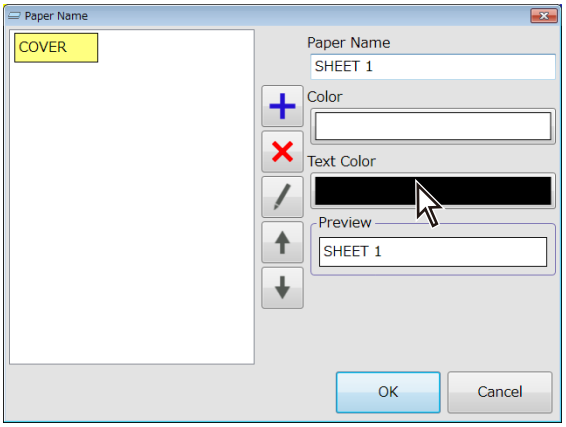


The screen to select a background color is displayed.

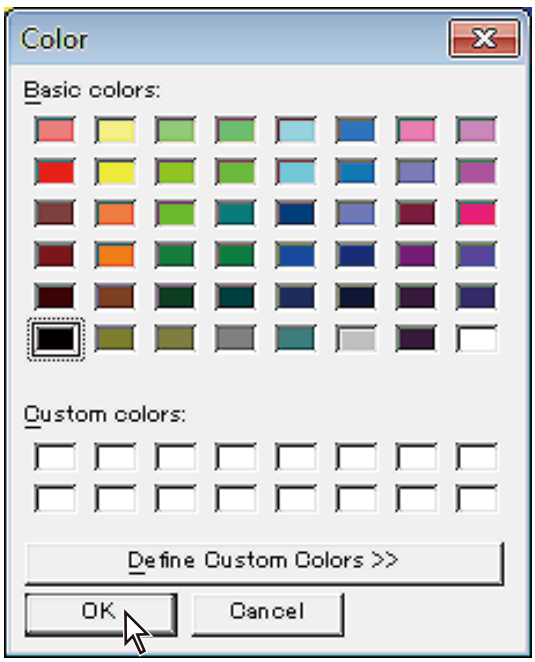


5 **Select a color and click [OK].**

6 **Click the [Text Color] button.**



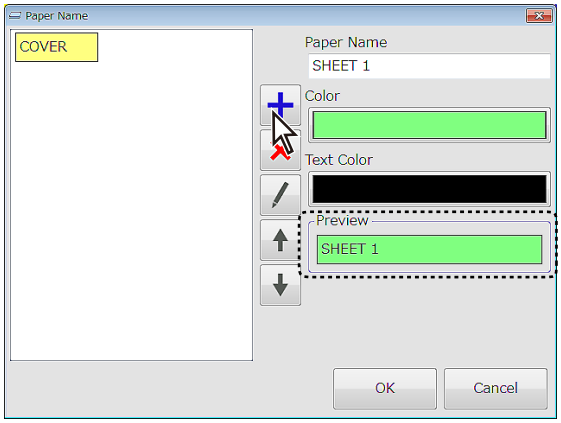
The screen to select a text color is displayed.



7 **Select a color and click [OK].**

8 **Check the image displayed in the [Preview] box.**

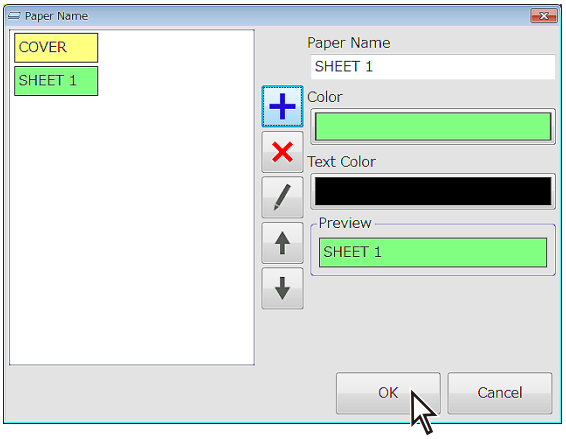
9 **Click the + button.**



The paper name you have given is displayed.

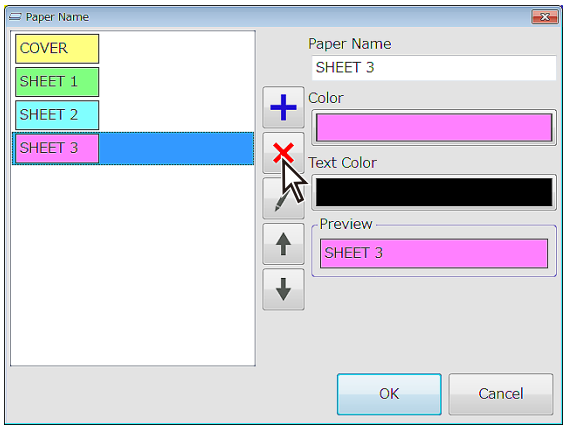
10 **Click [OK].**

The paper name setting screen is closed.



Deleting a fine name

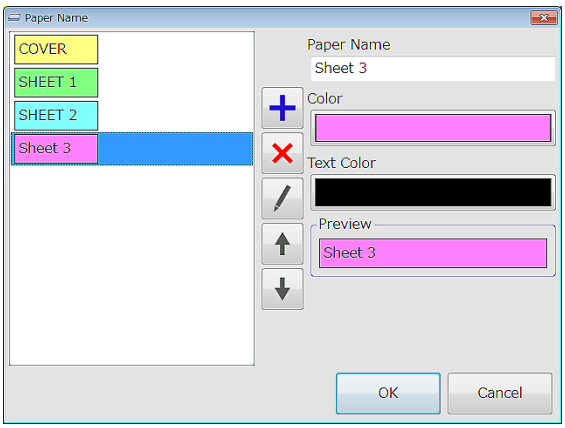
To delete a paper name, click the × button with the paper name selected.



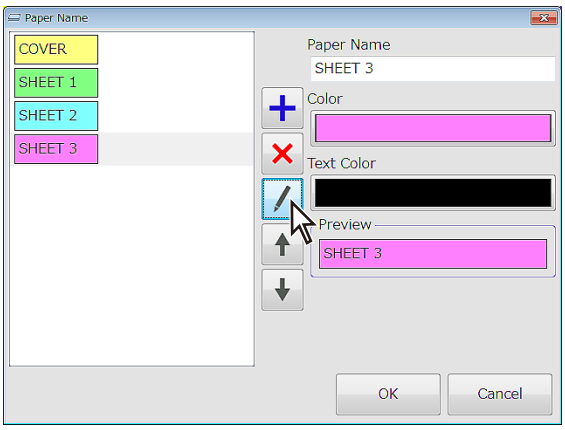
Editing a paper name

To change a paper name, background color and text color, follow the procedures below on the paper name setting screen.

1) **Select a paper name you want to edit from the paper name list.**
The paper name, background color and text color can be changed now.



2) **After completing editing, click the ✎ button.**
A name that already exists cannot be specified.



Moving a paper name

You can change the order of the paper names.
Press the ↑ or ↓ button to move the paper name.

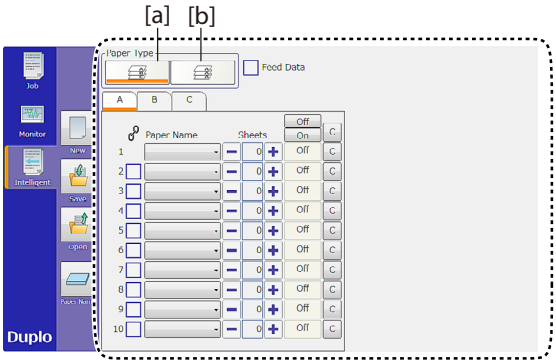
Memo Once you change the paper name list, all the settings in the work area will be cleared.

9-2. Setting the Details

Memo
- Before following the procedures below, make settings for the towers used and set [Processing Mode] to [Intelligent] either on the job summary screen or the downstream unit setting screen.
- If you set intelligent feed to divide one set of paper into several blocks when [Stack] has been set to [Sort], the DBM-400STR will not sort paper as you specify because it sorts paper everytime it receives paper from the collator. When [Stack] has been set to [Sort], do not make setting to divide one set of paper into several blocks.,

Paper is fed from the bottom for left feeding and from the top for right feeding. If you want to feed paper in this order, proceed to "9-2-1. Feeding Paper in the Fixed Order." If you want to feed paper in a desired order, "9-2-2. Feeding Paper in a Desired Order."

The common setting items for both orders are as follows.



Item	Explanation	Default
Paper Type	Select a paper type to be collated on a collator. [a] Collated sets of paper*1 [b] Same paper	Collated sets of paper
Feed Data	Click the box to apply a check mark when feeding paper in a desired order.	Off
🔗	Click the box to apply a check mark when using a bin together with a bin just above as a set.	Off
Paper Name	Select a paper name.	—
Sheets*2	Click the — or + button to specify the number of sheets.	0
On/Off	Specify whether to use the bin.	Off
C	Clear the setting.	—

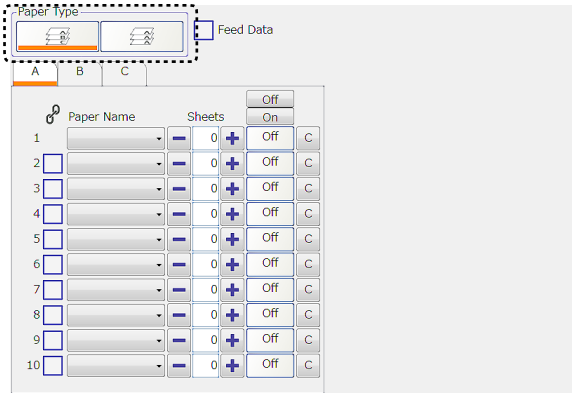
*1: When "collated sets of paper" is selected, presetting will be performed as "set presetting." Set presetting means to perform presetting for several pages according to the settings for intelligent feed. When stacking sheets with different images on a paper feed bin, presetting is performed for each page. This means presetting is performed several times and double feed detection is performed for each image. If an error has occurred during presetting, start presetting from the first page.

- The maximum number of sheets that can be stored at set presetting is 30. If the maximum number of sheets is 31 or more, mis-detection of double feeding will occur.
- You cannot set [Double Feed Detection] [Double Feed Detection Level] and [Light Sensitivity Adjustment] for each page.
- During presetting, paper is fed from all the bins to be used alternately at the same time.

*2: When a check mark is applied to [Feed Data], specify the number of sheets on the [Feed Data] screen.

9-2-1. Feeding Paper in the Fixed Order

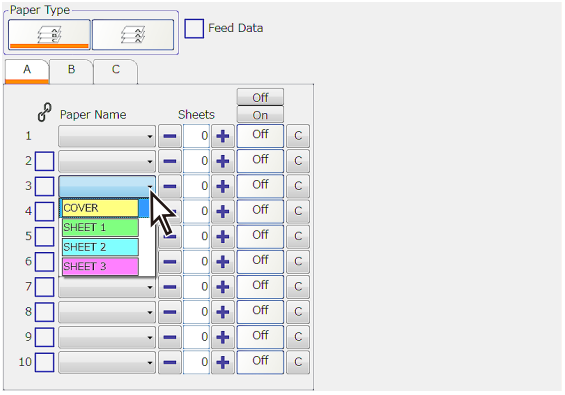
1 Select [Paper Type].



2 **Click the drop-down arrow of [Paper Type].**

Paper names are displayed.

3 **Select a paper name.**



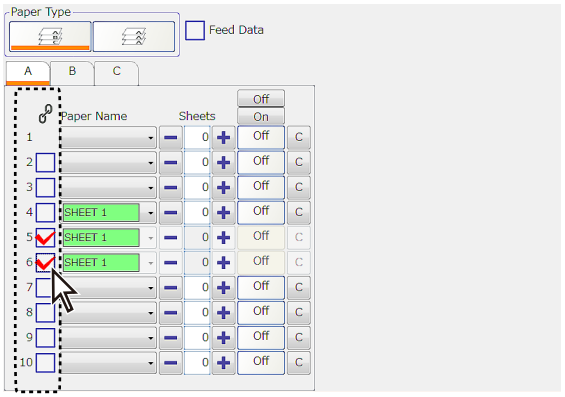
4 **To use the bin with the bin above as a set, click the box to apply a check mark.**

Collated sets of paper:

If check marks are applied to 5 and 6, the 4th, 5th and 6th bins are used alternately.

When the top bin runs out of paper, the next bin starts feeding.

If you stack paper on one of the bins to be used alternately, you can start operations without stacking paper on all the bins. However at the time of presetting you need to stack paper on all the bins. You also need to stack paper in the same page order on all the bins to be used alternately.



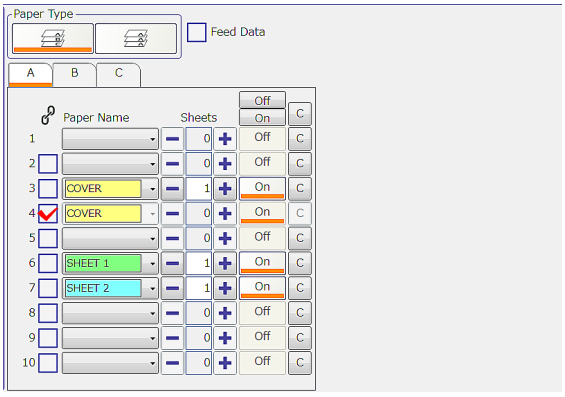
Note

- **If several bins used alternately have run out of paper at the same time, the machine will stop. Stack collated sheets on those bins and start feeding paper again.**

  Example) When the 3rd and 4th bins and the 6th and 7th bins are used alternately, if the 3rd and the 6th bins have run out of paper at the same time, the machine will stop. Stack collated sheets on the 3rd and 6th bins.

- **Do not set to use bins alternately for cover sheets if the cover and a book block need to be matched. When the upper bin runs out of paper, it takes some time for the bin below starts feeding paper. By the time the bin below starts feeding paper, other bins will already have started feeding paper, which will result in being ejected to the reject tray. A cover to be sent afterward will not match with a book block.**

  Example) As shown in the figure to the right, when collated covers are stacked on the 3rd and 4th bins and collated book blocks are on the 6th and7th bins, if the 3rd bin runs out of paper, by the time the 4th bin starts feeding covers, the 6th and 7th bins will already have started feeding paper, which will end up in the reject tray. Although a cover sheet is fed from the 4th bin later, it will not match with a book block.



Same paper:

If you have clicked the 5th and 6th bins to apply check marks and set the number of sheets to five, the five sheets will be sent in the following way.

A sheet of paper is fed from the 4th, 5th and 6th bins at the same time.

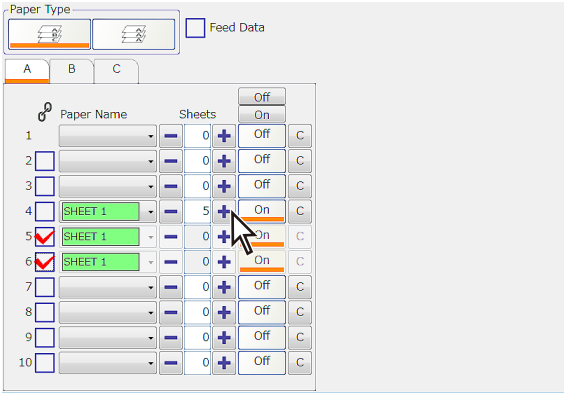
Then, a sheet of paper is fed from the 4th and 5th bins at the same time.

Stack paper on all the bins to be used.

5 **Click the + button to specify the number of sheets.**

When the number of sheets is specified, [On] is automatically displayed for the bin.

To clear the setting, click the C button.



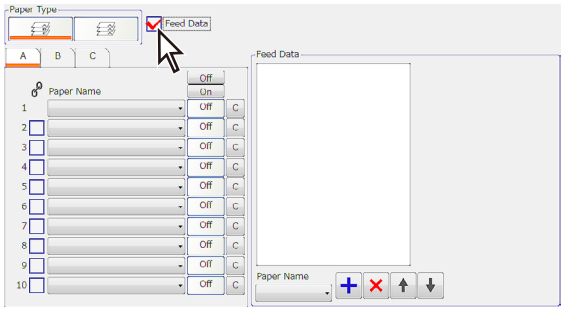
9-2-2. Feeding Paper in a Desired Order

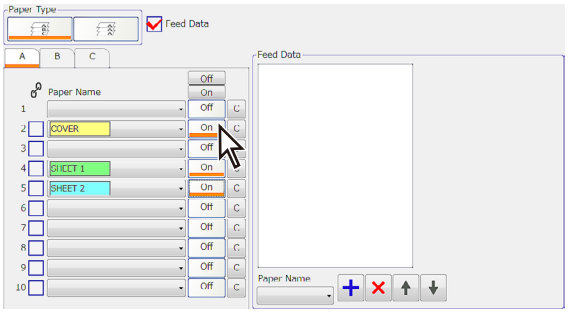
1 **Click the [Feed Data] box to apply a check mark.**

The feed data setting screen is displayed.

2 **Follow the procedures from steps1 to 4 in "9-2-1. Feeding Paper in the Fixed Order."**

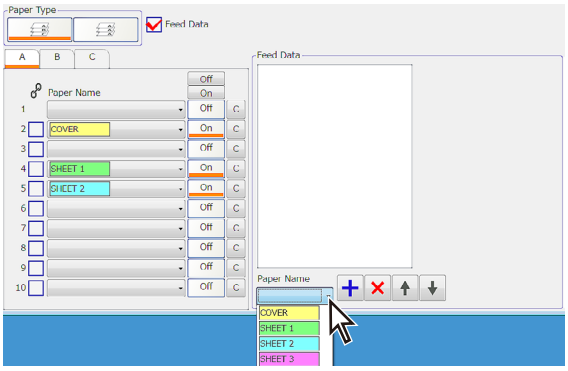
3 **Set the bin to be used to [On].**





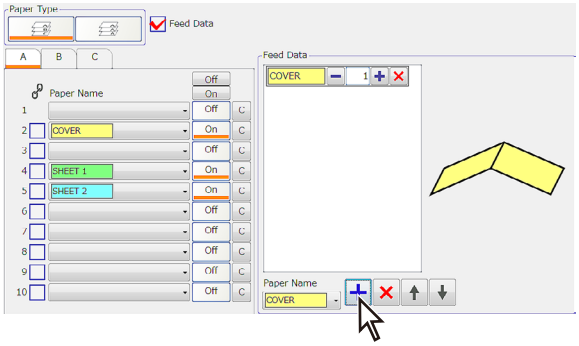
4 **Click the drop-down arrow of [Paper Name].**

Paper names are displayed. The feeding order will be displayed in illustration on the right side of the screen.

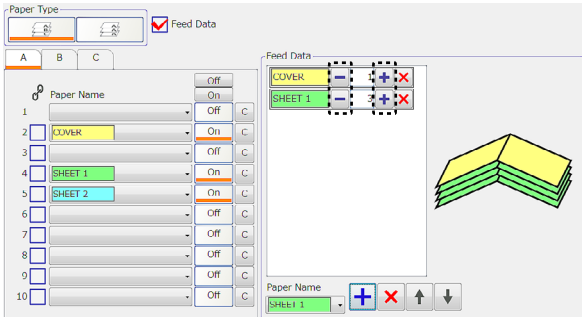


5 **Select a paper name and click the + button.**

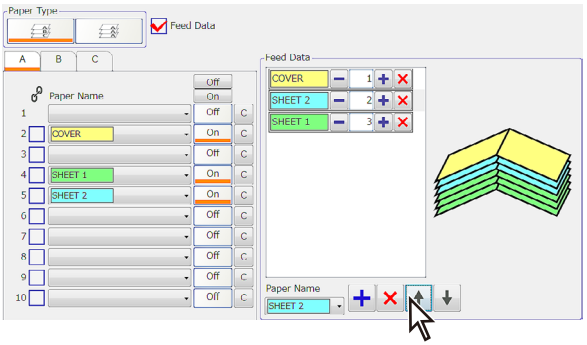
The selected paper name is displayed on the screen.



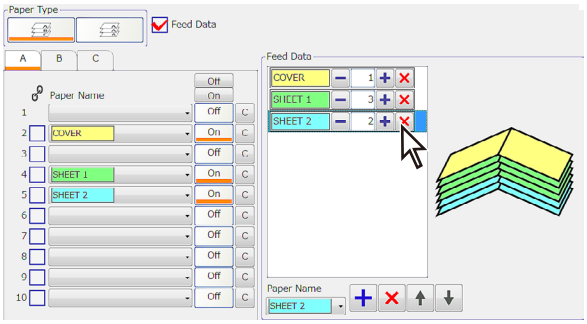
6 **Click the − or + button to specify the number of sheets.**



7 **With the paper name selected from the list, click the ↑ or ↓ button to move the paper name to a desired place.**



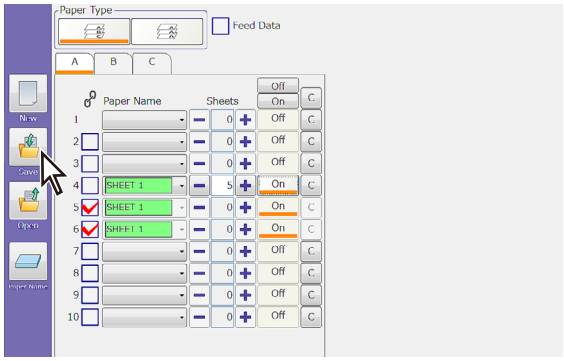
8 **To delete a paper name from the list, click the × button with the paper name selected.**



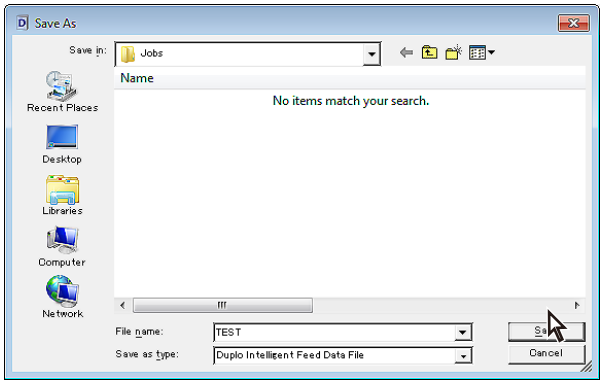
9-3. Saving the Settings

After completing settings for intelligent feed, you can save the settings.

1 **Click the [Save] button on the intelligent feed window.**



The [Save As] dialog box is displayed.



2 **Select a place to save.**

3 **Input a name for the file.**

If a forbidden character such as [*] and [?] is included in the name, the file cannot be saved.

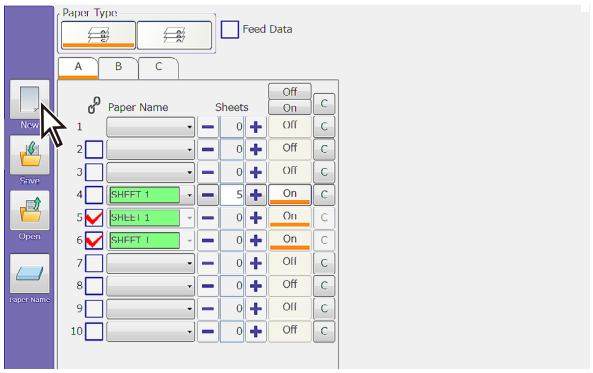
4 **Click the [Save] button.**

The file name you saved here is the name of the intelligent feeding data.

9-4. Initializing the Settings

When you want to return the settings you are currently making to default or make new settings, follow the procedures below.

Click [New] on the intelligent feed window.



If the settings you are currently making have not been saved, the message [Save Changes ?] is displayed.

Clicking [Yes] returns the settings to default after saving the settings.

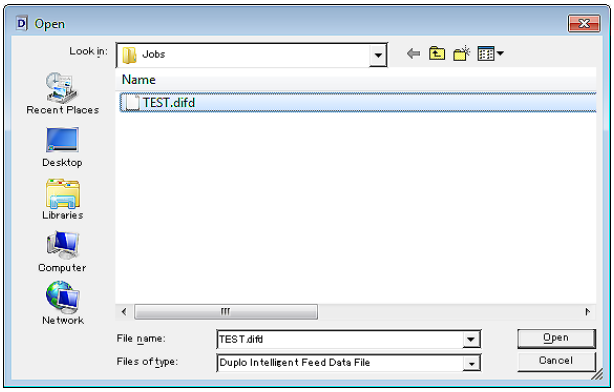
Clicking [No] returns the settings to default without saving the settings.

9-5. Loading Saved Data

1 **Click the [Open] button on the intelligent feed window.**
A dialog box is displayed to open a file.

2 **Search for a intelligent feeding data file to open and select it.**

3 **Click [Open].**

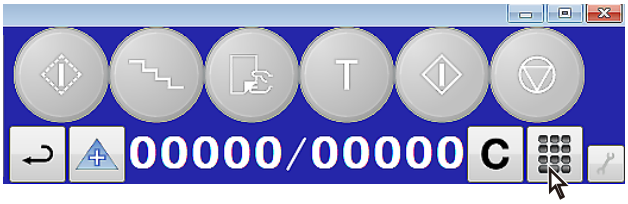


10. Setting the Number of Sets to be Processed and Custom Size

10-1. Specifying the Number of Sets to be Processed

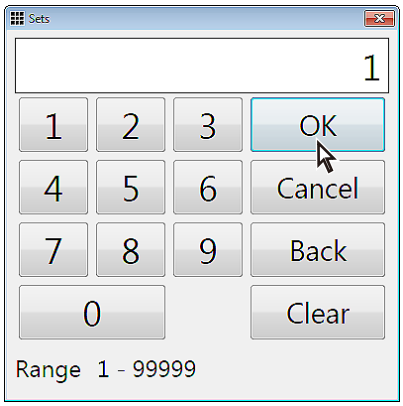
After completing settings for all the machines, specify the number of sets to be processed.

1 **Click ▦ in the counter area.**
The numeral value input screen is displayed.



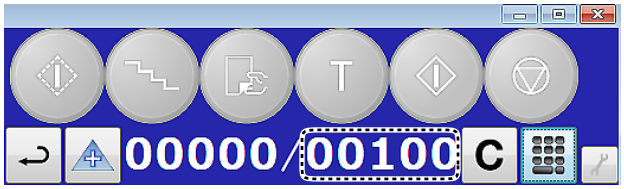
2 **Input the number of sets on the numeral value input screen.**

3 **Click [OK].**



4 **Check that the display is renewed on the number of sets display section.**

- Click ▲ (count up) of ▼ (count down) to switch the count method.
- Click ⮌ (on) or ⮌ (off) to switch the count repeating function between on and off.

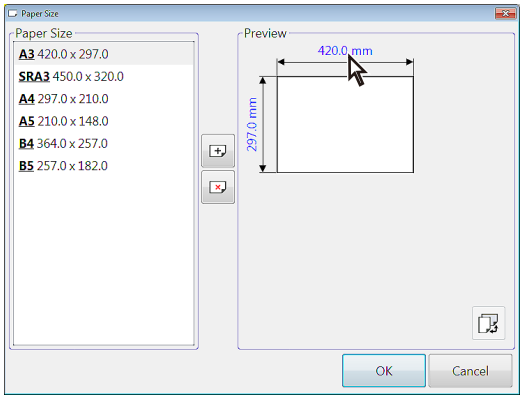


10-2. Setting the Custom Size

The paper size list is on the paper size setting window, and the regular sizes are listed at the default settings. If you cannot find the paper size to use in the list, set the custom size and add it to the list.

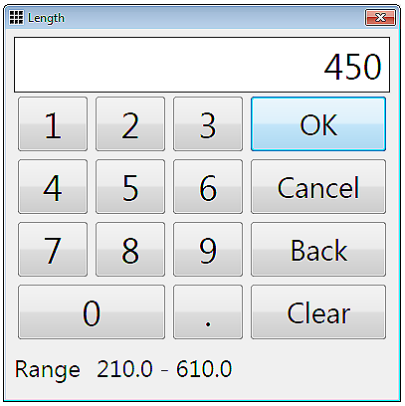
1 **Click the paper length (blue character) in the preview area.**

The numeral value input screen is displayed.



2 **Input the length of the custom size.**

3 **Click [OK].**

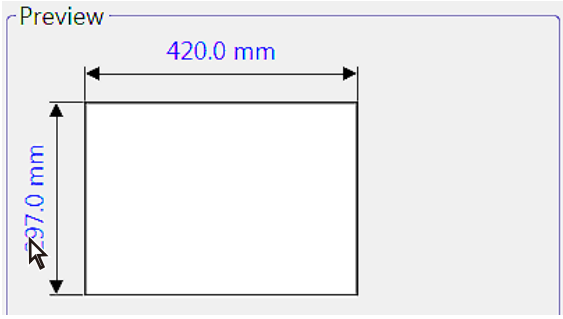


4 **Click the paper width (blue character) in the preview area.**

The numeral value input screen is displayed.

5 **Input the width of the custom size.**

6 **Click [OK].**



7 **Click .**

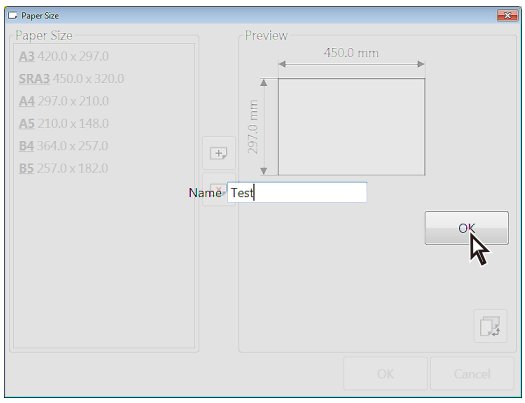
The paper size name entry screen is displayed.

8 **Input the name.**

Up to ten characters can be inputted.

9 **Click [OK].**

The custom size is set and it is added to the paper size list.



Memo
- Click the to change vertical feeding and horizontal feeding.
- In order to delete the custom size added, select the custom size to be deleted in the paper size list and click the button.
- You cannot delete the default regular sizes.

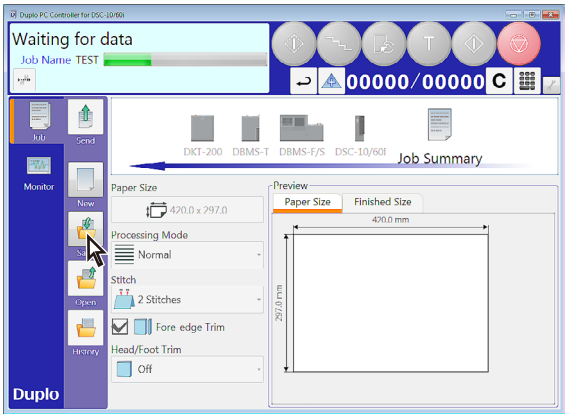
11. Saving Job Data

After completing settings on the PC CONTROLLER, it is recommended the set data is saved as [Job Data] on a PC. This job data can be sent from the PC CONTROLLER to the bookletmaking system and used again by loading as required.

1 **Check that the [Paper Size] is set on the job summary screen.**

2 **Click the [Save] button on the job window.**

The [Save As] dialog box is displayed.



3 **Select a place to save.**

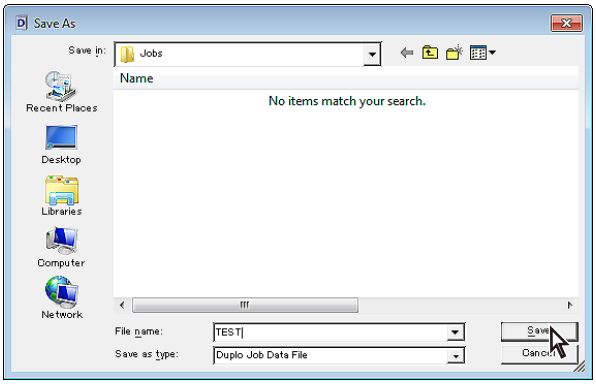
4 **Input a name for the file.**

If a forbidden character such as [*] and [?] is included in the name, the file cannot be saved.

5 **Click the [Save] button.**

The file name you saved here is the job name of the job data.

For details, refer to Chapter 4 "3. Using Existing Data" (☞ p.4-8).

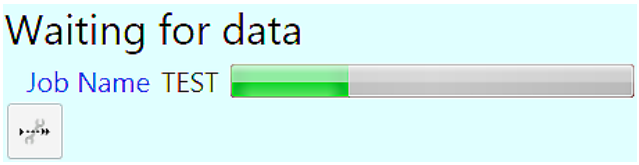


12. Sending Data

After completing settings for all the machines, send the job data saved to the bookletmaking system.

1 **Click the [Send] button on the job window.**

Job data displayed on the job window is sent to the bookletmaking system.



2 **Check that the display of action buttons are colored.**

Action buttons displayed in color can be clicked.

If any error has occurred, or the bookletmaking system is not in standby state, these buttons may not be displayed in color and cannot be used. In such a case, remove the cause of the error and return the bookletmaking system to the standby state.

13. Creating New Jobs

Use the new job creation window to create a new job.

On the new job creation window you can create and save a new job and edit jobs created in the past.

By using the new job creation window, you can process the job displayed on the job window in the bookletmaking system and at the same time create a job to operate next. The bookletmaking system can be effectively operated.

1 **Click the [New] button on the job window.**

The new job creation window will open.

2 **Create job data.**

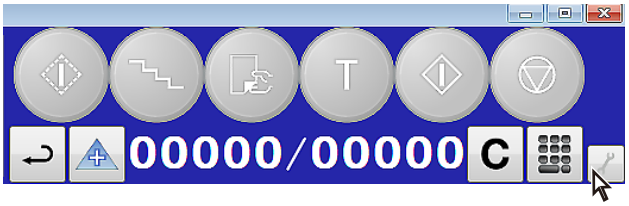
The job creation procedure on the new job creation window is the same as the procedure on the job window except that there are limitations as follows.

- Job data cannot be sent from the new job creation window to the bookletmaking system. Save the created job data and load it on the job window, then send it to the bookletmaking system. For details, refer to Chapter 4 "3-1. Loading Job Data" (☞ p.4-8).
- Job history cannot be displayed nor loaded on the new job creation window.

14. Setting to Power Saving Mode

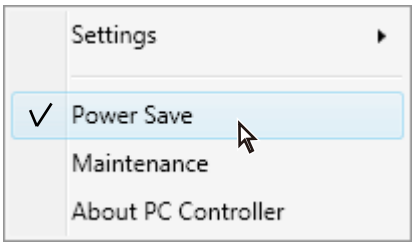
You can set the whole system to the power saving mode. When set to the power saving mode, the back light of the control panel turns off and the LED blinks.

1 **Click the menu button.**



2 **Click [Power Save] to apply a check mark.**

While the system is in operation, you cannot apply a check mark.



To cancel the power saving mode, remove the check mark in step2 above. When set to the power saving mode, you cannot start bookletmaking operations even by pressing the start button.

Memo

Chapter 4 Operating and Stopping the System

1. Operating the System

1-1. Presetting

Before starting collating operations, press the preset button first. Only one set of paper will be sent from the collator to inform the system the paper size and the paper feed bins to be used for bookletmaking operations. Once you have changed paper size and paper type, make sure to perform presetting. When other action button is pressed before performing presetting, an error will occur on the DSC-10/60i.

1 **Select a paper destination for preset paper on the LUL-HM setting screen of the DSC-10/60i.**

Refer to Chapter3 "[LUL-HM] Screen" in "3-2. Making Detailed Settings" (☞ p.3-14) for details.

2 **Click the preset button.**

3 **Check the collated set.**

Check the number of paper feed bins used for collation matches with the number of sheets in the collated set.

When mis-detection of double feeding and mis-feeding occur

Normal feeding can be judged as mis-detection or double feeding during presetting. In this case, solve the problem as follows.

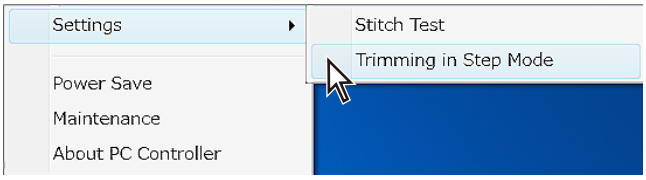
- If mis-detection occurs when [Double Feed Detection Level] is set to "thin paper," set it to "thick paper" and perform presetting again. If mis-detection still occurs, set it to off.
- If mis-feeding occurs when [Double Feed Detection Level] is set to "thick paper," set it to "thin paper" and perform presetting again. If mis-detection still occurs, set it to off.

1-2. Step by Step Operations

Step mode is a mode for adjusting the guides and stopper on each machine to their appropriate positions according to the paper. Perform step by step operations before starting bookletmaking operations using new job data or when you have changed the job data halfway through the bookletmaking job.

1 **To perform stitching in the step mode, click [Settings]-[Trimming in Step Mode], then apply a check mark to [Trimming in Step Mode].**

When you want to adjust the stitching position when offset trimming has been set, do not apply a check mark to [Trimming in Step Mode].



2 **Click the step button.**

One set is conveyed to the infeed section of the DBMS-F from the DSC-10/60i.

3 **Check the position of the guides and adjust them if necessary on the control panel of each machine.**

For adjustments, refer to the instruction manual supplied with each manual.

When offset trimming has been set

When a stitching position is not appropriate, adjust the stitching position on the DBMS-F adjustment screen on the PC CONTROLLER or the DBMS-F control panel. To adjust the trimming width, follow the procedures below.

1) Select the [Guide Adjustment] screen on the DKT-200 control panel.
2) Open the top cover.
3) Check the position of the head/foot guide, adjust the gap between the head/foot guide and the booklet on the [Guide Adjustment] screen.
4) Check the trimming position and the finished size of the booklet.

4 **Press the process key on the control panel of each machine.**

The set will conveyed to a next position.

5 **Repeat steps 2 through 4.**

When the stitches on the booklet are closer either to the foot or the head side

Even after adjusting a stitching position in step3 above, if the stitches are still closer either to the head side or the foot side and the trimming position is not correct, follow the procedures below.

A. After applying offset trimming to the head side, the stitches are closer to the foot side

1) Follow steps 1 and 2 in "1-2. Step by Step Operations."
2) Open the top cover of the DKT-200.
3) Move the adjustment dial of the head side to the direction of "20" by 1 or 2 scale.
4) Close the top cover of the DKT-200.
5) Narrow the head/foot guide on the [Guide Adjustment] screen of the DKT-200 control panel until the guide touches the booklet.
6) If the stitches are still closer to the foot side, repeat procedures in steps 1) through 5).

B. After applying offset trimming to the head side, the stitches are closer to the head side

1) Follow steps 1 and 2 in "1-2. Step by Step Operations."
2) On the [Guide Adjustment] screen of the DKT-200 control panel, widen the head/foot guide to the extent that the booklet do not bend.
3) Open the top cover of the DKT-200.
4) Move the adjustment dial of the head side to the direction of "0" by 1 or 2.
5) Close the top cover of the DKT-200.
6) If the stitches are still closer to the head side, repeat procedures in steps 1) through 5).

C. After applying offset trimming to the foot side, the stitches are closer to the foot side

1) Follow steps 1 and 2 in "1-2. Step by Step Operations."
2) On the [Guide Adjustment] screen of the DKT-200 control panel, widen the head/foot guide to the extent that the booklet do not bend.
3) Open the top cover of the DKT-200.
4) Move the adjustment dial of the foot side to the direction of "0" by 1 or 2.
5) Close the top cover of the DKT-200.
6) If the stitches are still closer to the foot side, repeat procedures in steps 1) through 5).

D. After applying offset trimming to the foot side, the stitches are closer to the head side

1) Follow steps 1 and 2 in "1-2. Step by Step Operations."
2) Open the top cover of the DKT-200.
3) Move the adjustment dial of the foot side to the direction of "20" by 1 or 2.
4) Close the top cover of the DKT-200.
5) Narrow the head/foot guide on the [Guide Adjustment] screen of the DKT-200 control panel until the guide touches the booklet.
6) If the stitches are still closer to the head side, repeat procedures in steps 1) through 5).

1-3. Adjusting Each Machine Separately (Separate Step Mode)

After operating the machine in the step mode, you can perform step-by-step operations only for a machine specified.

1 **Press the key on the control panel of the machine for which you want to make fine adjustment.**

2 **Press the test button of the PC CONTROLLER.**

The paper conveyed from the upstream unit stops at the machine which is to be fine adjusted.

3 **Operate the machine in the step mode.**

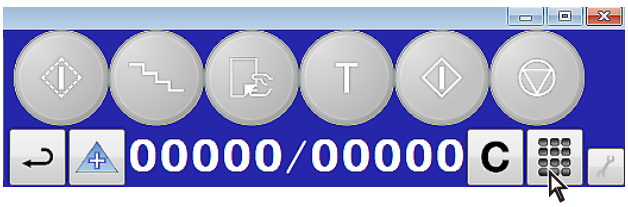
Ref. Refer to the instruction manual supplied with each machine for details on the step mode.

1-4. Hand Feed

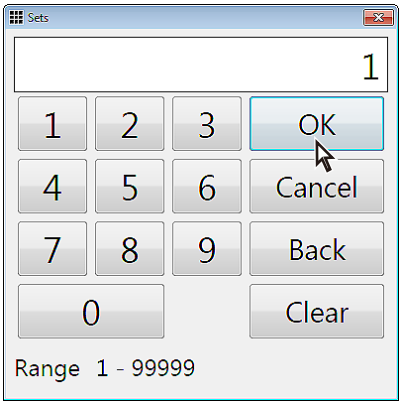
When feeding paper by hand from the LUL-HM, follow the procedures below.

1 **Click in the counter area.**

The numeral value input screen is displayed.



2 **Input the number of sets on the numeral value input screen.**



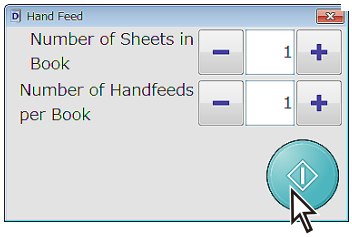
3 **Click [OK].**

4 **Insert a set of paper to the LUL-HM.**

When subset is divided into plural times, insert sheets by the same number of times as specified for the subset.

5 **Click the hand feed button.**

The hand feed setting screen is displayed.



6 **Specify the number of sheets and the number of hand feeding, then click the start button.**

When inserting the subset into the LUL-HM, if paper is fed before removing your hand, misaligned paper may jam inside the DBMS-F. If a paper jam frequently occurs, make slower the infeed guide timing (☞ p.3-16). Furthermore, insert the subset with the left and right sides of paper aligned.

1-5. Test Bookletmaking

Click the test button to check the bookletmaking state. The bookletmaking system performs bookletmaking only one set according to the job settings.

1 **Click the test button.**

The bookletmaking system performs bookletmaking process of only one set.

2 **Check the one set bound.**

When adjusting the stitching position and folding position, refer to "1-2. Step by Step Operations" (☞ p.4-1).

When adjusting the stitching state and finished length, refer to fine adjustment screen of each machine.

3 **Repeat steps 1 and 2 as required.**

1-6. Test Stitching

When you have changed a wire for the DBMS-S, perform a stitching test to check the stitching state.

1 **Click [Settings]-[Stitch Test], then apply a check mark to [Stitch Test].**

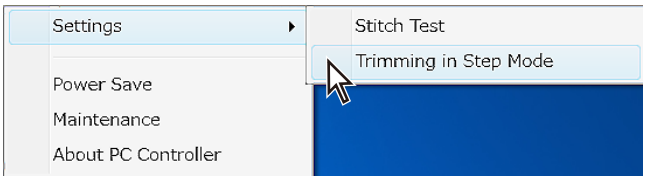
2 **Click the test button.**

3 **Feed one set from the paper feeding unit to perform test stitching in the DBMS-S.**

When clicking the test button, the check mark of [Stitch Test] will be automatically removed. To repeat test stitching, go back to step1.

1-7. Step by Step Hand Feed Operations

1 **Click [Settings]-[Trimming in Step Mode], then apply a check mark to [Trimming in Step Mode].**

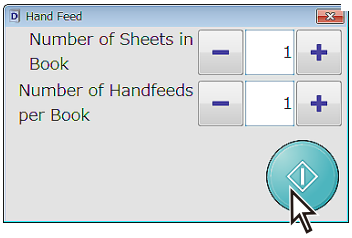


2 **Insert a set of paper to the LUL-HM.**

When subset is divided into plural times, insert sheets by the same number of times as specified for the subset.

3 **Click the step button.**

The hand feed setting screen is displayed.



Note **If you click the step button before inserting paper, paper will be fed from a collator.**

4 **Specify the number of sheets and the number of hand feeding, then click the start button.**

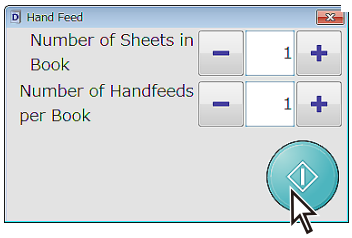
1-8. Hand Feed Test Bookletmaking

1 **Insert a set of paper to the LUL-HM.**

When subset is divided into plural times, insert sheets by the same number of times as specified for the subset.

2 **Click the test button.**

The hand feed setting screen is displayed.



If you click the test button before inserting paper, paper will be fed from a collator.

3 **Specify the number of sheets and the number of hand feeding, then click the start button.**

1-9. Hand Feed Test Stitching

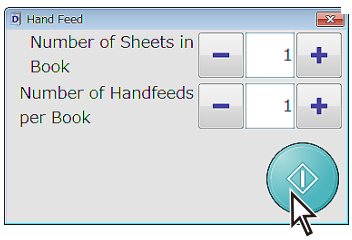
1 **Click [Settings]-[Stitch Test], then apply a check mark to [Stitch Test].**

2 **Insert a set of paper to the LUL-HM.**

When subset is divided into plural times, insert sheets by the same number of times as specified for the subset.

3 **Click the test button.**

The hand feed setting screen is displayed.



If you click the test button before inserting paper, paper will be fed from a collator.

4 **Specify the number of sheets and the number of hand feeding, then click the start button.**

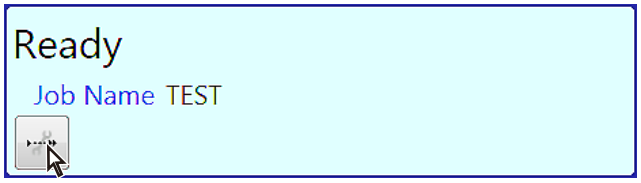
1-10. Changing Processing Speed

Although the PC CONTROLLER optimizes the operation automatically so that the job currently set can be processed at the most appropriate speed, you can change it as you wish. You can change the speed after clicking the send button or during bookletmaking operations.

1 **Check that the paper size has been set.**

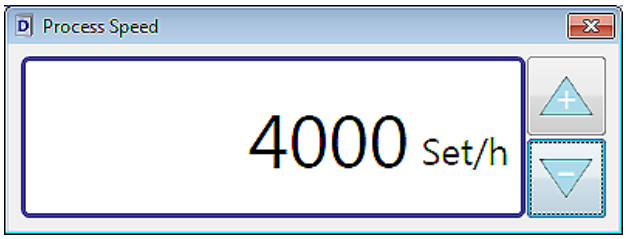
2 **Click the button in the message box.**

The processing speed change window is displayed.



3 **Change [Process Speed] using ▲ or ▼.**

- By changing the set speed, you can change the interval for the DSC-10/60i.
- When the numeral value increases, the interval becomes narrower. When the numeral value decreases, the interval becomes wider.
- If paper jams at the DBMS-S infeed section or stitching section, paper jam may be cleared by changing the set speed to a smaller value.
- The maximum number of the set speed varies depending on a paper size and a downstream unit.
- Depending on the processing mode, you may not be able to change the processing speed from low to high at one time. If the speed displayed on the screen stops to change after you keep pressing ▲, stop pressing it. If the screen is displayed in gray (a state where you cannot change the settings), wait for the screen to return to white (a state where you can change the settings) and press ▲ again to select a desired speed.



1-11. Resetting the Counter

The number of sets processed is displayed on the counts display section in the counter area.

Click the C button.

The counter returns to 0 when the counter is set to the count up mode, and the counter returns to the number of sets input on the job screen when the counter is set to the count down mode.

1-12. Starting Bookletmaking

After completing preset (☞ p.4-1), step by step operations (☞ p.4-1) and test bookletmaking (☞ p.4-4), start bookletmaking.

1 **Check the counter display.**
Click the C button to reset the counter.

2 **Click the start button.**
The bookletmaking system performs bookletmaking.

2. Stopping the System

After completing bookletmaking for the number of sets input, bookletmaking system will stop automatically. Normally there is no need to click the stop button.
If you need to stop the bookletmaking system during bookletmaking operation, click the stop button.

3. Using Existing Data

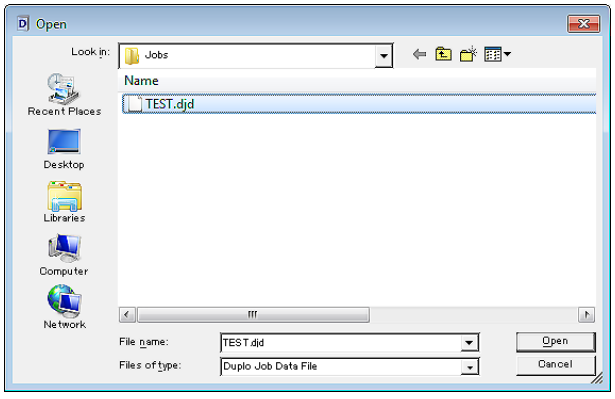
Data saved by clicking the [Save] button can be loaded according to the following procedures. You can also load the data saved on the new job creation window in the same way.

3-1. Loading Job Data

1 **Click the [Open] button on the job window.**
A dialog box is displayed to open a file.

2 **Search for a job data file to open and select it.**

3 **Click [Open].**



3-2. Deleting Job Data

Job data is saved in the specified folder with the extension ".djd."
Job data file can be deleted in the same way as deleting other files in the PC.

3-3. Job History

Job data sent to the bookletmaking system is saved automatically on the PC.
You cannot disable saving of histories nor change the folder to save data.
All saved histories are displayed by clicking the [History] button on the job window and you can load any data. By using the loaded data, the same processing as the saved settings can be performed. You can also make changes to the settings before starting processing. These settings can also be saved as a new job.
Up to 100 job histories can be saved in the existing folder. When exceeding 100, old data will be sequentially deleted.

The following information is displayed in job histories.

- No. :Displays the order in which jobs are executed.
- Job Name :Displays the job name that was given before sending data from the PC CONTROLLER to the bookletmaking system. If the job data was not saved, the date when the data was sent to the bookletmaking system is displayed instead of the job name.
- Length :Displays the paper size.
- Width :Displays the paper width.
- Date Modified :Displays the date and time when the job is executed.

3-4. Loading Job History

1 **Click the [History] button.**
The job history is displayed in the list format.

2 **Find the required data in the job history.**

3 **Double-click the required data.**

Memo

Chapter 5 Technical Information

1. Troubleshooting

1-1. Communication Errors

Communication-related errors occur when communication between the PC and bookletmaking system is not normal or when illegal settings are performed on the PC CONTROLLER. These errors will disable all or some of the action buttons and the [Send] button.

Correction method 1

These errors can be corrected by turning off and on the power switch of the DSC-10/60i.

1. **Start the PC CONTROLLER when the power of the DSC-10/60i is turned off.**
2. **Turn on the power of the DSC-10/60i.**
   After a short time, the PC CONTROLLER starts communication automatically.

Correction method 2

These errors can be corrected by quitting the PC once.

1. **Quit the PC CONTROLLER.**
   Save data as required, if any data is not saved.
2. **Start the PC CONTROLLER.**
3. **Check that error messages are not displayed.**

Correction method 3

If communication errors cannot be resolved using the method 1 above, quit both the PC CONTROLLER and the bookletmaking system.

1. **Quit the PC CONTROLLER.**
2. **Turn off the power of the bookletmaking system.**
3. **Check that the PC is connected to the DSC-10/60i correctly.**
4. **Turn on the power of the bookletmaking system.**
5. **Start the PC CONTROLLER.**
6. **Check that error messages are not displayed.**

Restart the PC if errors are not corrected by performing these operations.

1-2. Abnormal Drawing and Icon Image in State of Dot

In some environment of Windows® XP, the drawing may become abnormal on the PC CONTROLLER.
This phenomenon may be improved by performing the following procedures or restarting the PC.

The following procedures cannot be performed depending on the environment of the machine you use.

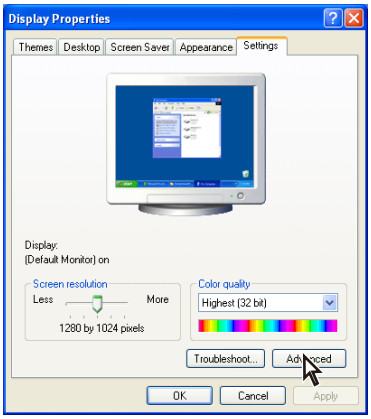
1 **Right-click on the desktop.**

2 **Click [Property].**

3 **Click the [Settings] tab.**

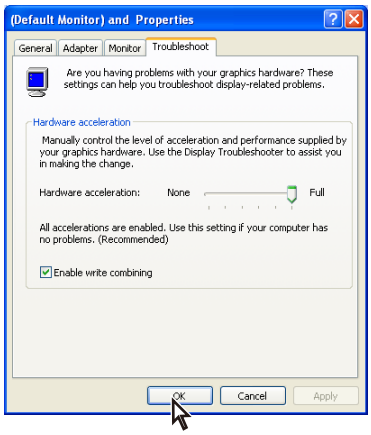
4 **Click [Advanced].**

5 **Click the [Troubleshoot] tab.**



6 **Move the setting of [Hardware acceleration] to the [None] side by one step at a time until the problem is cleared.**

7 **Click OK.**



1-3. Malfunctions of Connected Machines

The message [Trouble] will be displayed when connected machines are not operating normally.

Correction

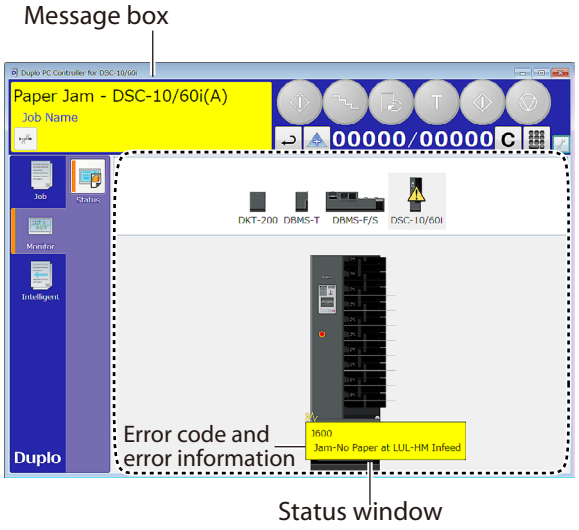
Quit both the PC CONTROLLER and the bookletmaking system and turn them on again.

1. **Quit the PC CONTROLLER.**
2. **Turn off the power of the DSC-10/60i.**
3. **Restart the PC.**
4. **Turn on the power of the DSC-10/60i.**
5. **Restart the PC CONTROLLER.**
6. **Check that no error messages are displayed.**

If the same error message is displayed again, contact your dealer.

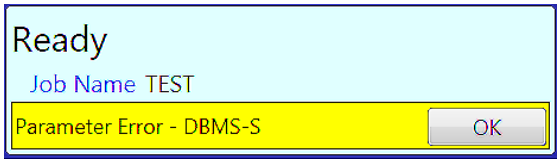
1-4. Status Window

- If errors occur in any of the machines, the status of that machine will be displayed in the message box and the status window on the monitor window will be displayed.
- An icon will be displayed at the place where the error occurred according to the contents of the error, and the error code and contents are displayed beside the icon.



1-5. Parameter Error

- Parameter errors occur on the machine when the parameters are set beyond the specifications. Information on various parameters will be displayed in the message box.
- If a parameter error occurs even after sending job data again, contact your dealer.



2. Recovery Methods after Suspending Work

When the sheets of paper are left in the downstream machine due to mis-feed and operations are suspended, the machine can be recovered by the following procedures.

Memo Depending on processing methods such as hand feed, you may not be able to continue processing.

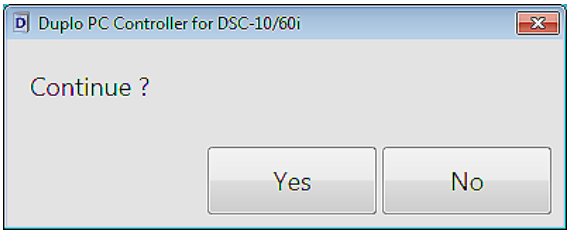
When the machine stops operation due to mis-feed.

1 **Check the state of sheets on the paper feeder.**

2 **Click the start button on the PC CONTROLLER.**

The continuation check window is displayed.

Memo Click the test button to test-feed. Click the step button to enter the step mode.



3 **Click either [Yes] or [No].**

Yes : Restarts bookletmaking for the next subset after the subset conveyed to the downstream unit that is recognized by the bookletmaking system. For example, if the fourth subset among five subsets is mis-fed and three subsets are conveyed to the downstream unit. feeding starts from the fourth subset.

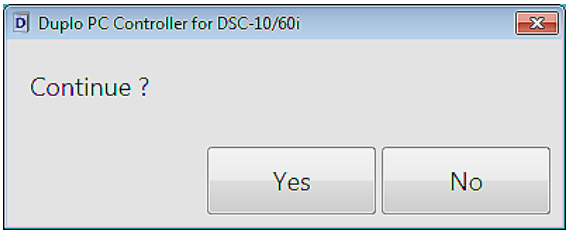
No : The bookletmaking system does not restart. When clicking the start button next, feeding is performed from the first subset.
If the sheets of paper are left in the bookletmaking system, remove all the sheets according to the error displayed.

When the unit stops due to no paper

1 **Stack paper on the paper feed bin.**

2 **Click the start button on the PC CONTROLLER.**

The window to confirm continuation is displayed.



Memo Click the test button to test-feed. Click the step button to enter the step mode.

3 **Click either [Yes] or [No].**

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